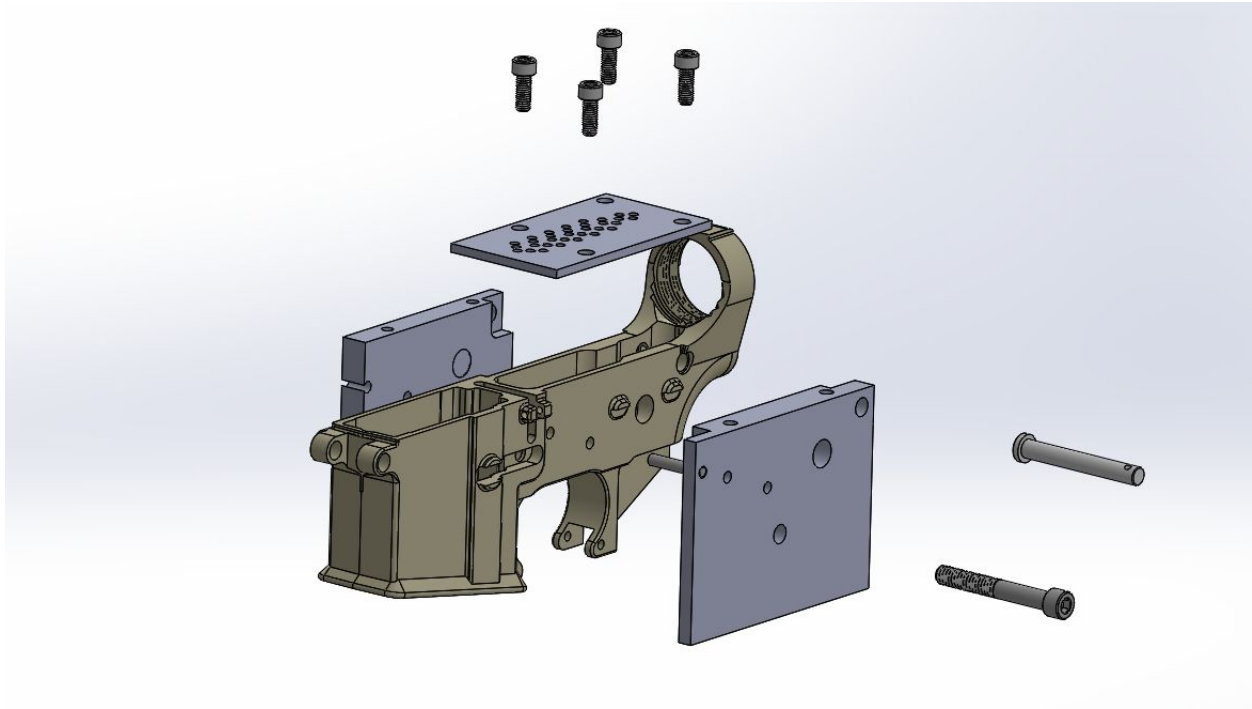
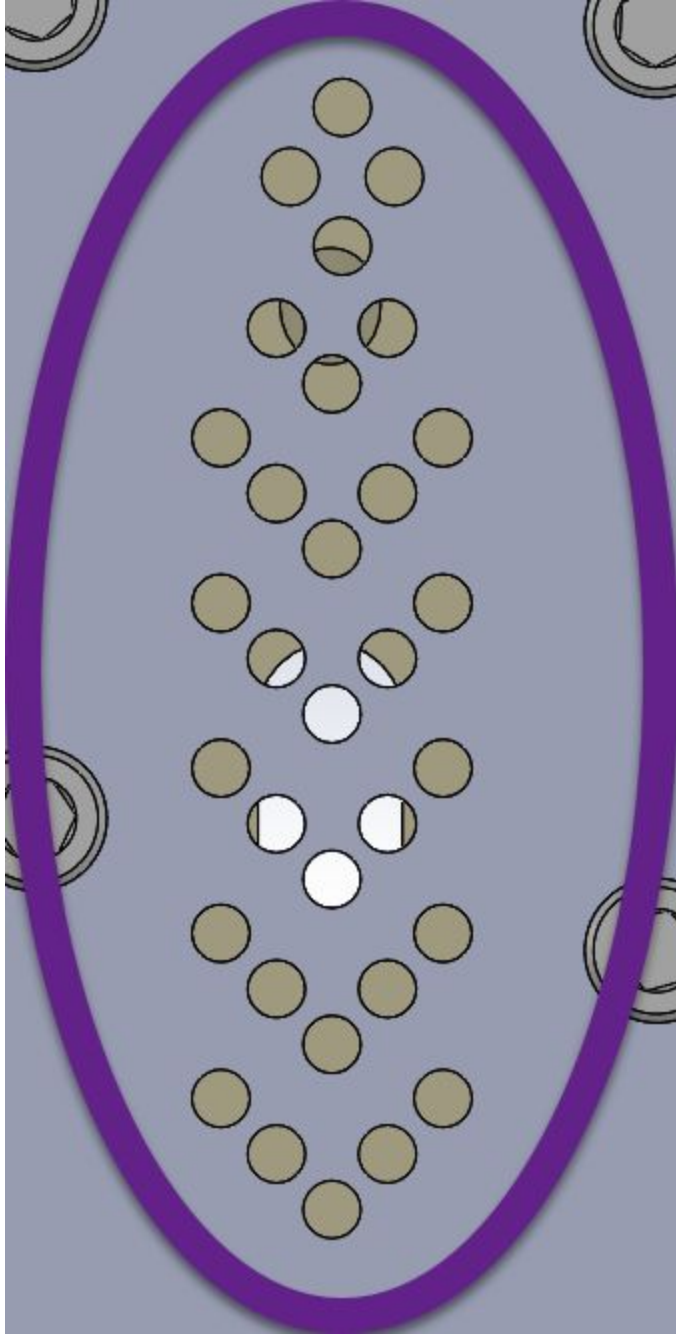


