

AMERICAN GUNSMITH TOOLING

AGT Revised Instructions For Daytona Tactical 80% DRILL PRESS JIG for the AR-15

THIS IS A DRILL PRESS JIG ONLY, THE TOP PLATE IS NOT DESIGNED FOR ROUTER USE

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.

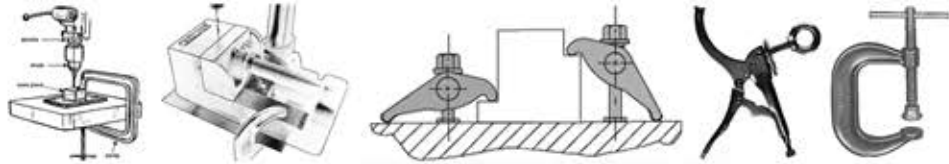
Measure twice and cut once. Safety and patience will help you to produce a quality, and long lasting product.

IMPORTANT DRILLING INFORMATION:

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. Drill about 1/16 to 3/16 into material and then back the drill out of the hole enough to clear any drilling chips in the flutes of the drill bit. Repeat process until hole is fully drilled to proper depth.

DRILL PRESS SAFETY:

Always hold jig in a vise or block in the jig with a stop block and c-clamp or scissors clamp, to prevent the drill from getting stuck in receiver and spinning the entire jig while you are trying to hold it in place. Securing jig and receiver will prevent injury.



AGT Revised Daytona Tactical 80% Lower Receiver Drill Press Jig Tool List

Minimum Requirements:

SAFETY GLASSES
WORK GLOVES

Drills & End Mills:

AGT 5/32 JOBBER DRILL
AGT 17/64 JOBBER DRILL
AGT 3/8 JOBBER DRILL
AGT 1/2 JOBBER DRILL
AGT 3/8 ENDMILL
AGT 1/4 ENDMILL

Additional:

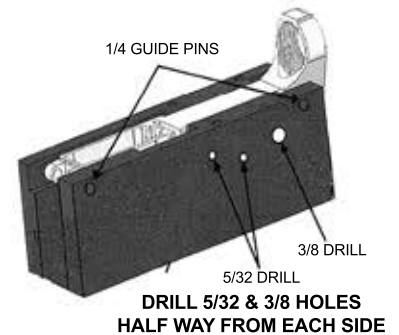
3/16 Allen Hex Wrench
Cutting Fluid (WD-40 Spray)
Caliper To Measure Depths

FIRST OPERATION:

Put the side plates on the receiver by aligning the 1/4 take down pin holes with the pressed in steel guide pins. Drill the trigger and hammer pin holes using the 5/32" drill bit, and drill the selector hole using the 3/8" drill bit.

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

When finished your 5/32 and 3/8 holes should be all the way through your 80% receiver.



SECOND OPERATION:

With the side plates still on the receiver aligned with the 1/4 take down pin holes and the pressed in steel guide pins, you must check for variances in widths of receiver forgings before you start drilling the trigger control pocket.

You should attempt to attach the Drilling Plate with the 4 screws provided. With a pencil trace the Drilling Plate circles on the receiver, then remove and measure to make sure the holes will be centered from side to side on the receiver. If not centered you may have to shim the side of receiver over slightly, or in extreme cases you may have to oversize the mounting holes on one side of the Drilling Plate where the 4 screws go through.

After alignment reattach the Drilling Plate with screws, securely. If using a vise do not over tighten on sides of fixture.

With the 1/2" drill bit, center the bit by eye in the middle of the 5/8 holes on the Drilling Plate.

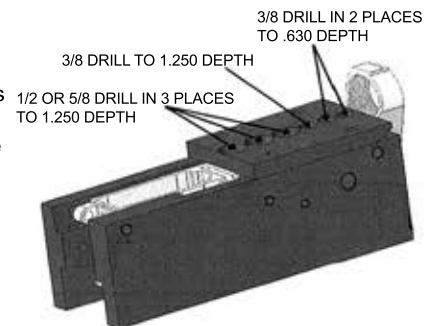
(You may use a 5/8 drill if you have one).

With bit centered, peck drill the first three large holes on the Drilling Plate to a depth of 1.25" from the top of receiver.

USE CAUTION WHEN USING A LARGE DRILL BITS. BLOCK IN, AND SECURE YOUR JIG TO AVOID INJURY.

Use a 3/8" drill bit to drill the first 3/8" hole (after the 5/8" holes), using the peck method to a depth of 1.25".

