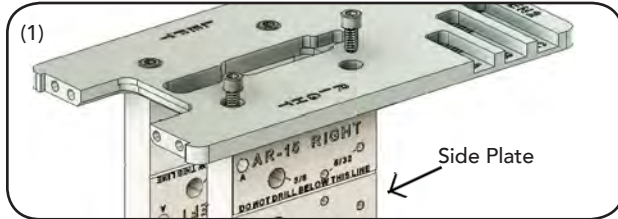
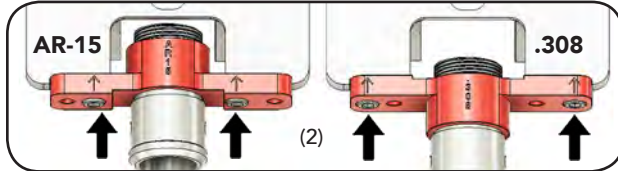


EASY JIG GEN 2 MP QUICK REFERENCE v3.4

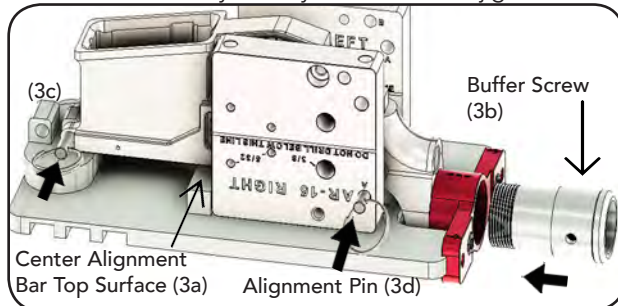
1 • Attach the right and left side plates to the jig using two 1/2" long bolts for each plate. For AR-15 and AR-9, orient the side plates with "AR-15" engraving facing out and the text facing up. For .308, orient the plates with ".308" engraving facing out and the text facing up. Loosely finger tighten the bolts into the countersunk top jig plate holes.



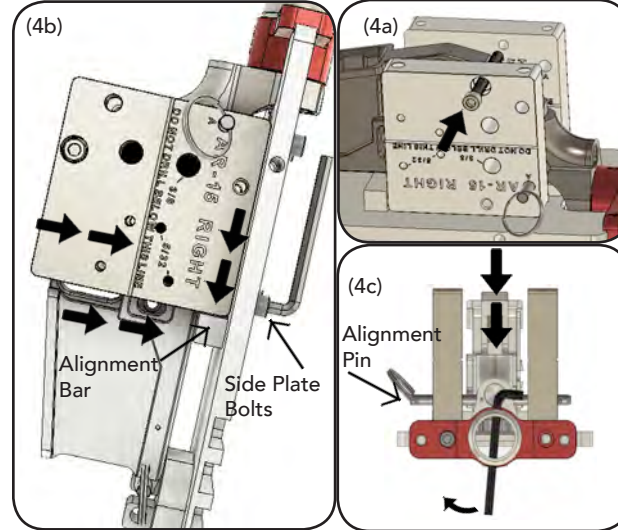
2 • Secure the red buffer screw support using two 1/2" bolts. The bolts must only be inserted into the countersunk holes below arrows. For AR-15, orient buffer support with "AR15" facing up. For .308, orient the support with ".308" facing up. Arrows must always point to the front of the jig.



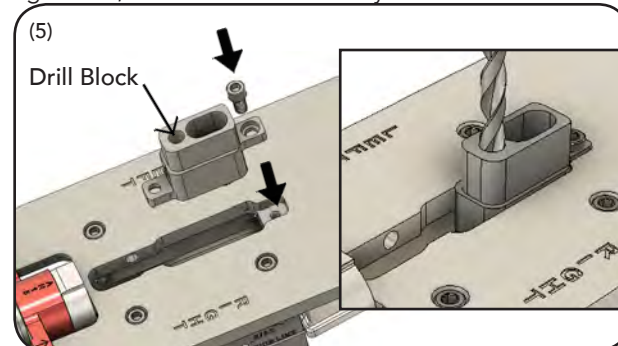
3a • Flip the jig upside down and slide the lower into the jig. If needed, stick 1 to 3 strips of blue painter's tape across the top surface of the center alignment bar so that the lower is snug against the bar when assembled. 3b) Insert the buffer screw into the buffer support and thread it loosely into the lower only 3 full turns. 3c) To secure an AR-15 lower, insert the short 1/4" pin through the front pivot pin holes of the lower and the jig. 3d) Slide the long 1/4" pin through both side plates and through the lower using the "A" alignment side plate holes. For .308 lowers, follow the same process but use the two thicker 9/32" pins to secure the lower to the jig. If too tight to insert the pins or to screw in the buffer screw, remove strips of the painter's tape as needed. At this point the side plates and the buffer screw should be only loosely secured to the jig.



