

80% MILLING JIG for the AR-15

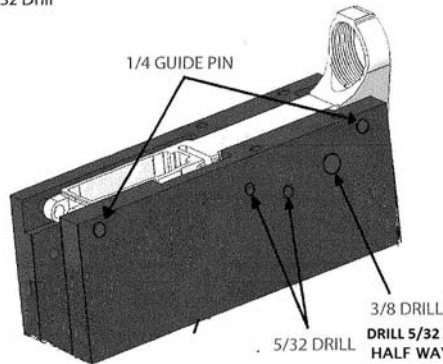
Disclaimer: Enclosed jig and instructions are intended for use on 80% receivers and has been tested on most popular forged, and billet 80% receivers currently on the market. Jig is intended for use to finish 80% receivers only and is in no way designed to finish receivers any less than 80%. It is the end user's responsibility to determine if finishing an 80% receiver is permitted by law in their state and, or municipality. This instruction sheet is offered for educational purposes only. The author assumes no liability whatsoever for any legal obligations, or misuse of this information. These instructions are intended for use by someone whom has knowledge of machinery and machine tooling necessary to complete an 80% receiver. The author assumes no liability for misuse, or damage; bodily, machinery, receiver, or otherwise. Purchase of this product and its instructions is acceptance of these terms. Please be safe in completing your project. Always use eye protection, and keep first aid supplies nearby if needed. Take your time. Measure twice and cut once. Safety and patience will help you to produce a quality, and long lasting product.

Tools needed:
 Safety glasses
 Dial calipers
 1/2 End mill
 3/8 End mill
 5/16 End mill
 5/16 Long End mill
 5/8 Drill
 3/8 Drill

When drilling use the peck drills method. To use the peck drill method use light pressure on the drill bit and drill a small amount. About .100 to .200 is preferred and back the drill out of the hole half way or more to clear any drilling chips. Repeat process until drill bit has fully drilled though receiver body.

Note:: All Drill and mill depths are from the top of the receiver (Not the jig).

5/32 Drill



FIRST OPERATION:

Put the side plates on the receiver by aligning the take down pin holes with the pressed in steel guide pins. Drill the trigger, hammer pin holes using the 5/32" drill bit all the way thru the receiver and drill the selector hole using the 3/8" drill bit all the way thru the receiver.

NOTE: TO INSURE ACCURACY OF PLACEMENT OF HOLES DRILL HALF WAY THRU RECEIVER FROM ONE SIDE, FLIP THE JIG OVER AND DRILL THE REST OF THE WAY THRU THE OTHER SIDE.

3/8 DRILL
 DRILL 5/32 AND 3/8 HOLES FROM HALF WAY FROM EACH SIDE
 3/8 DRILL IN 2 PLACES TO .630 DEPTH

SECOND OPERATION:

Put the side plates on the receiver by aligning the take down pin holes with the pressed in steel guide pins. Prior to doing any drilling due to variances in widths of forgings you should attach the first plate with the 4 screws provided and mark with a pencil then remove and measure to make sure that the holes will be center from side to side. If not centered you may have to shim the side of receiver over, or in extreme cases you may have to oversize the holes in one side of the top plate where the 4 screws go thru. After checking alignment reattach the top plate with screws securely. If using a vise do not over tighten on sides of fixture..

Use the 5/8" drill bit in the first three large holes. Use caution when using a large drill bit. Peck drill to a depth of 1.25" from top of receiver. Use the 3/8" drill bit to drill the first small hole using the peck method to a depth of 1.25". Use the 3/8" drill bit to drill the last two small holes closest to the buffer tube to a depth of .630 from top of receiver using peck method.

