



## **AR-10/AR-15 Jig Instructions**

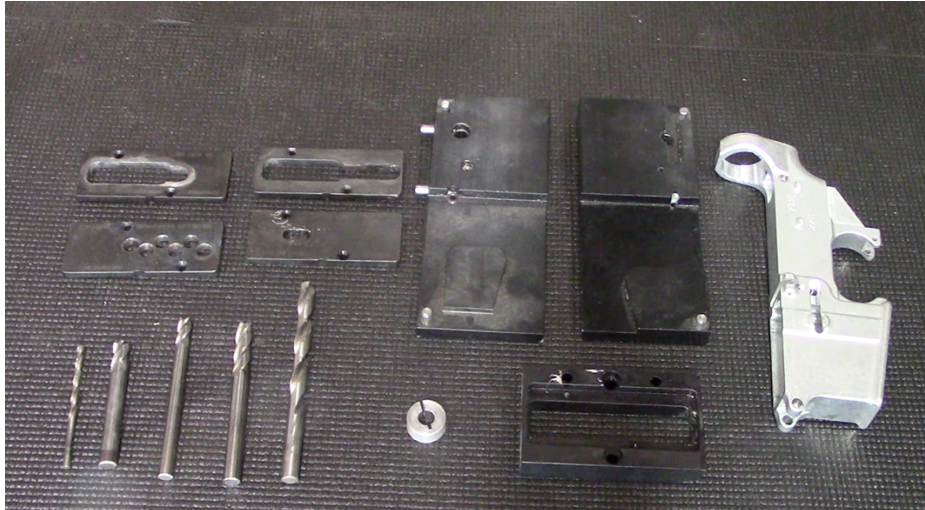
**\*\*\*\*WARNING\*\*\*\***

**Machining is risky. American Made Tactical is NOT responsible for any broken end mills, drills, or failure. There are NO returns or refunds on any machined parts.**

**Jigs do not come with tooling. To purchase, visit [AmericanMadeTactical.com](http://AmericanMadeTactical.com) and click on the Accessories Section**

## STEP 1

- A. Unpack everything and lay it out on a flat surface. Please note: USE THE INCLUDED DRILL STOP FOR MORE ACCURATE RESULTS.



- B. Place the left and right side plates on the lower.  
C. Place the next plate (center plate) attaching to the left and right plates with the set screws provided.  
D. Tighten down with the Allen wrench provided

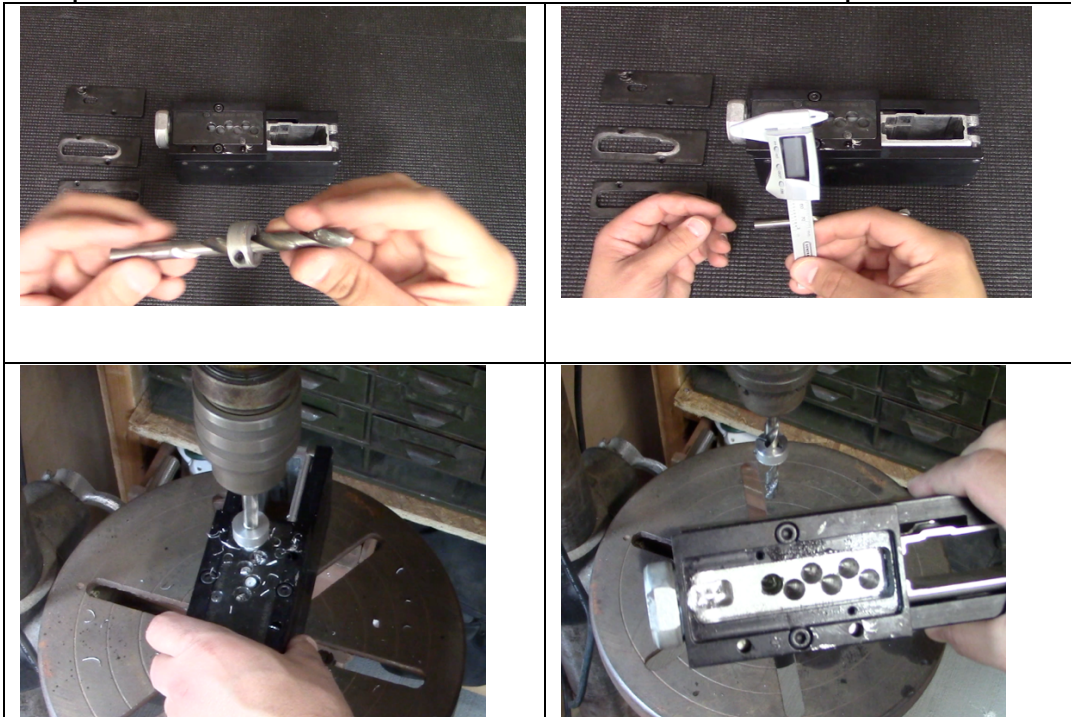


## STEP 2

Set 1st plate (honeycomb style plate) into nest plate. Tighten down with the allen wrench and set screws that were provided.



