

## 80% MILLING JIG FOR THE AR-15

DISCLAIMER: These instructions are intended for use by someone who has knowledge of machining and machine tooling necessary to complete an 80% receiver. It is the end user's responsibility to determine if finishing an 80% receiver is permitted by law in their state and/or municipality. These instructions are offered for educational purposes. The author and jig manufacturer assumes no liability for misuse or damage; bodily, machinery, receiver or otherwise. The purchase of this product and its instructions are acceptance of these terms.

### Tools Needed:

Safety Glasses

Dial Caliper

1/2 End Mill

3/8 End Mill

5/16 End Mill

5/16 Long End Mill – (receivers with integrated trigger guards ONLY)

5/8 Drill

3/8 Drill

5/32 Drill

When drilling, use the peck drills method: to use the peck drill method, use light pressure on the drill bit to drill small amount. About .100 to .200 is preferred and back the drill out of the hole halfway or more to clear and drilling chips. Repeat the process until the drill bit has fully drilled through the receiver body.

The enclosed jig and instructions are intended for use with the 80% receivers and has been tested on most popular forged and billet 80% receivers. This jig is specifically intended for use to finish 80% receivers ONLY and is in no way designed to finish receivers any less than 80%

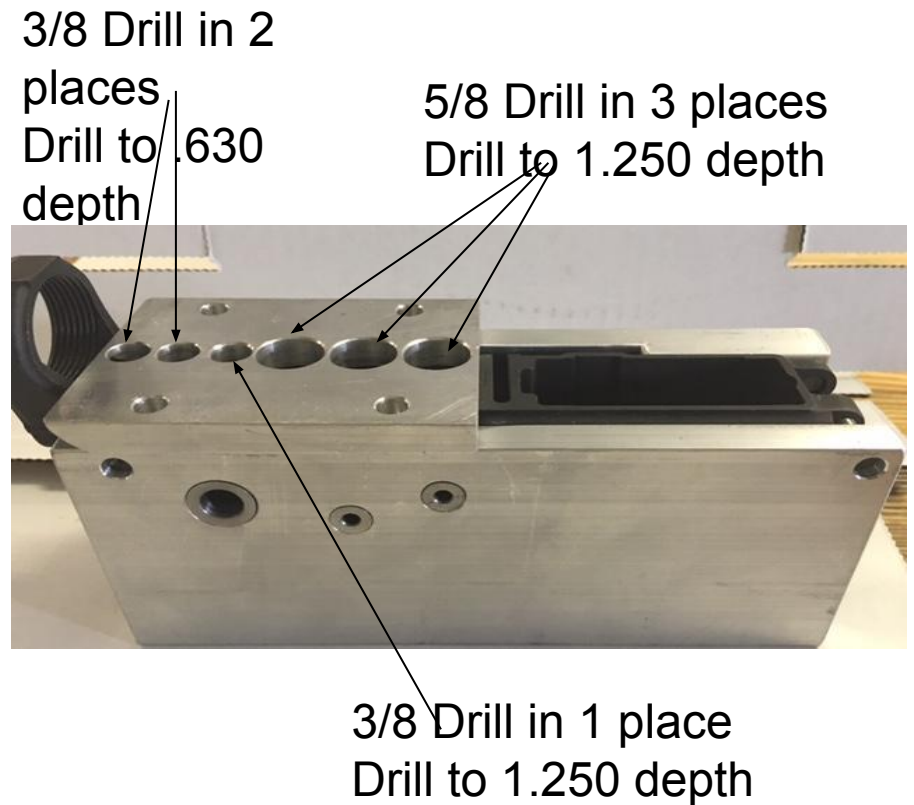
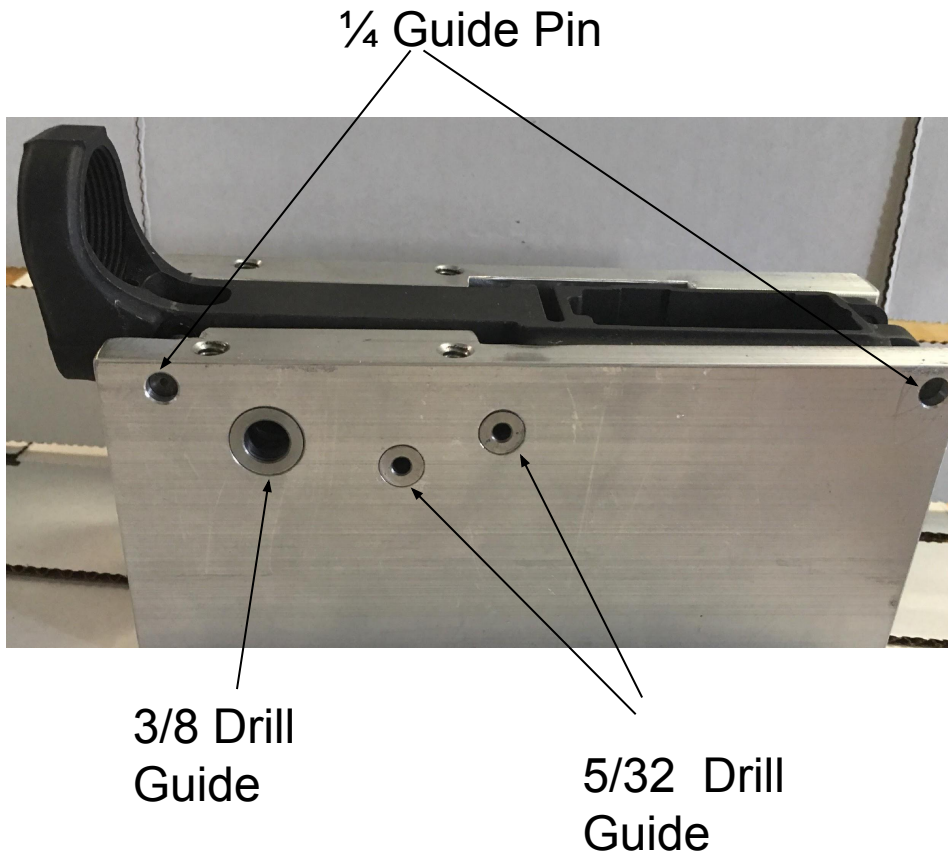
Please be safe in completing you project.