F5 MFG 80% Jig Instructions

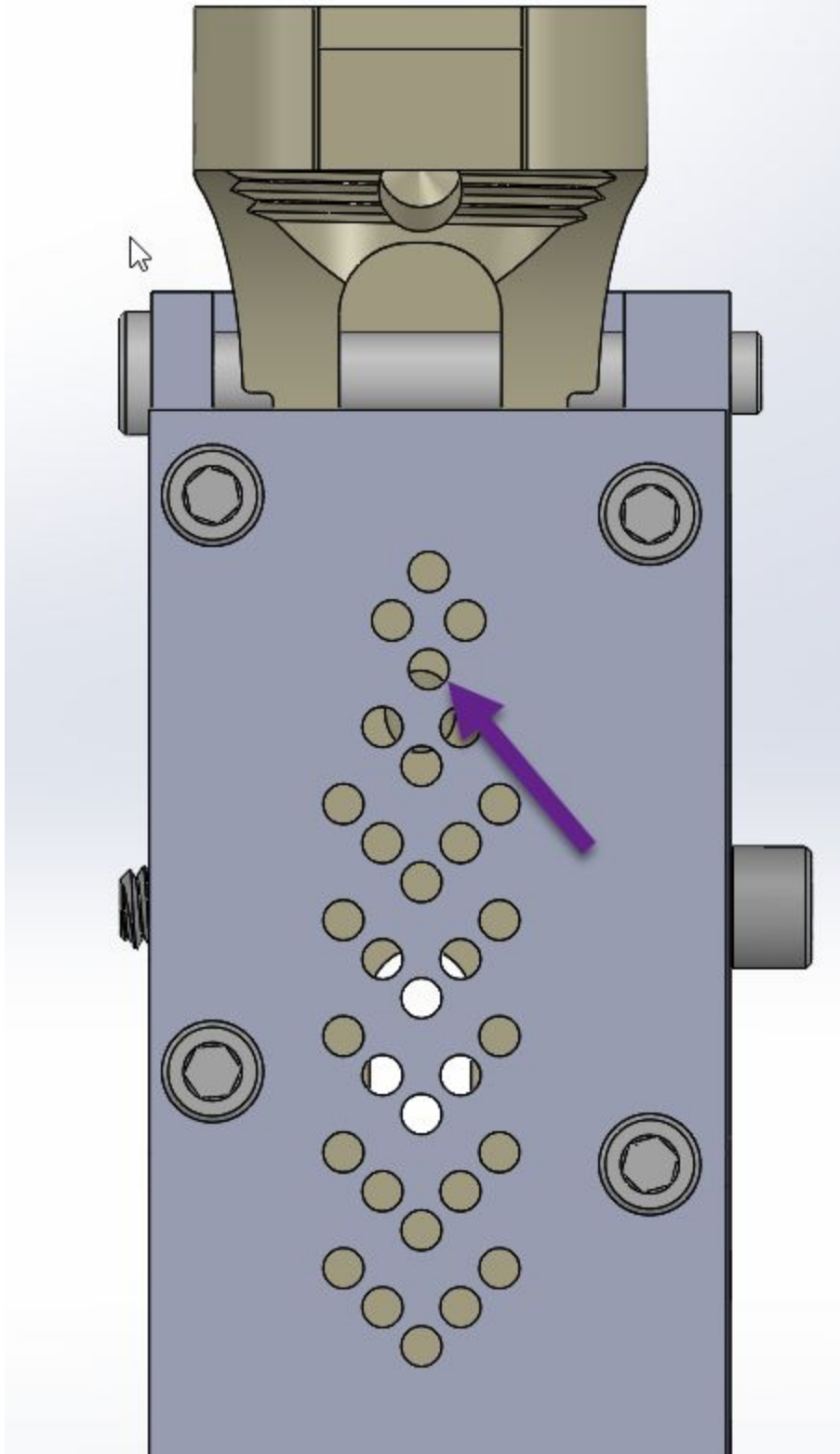
Assemble the two small side plates, and smaller steel plate with many holes, using screws as shown.



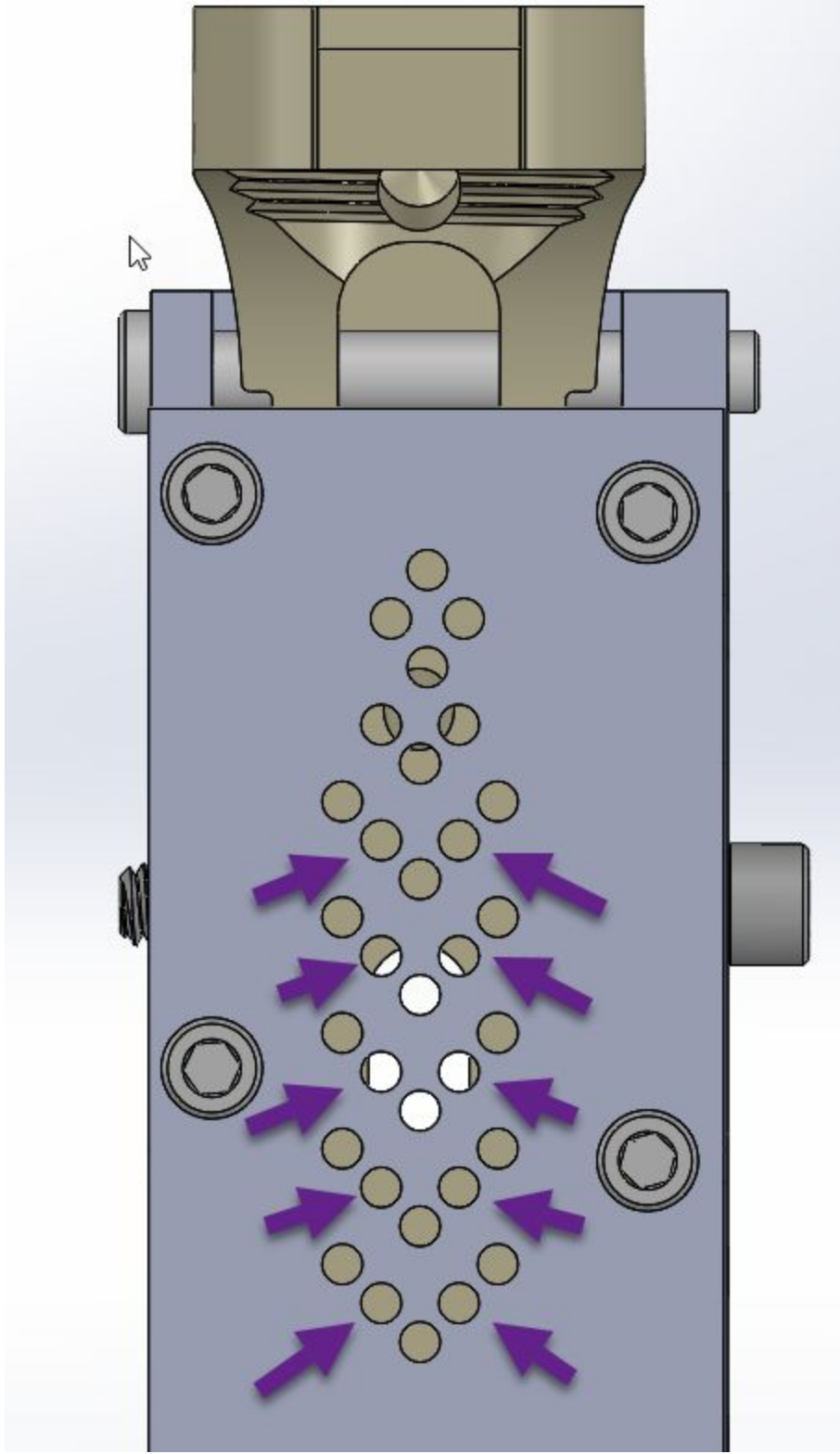
Using the $\frac{1}{8}$ " Drill Bit, drill all top holes to a depth of 1.36", make sure to use a lubricant and ensure that the drill comes out multiple times from each hole to help clear chips.



