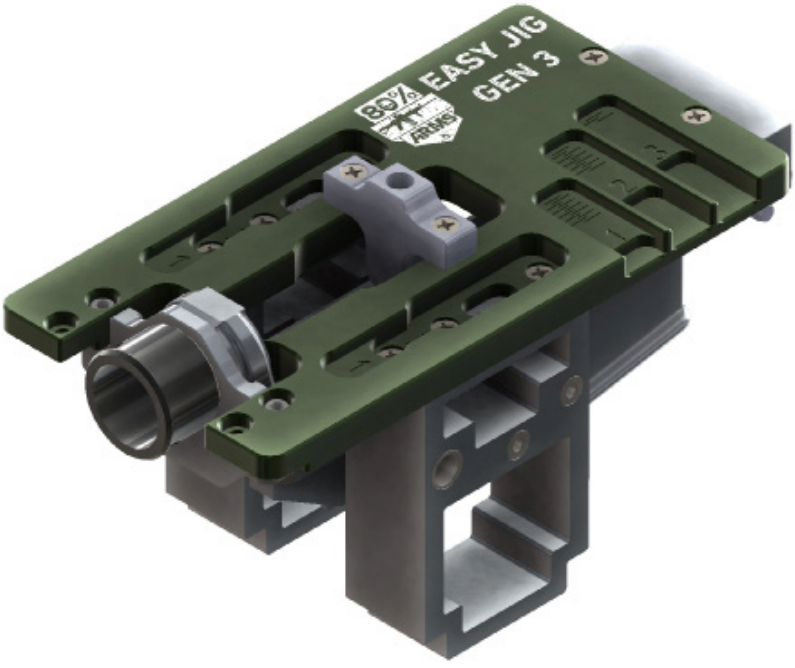
EASY-JIG®

80 PERCENT ARMS

GEN 3 MULTI-PLATFORM



Easy Jig®, Gen 3, MULTI-PLATFORM
AR-15/AR-9 & AR-10/LR308

USER MANUAL

V3.0

SPECIAL LEGAL NOTICE

DUE TO RECENT CHANGES BY THE ATF REGARDING THE DEFINITION OF FIREARM FRAMES AND RECEIVERS, 80 PERCENT ARMS CAN NO LONGER SELL CERTAIN JIGS DIRECTLY TO CUSTOMERS OR PROVIDE IN-HOUSE SERVICE OR SUPPORT. HOWEVER, CUSTOMERS CAN STILL PURCHASE JIGS AND REPLACEMENT PARTS, AND RECEIVE TECHNICAL SUPPORT THROUGH OUR AUTHORIZED DEALERS AND RETAILERS.

WE APOLOGIZE FOR THIS INCONVENIENCE, WHICH WE BELIEVE STEMS FROM AN UNLAWFUL AND UNCONSTITUTIONAL ATF ACTION. AT THE TIME OF PRINTING THIS MANUAL, 80 PERCENT ARMS IS ACTIVELY CHALLENGING THESE ATF REGULATIONS IN COURT. WE HAVE ACHIEVED FAVORABLE RULINGS AT BOTH THE DISTRICT AND APPELLATE COURT LEVELS AND ARE AWAITING THE SUPREME COURT OF THE UNITED STATES TO TAKE UP OUR CASE FOR A FINAL DECISION. WE WILL POST UPDATES ON OUR WEBSITE CONCERNING THE STATUS OF THE LITIGATION.

UNTIL A DEFINITIVE RULING IS REACHED IN OUR CASE AGAINST THE ATF, RESTRICTIONS REMAIN. MANUFACTURERS LIKE US ARE PROHIBITED FROM SELLING A COMBINATION OF JIGS AND UNFINISHED FRAMES/RECEIVERS TO THE SAME CUSTOMERS AND FROM PROVIDING SUPPORT FOR THESE ITEMS. UNDER THE NEW RULES, COMBINING A JIG WITH AN UNFINISHED FRAME/RECEIVER MAY LEAD THE ATF TO CLASSIFY IT AS A FULLY FUNCTIONAL FIREARM, EVEN BEFORE ANY MODIFICATION TO THE 80% FRAME/RECEIVER IS MADE.

PLEASE CONSULT YOUR LOCAL, STATE, AND FEDERAL LAWS TO DETERMINE THE LEGALITY OF THESE PRODUCTS IN YOUR AREA, AND BE AWARE OF ANY RECENT LEGAL CHANGES THAT MAY AFFECT YOU. WE ARE NOT ATTORNEYS AND ARE UNABLE TO OFFER LEGAL ADVICE.

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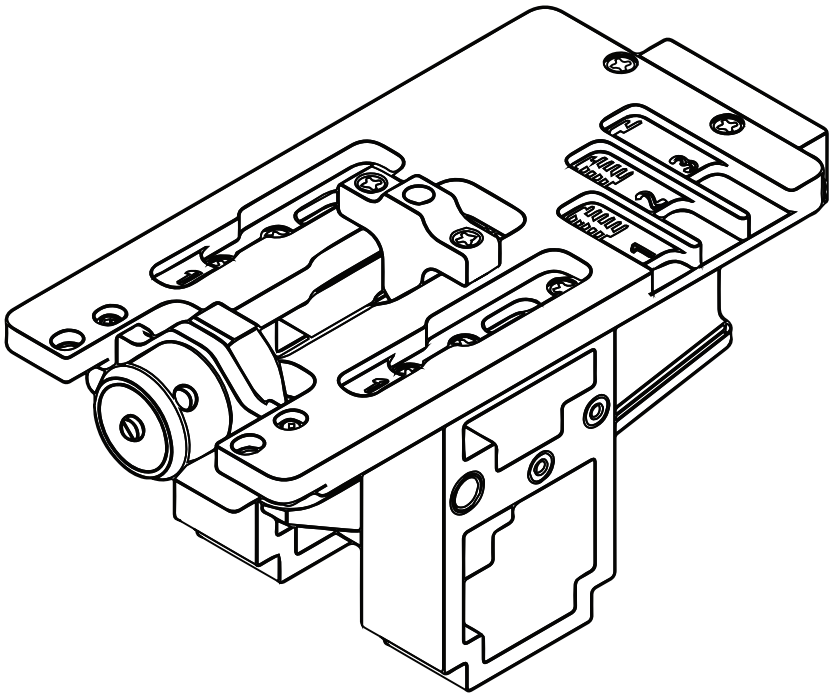
WELCOME

THE 80 PERCENT ARMS EASY JIG® GEN 3 MULTI-PLATFORM MILLING SYSTEM IS THE ULTIMATE 80% ROUTER JIG ON THE MARKET. THIS HIGH QUALITY CNC PRECISION MACHINED JIG IS THE MOST DURABLE, COST EFFECTIVE, EASY TO USE, AND FASTEST WAY TO EFFORTLESSLY FINISH YOUR 80% LOWERS



WARNING & SAFETY NOTICES

READ ALL INSTRUCTIONS AND WARNINGS BEFORE USING THE PRODUCT. DO NOT USE THIS PRODUCT IF YOU DO NOT UNDERSTAND THE INSTRUCTIONS AND WARNINGS. FAILURE TO CLOSELY READ AND COMPLY WITH LISTED INSTRUCTIONS AND WARNINGS MAY RESULT IN DAMAGE TO PROPERTY, SERIOUS INJURY, OR DEATH. DO NOT USE THIS PRODUCT IF YOU CANNOT LAWFULLY PURCHASE A FIREARM.

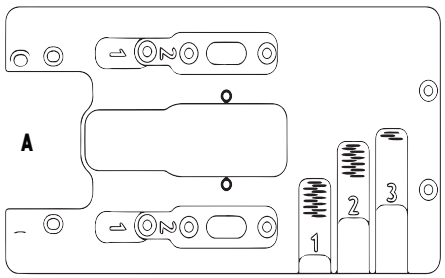
USING THIS PRODUCT ON AN 80% LOWER WILL CONVERT THE 80% LOWER INTO A FIREARM. EVEN IF THE 80% LOWER IS NOT FULLY MILLED TO COMPLETION, IT WILL STILL BE LEGALLY CONSIDERED A FIREARM. IT IS YOUR RESPONSIBILITY TO COMPLY WITH ALL FEDERAL, STATE, AND LOCAL LAWS AND REGULATIONS REGARDING THE OWNERSHIP, POSSESSION, AND TRANSPORTATION OF A FIREARM. CERTAIN CONFIGURATIONS CREATED BY THE END-USER, WHEN COMBINING A LOWER WITH AN UPPER, MAY CLASSIFY THE FIREARM UNDER THE NATIONAL FIREARMS ACT, WHICH IMPOSES REGISTRATION, TAXES, AND OTHER REQUIREMENTS ON THE OWNERS OF SUCH FIREARMS.

WORKING WITH POWER TOOLS AND CUTTING METAL IS INHERENTLY DANGEROUS. USE SAFETY EQUIPMENT AND FOLLOW ALL SAFETY INSTRUCTIONS PROVIDED BY THE POWER TOOL'S MANUFACTURER. BY USING THIS PRODUCT YOU AGREE THAT YOU ARE AWARE OF THESE RISKS, AND AGREE NOT TO HOLD 80 PERCENT ARMS LIABLE FOR ANY INJURIES OR PROPERTY DAMAGE THAT MAY OCCUR THROUGH THE USE OF OUR PRODUCTS. PROCEED AT YOUR OWN RISK.

