



Third Operation:

With the side plates still on place the first mill plate on top of the jig and secure with 4 screws provided. Again check for alignment from side to side before milling. If not centered from side to side follow steps mentioned in second operation for alignment. If using vise be sure not to over tighten. The jig was designed to use 5/8" drill bits in the second operation in the main trigger group pocket to help minimize the amount of milling.

Use the 1/2" end mill for the trigger/hammer portion of the pocket. Slowly plunge the end mill to half the total depth of the pocket. Mill around the contour of jig mill plate. Repeat at full depth. Do the same for the pocket portion you drilled with the 3/8" drill bit to 1.25" using the 3/8" end mill. Use the same process for the rear take down lug pocket, but only going to a finish depth of .630.

Fourth Operation:

Note: the trigger slot plate should be placed on the jig so that the slot is closer to the buffer tube area.

With the receiver still secured between the side plates place the trigger slot mill plate on top and secure with 2 of the screws provided. If using a vise do not over tighten. This operation is for the slot the trigger fits thru.

Using a 5/16" end mill. Center the end mill in the trigger slot hole in the top plate. Slowly plunge to a depth of 1.55" or until the end mill has drilled all the way thru lower shelf of receiver. Follow the contour of the trigger slot plate slowly to make the full length of cut needed for trigger pocket.

FOLLOW CONTOUR WITH 5/16 END MILL MILL TO 1.550 DEPTH

