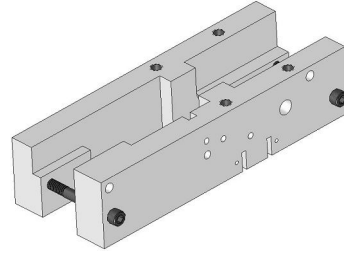
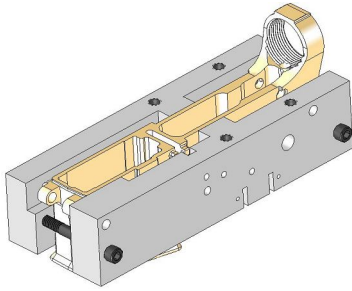


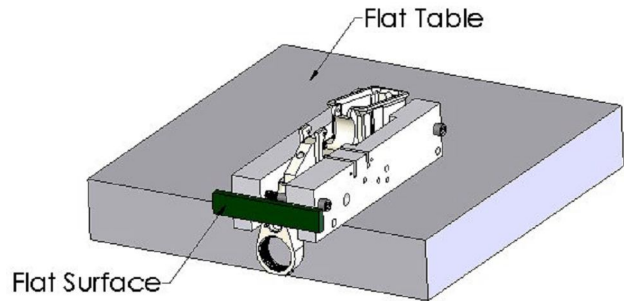
# AR-15 Setup Blocks / Drill Fixture Jig

- Quick start guide -



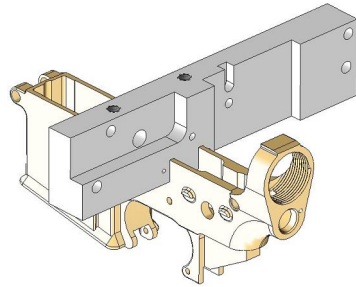
## Setup for side holes:

Place the blocks on both sides of the receiver and loosely tighten the two bolts. Put the assembly upside down on the edge of a flat table and use another flat surface to make sure the back of the receiver is coincident with the back surface of the blocks (this is for location purposes) **These two location surfaces must be to finish specs before use.** Then simply tighten the bolts and you are ready to drill the side holes.



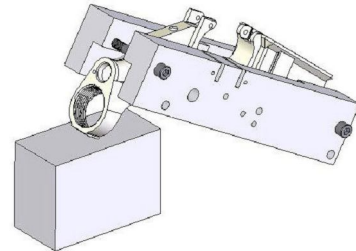
## Setup for bolt catch hole:

Simply slide the ~block with the slots~ over the receiver and clamp them together with a C-clamp and you are ready to drill the bolt catch hole.



## Setup for pistol grip hole:

Slide the pistol grip on the receiver to mark where the hole should be drilled. Then place a 2½" piece of wood under the receiver as shown (this will make the pistol grip plane horizontal). Now you're ready to drill the pistol grip hole.



Although I've had great success using these blocks, they come with no warranties or guarantees. I am in no way responsible for what is done with these blocks or what they are used to make. NOTICE: All products and photos contained herein are the property of JWH Enterprises, and are copyrighted and/or trademarked. The copying of these images and/or reproduction of my products in any form is strictly prohibited without my written consent. All violators will be charged to the fullest extent of US Copyright and Trademark laws.

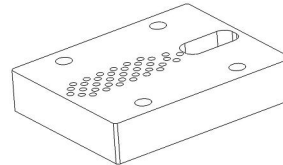
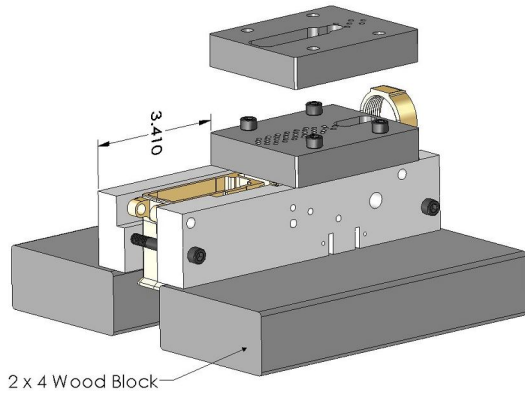
Be sure to check out the tutorial on my website [www.cncguns.com](http://www.cncguns.com)