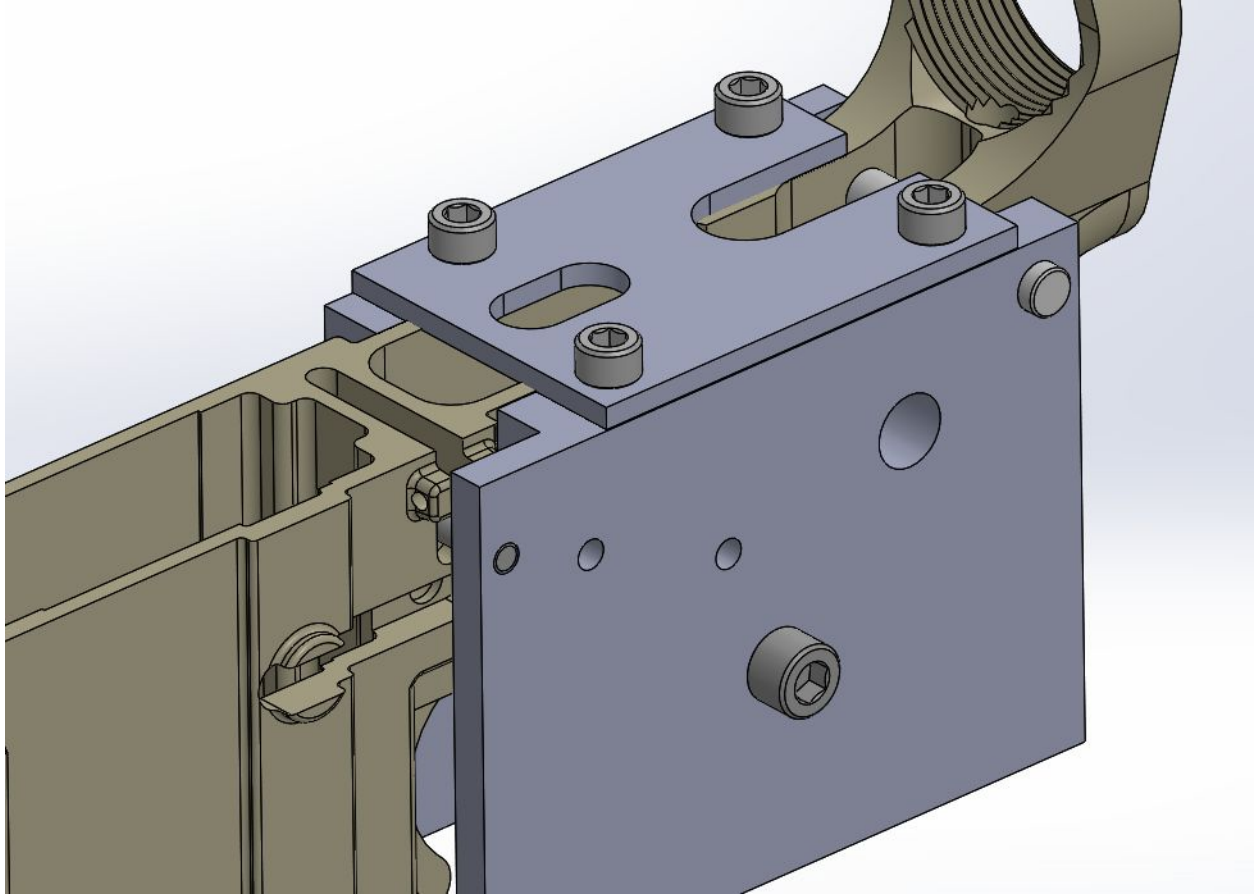
Using the 7/16" Bit, drill the following hole to a depth of 1.249" (make sure to set the drill stop to the proper dimensions)



