



THE DIY MAC 11 PROJECT

Bom:

- Hacksaw or equivalent
- Dremel or Router
- Router plate or Multi-Purpose Cutting tool for Dremel
- Carbide cutting blade(router)
- Dremel Cutting Blade (<https://www.amazon.com/gp/product/B0004TIJJW/>)
- Router Cutting Blade (https://www.amazon.com/gp/product/B0112TD8JM/ref=ppx_yo_dt_b_search_asin_title?ie=UTF8&psc=1)

Or https://www.amazon.com/Foos-Straight-Carbide-Router-bits/dp/B07QLGWS5P/ref=sr_1_9 and **also**

<https://www.amazon.com/gp/product/B00004UDJL/>

- Drill + 1/4" bit
- Shop Vac
- Mask(n95) or Respirator
- 1/4" pull pin
- Mac Bolt Barrel Trunnion (proof required)
- Glock 33rnd Mag spring (<https://www.midwayusa.com/product/1006113364?pid=513044>)
- SCS Plates
- Ar fcg

Hardware

You can either buy a premade kit from DB's website(<https://dbdesignworks.com/store/p/db9alloy>) or source it yourself.

- (4) m3x35mm button head bolts
- (4) m4x35mm button head bolts
- (1) m5x25mm socket head bolt
- (1) m5 square nut
- (2) m6 socket cap nuts
- (1) m6 x 25mm threaded rod
- (2) m4x25mm button head bolts
- (2) m4x30mm button head bolts
- (4) m4 lock nuts

- (1) sten mag release compression spring
- (1) dowel pin 4mmx22mm for Sten mag release

Currently you will need to buy 1 additional m4x35mm button head bolt
He will have that included on his site soon but for now count on sourcing it yourself.

Not included in DB's Hardware Kit

- Grade B7 Medium-Strength Steel Threaded Rod, 10-24 Thread Size, 1 Foot Long

mcmaster(<https://www.mcmaster.com/98957A893/>)

Check your local ace hardware

- Steel Binding Barrels and Screws
10-24 Thread Size, for 1/4"-3/8" Material Thickness

mcmaster(<https://www.mcmaster.com/98002A201/>)

This requires 2 for both female sides

<https://www.menards.com/main/hardware/fasteners-connectors/bolts/binding-posts-joint-connector-bolts/midwest-fastener-reg-zinc-slotted-button-head-binding-post-1-count/81100/p-1541140100719-c-19382.htm?exp=false>

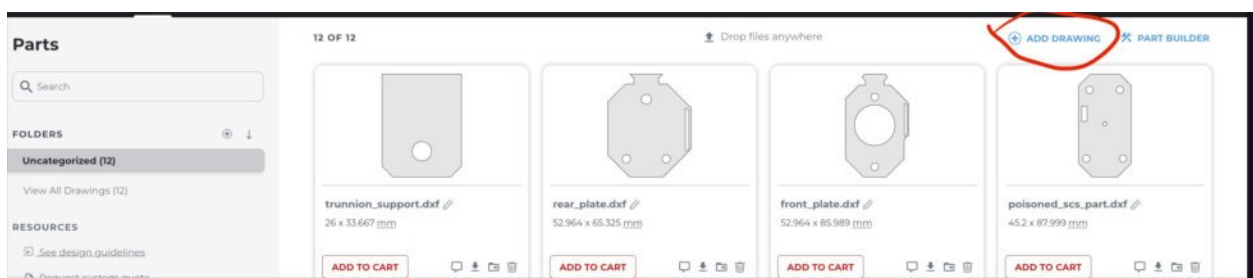
If Building Rifle Length Mac you will need :

