

5 Round Flush Mount Magpul Mod How-To

By NoExpert

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Tools needed: phillips screw driver, 1/8" and 3/32" or 7/64" TiN coated or Cobalt drill bits, drill press or hand drill, counter sink bit (3/8" bit will work), large cutters/dikes, utility knife, needle file set, flat file, pointed punch and hammer (if you don't have the type you just press down and it snaps), sharpie.

Parts/supplies needed: USGI M14 mag floor plate, Magpul ranger plate for USGI mags, masking tape, #4 X 1/2" stainless steel flat head phillips screws, enamel paint, JB Weld (or some sort of epoxy based adhesive), toothpicks.



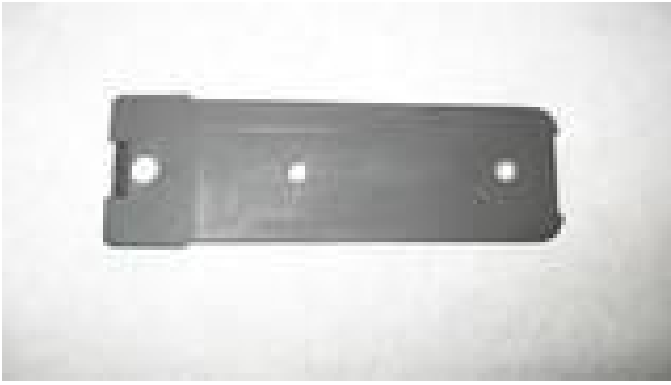
Using the tip of your utility knife (with a new blade I hope) lightly stab into the mount surface of the ranger plate to find out where the stainless steel backing plate is under the rubber and mark where you plan to drill.



Transfer those marks to the bottom of the M14 floor plate (I used a small drop of enamel paint). After this use your punch to mark where the holes will go (the floor plates are hardened making the bit want to walk so this is important).



Now drill your 1/8" holes into the floor plate.



Next align the Magpul on the floor plate to see if the marks still line up. If so, great, if not, no big deal, just remark it. Grab your utility knife now and cut the rubber on the Magpul around your mark and remove it to expose the steel plate. Match up the floor plate and Magpul again and lightly punch the exposed plate. Get your 3/32" or 7/64" drill bit and drill through the plate (be careful, not too deep). Start with 3/32" and try a screw in it, if it damages the screw too much go to 7/64". Discard the test screws.



Check alignment again and load up your countersink or 3/8" bit. If the alignment is off you can steer the countersink/drill bit around to center the hole. Just be patient and go slow. Be sure to countersink the TOP of the floor plate (little tab at the rear should be up when countersinking). Take just a little off at a time checking the screw heads to make sure they don't go through the holes. Stop when the heads are flush or close to it.



Grab two new screws and cut about 1/3 to 1/2 of the screw portion off. This is to prevent over penetration in the Magpul.

Make up a small batch of JB Weld. Using a toothpick get the JB Weld into the holes on the Magpul and on the rubber surface that will contact the floor plate. Push the two together and install the two cut down screws.



Put a strip of masking tape over the back of the plate that covers the whole plate. Using your flat file lightly file the screw heads (tape will come off the heads within a couple strokes) till your filing the tape around the screws off evenly (I had to retape several times due to tears).

Put some enamel paint on the screws and holes to seal up any exposed steel. (I used VW tornado red touch up paint since it's what I had close by).



Now at this point you can call it done, completely up to you. Personally I wanted a little cleaner look so I continued. This part was a pain so I was happy to just get it done and forgot about pictures, I was also covered in JB Weld and didn't want my camera permanently bonded to me...

Put masking tape up tight to the back of the Magpul, put it inline with the exposed steel plate of the Magpul on the sides and about 1/16" under the Magpul on the front. Fold the tape back to itself and the floor plate to make it more stable and so you aren't fighting the tape as much.

Make up some more JB Weld and let it sit a little bit to thicken up (you can rush in but boy is it messy). Now using a toothpick start working the JB weld

into the undercut portions of the Magpul (do NOT do the back end/large hole yet. Once you get a good bead of JB Weld in the undercut on the front and sides wrap masking tape around it (in a U shape with one edge against the floor plate and each side extending to the end with the hole) to hold it in and fairly flush with the sides. Now fill in the hole in the back of the Magpul and stand the assembly up so the JB Weld settles evenly in the hole and doesn't pour out. Having some above the hole won't hurt and is actually better.

Go relax a bit, watch some TV, drink a beer, have a smoke, come on here and complain about my instructions, whatever you do to relax a bit.

Now check on the drying process, touch the JB Weld in the hole, if it sticks to you, too soon, go do something else. If it doesn't stick but you leave a light fingerprint you can carefully remove the tape, very careful, you can rip out the JB Weld if you go too fast, be sure to watch it as you go. If it takes effort to leave a fingerprint or can only leave a nail print you're right on time. Get the tape off (will be really stuck to the JB Weld). Using your utility knife cut the JB Weld at an angle from the lowest point of the rubber to the floor plate (about where the end of your masking tape is) along the two sides and front taking out a small wedge shape of JB weld. Use the masking tape you put on the floor plate earlier to help remove the wedge. Only remove the front and side masking tape.

Now grab your flat needle file and mask off one side of it. Usually they have one smooth edge and one filing edge, with the smooth edge out and masking tape side against the floor plate file the JB Weld till you just see the steel plate in the Magpul on the sides and about 1/16" on the front. On the back file it smooth and flush with the Magpul. The Magpul rubber is pretty resilient so don't worry too much about hitting it with the file.





When done remove the masking tape from the rear and test fit it in your magazine. The channels you filed should just fit the lips on the magazine body.





Let it dry and you're done.

