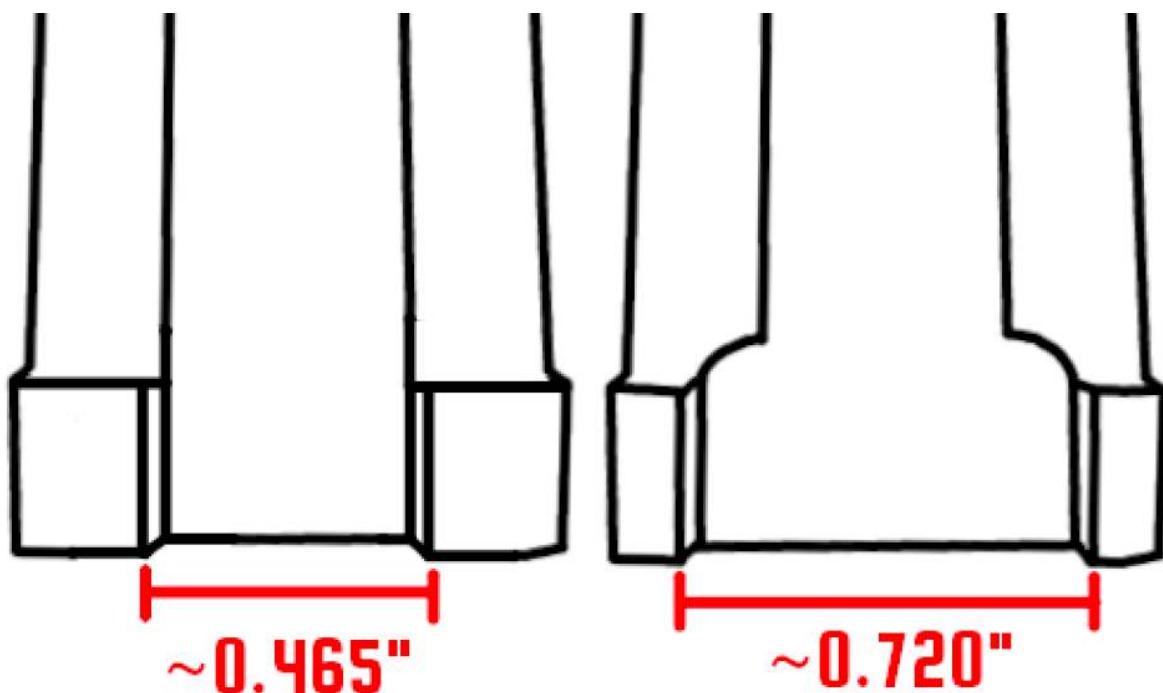


TSW Style Magwell - Instructional Guide

Milling Operations

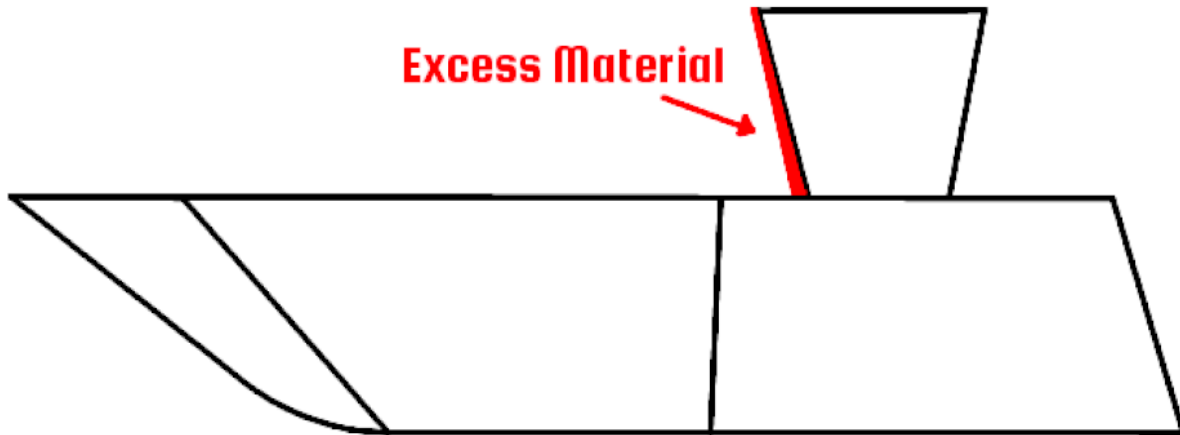
Just like the original TSW magwells, the ears on the rear of the pistol frame will have to be modified. Make sure you take note of the evenness of the ears relative to the opening for the magazine at the bottom of the pistol. Due to the nature of the production of these frames, the ears are sometimes off center and careful planning is needed to ensure an installation that lands the magwell in the correct location.



These ears start at a width of 0.465" and will have to be widened by about 0.125" per side, for a total of roughly 0.720". This cut will also have to be in plane with the rear strap of the frame. These magwells ship a little oversize in the event that the milling is not entirely precise and often they have as much as 0.010" per side to accommodate this error. The overall height of the milled area up the rear of the frame is not important, though it should be high enough to clear the tabs on the top of the magwell. After milling the frame slightly undersize of the magwell, file the sides of the magwell in order to fit it into the frame. It should lightly tap into the frame with a wooden block or a soft hammer. If you are doing this install on

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an aluminum frame, be aware that the aluminum alloy used for these frames is VERY BRITTLE and because of this, the magwell should be a free sliding fit rather than needing to be tapped into position.



What you'll notice is the magwell is not fully seated forwards. This is due to additional material left at the front of the magwell to allow for fitting to out of spec frames. The material left is about 0.030" and it is best removed from the face of the part using a 30 degree included angle cutter. Below is the cutter I used for this operation. This material can also be removed with the careful use of a safe sided file and an angle block. Due to manufacturing constraints and the need to leave excess material here, the existing angle on the magwell is not 30 degrees.

https://www.maritool.com/p19699/Solid-Carbide-Dovetail-Cutter-.250-dia-X-30-degree-included/product_info.html

After removing the material from the angled faces, and installing the magwell, clamp it in place and drill through the existing holes on the frame ears. Ensure that you drill each side straight and independent of each other. These holes should be drilled on-size of the existing hole. From here you need only pin the grip, magwell, and frame together. Once pinned together, you can use files and rotary tools to blend the magwell and frame together. A high polish will ensure the best user experience.