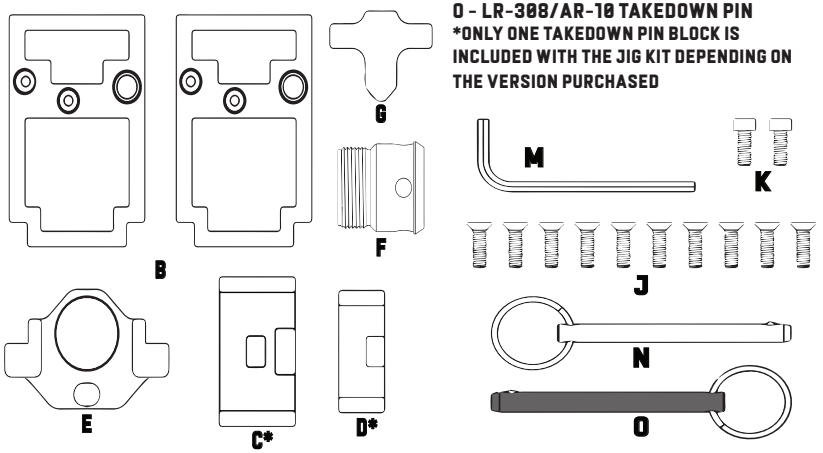
80 PERCENT ARMS WARNS ALL USERS OF OUR PRODUCTS TO EXERCISE EXTREME CAUTION IN THE HANDLING OF ANY FIREARM. BECAUSE ANY FIREARM IS POTENTIALLY DANGEROUS, THE USER SHOULD SUCCESSFULLY COMPLETE A RECOGNIZED FIREARMS SAFETY COURSE BEFORE HANDLING OR EMPLOYING ANY FIREARM. BEFORE ATTACHING YOUR FINISHED LOWER RECEIVER TO AN UPPER RECEIVER, ENSURE THAT THE SAFETY AND TRIGGER MECHANISMS ARE FUNCTIONING PROPERLY. THIS MUST BE DONE BEFORE THE LOWER RECEIVER IS ATTACHED TO AN UPPER RECEIVER OR MADE CAPABLE OF FIRING. IF YOU ARE NOT AN EXPERIENCED GUNSMITH, PLEASE TAKE YOUR COMPLETED LOWER RECEIVER TO A LICENSED GUNSMITH WHO CAN ENSURE THAT IT IS FUNCTIONING PROPERLY, AND THAT THE SAFETY IS IN GOOD WORKING ORDER. REMEMBER, YOU ARE THE MOST IMPORTANT SAFETY DEVICE WHEN IT COMES TO THE SAFE HANDLING OF YOUR FIREARMS. BY USING OUR PRODUCT YOU FURTHER AGREE THAT 80 PERCENT ARMS WILL NOT BE HELD LIABLE FOR ANY PERSONAL INJURY, DEATH OR PROPERTY DAMAGE THAT RESULTS FROM THE USE OF ANY FIREARM CREATED WITH OUR PRODUCTS. IF YOU DO NOT AGREE TO THESE TERMS, PLEASE DO NOT USE THIS PRODUCT, AND CONTACT US TO RETURN YOUR UNUSED PRODUCT FOR A REFUND.

UNDER NO CIRCUMSTANCES SHALL 80 PERCENT ARMS BE RESPONSIBLE FOR INCIDENTAL OR CONSEQUENTIAL DAMAGES WITH RESPECT TO ECONOMIC LOSS, INJURY, DEATH OR PROPERTY DAMAGE, WHETHER AS A RESULT OF BREACH OF WARRANTY, NEGLIGENCE OR OTHERWISE. SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU.

JIG HARDWARE SET

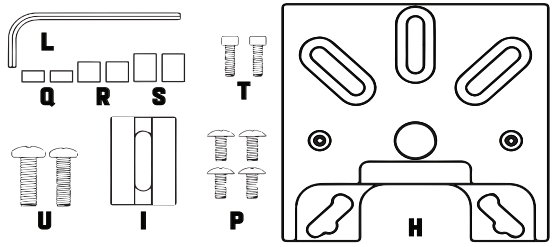


A - TOP PLATE
B - SIDE WALL (2)
C* - FRONT TAKEDOWN PIN BLOCK - MP
D* - FRONT TAKEDOWN PIN BLOCK - AR15
E - BUFFER SCREW SUPPORT
F - BUFFER SCREW
G - DRILL BLOCK
J - JIG SCREWS (10) (8-32 x 5/8)
K - BUFFER SUPPORT SCREWS (2)
L - 9/64 HEX KEY
N - AR-15/AR-9 TAKEDOWN PIN
O - LR-308/AR-10 TAKEDOWN PIN
*ONLY ONE TAKEDOWN PIN BLOCK IS INCLUDED WITH THE JIG KIT DEPENDING ON THE VERSION PURCHASED



ROUTER ADAPTER HARDWARE SET

M - 7/64 HEX KEY
H - ROUTER ADAPTER PLATE
I - SIDE BLOCK ADAPTER
P - ROUTER ADAPTER SCREWS (4) (M4-0.7 x 10mm)
Q - GUIDE PINS - SMALL (2)
R - GUIDE PINS - MEDIUM (2)
S - GUIDE PINS - LARGE (2)
T - GUIDE PINS SCREWS (2)
U - SIDE BLOCK SCREWS (2)



REQUIRED TOOLS

- COMPATIBLE HANDHELD ROUTER
- SPEEDMILL™ SEE PAGE 26 FOR ROUTER COMPATIBILITY*
- HAND DRILL OR DRILL PRESS
- VISE W/ 3IN OR LARGER JAWS
- DRILL BIT - 3/8”
- DRILL BIT - 21/64”
- DRILL BIT - 5/32”
- PHILLIPS SCREWDRIVER- #2
- CUTTING FLUID
- EYE PROTECTION
- HEARING PROTECTION
- SHOP VAC

IMAGES OF PRODUCTS ARE SUBJECT TO CHANGE

IMPORTANT POWER TOOL SAFETY NOTICE

EYE AND EAR PROTECTION MUST BE WORN AT ALL TIMES WHEN OPERATING ANY POWER TOOLS WITH YOUR EASY JIG® GEN 3. YOU MUST WEAR IMPACT RESISTANT ANSI Z87.1 RATED SAFETY GOGGLES AT ALL TIMES TO PROTECT YOUR EYES FROM FLYING DEBRIS OR CHIPS WHILE DRILLING, MILLING, OR CLEANING UP. DO NOT WEAR OPEN STYLE SAFETY GLASSES AS THEY DO NOT PROVIDE ADEQUATE PROTECTION FROM FLYING DEBRIS OR CHIPS. AVOID USING COMPRESSED AIR TO BLOW OR CLEAR METAL CHIPS.

EXAMPLES OF SUITABLE EYE PROTECTION INCLUDE:

- 3M VIRTUA CCS PROTECTIVE EYEWEAR WITH FOAM GASKET
- DEWALT DPG82 GOGGLES

ASSEMBLY & DESIGN

THE EASY JIG GEN 3 MULTI-PLATFORM SYSTEM IS THE SUPREME 80% LOWER MILLING JIG FOR QUALITY, SPEED, PRECISION, DURABILITY, AND EASE OF USE. WITH OUR INDUSTRY-LEADING PATENTED ROUTER MILLING TECHNOLOGY, IT’S THE ONLY JIG YOU WILL EVER NEED.

ITS FOOLPROOF SYSTEM CONVERTS EFFORTLESSLY BETWEEN PLATFORMS IN SECONDS FOR EXTREMELY FAST MILLING OF ALL AR-15, PISTOL CALIBER, AND .308 LOWERS.

IF YOU PURCHASED THE EASY JIG® GEN 3 AR-15/AR-9 ONLY VERSION, YOU HAVE THE OPTION OF PURCHASING A MULTI-PLATFORM TAKEDOWN PIN BLOCK (D) SEPARATELY THAT WILL ALLOW YOUR JIG TO BE USED WITH AR-15, AR-9, AND .308 PLATFORMS.

ROUTER INFORMATION

THE EASY JIG® GEN 3 SYSTEM REQUIRES A ROUTER FOR MILLING LOWERS. THEY MAY BE FIXED OR VARIABLE SPEED. A NUMBER OF FULL-SIZE FIXED BASE ROUTERS CAN ALSO BE USED WITH THE OPTIONAL FULL-SIZE ROUTER ATTACHMENT PLATE.

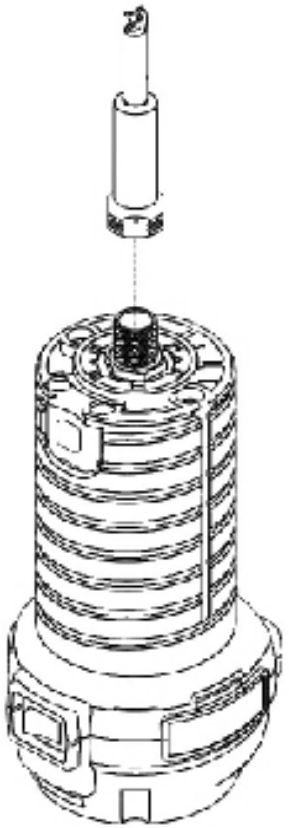
THE EASY JIG® GEN 3 SYSTEM SUPPORTS THE LARGEST NUMBER OF ROUTERS OF ANY SYSTEM. SOME ROUTERS ARE BETTER THAN OTHERS WITH THE MAIN DIFFERENCE BEING THE EASE, ACCURACY, AND SPEED OF ADJUSTING THE MILLING DEPTH. CERTAIN ROUTERS HAVE LIMITED TRAVEL AND REQUIRE A SPECIFIC SET UP. PLEASE REVIEW APPENDIX “A” AT THE END OF THIS MANUAL FOR YOUR SPECIFIC ROUTER INFORMATION BEFORE STARTING.

ROUTER ADAPTER PLATE INSTALLATION

*R.A.P = ROUTER ADAPTER PLATE

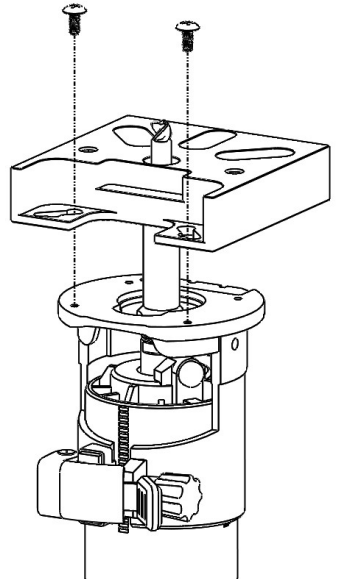
A1 - BEFORE PROCEEDING, UNPLUG THE ROUTER AND REMOVE THE FACTORY ROUTER PLATE AND ADJUSTABLE BASE FROM THE ROUTER TO EXPOSE THE COLLET AND SPINDLE. REMOVE THE COLLET AND MAKE SURE THE SPINDLE AND SPEEDMILL™ ARE CLEAN AND FREE OF ANY BURRS OR DEBRIS. IMPERFECTIONS ON THE SURFACE OF THE SPINDLE CAN IMPACT THE FINISH QUALITY. THE ORIGINAL COLLET AND COLLET NUT WILL NOT BE USED.

A2 - THREAD ON THE CORRECT SIZE SPEEDMILL™ FOR YOUR ROUTER. TIGHTEN WITH A WRENCH. ALWAYS LEAVE A PROTECTIVE COVERING ON THE SPEEDMILL™ TIP UNTIL YOU ARE READY TO BEGIN MILLING. THE SPEEDMILL™ IS A USA MADE, HIGH QUALITY, SOLID CARBIDE END MILL IN A CUSTOM THERMAL COLLET DESIGNED FOR MILLING ALUMINUM. CARBIDE IS KNOWN FOR ITS DURABILITY, HOWEVER TAKE GREAT CARE NOT TO DROP OR HIT THE SPEEDMILL™ AS DAMAGE TO THE END MILL CAN AFFECT THE FINISH OF YOUR LOWER. IF THE SPEEDMILL™ DOES NOT FIT THE ROUTER, YOU HAVE THE WRONG SPEEDMILL™ SIZE. PLEASE REFER TO APPENDIX "A" FOR ROUTER COMPATIBILITY INFORMATION.



