

# AR15/M16 Magwell Broaching Kit

## SETUP & PROCESSING INSTRUCTIONS

### *THE FUTURE OF BROACHING*

#### **Setup Recommendation:**

- Ensure your part fixturing is rigid and secure
- Use your standard water-soluble coolant at 8-12% dilution rate

#### **Tool Holder/Machine Requirements:**

- Standard side-lock holders are sufficient in most applications
- The machine has a mechanical spindle brake
- Use a Benz LinS Axial Broaching Head or equal product may be required if the machine does not have a mechanical spindle brake

#### **Programming tips:**

- Rough the pocket as close to the net shape as possible
- See cutting data below for milling recommendations

The **duMONT CNC AR15/M16 Magwell Kit** comes with 3 holders, 2 of each type of 3 inserts, 2 drivers, and an alignment tool in a durable case. This kit allows all broaching of a magwell to be done within the CNC cycle. The need for a secondary broaching process in a special purpose broaching machine is eliminated!



**Insert 1**  
Profile Insert

**Insert 2**  
Long Straight Insert

**Insert 3**  
Mag Catch Insert



**Save time: Approximate  
1 minute 30 sec. total  
broaching cycle time**

### CUTTING DATA

300-500 IPM with  
.0035 stepover

ROUGHMILL  
(with a  $\phi 3/8$ " endmill)  
then 51 passes

OR

ROUGHMILL  
(with a  $\phi 1/2$ " endmill)  
then 69 passes

3 passes at final depth

Estimated Tool Life,  
2,600 pieces TiN coated  
EDP 99911 for AR10  
EDP 99916 for AR15  
Can be Resharpended  
2-3 times

300-500 IPM with  
.0035 stepover

ROUGHMILL  
(with a  $\phi 3/8$ " endmill)  
then 45 passes

OR

ROUGHMILL  
(with a  $\phi 1/2$ " endmill)  
then 63 passes

3 passes at final depth

Estimated Tool Life,  
2,600 pieces TiN coated  
EDP 99912 for AR10  
EDP 99917 for AR15  
Can be Resharpended  
2-3 times

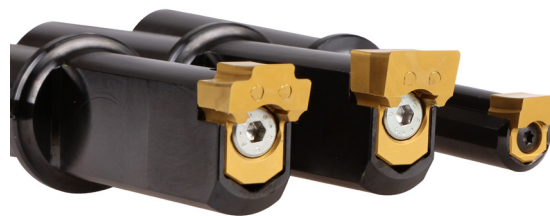
300-400 IPM with  
.0025-.0055 stepover

ROUGHMILL  
(with a  $\phi 3/8$ " or  $\phi 1/2$ " endmill)  
then 15 passes

3 passes at final depth

Estimated Tool Life,  
4,000 pieces TiN coated  
EDP 99918 for AR10 & AR15  
Can be Resharpended  
2-3 times

1-1/4" Shank Diameter Holders



A standard CNC broaching tool can be added if you would like to make the magazine reliefs square corners.

## AR15/M16 and AR10 FIREARMS KIT

### ELIMINATE THE NEED FOR A SECONDARY BROACHING OPERATION

- All broaching done in one step
- No operator required
- These kits are a quarter of the total tool life cost of a traditional magwell broach.

**99910 AR10 Magwell Kit**

**99915 AR15 Magwell Kit**

Kit Components	
EDP No.	Description
99553	M6 Screw for Holder 99922
99554	M8 Screw for Holder 99921
99910	AR10 Mag Well Kit
99911	AR10 INSERT 1 (PROFILE)
99912	AR10 INSERT 2
99915	AR15 MAGWELL KIT
99916	AR15 INSERT 1 (PROFILE)
99917	AR15 INSERT 2 (STRAIGHT)
99918	AR15 & AR10 INSERT 3 (MAG CATCH)
99921	AR15 & AR10 HOLDER 1 (TAKES INSERT 1 & 2)
99922	AR15 & AR10 HOLDER 2 (MAG CATCH)



**KIT 99915**

**Broaching an Opportunity for Loyal Customers to Save**

Any kit order includes a **\$100 Gift**

towards resharpening your broaching inserts.

Valid for 12 months from date of order.