- (2)m4x35 socket head bolts
- (3)m4 nuts
- (1)m4 x 20mm

Ordering Plates From SCS

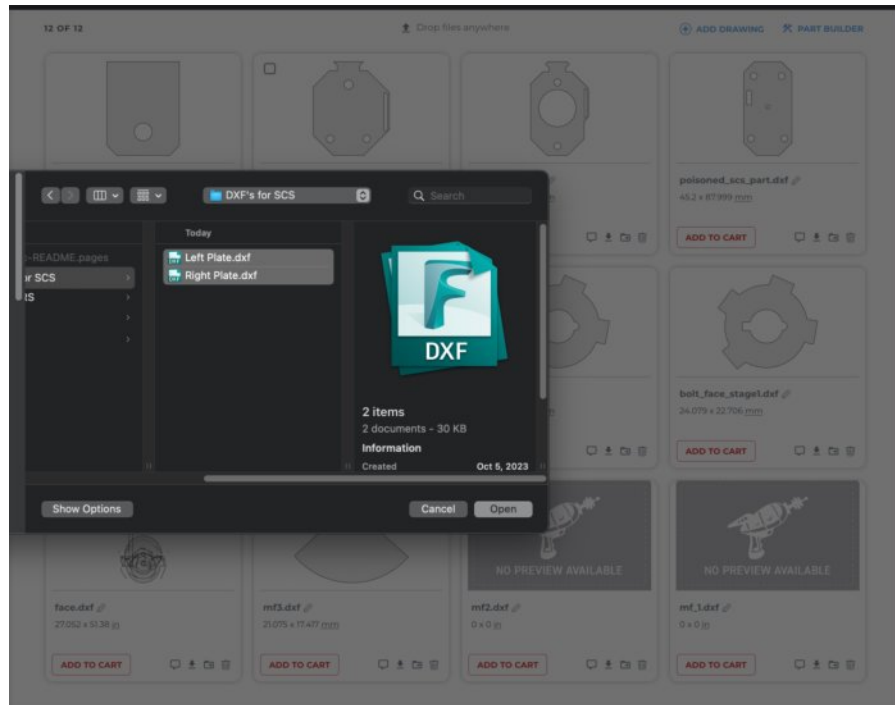
Go to <https://sendcutsend.com/>

Make and account if you dont already have one

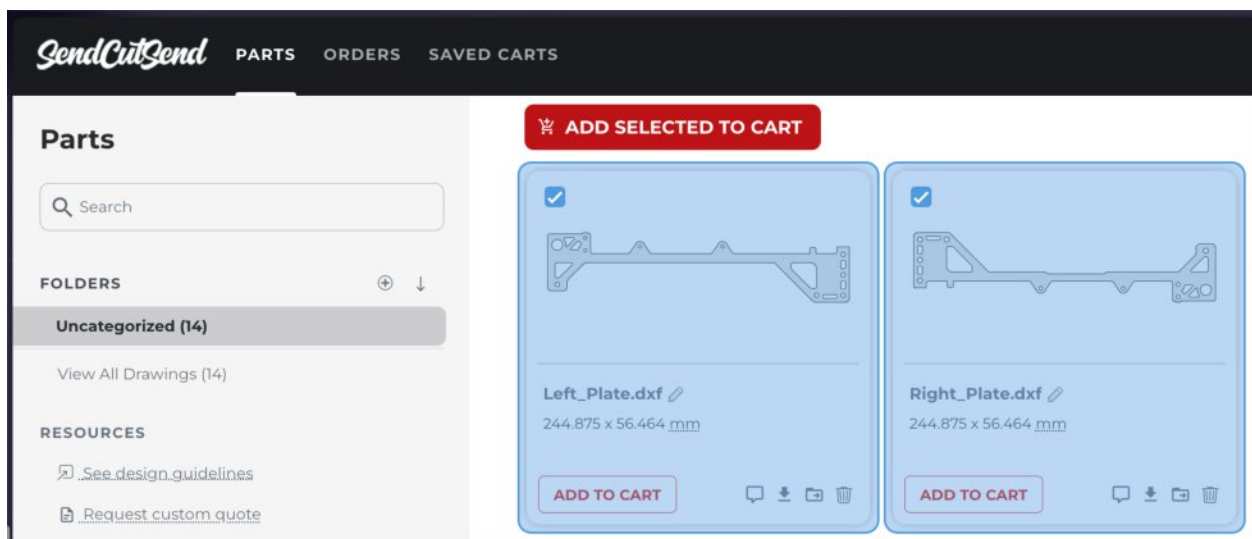


Then click add Drawing in the top right corner (see above example)

