



Ream the .500 hole.
 2" slot is milled thru entire block.
 There is a coil spring that fits into the .500 hole
 to provide tension on the plunger assembly.

The .201 hole is threaded 1/4-20 full length of the available tap.
 My Tap has about .700 length of full diameter threads.

My Spring is 1.00 inch long and compresses to .5" so
 I need about .5" of movement for full adjustment.

EM Grinding Fixture	
Block	
11/25/2024	JR