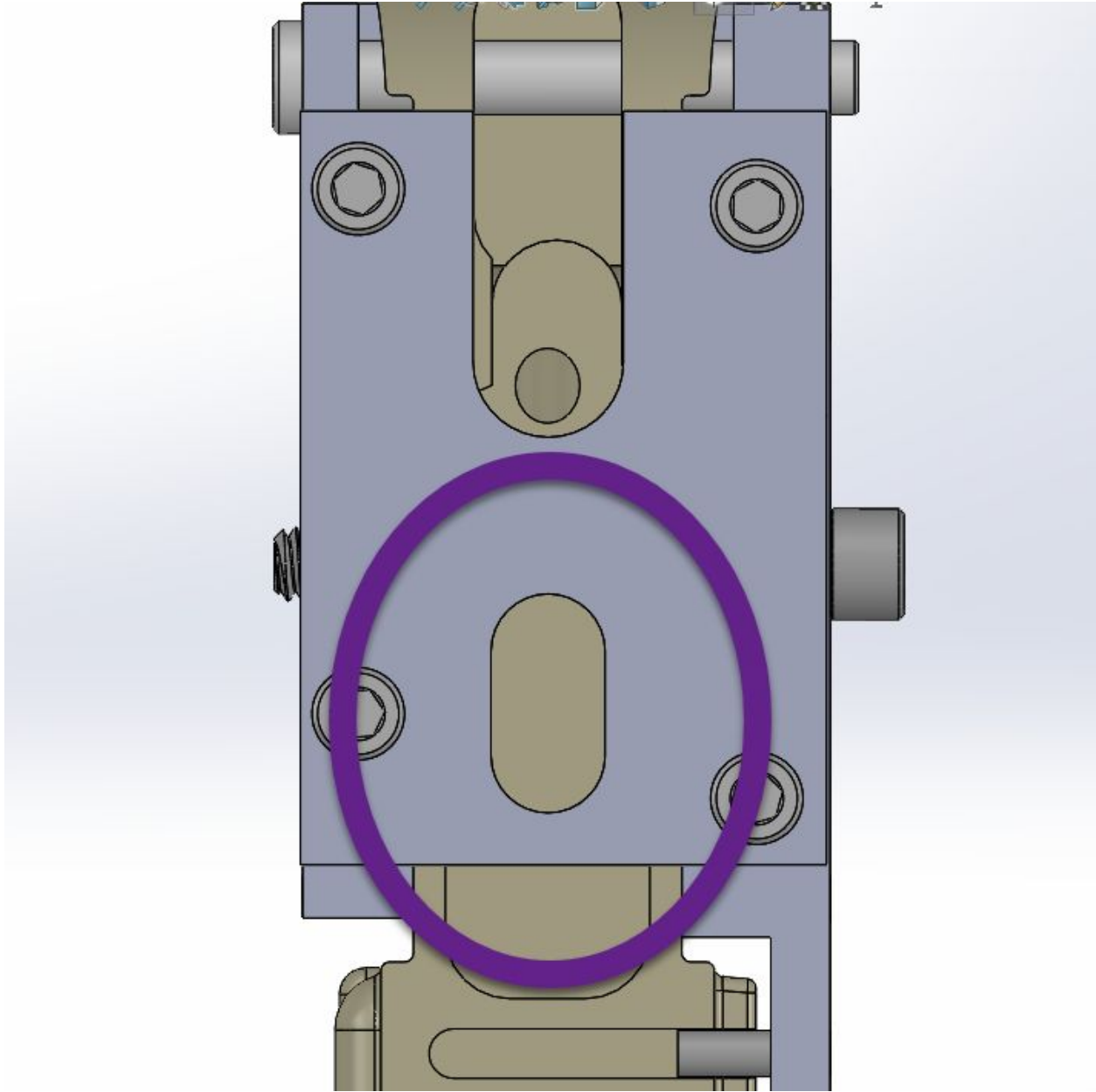
Next, using the $\frac{3}{8}$ " Bit, drill the following holes to a depth of 1.249" (make sure to set the drill stop to the proper dimensions), make sure to drill the correct sequence of holes.



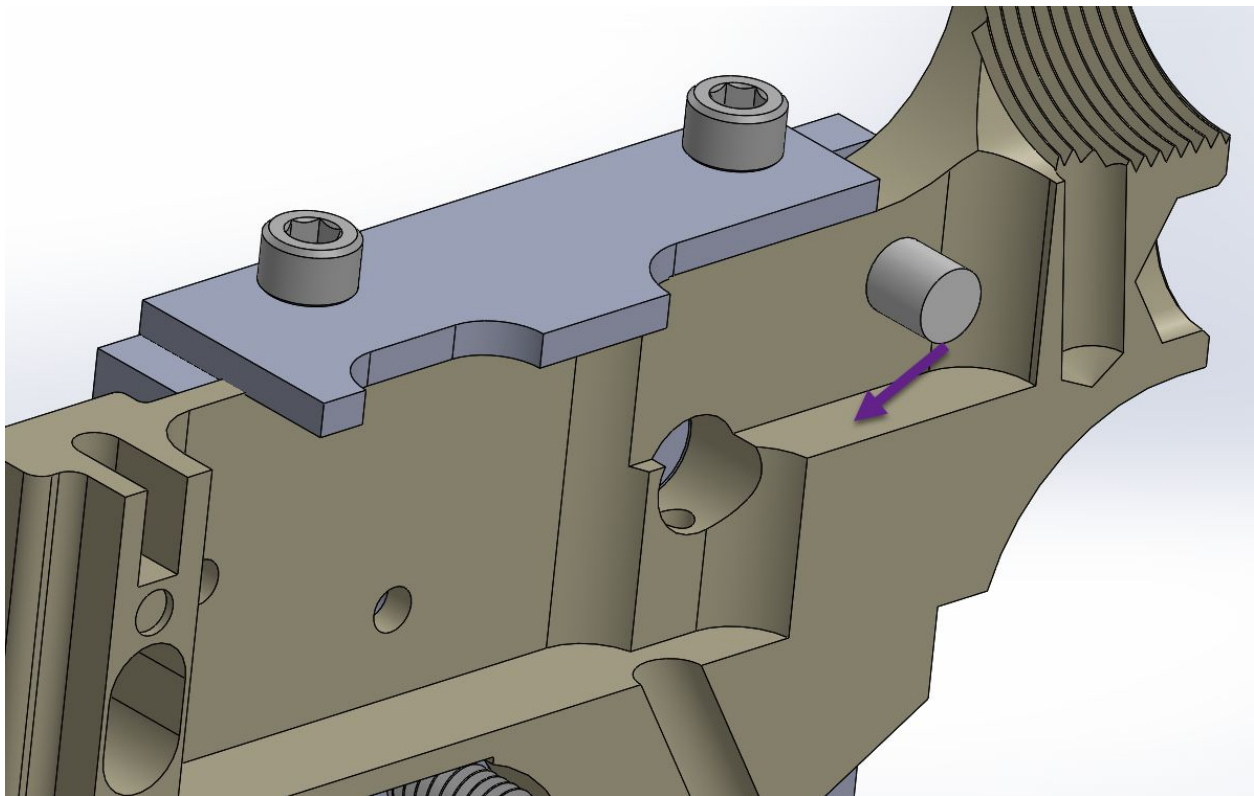
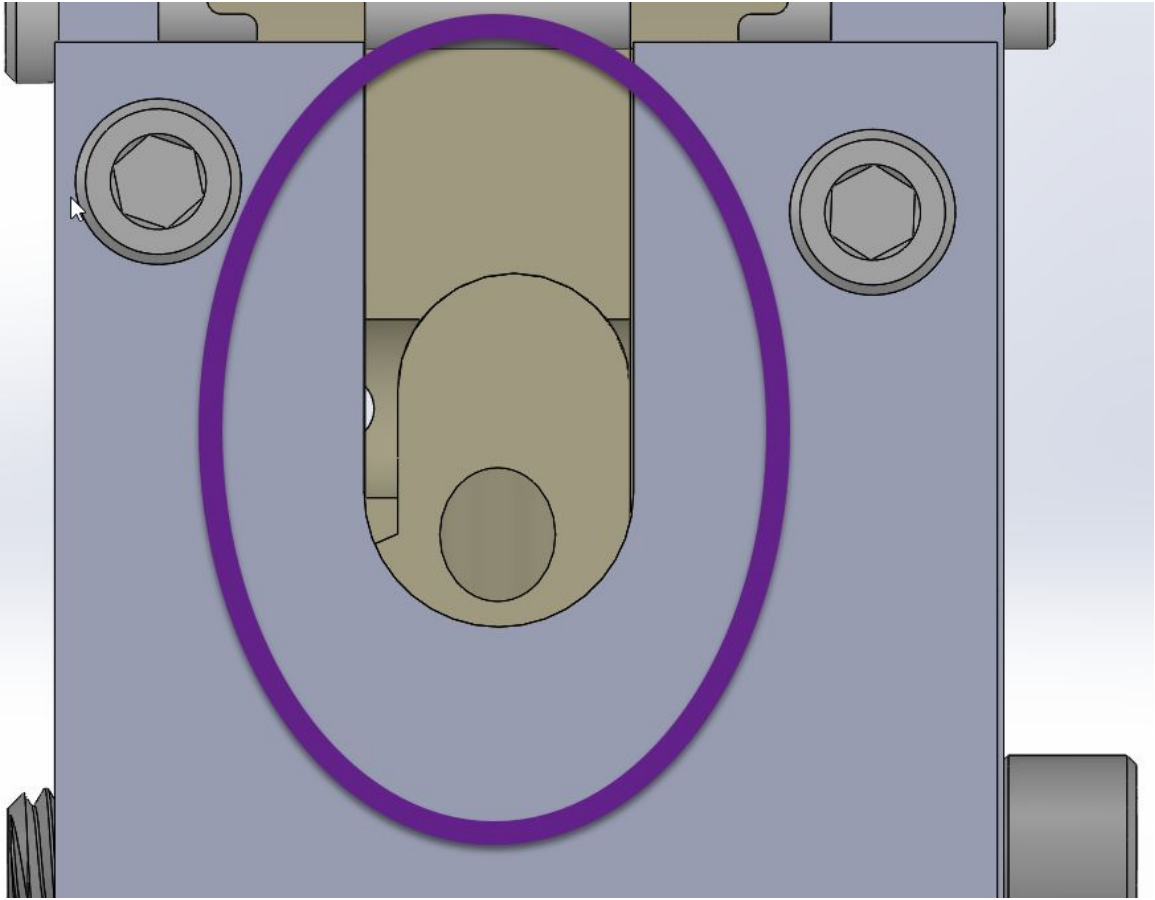
Bolt on trigger pocket milling guide (as shown)