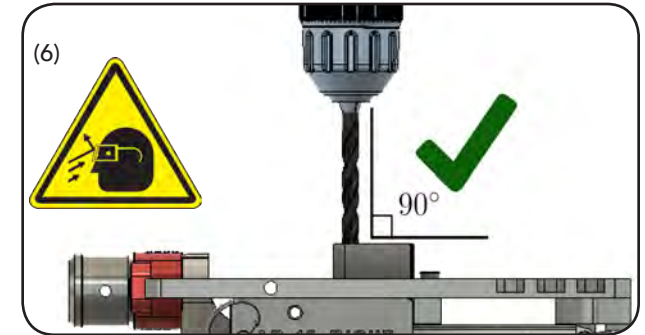
4a • Screw the long fully threaded vice support bolt into the countersunk hole on the side plate **before the side plates have been tightened**. Screw it all the way in until flush with the side plate wall. Bolt should thread easily into second plate. If not, stop, back out bolt, move side plates, and retry. 4b) Align and tighten the jig assembly by setting the jig on its front edge. With the side plates finger tight only, the side plates will rest on the center alignment bar. Press the side plates flush against the center bar and firmly tighten the 4 side plate bolts. Next, while pressing the lower down flush against the center alignment bar, hand tighten the buffer screw fully into the lower. 4c) Insert the hex key through the two holes on the buffer screw. Press the lower down flush against the alignment bar while tightening the buffer screw using the hex key for leverage.



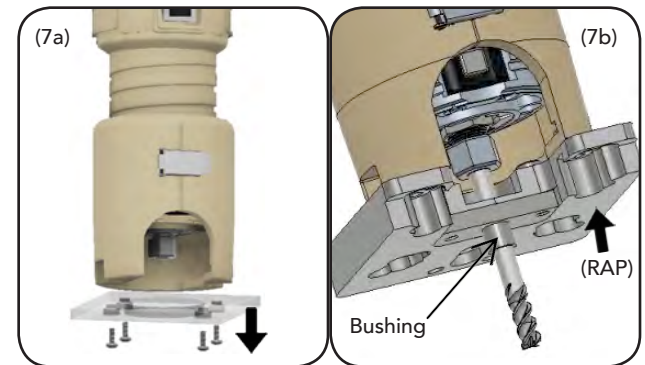
5 • Insert the Drill Block into the jig with the small round pilot hole facing the buffer screw and the oval trigger slot facing the front of the jig. Screw down the drill block using a single 1/2" bolt that goes through the countersunk hole in the drill block tab closest to the oval slot. When fully tightened, this bolt will not be fully flush in the hole.



6 • Before drilling the pilot hole, put on ANSI 87.1 rated safety glasses. Use the bubble level to ensure all work surfaces are level. Secure the jig in a vice and insert a 21/64" jobber length drill bit in a hand drill or drill press. If using a hand drill, take care to drill straight and perpendicular to the jig. Apply oil to the drill bit and drill block hole. Drill a hole completely through the lower drilling at a medium speed to avoid heat buildup. If using a longer drill bit, and a lower with an integrated trigger guard, use care not to drill into the trigger guard. **Remove the drill block and the alignment pin (3d) after drilling the pilot hole. Retighten buffer screw by following the steps in (4c).**