ALWAYS use eye protection and keep first aid supplies nearby if needed.

Take your time.

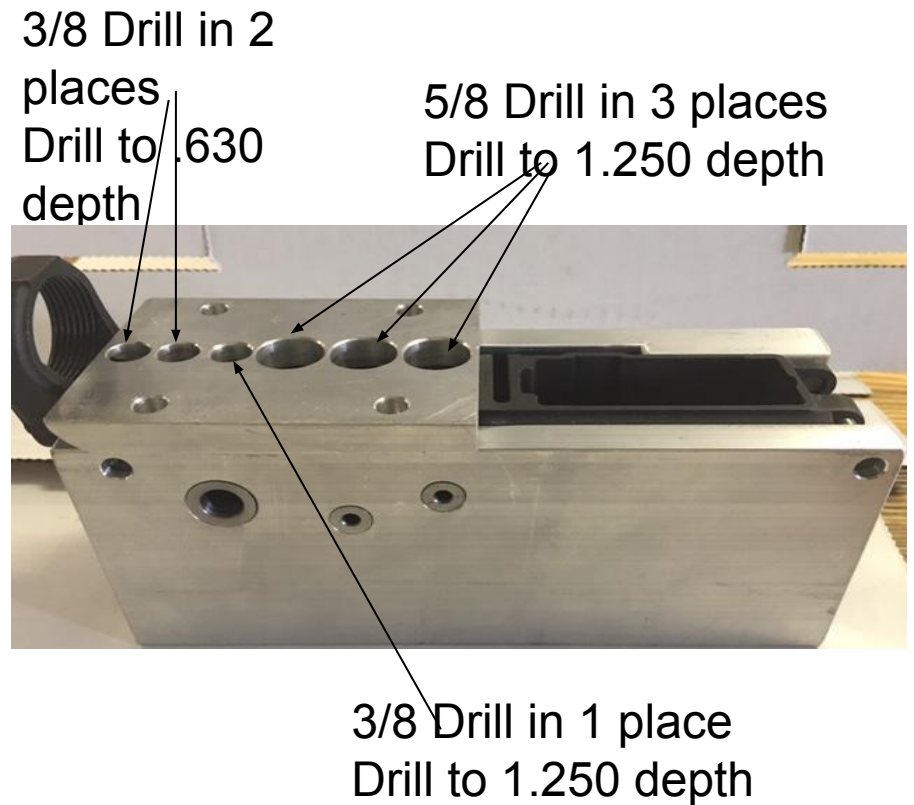
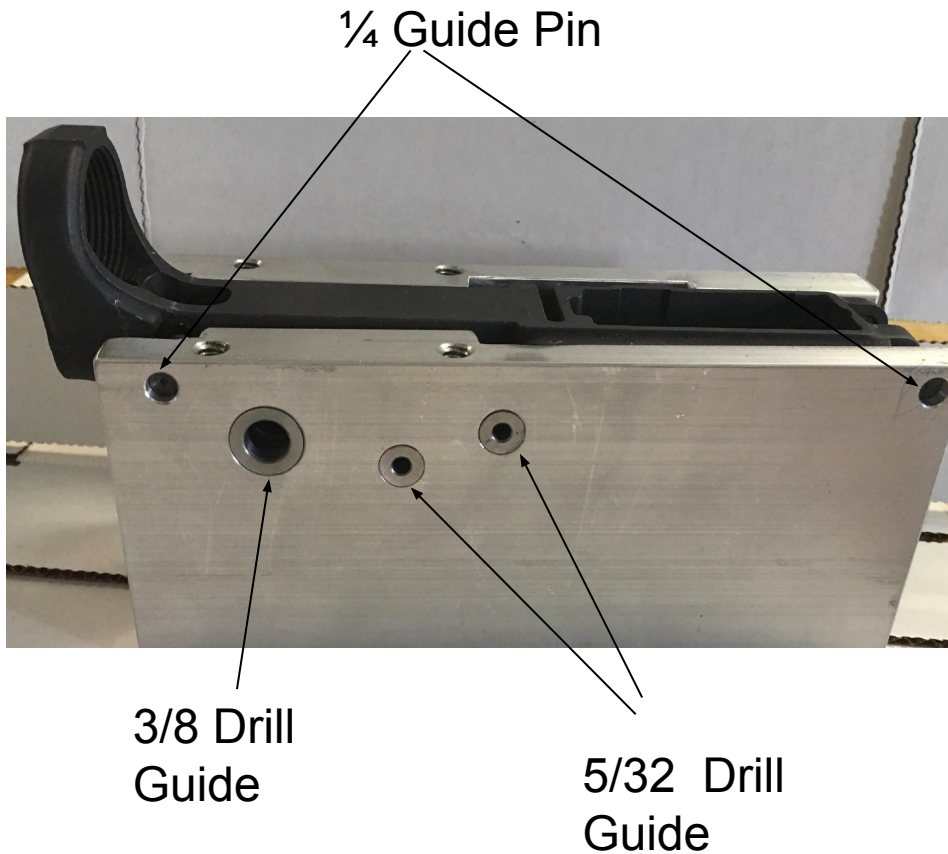
Measure twice and cut once.

