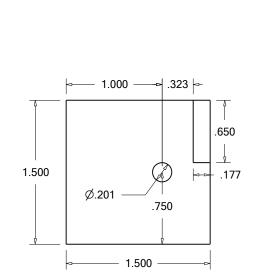
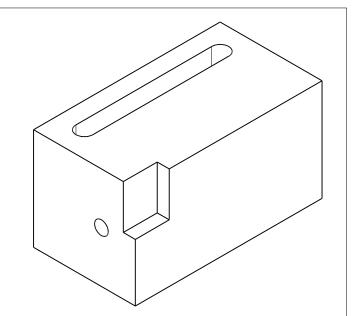
--- .375 ---⊲ .500 ∽ ⊲ .500 ∽ А .500 -.375 1.438 2.750 2.000 .700 4 .612 .500 4 |---- .650 ----|201|---- .650 ----| Section A-A -→ .375 ~-





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 inche long and compresses to .5" so I need about .5" of movement for full adjustment.

	EM Grinding Fixture	
	Block	
	11/25/2024	JR