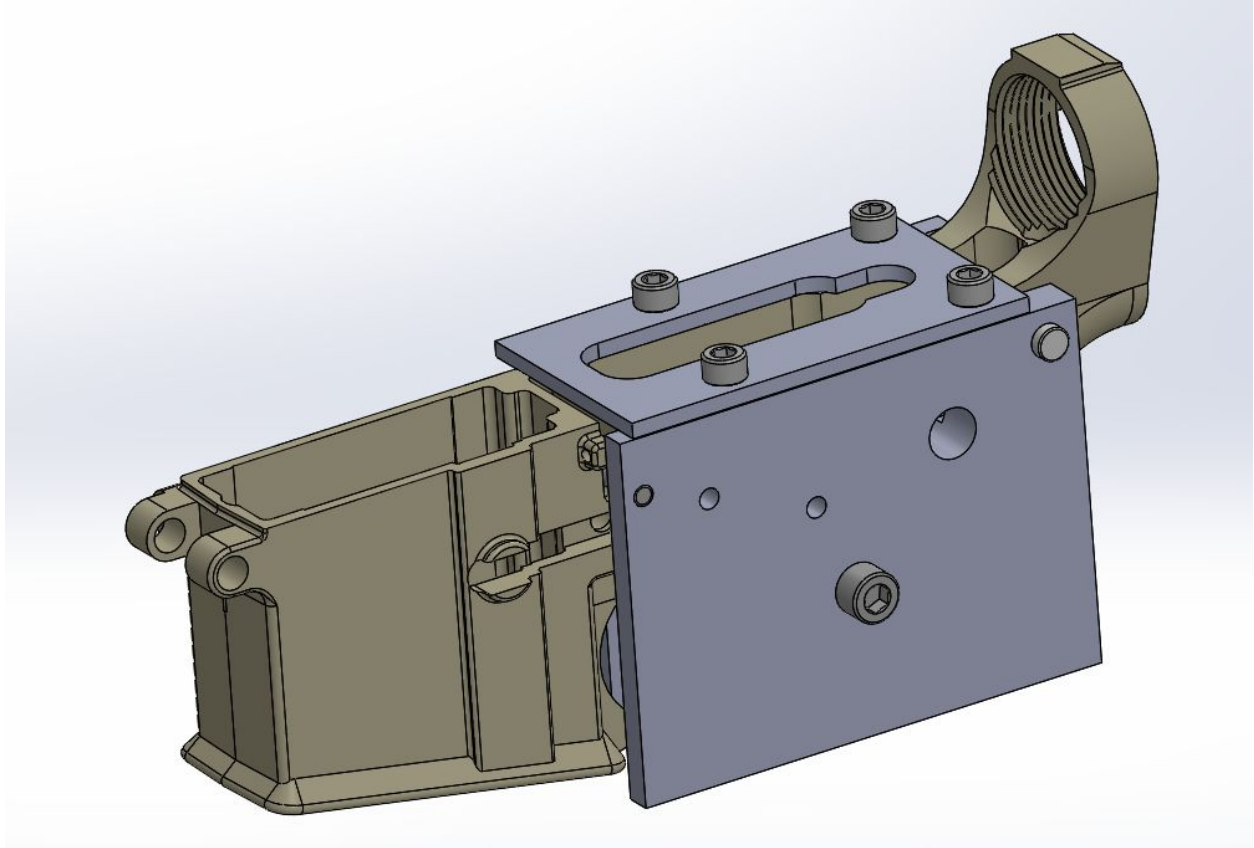
Using the $\frac{3}{8}$ " Drill bit, drill the trigger pocket completely through and clear out the pocket to match the profile of the guide.