Thanks and good luck – [justin@cncguns.com](mailto:justin@cncguns.com)

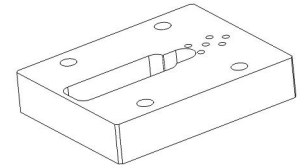
*A well-regulated militia being necessary to the security of a free state, the right of the people to keep and bear arms shall not be infringed.*

- Optional -

# AR-15 Setup Blocks / Milling jig Adapter



Drilling Adapter Plate



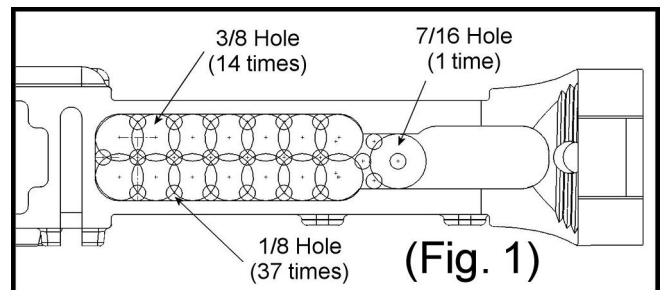
Milling Adapter Plate

## Setup drilling adapter plate:

Follow the previous steps for setting up the AR15 lower receiver in the drilling jig. Then bolt the drilling adapter plate to top of drill jig. Insure the distance from the front of the drilling jig to the front of the adapter plate is 3.410 and also make sure the adapter is centered on top of the drilling jig.

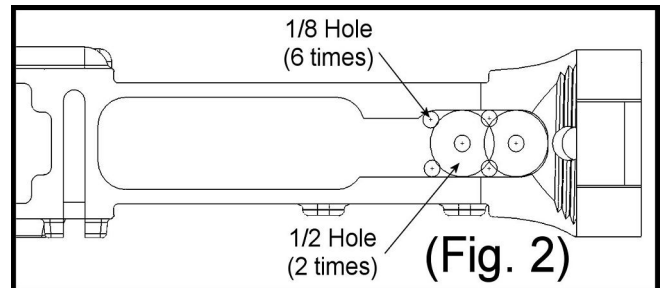
## Drill holes in fire control area:

Drill the (37) 1/8 diameter holes to a depth of 1.249 from the top surface of the receiver. Remove the drilling adapter plate and drill the (14) 3/8 diameter holes and the (1) 7/16 hole to the same depth. See (Fig. 1)



## Setup milling adapter plate:

Bolt the milling adapter plate to the top of the drill jig. Again, insure the distance from the front of the drilling jig to the front of the adapter plate is 3.410 and the adapter plate is centered on top of the jig.



## Mill fire control area pocket:

With a 3/8 carbide endmill secured in the drill chuck, plunge the endmill into the pocket of the milling adapter to a depth of approximately 0.025". While holding the drill jig tight with your hands, move the jig into the endmill until the edge of the endmill touches the edge of the pocket. Let the endmill cut the entire perimeter of the pocket and then plunge the endmill another 0.025" and repeat the procedure until you reach a depth of 1.249 from the top surface of the lower.

## Fire control area shelf: (optional)

If the fire control area shelf needs to be milled out, bolt the milling adapter plate on the drill jig as described before and drill the (6) 1/8 diameter holes 0.630 deep. Remove the adapter plate and drill the (2) 1/2 diameter holes to the same depth. Attach the drilling adapter plate like before and use a 3/8 carbide endmill to mill the pocket out at 0.025" steps to a depth of 0.630. See (Fig. 2)

For more detailed information, reference the tutorial on my website [www.cncguns.com](http://www.cncguns.com)

## -- NOTICE --

*Cutting tools are dangerous. Always wear proper protection when using drills and endmills. The method described above has been proven to work. I am not responsible for any accidents resulting from the misuse of these tools.*