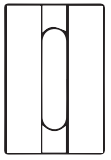
A2.1 - REINSTALL THE ROUTER'S FACTORY BASE, BUT DO NOT INSTALL THE BASEPLATE. TAKE THE 3 R.A.P. SCREWS [P] INCLUDED WITH YOUR JIG AND CHECK THAT THE SCREWS MATCH THE THREAD PITCH ON ROUTER BASE AND THREAD EASILY INTO THE BASE. YOU WILL LATER BE USING THE SCREWS TO ATTACH THE R.A.P. TO YOUR ROUTER BASE IN STEP A3.

IF THE SCREWS DO NOT THREAD EASILY, YOU MAY NEED TO PURCHASE TRUSS OR PAN HEAD SCREWS THAT MATCH THE THREAD PITCH ON YOUR ROUTER. NEVER USE TAPERED HEAD SCREWS TO MOUNT THE R.A.P



M5-0.8 X 20MM
M6-1.0 X 20MM

U



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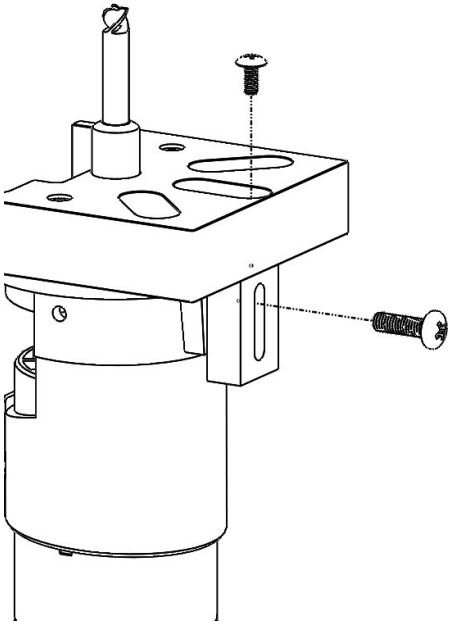


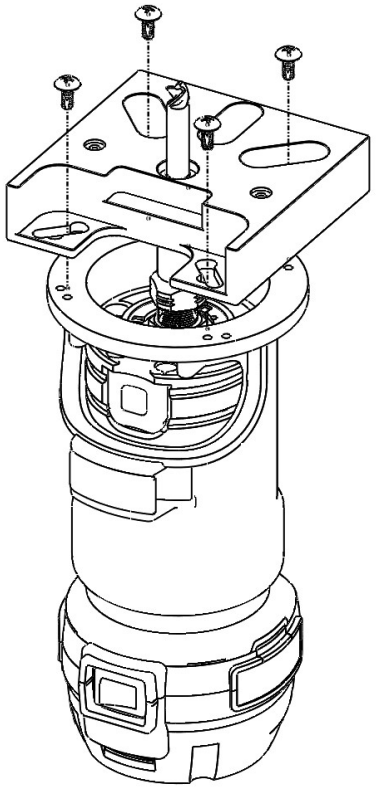
A3.1 - WITH THE THICK PORTION OF THE SPEEDMILL™GOING THROUGH THE R.A.P. BEARING, ALIGN THE TWO SCREW HOLES OF THE ROUTER'S BASE (ON OPPOSITE SIDE OF THE ROUTER'S ACCESSORY MOUNT) WITH THE HOLES IN THE R.A.P. LOOSELY THREAD THE 2 ROUTER ADAPTER SCREWS (P) THROUGH THE R.A.P. AND INTO THE ROUTER'S BASE.

A3.2 - ALIGN AND LOOSELY MOUNT THE SIDE ADAPTER BLOCK (I) TO THE BACK OF THE ROUTER USING THE ROUTER'S ACCESSORY MOUNTING HOLE AND ONE OF THE SIDE BLOCK SCREWS (U) WHICH FITS YOUR ROUTER. ONLY TIGHTEN ENOUGH SO THE SIDE ADAPTER BLOCK IS FLUSH WITH THE ROUTER BUT CAN STILL SLIDE ALONG THE ROUTER ACCESSORY RAIL.

A3.3 - LOOSELY THREAD A ROUTER ADAPTER SCREW THROUGH THE R.A.P. GOING INTO THE SIDE ADAPTER BLOCK. ALIGN THE SIDE ADAPTER BLOCK SO IT IS TOUCHING AND FLUSH WITH THE ROUTER AND THE R.A.P. TIGHTEN THE R.A.P. SCREW. TIGHTEN THE SIDE ADAPTER BLOCK SCREW. TIGHTEN THE TWO OTHER R.A.P. SCREWS.

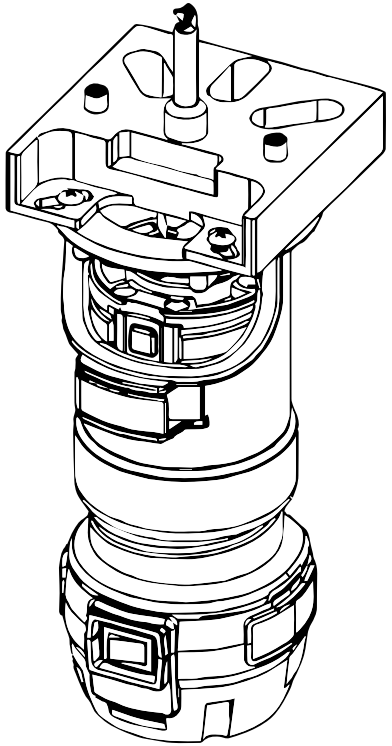
ALTERNATE ROUTER ADAPTER PLATE INSTALLATION

A4 - SLIDE THE R.A.P. OVER THE SPEEDMILL™ THROUGH THE CENTER HOLE OF THE BEARING. ADJUST THE ROUTER'S BASE DEPTH IF NECESSARY. BE CAREFUL TO NOT DAMAGE THE END MILL WHEN INSERTING THE END MILL THROUGH THE R.A.P. BEARING HOLE.



A5 - ROTATE THE R.A.P. TO ALIGN WITH THE HOLES ON ROUTER'S BASE WITH THE HOLES ON THE R.A.P. AS SHOW ON THE DIAGRAM ON THE RIGHT.

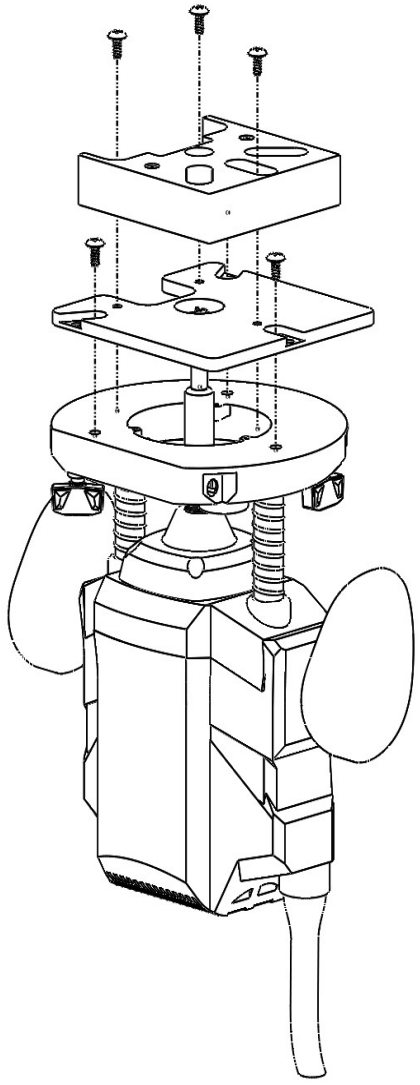
THREAD THE 4 ROUTER ADAPTER SCREWS (P) THROUGH THE R.A.P. TO SECURE IT TO THE ROUTER'S BASE. TIGHTEN THE SCREWS CAREFULLY WITH A PHILLIPS SCREW DRIVER. TAKE CARE TO NOT TO MISALIGN THE R.A.P.



SOME ROUTERS WITH A SMALLER BASE REQUIRE AN ALTERNATE R.A.P. INSTALL METHOD USING THE ROUTER ADAPTER BLOCK (I) AND ONLY 3 SCREWS.

IF YOU DO NOT NEED THE ALTERNATE INSTALLATION, SKIP TO B1 JIG ASSEMBLY ON PAGE 10.

*LARGE ROUTER ADAPTER PLATE INSTALLATION

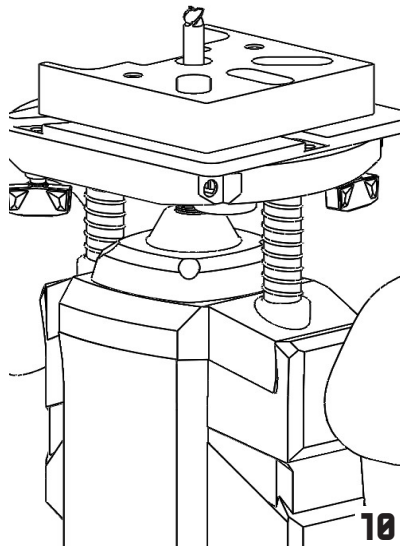


A6 - IF STEPS A4 AND A5 DO NOT WORK WITH YOUR ROUTER, YOU MAY HAVE A LARGE ROUTER THAT TYPICALLY HAS A TWO HANDLE BASE AND REQUIRES A FULL SIZE ROUTER PLATE ADAPTER THAT IS SOLD SEPARATELY

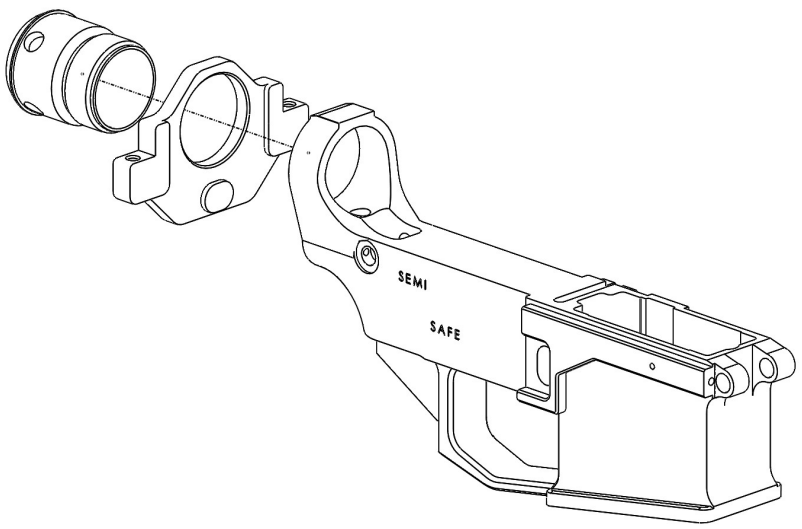
A6.1 - REMOVE THE FACTORY BASE FROM THE ROUTER AND INSTALL THE FULL SIZE ROUTER ADAPTER PLATE OVER THE SPEEDMILL™ USING THREE OF THE SCREWS REMOVED FROM THE ROUTER'S BASE AS SHOWN.