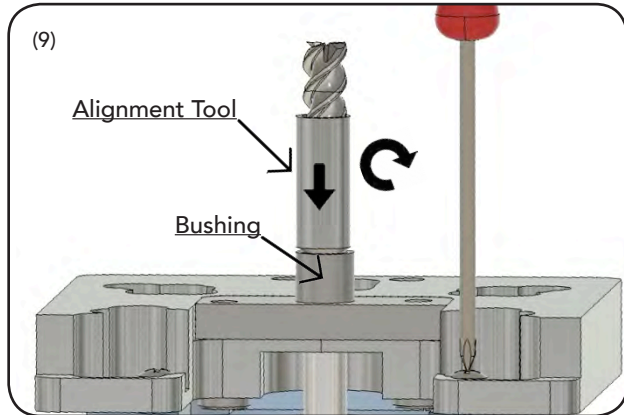
7a • Unplug router to install the Router Attachment Plate (RAP) by first removing the router's sub base which came with the router. 7b) Fully tighten the end mill into the router and slide the RAP over the end mill with the bushing pointed down and the plate cutout facing the front of the router.



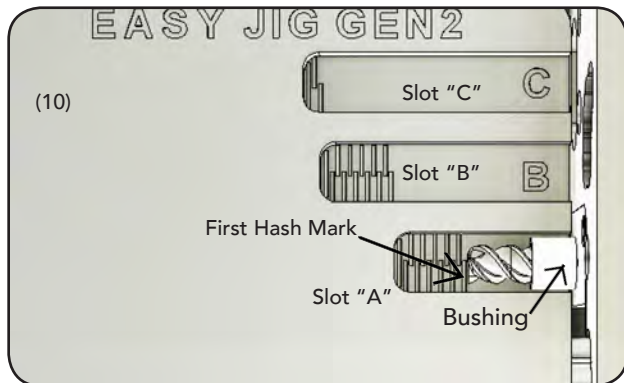
8 • Reuse the router's screws to loosely secure the RAP to the router. Select the holes on the RAP that best match the screw holes on your router. If the router came with tapered screws, replace them with screws that have a flat inner face. Do not tighten the screws at this time.



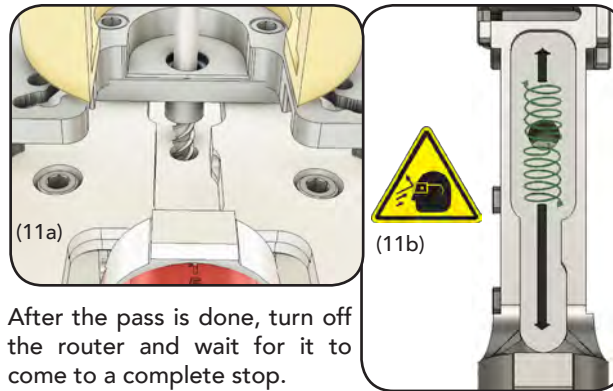
9 • With the router attachment plate loosely screwed onto the router, slide the end mill alignment tool over the end mill, tapered end first. Twist and press the alignment tool down against the bushing. While firmly holding the alignment tool down, tighten the screws to secure the RAP to the router. Remove the alignment tool. The router assembly is now in perfect alignment and ready for use.



10 • With the router being held sideways, insert the bushing fully into slot "A" on the jig plate. Adjust the end mill depth so the tip of the end mill is on the first hash mark.

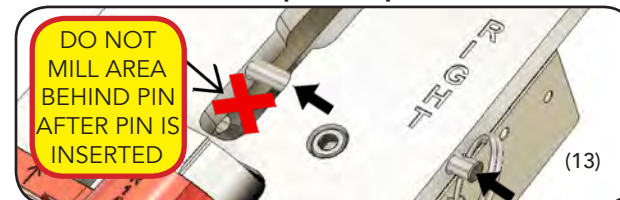


11 • Prior to milling, secure the jig in a vice and put on eye and hearing protection. Hash marks are only a guide. If experiencing chatter, vibration, or extra noise, reduce the depth of the end mill and slow down how fast you move the router. 11a) Spray lubricant on the lower and insert the end mill into the pilot hole. Orient the jig with the buffer end toward you. **Press down firmly** and turn on the router set to 75-100% of full speed. 11b) Slowly move the router in a dime size **clockwise circular pattern** to the front and then to the back of the lower. **Do not mill in a straight line.** After the center area has been milled, finish milling the sides by following the contour of the jig template.