Safety and patience will help you produce a quality product.



**First Operation:** Use the guide pins to align the receiver take down with guide holes in jig plate. Place the first drill plate on top of the jig and secure with 1/4-20 bolts provided. Drill the trigger, hammer pins, and the selector hole. Use the 5/32" drill and guide holes in the jig to peck drill the trigger and hammer pin holes. Peck drill the selector hole. Use the 3/8" drill and the guide hole in the jig to drill the selector hole.

**Second Operation:** Use the guide pins provided to align the receiver take down pin holes with the guide holes in jig plate. Place the first drill plate on top of the jig and secure with 1/4-20 bolts provided. The vise will secure the receiver in the jig. Be sure not to over clamp the vise. Use the 5/8" drill in the first three large holes. Use caution when using the large drill. Peck drill to a depth of 1.250. Use the 3/8" drill to drill the first small hole. Peck drill to a depth of 1.250. Use the 3/8" drill to drill the last two small holes closest to the buffer tube hole. Peck drill to a depth of .630.

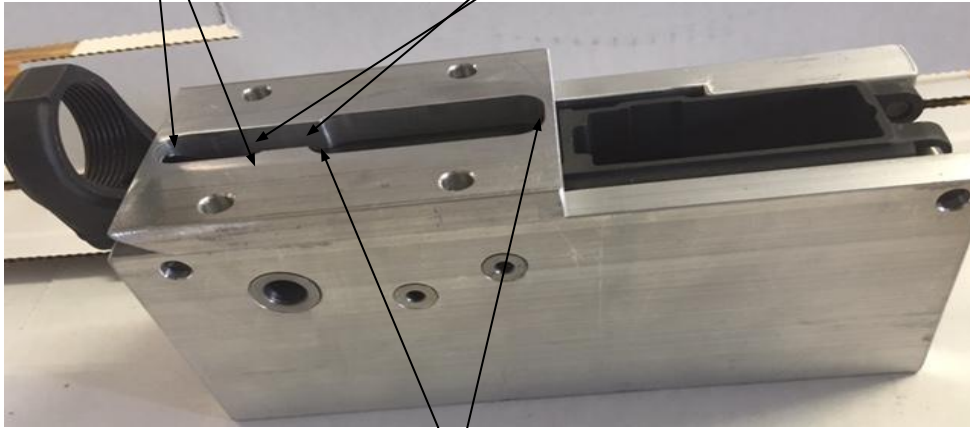


**First Operation:** Use the guide pins to align the receiver take down with guide holes in jig plate. Place the first drill plate on top of the jig and secure with 1/4-20 bolts provided. Drill the trigger, hammer pins, and the selector hole. Use the 5/32" drill and guide holes in the jig to peck drill the trigger and hammer pin holes. Peck drill the selector hole. Use the 3/8" drill and the guide hole in the jig to drill the selector hole.