A6.2 - ADJUST THE ROUTER'S BASE DEPTH AS NECESSARY TO ENSURE THE THICKER PART OF THE SPEEDMILL™ PASSES THROUGH THE CENTER HOLE AND BEARING OF THE R.A.P.

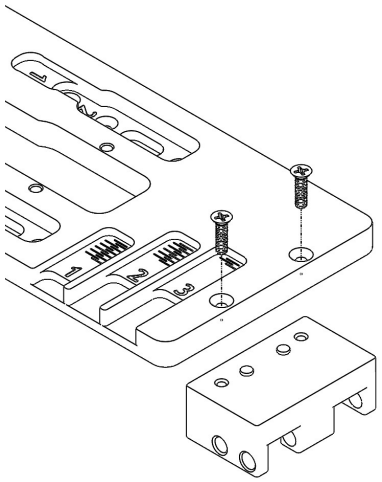
ATTACH THE R.A.P. TO THE FULL SIZE ROUTER ADAPTER PLATE USING THE 3 ROUTER ADAPTER PLATE SCREWS (P)



JIG ASSEMBLY

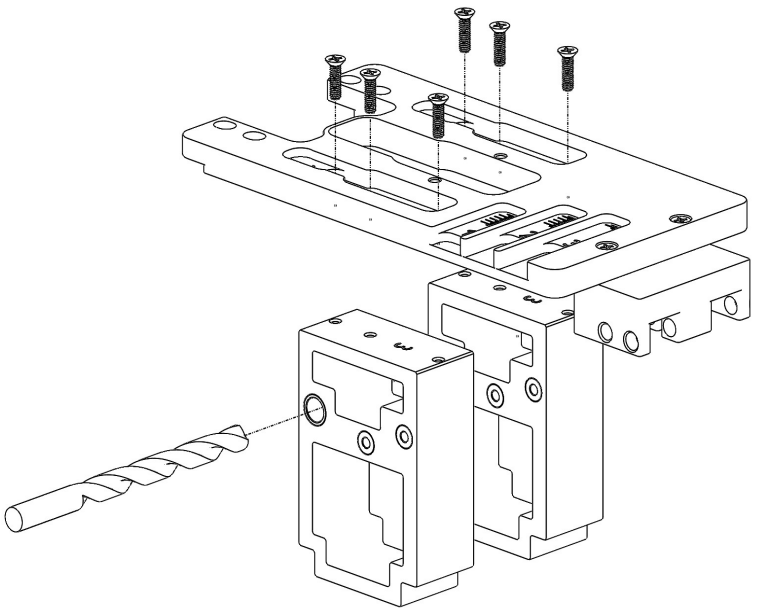


B1 - ALIGN THE BUFFER SCREW SUPPORT (E) WITH THE LOWER RECEIVER AS SHOWN AND LOOSELY THREAD THE BUFFER SCREW THROUGH THE BUFFER SCREW SUPPORT AND INTO THE LOWER RECEIVER AS SHOWN IN THE DIAGRAM ABOVE. SET ASIDE FOR NOW.

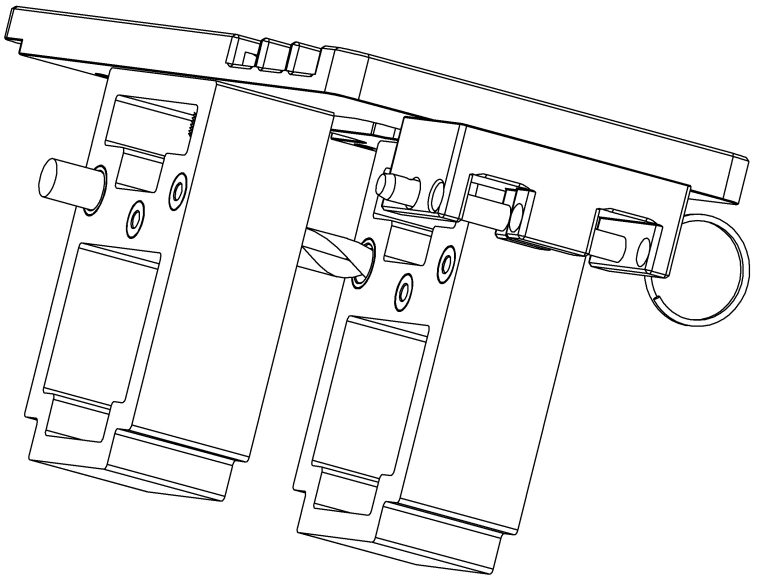


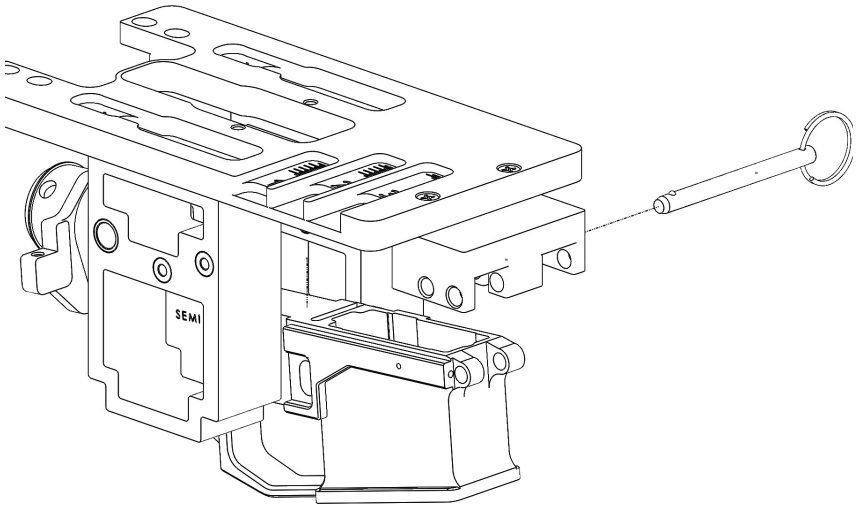
B2 - INSTALL THE FRONT TAKEDOWN PIN BLOCK* TO THE TOP PLATE USING 2 OF THE JIG SCREWS (J). THE TWO SCREW HOLES ON THE TOP PLATE WILL ALIGN WITH THE TWO SCREW HOLES OF THE FRONT TAKE DOWN PINBLOCK* AS SHOW IN DIAGRAM. PLEASE MAKE SURE THE TAKEDOWN PIN BLOCK IS PROPERLY ALIGNED WITH THE TOP PLATE (A)

* THE FRONT TAKEDOWN PIN BLOCK (C) THAT IS SHOWN IN THE DRAWING ON THE LEFT IS THE MULTIPLATFORM VERSION.



B3 - VERY LOOSELY ATTACH THE SIDE WALLS TO THE TOP PLATE USING 6 JIG SCREWS (J). INSERT A 3/8" DRILL BIT THROUGH BOTH SIDE WALL'S 3/8" DRILL BUSHINGS. SLIDE A DRILL BIT BETWEEN THE BUSHINGS TO ALIGN THE WALLS, THEN TIGHTEN THE WALLS TO THE TOP PLATE USING PREVIOUS LOOSELY ATTACHED 6 JIG SCREWS (J)





B4 - PLACE THE LOWER RECEIVER INTO THE JIG AS SHOWN IN THE DIAGRAM ABOVE. ALIGN YOUR LOWER RECEIVER'S FRONT TAKEDOWN PIVOT PIN HOLES WITH THE FRONT TAKEDOWN PIN BLOCK HOLE. THEN INSERT THE TAKEDOWN PIN THROUGH THE HOLES TO SECURE THE LOWER TO THE JIG.

N

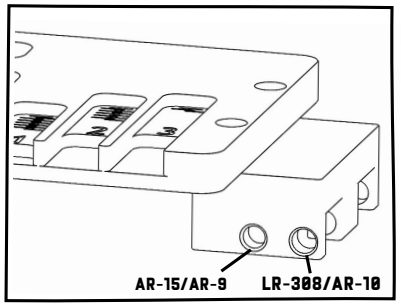
FOR AR15/AR9, USE THE SILVER PIN

O

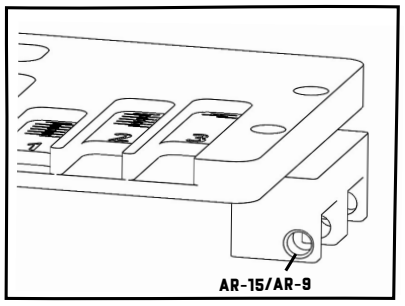
FOR LR308/AR10, USE THE BLACK PIN

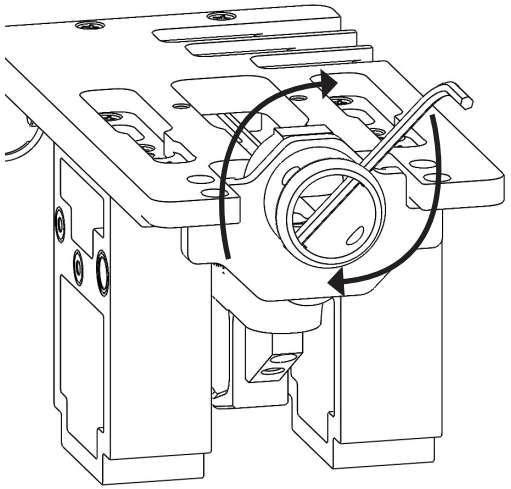
DEPENDING ON THE JIG VERSION PURCHASED,
YOU WILL HAVE ONE OF THE TWO TAKEDOWN PIN BLOCKS SHOWN BELOW.

C - FRONT TAKEDOWN PIN BLOCK - MP

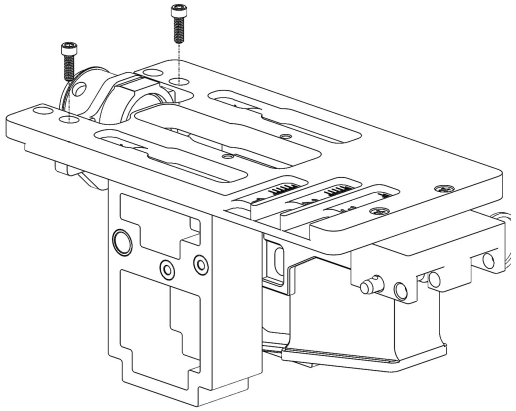


D - FRONT TAKEDOWN PIN BLOCK - AR-15/AR-9

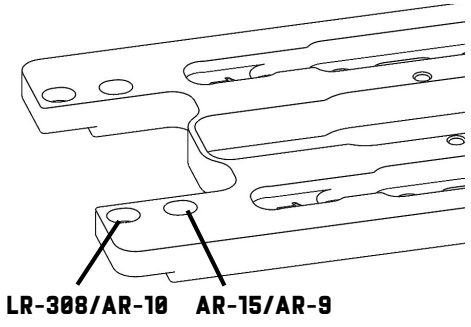




B5 - SECURE THE BUFFER SCREW SUPPORT TO THE LOWER RECEIVER BY TIGHTENING THE BUFFER SCREW. (INSERT THE SUPPLIED HEX KEY (M) THROUGH THE HOLES IN THE BUFFER SCREW FOR LEVERAGE. DO NOT USE EXCESSIVE FORCE.) PERIODICALLY CHECK THIS REMAINS TIGHT THROUGHOUT THE MILLING PROCESS.