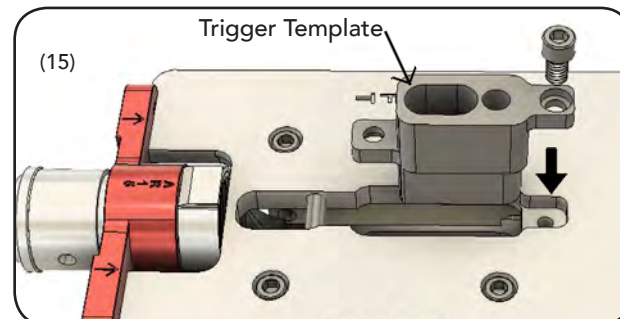
After the pass is done, turn off the router and wait for it to come to a complete stop.

12 • Insert the bushing back into slot "A" and move the end mill to the next hash mark. Repeat the above steps until you have milled out the full depth of slot "A".
13 • Fully Insert the long 1/4" pin through the main jig plate. **This pin prevents further milling of the rear shelf. Do not mill area behind pin once pin has been inserted.**

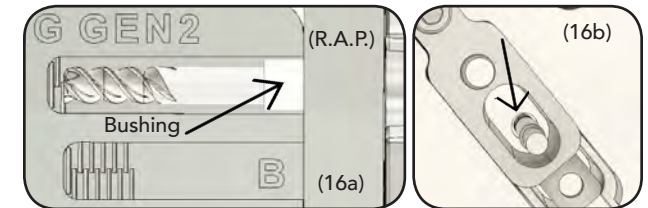


14 • With the router held sideways, insert the bushing fully into slot "B" on the jig plate. Adjust the end mill depth so the tip of the end mill is on the first hash mark. Mill slot "B" following the same process used with slot "A". For slot "B" mill in 1/2 hash mark increments. The last pass for slot "B" should be at the full depth of the slot.

15 • Clear out chips from the jig and lower. Insert the trigger template into the jig with the small round pilot hole facing the front of the jig and the oval trigger slot facing the buffer screw. Screw down the trigger template using a single 1/2" bolt that goes through the countersunk hole in the drill block tab. Note that when fully tightened, this bolt will not be flush in the countersunk hole.

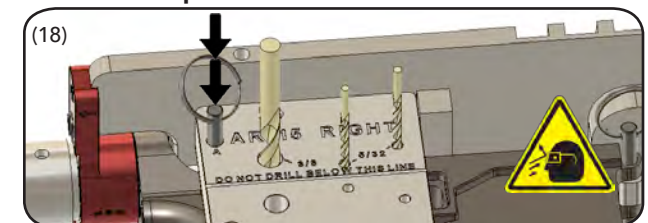


16a • Insert the bushing fully into slot "C" and set the end mill length to the first hash mark. 16b) Insert the end mill into the oval trigger template and through the pilot hole in the lower. Check that the end mill is in the pilot hole by ensuring the router attachment plate is flush against the main jig plate and the router can not rock side to side. **Maintain firm downward pressure** and turn on the router. Mill out the trigger slot by moving the router **slowly in small clockwise circles**. Repeat the same process for the next two hash marks to finish milling the trigger slot.



17 • REMOVE TRIGGER TEMPLATE FROM JIG BEFORE THE NEXT STEP OR YOU WILL DAMAGE THE LOWER.

18 • Turn the jig on its side to drill the holes for the safety selector, trigger, and hammer pins. Clamp vice securely to the front and rear edge of the bottom side plate. If clamping to the jig main plate, **use a block of wood to protect the top surface of the main jig plate from vice or clamp jaw damage.** Remove the pin from jig main plate and insert the pin through the "A" alignment hole. Tighten the buffer screw while pressing the lower down flush against alignment bar. Drill the 3/8" safety selector pin hole and the 5/32" trigger and hammer pin holes through the right wall only. **Do not drill all the way through from one side plate to the other side plate.** Flip over the jig and drill the same holes for the left wall. **Do not start the drill until the drill bit is all the way through the side plate and the tip of the drill bit is touching the lower. Do not press down too hard on the drill or drill press. Use medium speed. Do not use a cordless hand drill.**



19 • Unscrew the long bolt from the side plates. Remove the front quick release pin. Unscrew the buffer screw. Remove the lower from the jig. Poke a paper clip through the safety selector detent hole to clear out any chips inside. **IMPORTANT: Read the full user manual, warnings, and notices before using this product. Specific router set up information may be needed from the user manual.**