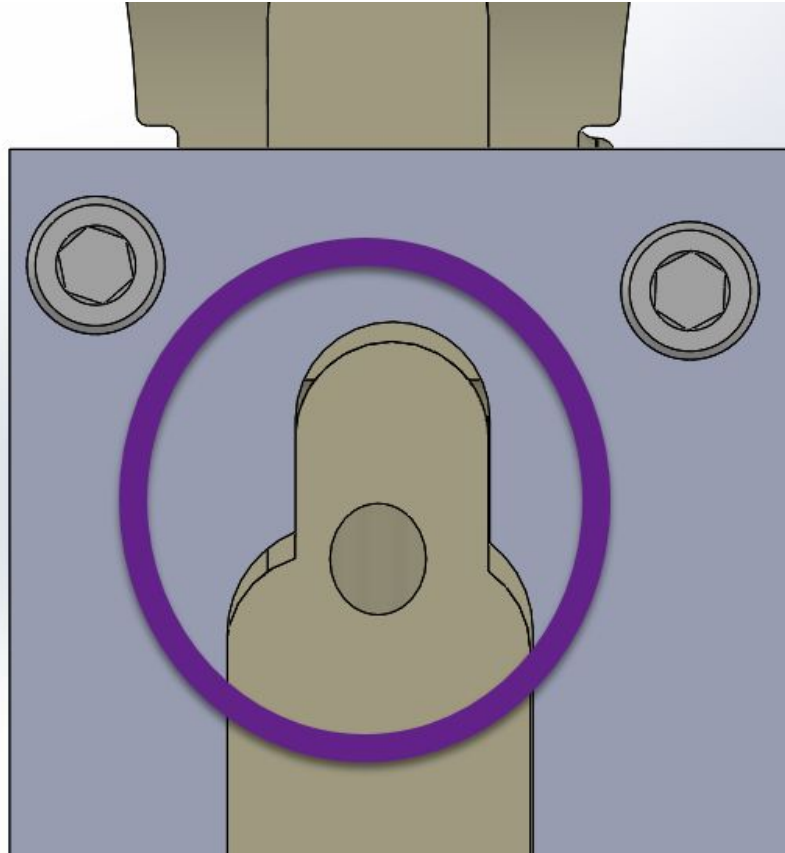


Using the supplied $\frac{3}{8}$ " Endmill, mill out this pocket shown to the bottom of the pre milled pocket. Use the $\frac{3}{8}$ " drill stop on the endmill, and take cuts of approximately .125" per milling, and go slow using lubricant. Do not go any lower than this face.



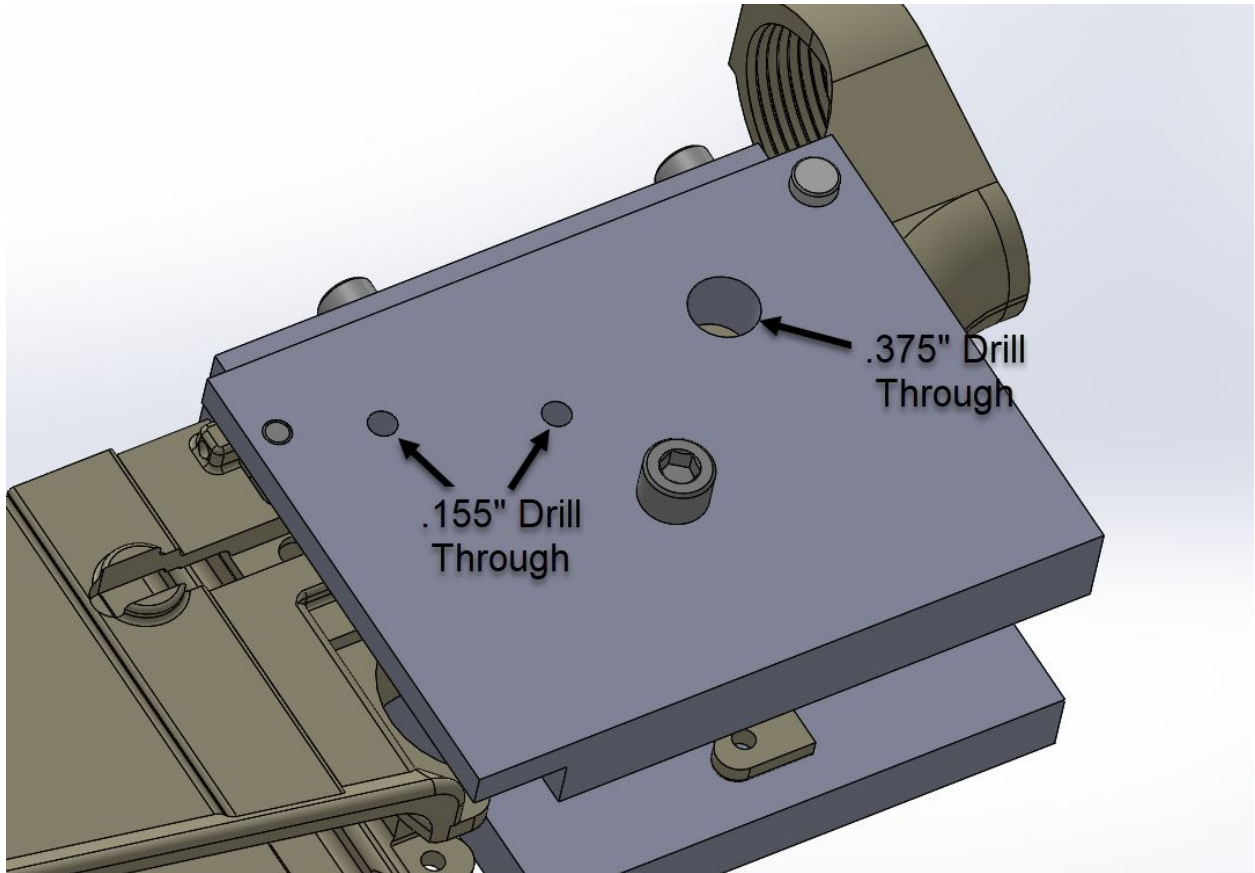
Install the final guide, and using the $\frac{3}{8}$ " endmill, finish this area of the lower to a depth of 1.36", taking .125" cuts and moving slowly without too much sideways pressure, let the endmill do the work.