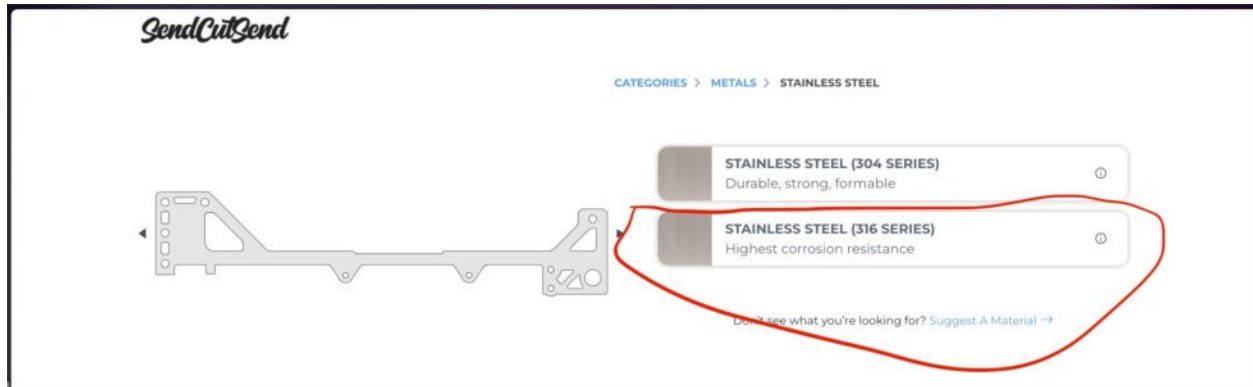
Select both the plates, and upload them



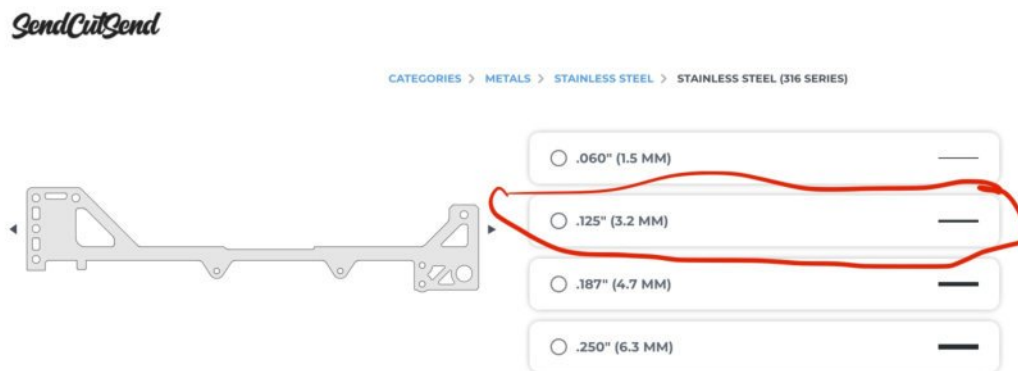
Once the upload is finished select them both then click add to cart



Go to cart, once there select 316 stainless



Then select 0.125"



On the left plate only, Select Additional Services

For the first selection choose m3 for the second choose m4, nothing for the 3rd option

Click next, you can have them powder coated(sis does a good job they come out nice) or opt to have the raw finish.



3D 2D

Choose below or click a feature on your drawing to add services

9 Taps
One feature per hole

DIAMETER	FEATURE
> 2.600mm	M3 X 0.5
> 3.600mm	M4 X 0.7
> 8.800mm	Select

RESET ALL DONE

Qty 1

\$43.99 /ea

VIEW DETAILS -

2 = \$30.72/ea
10 = \$24.28/ea
100 = \$19.22/ea
1000 = \$16.93/ea
10000 = \$14.74/ea

Subtotal:
\$43.99

ALIEXPRESS LINK

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1Pcs High Strength Length 500mm
OD8mm10mm15mm18mm20mm22mm25mm30mm Twill
Matte Surface 3K Carbon Fiber Rectangular Square Tube

