



INSTRUCTIONS V1.2

PARTS & TOOLS



PARTS

- A.... Guide Plate
- B. .. Router Adapter
- C. .. (4) Router Adapter Screws
- D ... Router Adapter Side Block
- E.... (2) Router Side Block Screws
- F.... Left Side Plate
- G ... Right Side Plate
- H ... AR-15/AR-9 Buffer Plate
- I..... 308/AR-10 Buffer Plate

- J.... AR-15/AR-9 Takedown Adapter
- K308/AR-10 Takedown Adapter
- L.... AR-15/AR-9 Takedown Pin
- M....308/AR-10 Takedown Pin
- N ... Drill Guide
- 0...Buffer Adapter
- P.... (14) Jig Screws
- Q...Guide Pin Set

TOOLS NEEDED

- 1. Router
- 2. Drill
- 3. 5D Tactical ReadyMILL™
- 4. 3/8" Drill Bit
- 5. 21/64" Drill Bit
- 6. 5/32" Drill Bit
- 7. Vise
- 8. Shop Vac or Compressed Air
- 9. #2 Phillips Screwdriver
- 10. 7/64" Allen Wrench
- 11. Eye Protection
- 12. Ear Protection
- 13. WD-40 or Cutting Fluid

Thank you for your Router Jig Pro purchase. At 5D Tactical, we understand you have chosen to spend your hard earned money with us, and because of that, we strive for 100% customer satisfaction. Your Router Jig Pro carries a LIFETIME WARRANTY against manufacturer's defects. Please contact us by phone at 508-834-4223 or email sales@5DTactical.com with any questions or concerns regarding the use of your Router Jig Pro. *Replacement parts and a selection of 80% lowers are available for purchase on our website, 5DTactical.com.*

PART 1: JIG ASSEMBLY

1-1 Clean surface of the 80% receiver and apply masking tape to the sides.
1-2 Apply the Buffer Plate to the back of the receiver as shown. Use grey Buffer Plate for AR-15/AR-9 receivers and black Buffer Plate for .308/AB-10 receivers.



1-3 Loosely thread the Buffer Adapter into the receiver until the Buffer Plate is pressed against the back of the receiver.

1-4 Loosely install the Takedown Adapter to the Guide Plate using (2) Jig Screws. Use grey Takedown Adapter for AR-15/AR-9 receivers and black Takedown Adapter for .308/AR-10 receivers.





1-5 Align the receiver with the Takedown Adapter, pass the Takedown Pin through the receiver and adapter. Use the correct Takedown Pin for the receiver.







1-6 Align the Buffer Plate with the holes in the rear of the Guide Plate. Loosely install (2) Jig Screws.



AR-15/AR-9



.308/AR-10

1–7 While grasping Guide Plate, tighten (4) Jig screws, securing Buffer Plate and Takedown Adapter.

1-8 Orient Side Plates, observing Left and Right with flat sides facing out. Set Guide Plate and receiver assembly atop Side Plates. Loosely thread (8) Jig Screws and then tighten.



1-9 While grasping Guide Plate, pass Phillips screwdriver through the hole in the Buffer Adapter, and tighten. Periodically check for tightness during jig use.



1–10 Install the Drill Guide as shown. Loosely insert (2) Jig Screws, then tighten.



1-11 Clamp Jig Assembly securely in a vise as shown by the notches provided in the Side Plates. DO NOT CLAMP JIG BY OUTSIDE OF SIDE PLATES. DAMAGE WILL OCCUR. REVIEW IMAGES CAREFULLY.



PART 2: DRILLING STEP 1

2-1 Spray WD-40 into Drill Guide hole and insert 21/64" drill bit. Do not start the drill until the bit is fully inserted. Using care to keep the drill bit straight and perpendicular to the receiver, begin drilling. Periodically pull the drill bit out of the Guide to clear chips. Apply WD-40 liberally. Drill until the bit exits the bottom of the receiver.



-2 Uninstall the Drill Guide by removing the (2) Jig Screws.



PART 3: MILLING STEP 1

GO TO APPENDIX A FOR ROUTER ADAPTER INSTALLATION INSTRUCTIONS

GENERAL NOTES ON MILLING - READ ENTIRELY:

- The provided depth gauge hash marks denote the maximum depth of cut per pass. *BEGINNERS AND THOSE SEEKING MAXIMUM FINISH QUALITY SHOULD MAKE MILLING PASSES AT LESS THAN A FULL HASH MARK*. Attempting to mill to at depth increments higher than recommended can cause damage to the end mill and/or receiver.
- Ensure that your router base lock is tight and functioning properly. If the router depth moves while milling, the end mill and/or receiver can be damaged.
- If using a variable speed router, set to the highest speed setting. Do not insert or remove the end mill while the router is spinning.
- Prior to turning the router on, ENSURE THE END MILL IS CENTERED WITHIN THE MILLING PILOT HOLE AND NOT CONTACTING ANY PART OF THE RECEIVER. Hold firmly

and apply moderate downward pressure when starting the router.

 While milling, move the router smoothly and in a clockwise manner as shown in the image. Keep the Router Adapter flat against the Guide Plate at all times. Avoid abruptly pulling the router or exerting excessive force. Slowly nibble away at the receiver. If you begin to experience chattering, slow down and/or take shallower depths of cut. Apply WD-40 or cutting fluid liberally and remove chips frequently.



3-1 Install #1 (Short) Guide Pins to Router Adapter using (2) Guide Pin Screws and 7/64" Allen Wrench. Open end of pins should be facing up. Do not overtighten. Make sure pins are fully seated.