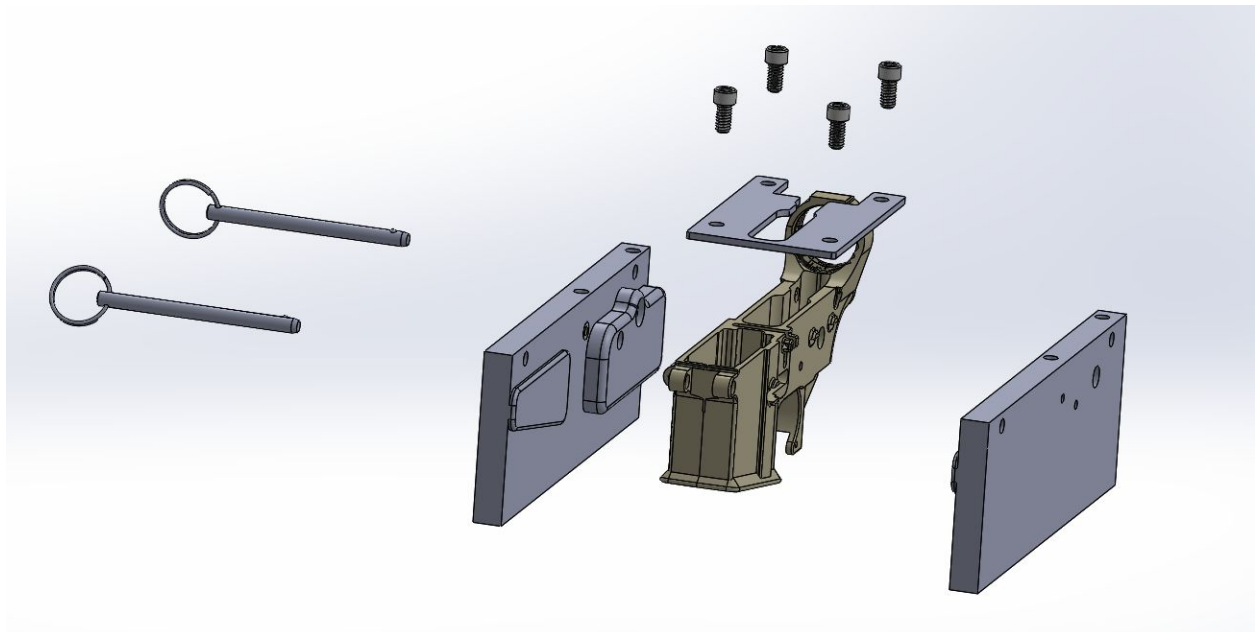


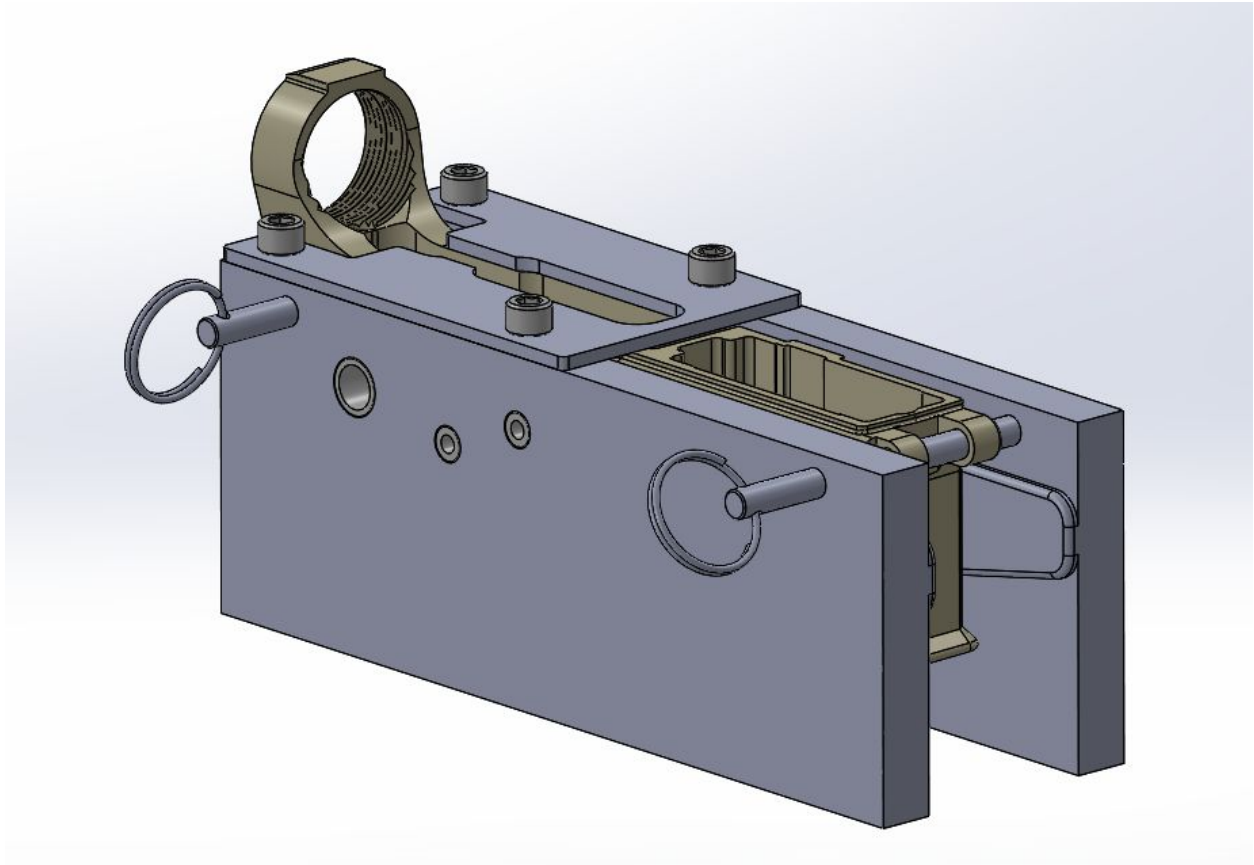
At this point, a choice needs to be made. This jig can be used with the last guide, and the user can use a file to finish the insides of the Receiver. If the user wants a smoother finish, please proceed to the next section (large plates). If the user would prefer to finish with a file, keep the final plate installed.

Using the .155" and .375" drills, drill all the way through the shown holes. Clean up any burrs you see and test fit all lower receiver parts.

