

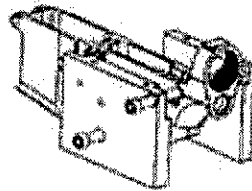


80% AR-15 Lower Jig
DRILL PRESS Instructions (Page 1)

PARTS INCLUDED: (Underlined Items are required for the drill press process)

<u>1x Left Plate</u>	<u>4x 10-32 x 1/2" bolts</u>
<u>1x Right Plate</u>	<u>1x 1/4-20 x 1 3/4" bolt</u>
<u>1x Milling Plate #1</u>	<u>1x 1/4-20 x 1 1/2" bolt</u>
<u>1x Milling Plate #2</u>	<u>1x Drill Press Plate</u>

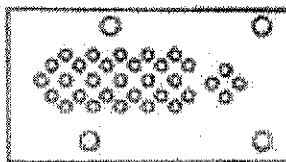
STEP 1: Assemble left and right side plates as shown using the 1/4-20x 1 3/4" bolt through the rear take down pin hole and the 1/4-20 x 1 1/2" bolt through the recessed hole.



STEP 2: Drill the safety selector hole using a 3/8" drill bit.

STEP 3: Drill the trigger pin and hammer pin hole with a 5/32" drill bit.

STEP 4: Bolt on drill press plate using the four 10-32 x 1/2" bolts. Drill each hole in the top plate with a 1/8" drill bit. Drill holes to a depth of 1.367" from the TOP of the drill plate.

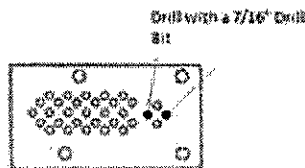


STEP 5: Remove drill press plate.

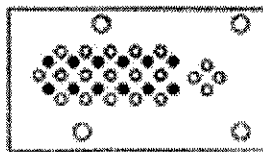


80% AR-15 Lower Jig
DRILL PRESS Instructions (Page 2)

STEP 6: Use a 7/16" drill bit and drill out the following TWO holes to a depth of 1.249" measured from the top of the receiver.



STEP 7: Drill out the following TWELVE holes with a 3/8" drill bit to a depth of 1.249" measured from the top of the receiver. **NOTE: DO NOT DRILL THROUGH DRILL PRESS PLATE!**



STEP 8: Bolt on milling plate 2 and use a 3/8" drill bit to drill out the trigger hole. Line up your drill bit with the left radius and drill through. Line up your drill bit with the right side and drill through. Place drill bit in the center remaining material and drill through.

STEP 9: Some filing/grinding may be needed after you drill the three holes to clean up the interior pockets. You can attach milling plate 1 and use it as a guide for your file.

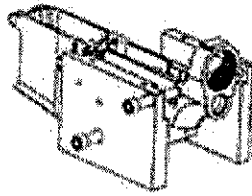


80% AR-15 Lower Jig
MILLING MACHINE Instructions (Page 1)

PARTS INCLUDED: (Underlined Items are required for the milling machine process)

<u>1x Left Plate</u>	<u>4x 10-32 x 1/2" bolts</u>
<u>1x Right Plate</u>	<u>1x 1/4-20 x 1 3/4" bolt</u>
<u>1x Milling Plate #1</u>	<u>1x 1/4-20 x 1 1/2" bolt</u>
<u>1x Milling Plate #2</u>	1x Drill Press Plate

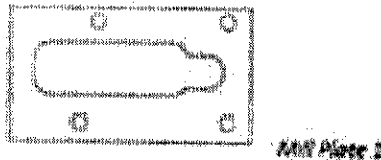
STEP 1: Assemble left and right side plates as shown using the 1/4-20x 1 3/4" bolt through the rear take down pin hole and the 1/4-20 x 1 1/2" bolt through the recessed hole.



STEP 2: Drill the safety selector hole using a 3/8" drill bit.

STEP 3: Drill the trigger pin and hammer pin hole with a 5/32" drill bit.

STEP 4: Bolt on milling plate #1 using the four 10-32 x 1/2" bolts.

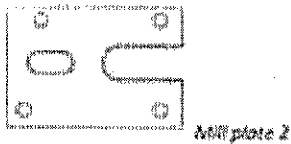


STEP 5: Mill out the trigger pocket following the milling plate #1 pocket guide. Mill to a depth of 1.367" measured from the top of the milling plate.



80% AR-15 Lower Jig
MILLING MACHINE Instructions (Page 2)

STEP 6: Remove milling plate # 1 and bolt on milling plate #2.



STEP 7: Mill the trigger hole completely through following the guide.

STEP 8: Machine the remaining material to a depth of .748" measured from the top of milling plate #2. Continue to machine past the top plate guide until you reach the pre-machined slot at the back of the lower. **NOTE:** We advise only removing 3/8" depth of material at a time.