With the same 3/8" drill bit, drill the last two holes closest to the buffer tube to a depth of .630 from the top of receiver, using peck method.



PLEASE NOTE:

Instructions were created for American Gunsmith Tooling Only!
There is no guarantee of successful results with the use of tooling other than AmericanGunsmithTooling.com tooling.

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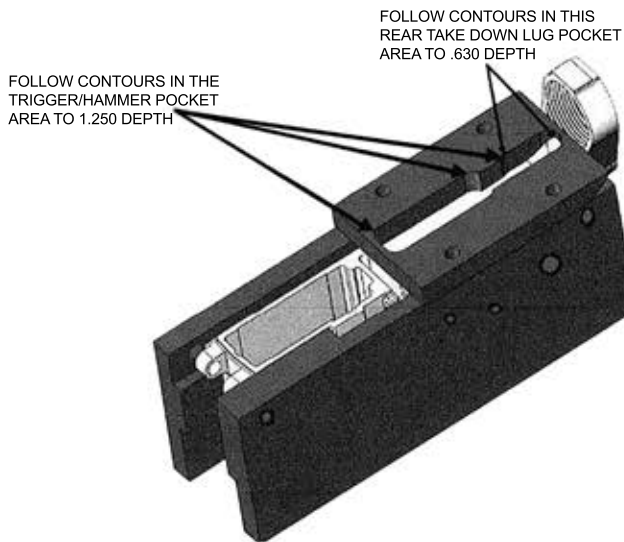
When drilling use the peck drills method. To use the peck drill method use light pressure on the drill bit and drill a small amount. Drill about 1/16 to 3/16 into material and then back the drill out of the hole enough to clear any drilling chips in the flutes of the drill bit. Repeat process until hole is fully drilled to proper depth.

DRILL PRESS SAFETY:

Always hold jig in a vise or block in the jig with a stop block and c-clamp or scissors clamp, to prevent the drill from getting stuck in receiver and spinning the entire jig while you are trying to hold it in place. Securing jig and receiver will prevent injury.

Third Operation:

With side plates still on, secure large mill plate on top of the jig with 4 screws. Again check for alignment from side to side before milling. If not centered side to side follow steps from second operation for alignment. If using vise be sure not to over tighten. Use the 3/8" end mill for the trigger/hammer portion of the pocket. Slowly plunge end mill to approximately 1/4" deep from the top of the receiver. Mill around contour of mill plate. (Do Not mill rear take down lug pocket yet) Slowly plunge the end mill approximately another 1/4" deeper. Mill around the contour of jig mill plate Repeat these steps until at full depth of 1.25"
Use the same process for the rear take down lug pocket, being careful to only mill to a finish depth of .630



Fourth Operation:

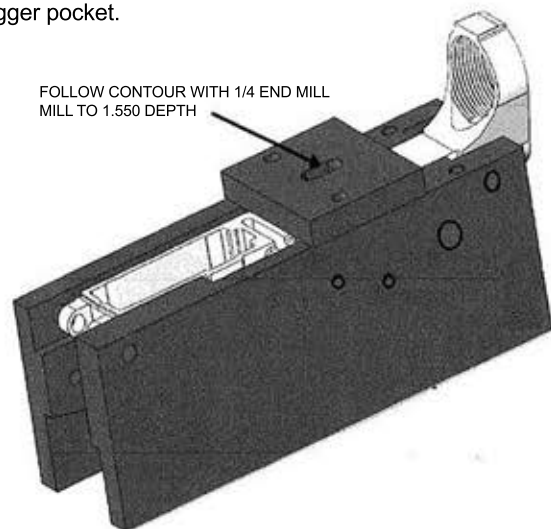
Note: The trigger slot plate should be placed on the jig so that the slot is closer to the buffer tube area. With the receiver still secured between the side plates place the trigger slot mill plate on top and secure with 2 of the screws. If using a vise do not over tighten. This operation is for the slot the trigger fits through. Using a 17/64" drill center the drill in the trigger slot hole in the top plate near the end of the slot. Slowly plunge to a depth of 1.55" or until the drill has drilled all the way thru lower shelf of receiver. Move drill over to the other end of the slot and repeat so that you have two holes in the lower shelf of the receiver. Using the 1/4" end mill. Center the end mill in the trigger slot hole in the top plate near the end, over the hole you just drilled. Slowly plunge end mill to a depth of 1.55" or until the end mill is 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.

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AGT 3/8 ENDMILL
AGT 1/4 ENDMILL

Additional:
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Cutting Fluid (WD-40 Spray)
Caliper To Measure Depths



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