- E. Drill .375 dia. Drill 2 inches deep from face of plate. Note: the drill stop is on to ensure correct depth. We recommend a digital measurement tool for extra accuracy, like the one pictured below, but another measurement tool, like a tape measure, will work.
- F. Also note: due to build-up of chips you will more than likely need to remove the plates to vacuum or blow out excess aluminum chips.





## STEP 3

- A. Remove #1 plate, replace with #2 plate.
- B. Use 3/8 dia. end mill to mill out #2 plate - 1.375 deep from face of plate. Use drill stop for better accuracy.
- C. When milling around plate, shaft of end mill is able to hit side, make sure it is low enough so it is not cutting the plates as you mill. Also note, take it a small layer at a time, do not plunge down to 1.375 right away or it will take you a very long time. Take it a bit at a time, or however much your drill press, mill, or drill can handle. Keep lubricated with aluminum cutting fluid for smoother cutting.





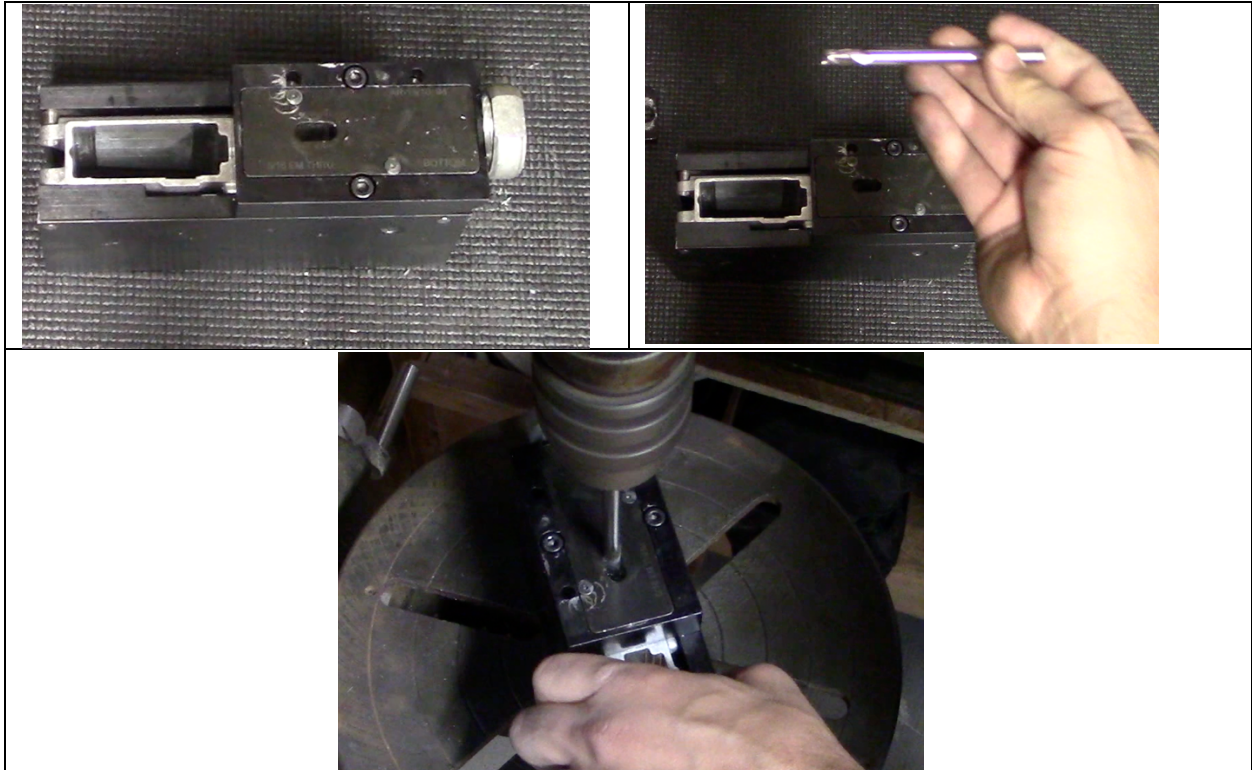
## STEP 4

- A. Remove #2 plate, replace with #3 plate.
- B. Use 3/8 dia. end mill to mill out #3 plate 2.00 deep from face of plate. This step will take the longest. Don't be afraid to take it in shifts! Again, take it a small layer at a time, do not plunge down to 2.00 right away or it will take you a very long time to mill, especially if you are just using a drill press. Take it a bit at a time, or however much your drill press, mill, or drill can handle. Keep lubricated with aluminum cutting fluid for smoother cutting.



## STEP 5

- A. Remove #3 plate, replace with #4 plate.
- B. Use 5/16 dia. end mill to mill out #4 plate through the bottom of the lower.  
You will go completely through the bottom of the lower.



## STEP 6

- A. Use 3/8 bit to drill through the hardened drill bushing side of the jig kit and go through both walls.



- B. Use 5/32 drill bit to drill through both remaining holes through the entire lower on hardened drill bushing side.





## STEP 7

A. Remove plates, clean lower, and start your build!

