

rear of the magazine is the cause. *

There are normally minor differences regarding the "height" of any stamped or milled frame measured from the top rail to the area where the selector stop resides, and varying the depth of the depression in the selector stop is the method of adjustment. Since many of these selector stops are from used kits assembled elsewhere, there may be dimensional issues when mounted onto a new frame.



In the photograph above, a selector stop is shown touching a stamped frame. There are a couple of rivets helping to keep it in its correct position while a 10,0mm thick plate and Vernier beam caliper are used to make the measurement. Note - the plate does not have to be 10,0mm thick and the beam caliper need not be of the Vernier type. I prefer the 10,0mm plate since "10" is an easy value to mentally subtract from the total reading. The measurement indicates 49,95mm which translates to $49,95\text{mm} - 10,0\text{mm} = 39,95\text{mm}$. So, the chosen selector stop for this frame will not work correctly. Since a selector stop with the correct depth of depression is not available it must be machined to the correct depth.

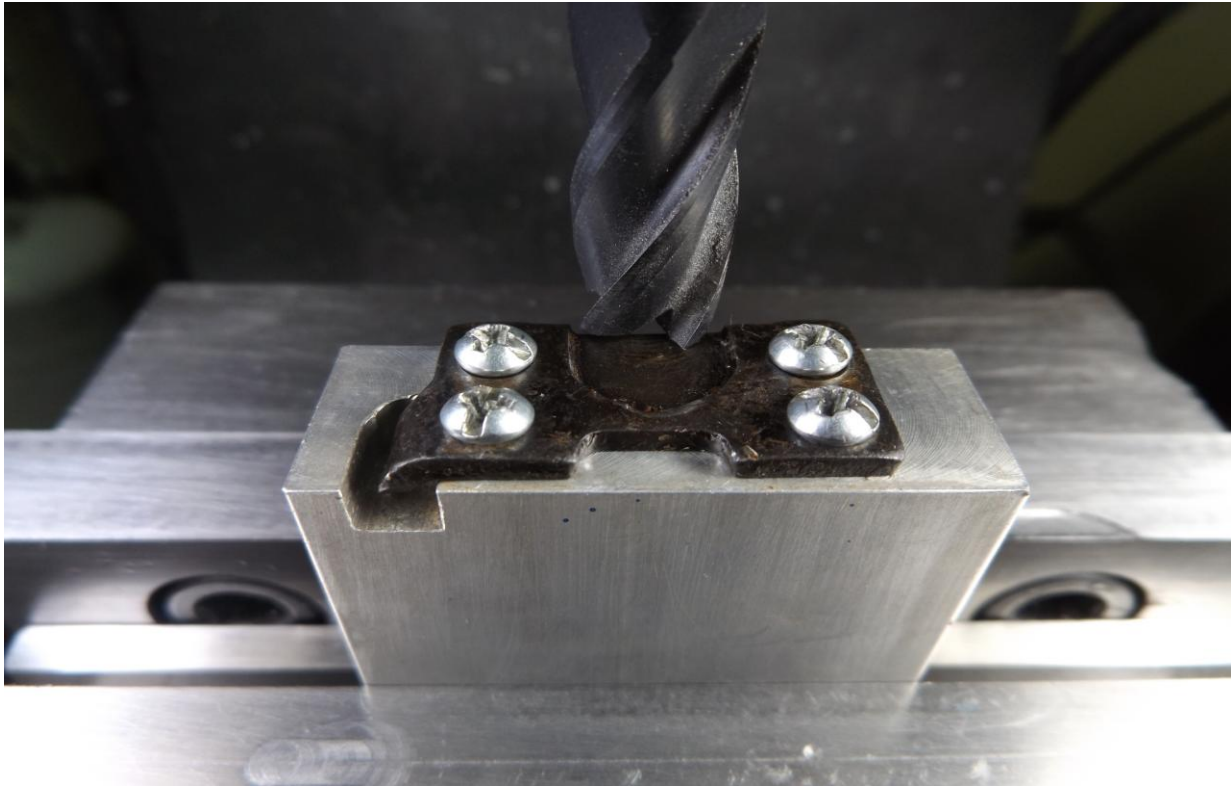
In the case of this selector stop and frame assembly, the depth of the depression must be increased 0,75mm.



In the photograph above, you can see a simple tool that allows holding the selector stop while the depression depth is increased. It is made from aluminium with a pattern of tapped Nr. 6-32 UNC holes. The top of this fixture has an angle of 2-degrees 30-minutes to closely match the 2-degree 33-minute theoretical angle of the lower plane of the stamped or milled frame.



In the photograph above, the selector stop is fastened to the fixture with the screws. In the photograph immediately below, a diameter 0.500" endmill is centered to the depression, touched off, lowered to the correct depth and the cut is usually made in a single pass. Note that the specification of the width of the depression is 12,6mm and the diameter 0.500" endmill will give a slight width increase to 12,7mm. This does not affect function.



The machined selector stop is again placed on the frame and a measurement made to verify that it is correct. Once verified the selector stop is assembled with the triggerguard and all is riveted in place.

*It is my practice for a 5,56 x 45 rifle or carbine to arrive as close to 39,05mm (39,2mm - 0,15mm) as possible in order to raise the magazine to the maximum allowed height.

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