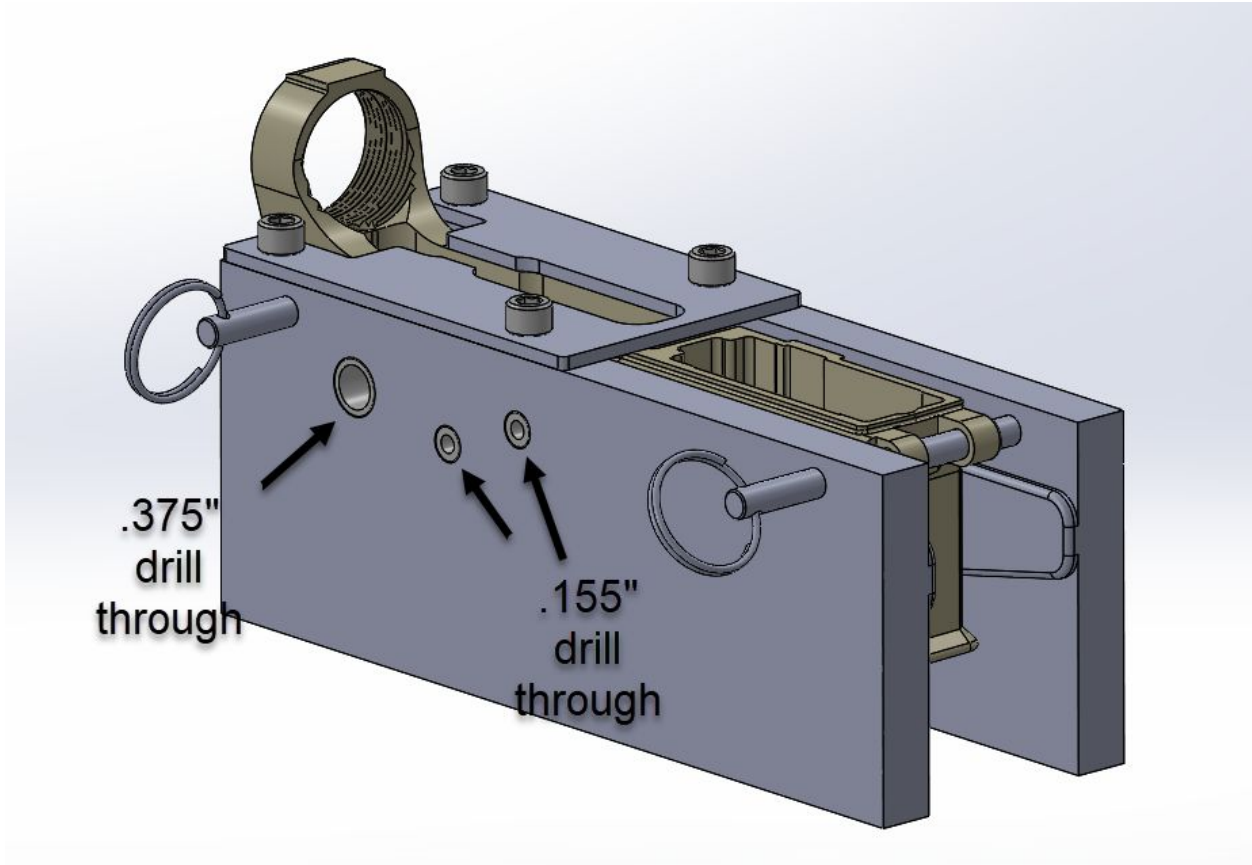


If you plan on finishing the internal walls with the supplied endmill, place the lower in the large side plates as shown with the steel plate that matches up with the holes in the top.

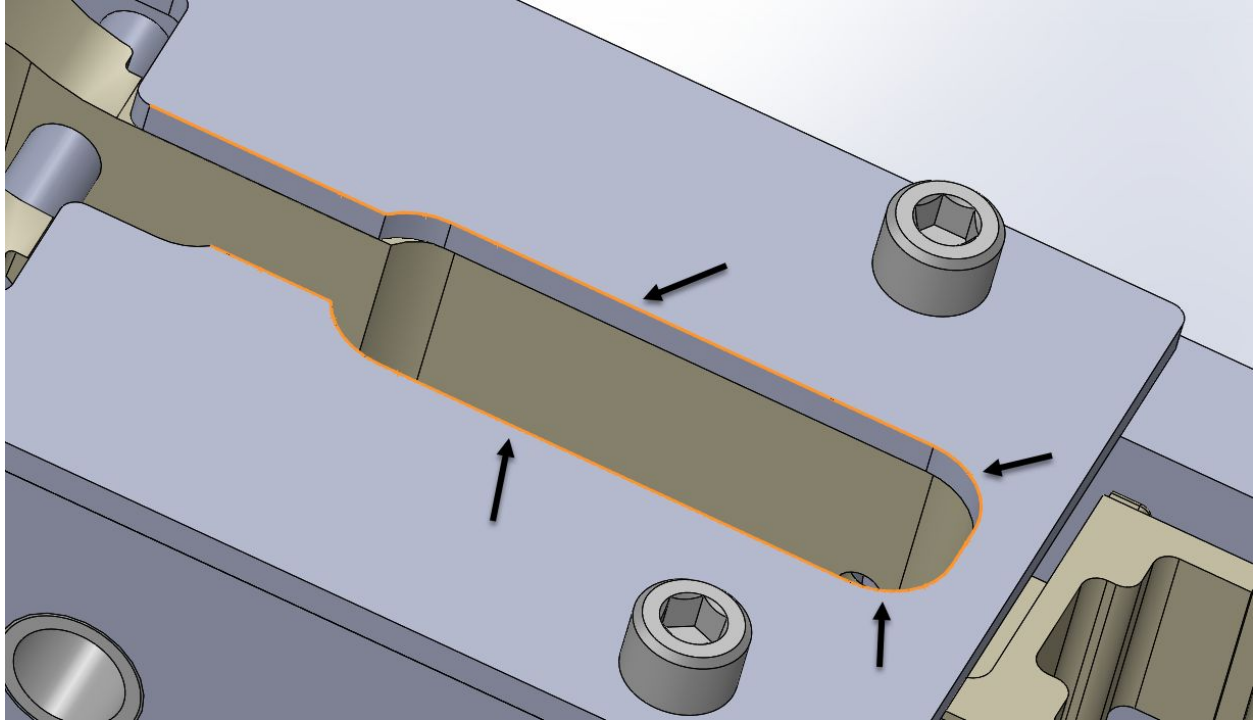




Using the $\frac{3}{8}$ " and .155 drill bits, drill from the side with the drill bushings for best longevity of your 80% Jig



Using the $\frac{3}{8}$ " endmill, and taking small cuts at .125" per "perimeter", follow the highlighted perimeter down to 1.36" from the steel guide.



Clean up any burrs that you see, and your 80% lower should be ready for assembling the lower parts kit.