★★★★★ 5.0 7 Reviews | 33 Sold

\$19.00

🟡 Extra 2% off

Color: 28X28X26MM

8X8X6MM

10X10X8MM

12X12X10MM

12X12X8MM

15X15X13MM

15X15X10MM

18X18X16MM

18X18X13MM

20X20X18MM

20X20X16MM

22X22X20MM

22X22X18MM

24X24X22MM

24X24X20MM

24X24X18MM

25X25X23MM

25X25X22MM

25X25X20MM

26X26X24MM

26X26X22MM

28X28X26MM

28X28X24MM

30X30X28MM

30X30X27MM

30X30X26MM

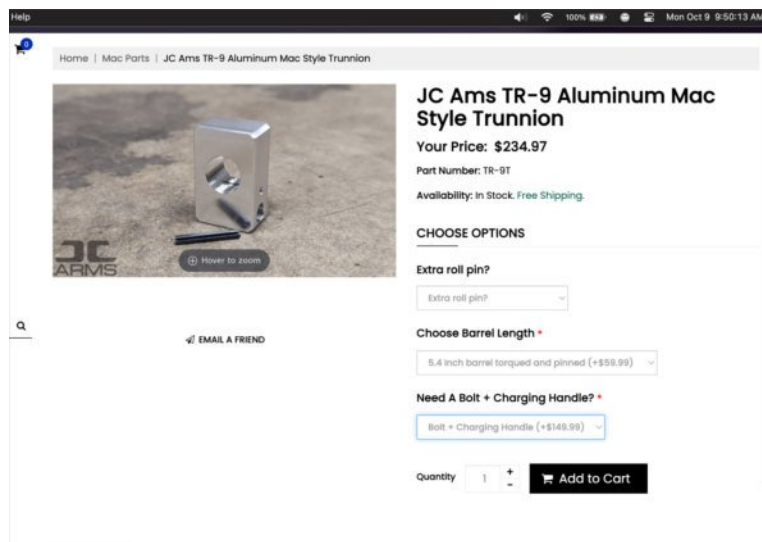
Related items

<https://www.aliexpress.us/item/3256803497898996.html>

Make sure your selecting the 28x28x26 square tube.

For pre drill trunnion use JC-Arms

<https://jc-arms.com/jc-ams-tr-9-mac-style-trunnion.html>



The screenshot shows a product page for the JC Arms TR-9 Aluminum Mac Style Trunnion. The page includes a product image with a 'Hover to zoom' button, a search icon, and an 'EMAIL A FRIEND' button. The product details are as follows:

- Product Name:** JC Arms TR-9 Aluminum Mac Style Trunnion
- Your Price:** \$234.97
- Part Number:** TR-9T
- Availability:** In Stock. Free Shipping.

CHOOSE OPTIONS

- Extra roll pin?** (Dropdown menu)
- Choose Barrel Length *** (Dropdown menu): 5.4 inch barrel torqued and pinned (+\$59.99)
- Need A Bolt + Charging Handle? *** (Dropdown menu): Bolt + Charging Handle (+\$149.99)

Quantity: 1 (with +/- buttons) **Add to Cart**

Cutting guide

A N95 mask or Respirator is required any time you are drilling routing or cutting the cf tube!



To start, after you've printed the jig for the tube and removed the support material, make sure the jig is lined up with the end of the cf tube.(in this photo the hole, support material is still present, that should also be removed)



This is showing getting ready to drill the 1/4" through the jig and the CF tube. A drill press is preferred to help keep everything stable, but a cordless drill with a steady hand works too(when using a hand drill it is usually better to drill from each side, rather than a single plunge down all the way through)



You can use any pin, bolt, or rod that you want that is 1/4" to insert through the jig and the cf tube to hold the position



After the pin is in place, drill (1) 1/4" hole anywhere in the area to be cut out. This will be used as the starter hole for the router.



Cut the other end of the CF tube flush to the end of the jig. A hacksaw works just fine.



When finished the tube should be cut flush like the example above.



Router base attached and carbon fiber bit installed. This bit is expensive, but cuts like butter. https://www.amazon.com/gp/product/B0112TD8JM/ref=ppx_yo_dt_b_search_asin_title?ie=UTF8&psc=1
As an alternate bit you can use this syle. It will get dull fast cutting CF. https://www.amazon.com/Foos-Straight-Carbide-Router-bits/dp/B07QLGWS5P/ref=sr_1_9



Insert your router bit into one of the start holes. Hold onto the router and turn it on. Slowly move the router to one side until the collar stops on the groove in the jig. Then follow the jigs shape with the router. Take your time and have a good grip on the router. Make multiple passes to make sure you have cut the shape exactly. Clamping the jig in a vice is highly recommended!! Wear a mask!!!



This is the front after routing. It needs the rounded corners squared up. Use a file or sandpaper to get it cleaned up. Wear a mask!!



This is how the end should look once squared up by hand.

