

# MUP-1 Jig

By JSD Supply

# JSD SUPPLY

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### MUP-1 Jig Instructions

#### Included

2 Side Plates  
1 Top Plate  
7 Drill Bits  
4 Bolts

#### Recommended Tools

Dremel  
Vise  
Drill Press  
Files  
Hacksaw

## 1. Assembling the jig

- 1.1. Place the two side plates together and secure them with the provided bolts. Do not tighten all the way.
- 1.2. Place the 80% MUP-1 Receiver into the jig. Ensure the MUP-1 receiver bottoms out in the jig.
- 1.3. Tighten the bolts.

**DO NOT REMOVE THE MUP-1 FROM THE JIG UNTIL RAILS ARE BENT AND ALL HOLES ARE DRILLED**

## 2. Bending the slide Rails (approximate .860" from outside of rails)

- 2.1. Secure the jig in a vise with the rail tabs sticking up towards the ceiling.
- 2.2. With the MUP-1 receiver bottomed out in the jig, and the bolts tightened, place the contoured end of the top plate in between the first set of rails. Be sure that the 'top' of the top plate is now facing the ejector pin in the 80% MUP-1 receiver, so that you don't bend it as you start the rail bends.
- 2.3. Using a hammer, pound the top plate down to start the bending process of the slide rails.
- 2.4. Repeat step 2.3 for the second set of rails. **PLEASE NOTE!** This first step only starts the bend for each set of rails.
- 2.5. Loosen the bolts slightly, and with the MUP-1 receiver still in the jig, place the top plate down in to the MUP-1 receiver. Be careful to assure the top plate is aligned such that the ejector is not being contacted by the top plate.

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## Bending Rails – 3 Methods

1. Vise
2. Press
3. Hammer

### **USING A VISE:**

- 2.6. Tighten the bolts and place the jig on its side into a vise.
- 2.7. Squeeze the vise closed until the top plate fully bends the rails on to the side plates and bottoms out. Both front and rear rails need to bend to the side plates.

### **USING A PRESS:**

- 2.8. Tighten the bolts and securely place the jig on the platform of your press with the rails sticking up towards the ceiling
- 2.9. Press the top plate evenly over front and rear rails. Both front and rear rails need to bend to the side plates

### **USING A HAMMER:**

- 2.10. Secure the jig in a vise with the rails sticking up towards the ceiling
- 2.11. Carefully pound the top plate into the jig evenly front and rear. Both front and rear rails need to bend to the side plates

### **CUTTING RAILS:**

- 2.12. Secure the jig with the rails facing and top plate facing the ceiling.
- 2.13. Using the Top Plate as a cutting guide, remove the excess material on the slide rails using a hacksaw. (A Dremel or band saw or similar can be used)

**DO NOT REMOVE THE MUP-1 RECEIVER OR TOP PLATE FROM THE JIG**

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## 3. Drilling Holes

- 3.1. Keeping the top plate and MUP-1 receiver in the jig, place the fixture on its side and squeeze it in a vise so that the top plate is bottomed out and rails are again tight to the side plates
- 3.2. Drill all the corresponding holes. We recommend using a drill press. Use plenty of cutting oil.
- 3.3. Drill with even pressure.
- 3.4. Peck drill. Drill for a few seconds, then back off to clear the chips and to apply more oil. This keeps your bits cool. **YOU WILL DRILL INTO THE TOP PLATE.**
- 3.5. Drill one side, then the other side. **DO NOT DRILL FROM ONE SIDE THE WHOLE WAY THROUGH TO THE OTHER SIDE.**

**NOTE! The two closely-spaced #40 holes are intended to be a slot. Cut out the material between the two holes.**

## 4. Trigger and Safety Slot

- 4.1. While the MUP-1 receiver is in the jig (Opening where you used the 7/32" bit), use a Dremel with a cut off wheel to open the trigger slot. This opening needs to have enough material removed to allow the trigger to pass through that opening.

### **NOW YOU CAN TAKE THE MUP-1 OUT OF THE JIG**

- 4.2. On the opposite side of the trigger slot, you drilled 2 small holes (#40). Using a Dremel or a file, remove the material between those holes to make 1 opening. Using a shaping bit in a Dremel seems to work well. Take your time and remove material little by little.
- 4.3. Smooth the slot out. Any peaks or valleys or burrs will hinder operation of your safety bar and take down lever.

## 5. Final Steps

- 5.1. De-burr all holes.
- 5.2. Contour (if necessary) and de-burr the slide rails. On occasion, the Dremel method does not remove enough material to allow the MUP-1 to fit inside the slide. If this happens, remove material using a metal file or Dremel little by little on both left and right sides to ensure a proper fit. If you are using a Dremel, use it at the lowest speed and go slowly – you can always take more material off, but you can't easily add more on.

## 6. Assembly

- 6.1. Using the parts you've acquired, assemble your completed MUP-1 receiver. There are several videos online; at the time of this document's writing, this video will take you through the whole process:

<https://youtu.be/PuzUQcmH3Z0>

"Post Upgrade SIG P320 takedown and reassembly"

- 6.2. Using your Cal-X kit (or other grip and slide assembly), function-check your firearm to assure that the trigger function works, and resets as desired.
- 6.3. Take your new firearm to the range and enjoy!

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***Please observe all local, state, and federal laws!***