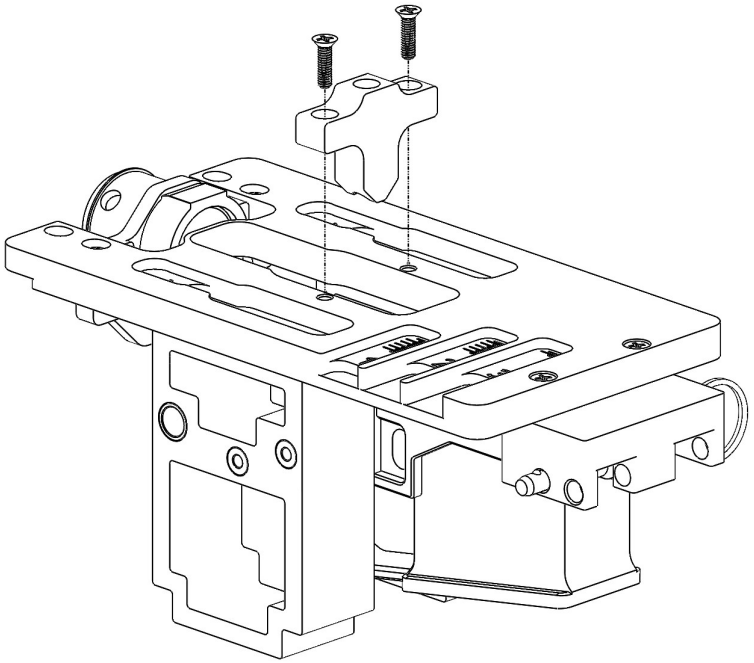
B6 - FASTEN THE 2 BUFFER SUPPORT SCREWS [K] TO CONNECT THE BUFFER SCREW SUPPORT TO THE TOP PLATE. DO NOT OVER TIGHTEN. PERIODICALLY CHECK THAT THESE SCREWS REMAIN TIGHT THROUGHOUT THE MILLING PROCESS.



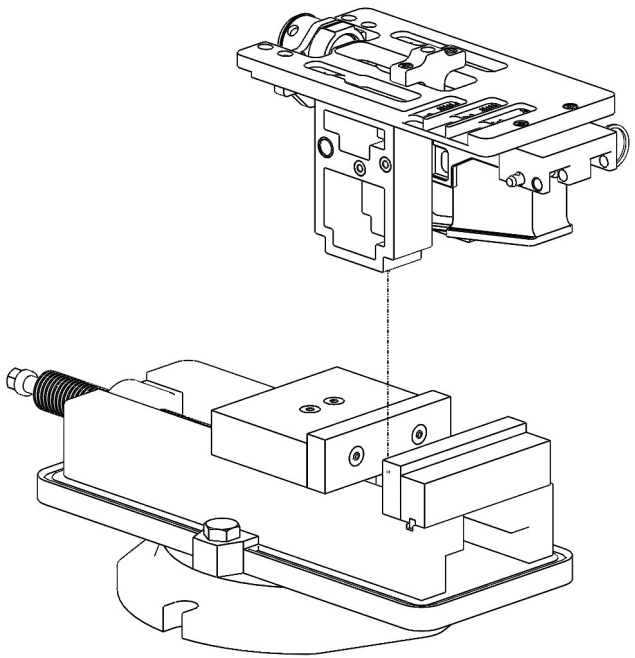
WHEN MILLING AN AR-15/AR-9, SCREW THE BUFFER SCREW SUPPORT INTO THE HOLES FURTHEST FROM THE REAR EDGE.

WHEN MILLING AN LR-308/AR-10, SCREW THE BUFFER SCREW SUPPORT INTO THE HOLES CLOSEST TO THE REAR EDGE.

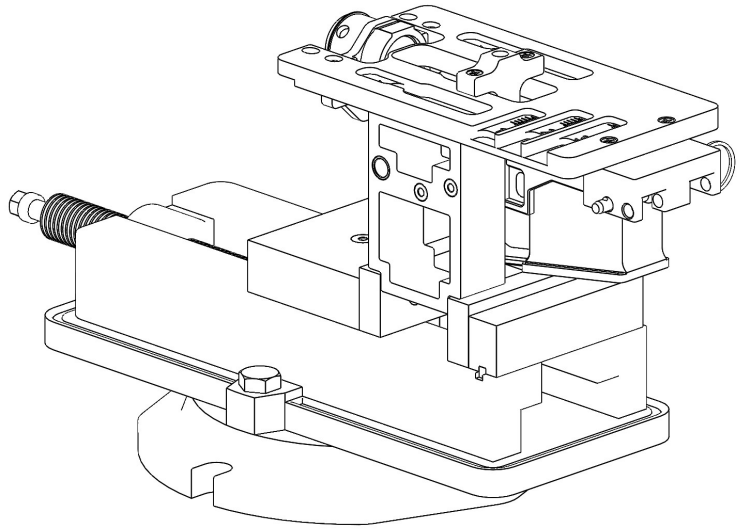
B7 - ATTACH THE DRILL BLOCK (G) TO THE TOP PLATE USING 2 JIG SCREWS (J). SECURELY TIGHTEN THE SCREWS WHILE BEING CAREFUL NOT TO STRIP THE THREADS.



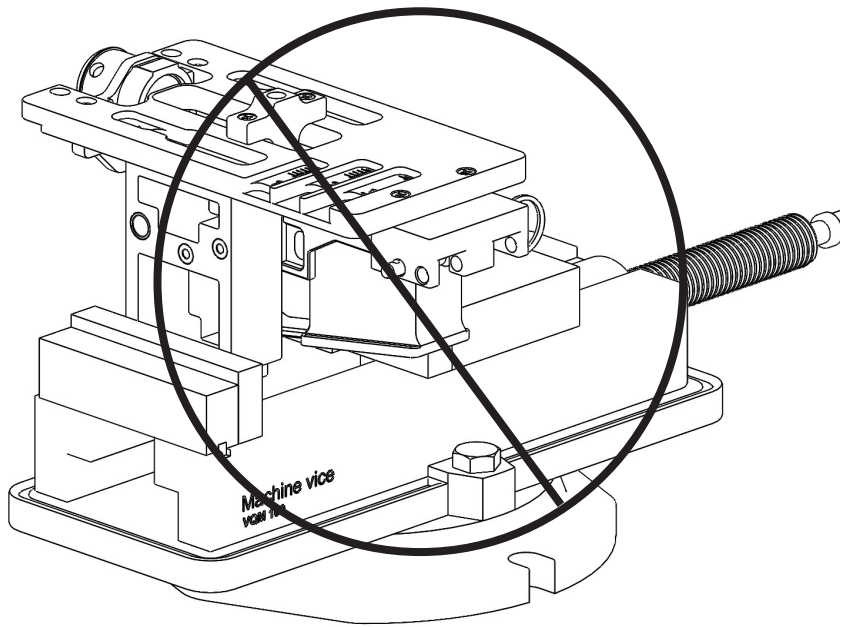
B8 - SECURE THE JIG ASSEMBLY INTO A FIXED VISE. ONLY CLAMP AGAINST THE FRONT AND BACK NOTCHED SURFACES OF THE SIDE PLATES AS SHOWN.



CORRECT VISE MOUNT



INCORRECT VISE MOUNT

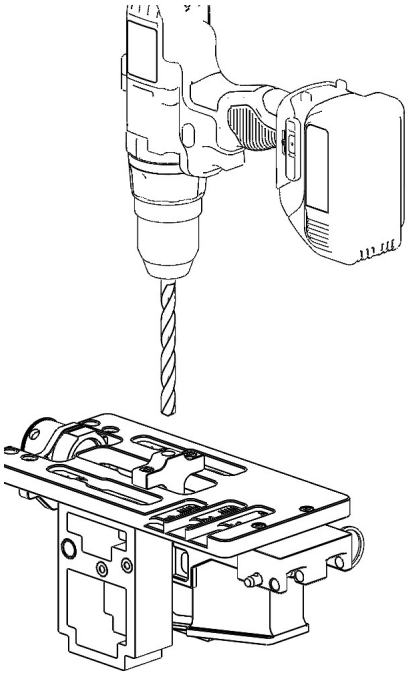


NEVER CLAMP THE VISE JAWS TO THE FACES OF THE SIDE WALLS OR YOU WILL DAMAGE THE JIG

READ CAREFULLY BEFORE STARTING ANY DRILLING OR MILLING:

- ALWAYS WEAR ANSI Z87.1 APPROVED EYE PROTECTION AND ANSI S3.19 APPROVED EAR PROTECTION WHEN USING POWER TOOLS.
- AVOID USING COMPRESSED AIR TO CLEAR CHIPS. THE CHIPS ARE SHARP AND COMPRESSED AIR CAN BLOW THEM INTO YOUR EYES.
- REMOVE CHIPS AFTER COMPLETING EACH PASS.
- THE BUFFER SCREW CAN ACCEPT A VACUUM HOSE/ADAPTER. FOR A CLEANER WORK ENVIRONMENT, CONNECT THE HOSE TO THE BUFFER SCREW AND RUN THE VACUUM WHILE MILLING TO SUCTION OUT CHIPS AND REDUCE THE AMOUNT OF CLEANUP. TO INCREASE EFFECTIVENESS, APPLY TAPE AROUND THE BOTTOM AREA OF THE TOP PLATE AND BETWEEN THE LOWER RECEIVER AND THE SIDE WALLS.
- CHECK THE LOCK/LATCH ON YOUR ROUTER'S DEPTH ADJUSTABLE BASE FOR PROPER FUNCTION. IF THE ADJUSTABLE BASE IS NOT SECURED AND MOVES WHILE MILLING, DAMAGE CAN OCCUR TO THE LOWER, JIG, AND SPEEDMILL™ AS WELL AS POSSIBLE HARM TO SELF CAN OCCUR.
- USE THE HIGHEST SPEED SETTING ON YOUR ROUTER IF EQUIPPED WITH A VARIABLE SPEED SETTING.
- APPLY CUTTING FLUID TO THE RECEIVER AND SPEEDMILL™ BEFORE MILLING EACH PASS.
- BEFORE STARTING EACH NEW PASS, BE SURE THE SPEEDMILL™ IS NOT TOUCHING THE LOWER RECEIVER AND IS CENTERED IN THE PILOT HOLE BEFORE TURNING THE ROUTER ON.
- WHILE MILLING, HOLD THE ROUTER FIRMLY WITH BOTH HANDS AND MAINTAIN MODERATE DOWNWARD PRESSURE ON THE ROUTER AT ALL TIMES.
- ALWAYS WAIT UNTIL THE ROUTER COMES TO A COMPLETE STOP BEFORE LIFTING THE ROUTER OFF THE JIG.
- DO NOT ALLOW THE ROUTER TO TILT OR LIFT OFF THE TOP PLATE WHILE MILLING.
- DO NOT EXCEED 1 HASH MARK AT A TIME. CUTTING TOO MUCH MATERIAL CAN RESULT IN A ROUGH FINISH AND CAN CAUSE DAMAGE TO THE SPEEDMILL™ AND THE LOWER RECEIVER.
- THE HASH MARKS ON THE DEPTH GAGES ARE CALIBRATED FOR A BALANCE BETWEEN SPEED AND FINISH QUALITY. THE LESS YOU CUT PER PASS, THE BETTER THE FINISH.
- MILLING SHOULD BE DONE BY MOVING THE ROUTER IN SLOW, SMALL, CLOCKWISE CIRCLES. DO NOT MILL IN COUNTER-CLOCKWISE CIRCLES AS THIS MAY CAUSE THE CUTTING FLUTES OF THE SPEEDMILL™ TO CATCH ON MATERIAL AND CAN RESULT IN GOUGES IN THE RECEIVER. SLOW DOWN WHEN MILLING INTO A CORNER OF THE TEMPLATE. CORNERS ENGAGE MORE OF THE END MILL AND CAN CAUSE EXCESSIVE CHATTER OR THE END MILL TO JUMP IF MOVING TOO RAPIDLY.

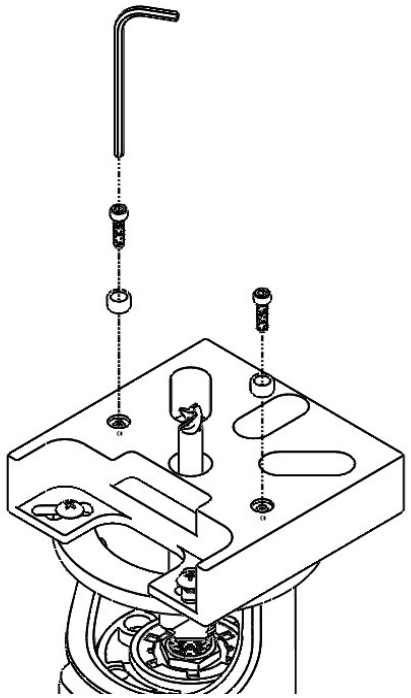
DRILLING THE PILOT HOLE



C1 - APPLY AMPLE CUTTING FLUID INTO THE DRILL BLOCK HOLE AND FULLY INSERT THE 21/64" DRILL BIT UNTIL IT TOUCHES THE LOWER RECEIVER. HOLDING THE DRILL VERY STRAIGHT, START DRILLING. USE A SLOW TO MEDIUM DRILL SPEED SETTING. FAST SPEED WILL QUICKLY OVERHEAT AND DULL THE DRILL BIT. FOR EVERY 5 SECONDS OF DRILLING, IT IS RECOMMENDED TO LIFT THE DRILL BIT OUT OF THE DRILL BLOCK TO CLEAR AWAY CHIPS. REPEAT THIS UNTIL THE DRILL BIT PASSES THROUGH THE FLOOR OF THE LOWER RECEIVER.

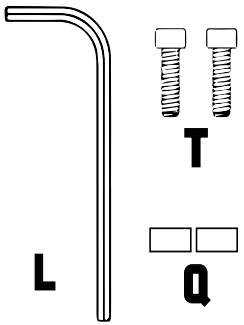
C2 - REMOVE THE DRILL BLOCK FROM THE JIG.

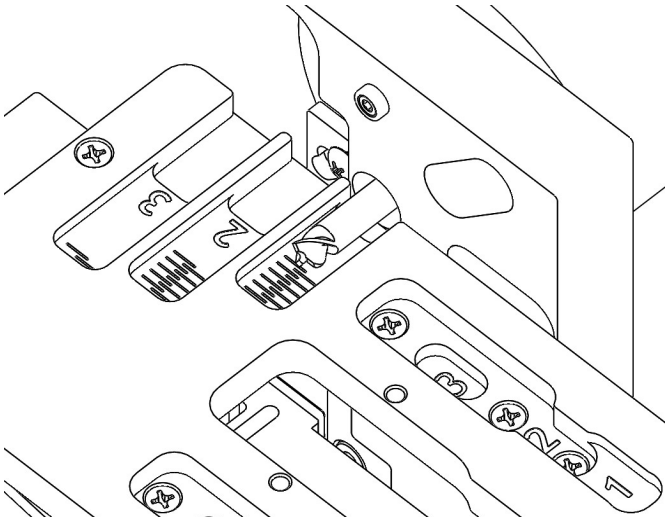
MILLING TEMPLATE 1



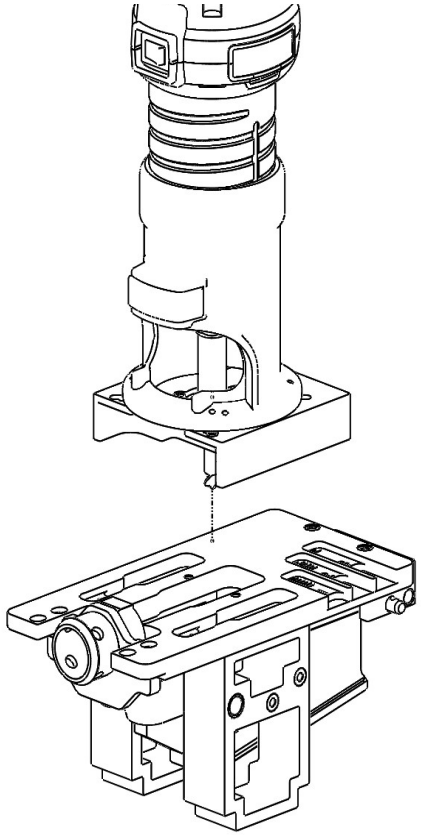
D1 - USING THE GUIDE PIN SCREWS, SECURE THE 2 SHORT GUIDE PINS TO THE R.A.P. USING HEX KEY (M). USE THE LONG END OF THE HEX KEY IN THE SCREW HEAD. TURN THE SHORT END WITH YOUR FINGERS TO AVOID OVER TIGHTENING AND SNAPPING OFF THE GUIDE PINS.

DO NOT EXCEED 10 IN-LBS



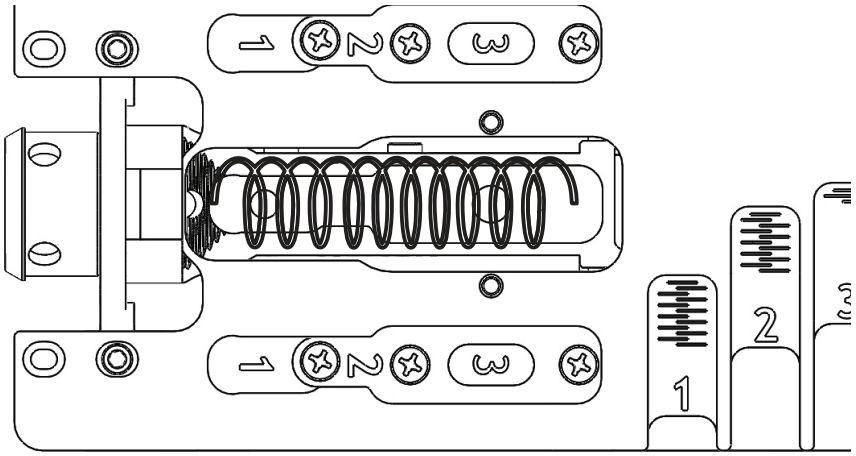


D1.2 - WHILE HOLDING THE R.A.P. FLUSH AND LEVEL AGAINST THE EDGE OF THE TOP PLATE, SET THE DEPTH OF THE SPEEDMILL™ TO THE FIRST HASH MARK OF DEPTH GAUGE "1" AND LOCK THE ROUTER BASE IN THIS POSITION AS SHOWN.

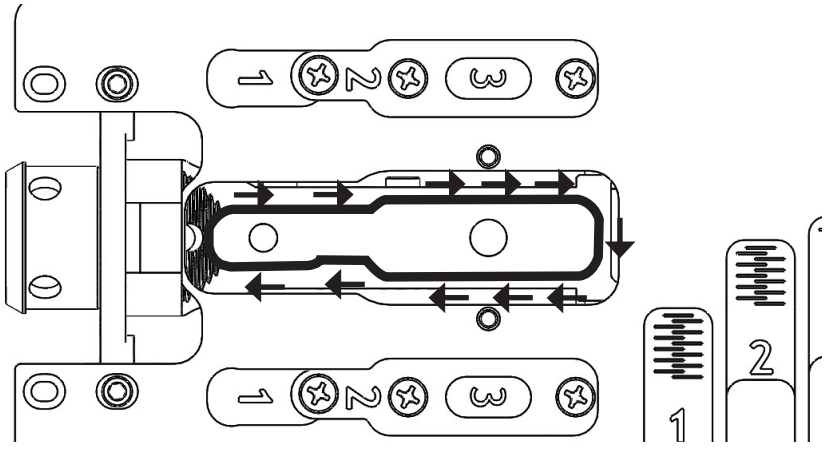


D1.3 - PLACE THE ROUTER ASSEMBLY ON THE TOP PLATE SO THAT THE SPEEDMILL™ CUTTING FLUTES ARE CENTERED IN THE PILOT HOLE AS SHOWN. THE CUTOUT IN THE R.A.P. SHOULD BE FACING THE BUFFER SCREW. THE GUIDE PINS SHOULD BE INSIDE THE RECESSED AREA OF BOTH TEMPLATES. SPRAY CUTTING FLUID ON THE TOP SURFACE OF THE RECEIVER AND SPEEDMILL™.

D1.4 - WHILE MAINTAINING FIRM DOWNWARD PRESSURE ON THE ROUTER WITH BOTH HANDS, TURN ON THE ROUTER . REDUCE DOWNWARD PRESSURE TO A MODERATE LEVEL AND BEGIN MILLING THE FIRST PASS IN THE PATTERN SHOWN BELOW, USING A SPIRAL CLOCKWISE MOTION.



