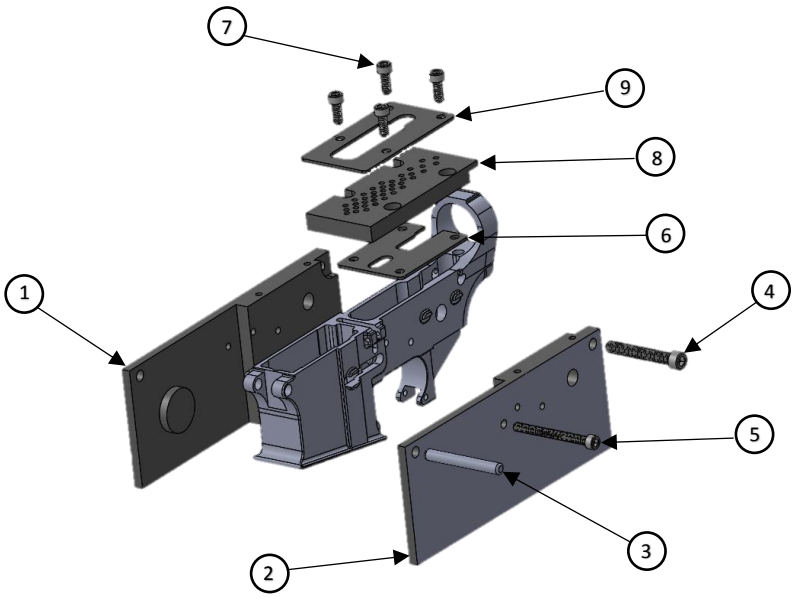
ANDERSON MANUFACTURING 80% LOWER RECEIVER JIG

-SUGGESTED METHOD-

Please begin by reviewing the assembly drawing below and identifying each of the components included in the kit. This document is intended to give general guidelines on completing the Anderson Rifles 80% lower receiver. Always use proper personal protective equipment and machine tool safety practices when working to complete the lower receiver. Anderson Manufacturing is not responsible for machining errors or injuries incurred during the completion of the 80% lower receiver. Read the complete document before proceeding.



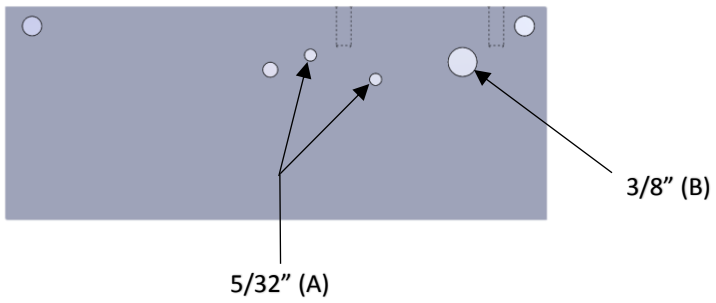
Item #	Description	Quantity
1	Fixture Plate # 1	1
2	Fixture Plate # 2	1
3	1/4” Pin	1
4	1/4”-20 SHCS 1-3/4" Length	1
5	10-32 SHCS 2" Length	1
6	Template # 1	1
7	10-24 SHCS 1/2" Length	4
8	Drill Plate	1
9	Template # 2	1
10	1/8", 5/32", 5/16", 3/8" Drill Bits	4
11	3/8" Flat End Mill	1

Step #1: Assemble the fixture as shown above using Fixture Plate #1, Fixture Plate #2, and the provided hardware (Items 3, 4, and 5)

Note: Be sure to use a cutting oil or light lubricant when drilling

- Before drilling any holes, make sure the fixture is square and level in your vise. Drill 5/32” holes (A) for hammer/trigger pins and 3/8” holes (B) for safety selector on each of the fixture sides (Do not drill all the way through both sides in one step. It is recommended to drill all holes on one side, then flip the fixture over and repeat the same step making it a total of 6 individually drilled holes)

<u>(Fixture Plate #2)</u>



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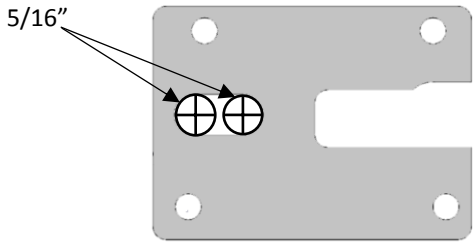
Step #2: Install Template 1 as shown in the picture on the previous page using provided screws. (Only one template bolts to the top at a time.)

- Drill two 5/16” thru holes (one on each end of the trigger hole slot shown below). Don’t worry about the remaining material between the two holes, this can be removed in a later step using a file, rotary tool, or die grinder.

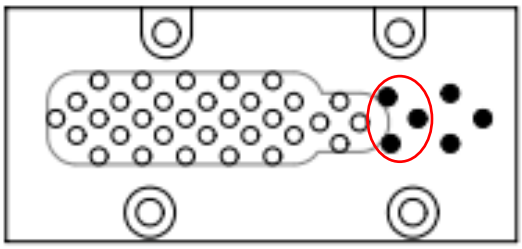
(Template # 1)



Step #3: Remove Template 1 and replace with the Drill Plate.