**Second Operation:** Use the guide pins provided to align the receiver take down pin holes with the guide holes in jig plate. Place the first drill plate on top of the jig and secure with 1/4-20 bolts provided. The vise will secure the receiver in the jig. Be sure not to over clamp the vise. Use the 5/8" drill in the first three large holes. Use caution when using the large drill. Peck drill to a depth of 1.250. Use the 3/8" drill to drill the first small hole. Peck drill to a depth of 1.250. Use the 3/8" drill to drill the last two small holes closest to the buffer tube hole. Peck drill to a depth of .630.

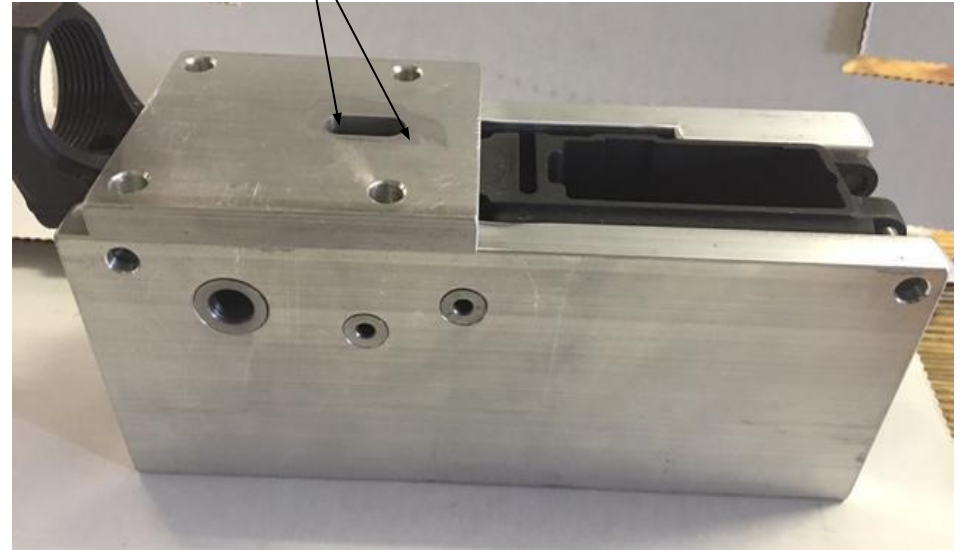
Follow contour in this area with 3/8 end mill to .630 depth.

Follow contours in this area with 3/8 end mill to 1.250 depth.



Follow contour in this area with 1/2 end mill to 1.250 depth.

Follow contours in this area with 5/16 end mill to 1.550 depth.



**Third Operation:** Use the guide pins provided to align the receiver take down pin holes with the guide holes in the jig plate. Place the first drill plate on top of the jig and secure with 1/4-20 bolts provided. The vise will secure the receiver in the jig.

Be sure not to over clamp the vise. The jig was designed to use 5/8" drills 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 the jig mill plate. Repeat to full depth. Do the same for the pocket portions that were drilled 3/8" drill using the 3/8" end mill. Use the same process for the rear take down lug pocket, but only going to a finished depth of .630

**Fourth Operation:** Use the guide pins provided to align the receiver take down pin holes with the guide holes in the jig plate. Place the first drill plate on top of the jig and secure with 1/4-20 bolts provided. The vise will secure the receiver in the jig. Be sure not to clamp the vise. This operation is for the slot the trigger fits through. Using a 5/16" end mill, center the end mill in the trigger slot in the jig and slowly plunge the depth stated in the picture or until the end mill has drilled through the lower shelf of the receiver. Slowly follow the contours of the jig.