AFTER MILLING THE FIRST PASS WITH THE SPIRAL CLOCKWISE MOTION, GO BACK AND MILL THE FULL CONTOUR OF THE TEMPLATE IN A CLOCKWISE DIRECTION AS SHOWN IN THE DIAGRAM BELOW. SLOW DOWN IN THE CORNERS.



D1.5 - REPEAT STEPS D1.2 THROUGH D1.4 MOVING THE DEPTH OF THE SPEEDMILL™ TO THE NEXT HASH MARK IN THE DEPTH GAUGE UNTIL THE SPEEDMILL™ BOTTOMS OUT IN THE GAUGE. DO NOT EXCEED ONE HASH MARK PER PASS AS THIS COULD PRODUCE TOOL CHATTER AND AN UNDESIRABLE FINISH QUALITY OF YOUR LOWER RECEIVER. REMEMBER TO USE CUTTING FLUID BEFORE BEGINNING EACH MILLING PASS.

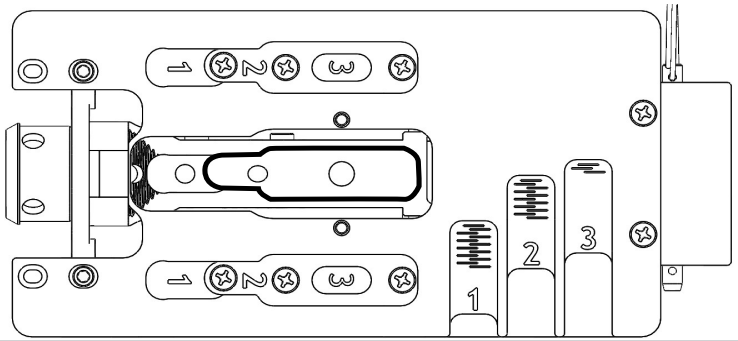
STOP, PLEASE WAIT TO BEGIN MILLING DEPTH GAUGE TEMPLATE 2!

MILLING TEMPLATE 2

D2.1 - UNPLUG THE ROUTER AND REMOVE THE TWO SHORT GUIDE PINS FROM THE R.A.P. AND REPLACE THEM WITH THE TWO MEDIUM GUIDE PINS USING THE SAME SCREWS AND HEX KEY. PLUG IN THE ROUTER.

D2.2 - WHILE HOLDING THE R.A.P. AGAINST THE EDGE OF THE TOP PLATE, SET THE DEPTH OF THE SPEEDMILL™ TO THE FIRST HASH MARK OF DEPTH GAUGE “2” AND LOCK THE ROUTER BASE IN THIS POSITION AS YOU DID IN STEP D1.2.

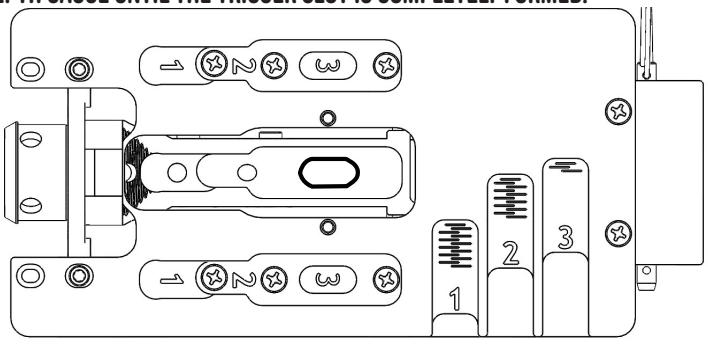
D2.3 - REPEAT STEPS D1.3 THROUGH D1.5. YOU MAY SEE A HOLE APPEAR FOR THE GRIP BOLT WHICH IS NORMAL. ENSURE YOU ARE ONLY MILLING THE OUTLINE OF TEMPLATE “2”, WHICH IS THE MAIN TRIGGER POCKET AREA. THE LOWER RECEIVER SHOULD LOOK LIKE THE IMAGE BELOW AFTER COMPLETING THE FINAL PASS (SPEEDMILL™ BOTTOMED OUT IN GAUGE) OF GAUGE “2”. STOP, DO NOT BEGIN MILLING THE NEXT DEPTH GAUGE.



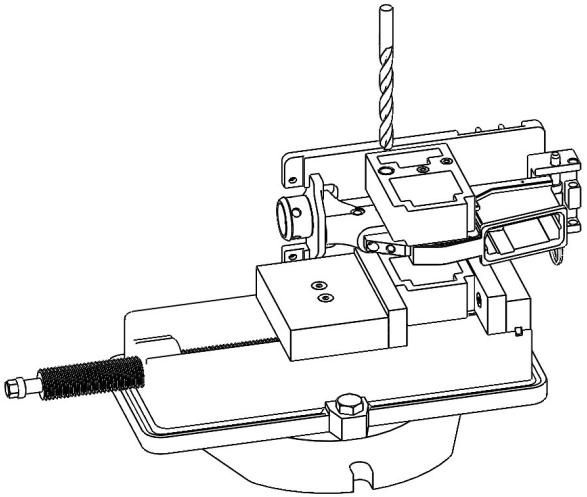
MILLING TEMPLATE 3

D3.1 - UNPLUG THE ROUTER AND REMOVE THE TWO MEDIUM GUIDE PINS FROM THE R.A.P. AND REPLACE THEM WITH THE TWO LONG GUIDE PINS USING THE SAME SCREWS AND HEX KEY. PLUG IN THE ROUTER.

D3.2 - WHILE HOLDING THE R.A.P. AGAINST THE EDGE OF THE TOP PLATE, SET THE DEPTH OF THE SPEEDMILL™ TO THE FIRST HASH MARK OF DEPTH GAUGE “3” (TRIGGER SLOT) AND LOCK THE ROUTER BASE IN THIS POSITION AS YOU DID IN STEP D1.2.REPEAT STEPS D1.3 THROUGH D1.5 MOVING THE DEPTH OF THE SPEEDMILL™ TO THE NEXT HASH MARK IN THE DEPTH GAUGE UNTIL THE TRIGGER SLOT IS COMPLETELY FORMED.



DRILLING TRIGGER, HAMMER, & SELECTOR HOLES



E1 - REMOVE THE EASY JIG® FROM THE VISE AND REPOSITION IT ON ITS SIDE AS SHOWN.

E2 - USING A 3/8” DRILL BIT IN A HAND DRILL OR DRILL PRESS*, APPLY AMPLE CUTTING FLUID TO THE DRILL BIT AND TO THE INSIDE OF THE LARGE DRILL BUSHING. SLIDE THE DRILL BIT ALL THE WAY THROUGH THE DRILL BUSHING SO IT IS TOUCHING THE LOWER BEFORE STARTING THE DRILL. THE DRILL BIT SHOULD EASILY SLIDE THROUGH THE DRILL BUSHING IF ALIGNED CORRECTLY. THE DRILL BIT SHOULD NOT BIND ON THE BUSHING. MAKE SURE TO HOLD THE DRILL STRAIGHT WHILE DRILLING. IF YOU ENCOUNTER EXTRA RESISTANCE OR THE TOOL/JIG BEGINS TO MAKE LOUD SCREECHING NOISES, STOP AND REPOSITION THE DRILL BIT IN THE BUSHING. DRILL ALL THE WAY THROUGH ONLY ONE WALL OF THE RECEIVER. DO NOT APPLY HEAVY PRESSURE ON DRILL.

E3 - REPLACE THE 3/8” DRILL BIT WITH A 5/32” DRILL BIT. APPLY CUTTING FLUID INSIDE BOTH OF THE SMALL DRILL BUSHING HOLES. SLIDE THE DRILL BIT ALL THE WAY THROUGH THE DRILL BUSHING BEFORE BEGINNING CUTTING. THE DRILL BIT SHOULD EASILY SLIDE THROUGH THE DRILL BUSHING IF ALIGNED CORRECTLY. THE DRILL BIT SHOULD NOT BIND ON THE BUSHING. MAKE SURE TO HOLD THE DRILL STRAIGHT WHILE DRILLING. IF YOU ENCOUNTER EXTRA RESISTANCE OR THE TOOL/JIG BEGINS TO MAKE LOUD SCREECHING NOISES, STOP AND REPOSITION THE DRILL BIT IN THE BUSHING. DRILL ONLY THROUGH ONE WALL OF THE LOWER RECEIVER.

E4 -REPOSITION THE EASY JIG® ASSEMBLY IN THE VISE FOR DRILLING OUT THE REMAINING TWO 5/32” HOLES IN THE RECEIVER USING STEP E3 AS A GUIDE.

E5 - REPEAT STEPS E1 -E4 FOR THE OTHER WALL OF THE LOWER RECEIVER.

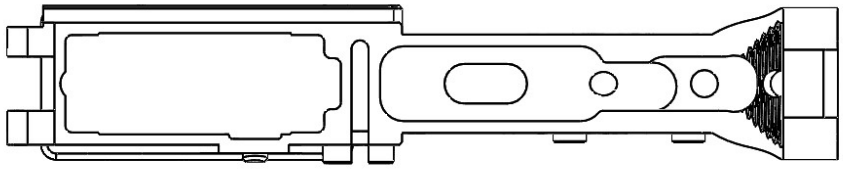
E6 - REMOVE THE LOWER RECEIVER FROM THE JIG ASSEMBLY. IT IS NOT NECESSARY TO DISASSEMBLE THE JIG SIDE PLATES TO REMOVE THE LOWER RECEIVER. TO REMOVE THE LOWER RECEIVER, UNSCREW THE BUFFER SCREW. REMOVE THE 2 JIG SCREWS ATTACHED TO THE BUFFER SCREW SUPPORT. PULL OUT THE QUICK RELEASE TAKEDOWN PIN FROM THE TAKEDOWN PIN BLOCK. SLIDE THE RECEIVER DOWN FROM THE BOTTOM OF THE JIG.

*IF USING A DRILL PRESS, IT IS VERY IMPORTANT TO DRILL PERPENDICULAR TO THE SIDE WALLS. ADJUSTMENTS TO THE POSITIONING OF THE JIG IN THE VISE MAY BE NECESSARY IF YOUR DRILL TABLE IS NOT ALIGNED TO THE CENTERLINE AXIS OF THE DRILL CHUCK. WHILE DRILLING, IF THE DRILL BIT AND DRILL BUSHING START TO BIND OR MAKE EXCESSIVE SCREECHING NOISES, STOP AND REPOSITION THE JIG TO BE BETTER ALIGNED WITH THE DRILL BIT IN THE DRILL PRESS.