- Drill 38 holes with the 1/8” drill provided to a depth of .25”. If using a drill with a depth set, be sure to take the drill plate height into account. (**Do not attempt** to drill the last three shaded holes when using an Anderson 80 percent lower receiver as this step has already been complete and may result in damage to the fixture bolt or drill bit)
- Remove the drill plate, drill the holes within the outlined area to a depth of 1.25” using the 1/8” drill.
- Only drill the three left-most shaded holes in the red circle to a depth of .630”, these holes will need to be squared off, with a file or rotary tool, after the pocket has been completely cut out when using an Anderson 80 percent lower. (The remaining shaded holes may be required for other 80 percent lowers. If so the jig screw will have to be removed from the fixture plates and all 6 shaded holes will be drilled)

(Drill Plate)



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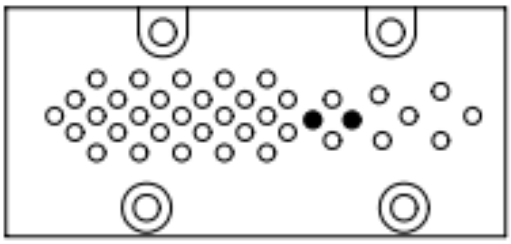
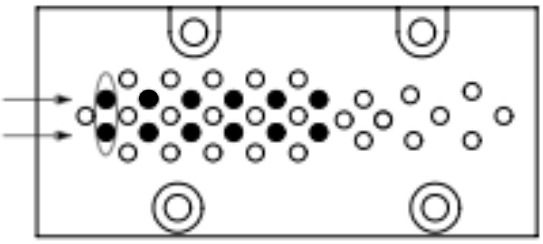
Step #4: Remove Drill Plate (Note: Drill Plate #3 is removed from the fixture- the image below is for reference to the 1/8" pre-drilled holes that are now in your 80% lower receiver)

- **A.)** Drill the 2 holes shown below to 3/8" 1.25", (or preferably 7/16" - not included) -**It is highly recommended** to step up drill sizes when drilling to final size. (use 5/32,5/16, and then 3/8)

- **B.)** After the holes in step 2A are completed to final size and depth, continue by following the same process (stepping up drill sizes) on the 12 shaded holes identified below working from left to right. (Take your time when drilling)



Step 4A

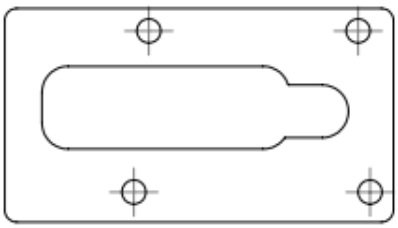


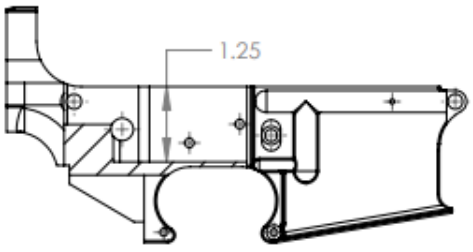
Step 4B

Step #5: Install Template #2

- Use this template to help guide removing the scallops that remain from the previous drilling process. Remove excess material from floor of pocket created by drill taper to 1.250". Using the 3/8" flat end mill in your drill press (high RPM setting) plunge to a depth of 1.25" and flatten the pocket face. (For your safety, **DO NOT** attempt to use the flat end mill in a hand drill. Do not attempt to use template #2 as a cutting guide for the end mill as the cutting edge can damage the template, the tool and the lower receiver) Reposition part in vise or reposition vise and plunge to specified 1.25" depth. Repeat this process until the pocket face is flat within the template.

<u>(Template # 2)</u>





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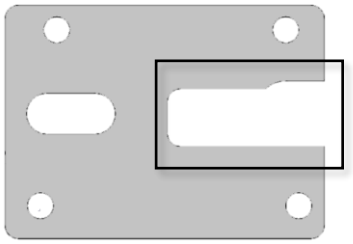
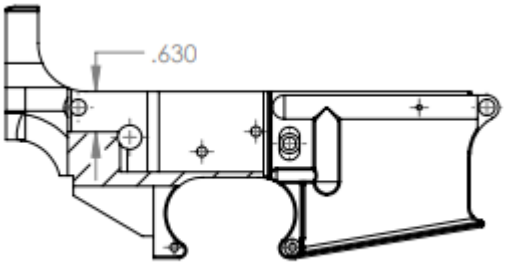
Step #6: Reinstall Template #1

- Using the same technique as in step 5, remove any metal scallops created by the drilling process on the pocket face by plunging to a depth of .630". Reposition vise or part and repeat until the second upper pocket is flat within the template. Custom fitting may be required for the rear lug pocket to allow an upper receiver to be attached, depending on the upper manufacturer.





Step #7: Disassemble the fixture and inspect your work. Using files or rotary tooling, remove any metal burrs and minor excess material. Sanding or polishing of holes may be required for fit, depending on the lower parts you decide to use. While assembling the components into the lower receiver ensure the components move freely and as expected without excessive tolerances. Ensure that the fire control group and safety selector function properly. Thoroughly test your firearm in a safe location after assembly. (Below are examples of how the fire control pocket and rear takedown lug pocket should appear when complete.)