FINISHING

F1 - INSPECT ALL THE EDGES OF ALL THE HOLES DRILLED FOR BURRS. PAY CLOSE ATTENTION TO THE SAFETY SELECTOR DETENT HOLE; CHIPS LIKE TO MAKE THEIR WAY INTO THIS CROSS-HOLE AND IMPEDE THE FUNCTION OF THE SAFETY SELECTOR DETENT. POKE AN UNBENT PAPER CLIP THROUGH THE SAFETY SELECTOR TO REMOVE BURRS AND/OR CHIPS FROM THIS HOLE. IT IS RECOMMENDED TO USE A DEBURRING TOOL TO REMOVE ALL BURRS FROM THE RECEIVER.

F2 - CLEAN THE RECEIVER OF ANY CHIPS, OILS, LUBRICANTS, ETC. MARKS FROM CHIPS RUBBING AGAINST ANODIZED RECEIVERS CAN BE REMOVED BY GENTLY RUBBING A SCOTCH-BRITE® SCOURING PAD WITH SOAP AND WATER OVER THE AREA.



YOUR LOWER RECEIVER IS COMPLETE!

TROUBLESHOOTING

THE 80 PERCENT ARMS EASY JIG®, GEN3 IS EXTREMELY EASY TO USE, EVEN FOR THE NOVICE USER. IN THE UNLIKELY EVENT YOU EXPERIENCE ANY TROUBLE USING YOUR JIG, PLEASE CONTACT YOUR 80 PERCENT ARMS DEALER FOR ADDITIONAL SUPPORT.

THE EASY JIG®, GEN3 IS CAPABLE OF FINISHING LOWER RECEIVERS IN LESS THAN AN HOUR. BEST RESULTS ARE ACHIEVED BY MILLING AT A SMOOTH AND SLOW PACE. THE SLOWER THE MILLING, AND THE LESS MATERIAL THAT IS REMOVED PER PASS, NEAR CNC FINISH QUALITY IS POSSIBLE WITH THE EASY JIG® GEN 3. IF YOU'RE UNABLE TO OBTAIN A SMOOTH FINISH, YOU MAY HAVE A DEFECTIVE OR WORN OUT ROUTER WITH TOO MUCH RUNOUT. WE RECOMMEND USING A HIGH-SPEED PRECISION ROUTER THAT WAS MADE FOR MILLING LOWERS FOR OPTIMAL RESULTS.

DUE TO NORMAL VARIANCES IN 80% RECEIVERS FROM DIFFERENT MANUFACTURERS, STACKING TOLERANCES, AND COMPATIBILITY REQUIREMENTS, NOT ALL THE DIMENSIONS WILL BE TO CNC MIL-SPEC TOLERANCES. EACH PART OF THE JIG HAS ITS OWN SET OF TOLERANCES AND WHEN ALL COMPONENTS AND THE LOWER ARE ASSEMBLED TOGETHER, THOSE TOLERANCES CAN STACK UP. THIS MAY RESULT IN MINOR DIMENSIONAL VARIANCES, SUCH AS THE THICKNESS OF THE FIRE CONTROL POCKET WALLS. REST ASSURED THAT THERE IS A LARGE MARGIN OF ERROR ALLOWABLE FOR THE LOWER TO STILL FUNCTION AS INTENDED.

MINOR DIFFERENCES IN WALL THICKNESS ARE NOT A DEFECT AND CAN BE CAUSED BY NORMAL TOLERANCE STACKING OR BY LOWER RECEIVERS IN WHICH THE CENTERLINE OF THE BUFFER TUBE AND TAKEDOWN PIVOT PIN HOLES ARE NOT PERFECTLY ALIGNED WITH THE CENTERLINE OF THE LOWER RECIEVER'S MAIN BODY.

COATINGS

IT IS NOT NECESSARY TO APPLY A COATING TO THE RAW ALUMINUM AREA AFTER MILLING. HOWEVER, IF DESIRED, OPTIONS SUCH AS ALUMI-BLACK, CERAKOTE, DURACOAT, AND CONVENTIONAL SPRAY PAINT ARE AVAILABLE TO ADD A FINISH TO THE RAW MILLED AREA. NOTE: ADDING A COATING TO THE ALUMINUM MAY CAUSE EXCESS BUILD-UP ON THE SURFACE MAKING ASSEMBLY OF PARTS DIFFICULT.

WARRANTY

80 PERCENT ARMS EASY JIG® CARRIES A LIFETIME WARRANTY VALID FOR THE ORIGINAL OWNER AGAINST MANUFACTURING DEFECTS. NORMAL WEAR IS NOT COVERED. TO OBTAIN WARRANTY REPAIRS, PLEASE CONTACT YOUR 80 PERCENT ARMS DEALER OR RETAILER. ALL RETURNS MUST HAVE AN RMA NUMBER FOR THE WARRANTY CLAIM TO BE PROCESSED.

LEGAL NOTICE

IT IS A VIOLATION OF FEDERAL LAW TO BUILD A FIREARM IF YOU ARE PROHIBITED FROM POSSESSING FIREARMS DUE TO A FELONY CONVICTION OR OTHER LEGALLY DISQUALIFYING REASON. THIS PRODUCT MAY BE ILLEGAL IN YOUR STATE. BY TAKING POSSESSION OF THIS PRODUCT, YOU CERTIFY THAT YOU ARE OVER THE AGE OF 21, YOU ARE LEGALLY ALLOWED TO BUILD AND OWN FIREARMS, YOU WILL USE THIS PRODUCT ONLY FOR LAWFUL PURPOSES, AND YOU HAVE CONFIRMED THAT YOU CAN LEGALLY POSSESS THIS PRODUCT IN YOUR LOCALITY. IF YOU DO NOT MEET THESE CRITERIA, DO NOT TAKE POSSESSION OF THIS PRODUCT. MISUSE OR MISHANDLING OF THIS PRODUCT CAN RESULT IN SEVERE INJURY OR DEATH TO YOURSELF AND OTHERS. IN NO EVENT SHALL WE BE LIABLE FOR ANY DIRECT, INDIRECT, PUNITIVE, INCIDENTAL, SPECIAL CONSEQUENTIAL DAMAGES, TO PROPERTY OR LIFE, WHATSOEVER ARISING OUT OF OR CONNECTED WITH THE USE OR MISUSE OF OUR PRODUCTS.

WHEN IN DOUBT, SEEK THE ADVICE OF AN ATTORNEY BEFORE MANUFACTURING ANY FIREARM. 80 PERCENT ARMS CANNOT PROVIDE LEGAL ADVICE.

TRADEMARK / PATENTS

“EASY JIG” IS A REGISTERED TRADEMARK OR TRADEMARK OF 80 PERCENT ARMS. THE PRODUCT COVERED BY THIS MANUAL IS PROTECTED UNDER COPYRIGHT, PATENT, AND OTHER INTELLECTUAL PROPERTY RIGHTS. THE ROUTER BASED EASY JIG® MILLING SYSTEM HAS MULTIPLE PATENTS AND IS THE EXCLUSIVE INTELLECTUAL PROPERTY OF 80 PERCENT ARMS. UNAUTHORIZED USE OF OUR ROUTER MILLING SYSTEM, IN WHOLE OR IN PART, IS PROHIBITED. PATENT VIOLATIONS ARE STRICTLY ENFORCED. ALL IMAGES AND CONTENT IN THIS MANUAL ARE COPYRIGHT© 80 PERCENT ARMS. UNAUTHORIZED DUPLICATION OR DISTRIBUTION OF THE CONTENTS OF THIS MANUAL WITHOUT THE PRIOR WRITTEN PERMISSION OF 80 PERCENT ARMS IS PROHIBITED. NO PART OF THIS MANUAL MAY BE REPRODUCED, STORED IN A RETRIEVAL SYSTEM, OR TRANSMITTED, IN ANY FORM, OR BY ANY MEANS, ELECTRONICALLY, MECHANICALLY, BY PHOTOCOPYING, OR OTHERWISE, WITHOUT THE PRIOR WRITTEN PERMISSION OF 80 PERCENT ARMS.

ROUTER COMPATIBILITY CHART

THE EASY JIG® GEN 3 IS DESIGNED TO REQUIRE A SPEEDMILL™ AND TESTED TO WORK WITH A VARIETY OF ROUTERS. PLEASE REFER TO THE CHART BELOW TO DETERMINE THE SIZE SPEEDMILL™ YOU NEED. OUR NEW SPEED MILL™ COMES IN FOUR DIFFERENT SIZES: 1/A, 2/B, 3/C, AND 4/D. THIS SIZING REFERS TO THE THREADED PORTION OF THE SPEEDMILL™ THAT SCREWS DIRECTLY ON THE ROUTER’S “SPINDLE” SIZE. 1/A HAS THE SMALLEST HOUSING DIAMETER AND SIZE 4/D HAS THE LARGEST WHICH ALSO REQUIRES A LARGE ROUTER BASE THAT IS SOLD SEPARATELY.

MAKE	MODEL	SPEEDMILL™ SIZE	R.A.P. INSTALL METHOD
80 PERCENT ARMS	FST-1	C/3	A5
BOSCH	PR10E* / PR20EV*	A/1	A5
BOSCH	1617 / 1617EV / 1617EVS	D/4	COMPATIBILITY MAY VARY DUE TO MANUFACTURING SPECS
BOSCH	GFK125CEN / GFK125CEK	-	NOT COMPATIBLE
BAUER	19121E-B / 19121E-N	C/3	A5
CRAFTSMAN	28212	B/2	A3
CRAFTSMAN	2767 /27683	D/4	A6
CRAFTSMAN	50429	D/4	A6
DEWALT	DCW600B	B/2	A3
DEWALT	DWE6000	A/1	A5
DEWALT	DWP611	B/2	COMPATIBILITY MAY VARY DUE TO MANUFACTURING SPECS
DEWALT	DW616	D/4	A6
DEWALT	DW618	-	NOT COMPATIBLE
KOBALT	KR-124B-03	-	NOT COMPATIBLE
HITACHI	M12VC	D/4	A6
MAKITA	RT0701C	C/3	A5
MAKITA	XTR01Z	C/3	A5
MILWAUKEE	M18	-	NOT COMPATIBLE
PORTER CABLE	450	B/2	A3
PORTER CABLE	6430 / 6435	A/1	A5
PORTER CABLE	8902	D/4	A6
RIGID	R22002	-	NOT COMPATIBLE
RIGID	R24012	A/1	A5
RYOBI	R1631K	-	NOT COMPATIBLE
SKIL”	RT1322-00	D/4	A6
* REQUIRES ADDITIONAL THROW OF ADJUSTABLE BASE FOR BEGINNING MILLING TEMPLATE “1”			

TOOL SIZE	THREAD & PITCH
A/1	M14 X 1
B/2	M15 X 1
C/3	M17 X 1
D/4	M20 X 1

A WELL REGULATED MILITIA,
BEING NECESSARY TO THE SECURITY OF A FREE STATE,
THE RIGHT OF THE PEOPLE TO KEEP AND BEAR ARMS,
SHALL NOT BE INFRINGED - 2ND AMENDMENT

MADE IN USA