3-2 Set end mill depth to the first hash mark using Depth Gauge #1. Set depth by holding the base of Router Adapter against the edge of the Guide Plate. Be sure Guide Pins are not between the Adapter and Guide Plate. Make sure router depth adjustment is locked after each depth setting.



3-3 Orient Jig so the buffer extension is closest to the user. Place router on Guide Plate, with the end mill centered within the drill hole. The Guide Pins should be positioned inside the #1 Guide Cavities on both sides. Hold firmly, turn router on and mill using consistent pressure and speed, moving in a clockwise manner.



3-4 Complete the first pass of milling, allowing the Guide Pins to trace the entire area of the Guide Cavities.



3-5 Set end mill depth to the second hash mark. Mill second pass following the same method and process as outlined in steps 3-3 and 3-4.



3-6 Continue milling in this manner, adjusting end mill depth 1 hash mark per pass until you have milled to the bottom of Depth Gauge #1. **STOP** Before continuing to Depth Gauge #2, the #2 (Medium) Guide Pins must be installed.







PART 4: MILLING STEP 2

4–1 Remove #1 (Short) Guide Pins and install #2 (Medium) Guide Pins. Do not overtighten.





Set end mill depth to the first hash mark using Depth Gauge #2.









4-3 Complete the first milling pass allowing the Guide Pins to follow the #2 Guide Cavities.



4–4 Set end mill depth to the second hash mark. Mill the second pass following the same method and process.



4–5 Continue milling, adjusting depth by 1 hash mark until you have milled to the bottom of Depth Gauge #2. **STOP** Before continuing to Depth Gauge #3, the #3 (Long) Guide Pins must be installed.







PART 5: MILLING STEP 3

Remove #2 (Medium) Guide Pins and install #3 (Long) Guide Pins. Do not overtighten.





5-2 Set end mill depth to bottom of Depth Gauge #3.



Place router on Guide Plate, with the end mill centered within the drill hole. The Guide Pins should be positioned inside the #3 Guide Holes on both sides. Gently mill in a clockwise manner until the trigger slot is formed.



SECTION 6: FINAL DRILLING

Clamp Jig Assembly in the Vise by the edges of the side plates, with the RIGHT Side Plate facing up. Ensure that the assembly is level. Spray WD-40 into the large Guide Hole and insert 3/8" drill bit. Do not start drill until bit is fully inserted in the Guide Hole. Apply moderate pressure and drill until the bit penetrates the right side wall and continue drilling through left side wall.



Spray WD-40 into both small Guide Holes and insert 5/32" drill bit into either remaining Guide Hole. Do not start drill until bit is fully inserted. Apply moderate pressure and drill until the bit penetrates the right side wall and continue drilling through left side wall. Repeat for remaining small Guide Hole.

NOTE: If your drill bits are not long enough to penetrate both walls, flip jig over and repeat process. Receivers with spray-on coatings such as Cerakote and Duracoat should be drilled from both sides for maximum finish quality.



PART 7: DISASSEMBLY

7-1 Remove Buffer Adapter. Loosen or completely remove Buffer Plate. Remove Takedown Pin. The Finished receiver can now be removed from the jig.



FINAL PRODUCT





APPENDIX A --ROUTER ADAPTER INSTALLATION

NOTE: Your ReadyMILL[™] is custom designed to fit tightly inside the Router Adapter Bearing. Prior to first use, the tool holder portion of the ReadyMILL[™] may require light oiling and/or cleaning with a mildly abrasive scouring pad to ensure a reliable slip-fit. DO NOT SAND OR GRIND YOUR ReadyMILL[™]. Do not force the ReadyMILL[™] into the bearing, or it may become stuck.

The end mill cutting teeth are extremely sharp, use the protective end mill cap whenever handling the ReadyMILL[™]. Remember to remove the end mill cap prior to use. Use caution when removing the end mill cap and wear gloves. Drilling and cutting tools can shatter, remember to always wear eye protection while operating power tools.

Reference the chart on the next page for specific instructions on how to install the Router Adapter to your router model.

ROUTER MODEL	INSTALL METHOD	READYMILL Model
Bosch PR10E ^x	2	A
Bosch PR20EV ^x	2	A
Bosch 1617EV	3*	D
Bosch 1617EVS	3*	D
Craftsman 28212 ^y		В
Craftsman 2767	3*	D
Craftsman 27683	3*	D
Craftsman 50429	3*	D
DeWalt DWE6000	2	A
DeWalt DWP611 ^z		В
DeWalt DW616	3*	D
DeWalt DW618	3*	D
Hitachi M12VC	3*	D
Makita RT0701C	2	C
Porter Cable 450	1	В
Porter Cable 6430	2	A
Porter Cable 6435	2	A
Rigid R24012 ^x	2	A

- * Installation Method 3 Requires Full-Size Router Adapter Plate
- X Pull out router base to attain minimum depth
- Y Requires only 3 Router Adapter Screws
- Z #1 Recommended Router

A1-1 Before proceeding, check that your router depth lock is fully functional. If necessary, tighten router depth lock. On most models, a nut or setscrew can be tightened to adjust the tension of the depth lock. If your router depth moves while milling, damage to the receiver and/or end mill may occur.

A1 -2^{Prepare} your router for milling by installing the ReadyMILL[™]. Unplug your router. Remove the plastic baseplate from the router base, and separate the base from the router. Remove the collet. Thread on the ReadyMILL[™] and tighten using a wrench. Reinstall the router base.



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A1-3 Orient the Router Adapter with router, and the notch away from the power cord. Pass the large diameter portion of the ReadyMILL[™] through the bearing to center the Router Adapter with the Router.



A1 -4 Installation Method 1. With the Adapter flat against router base, align Router Adapter with 4 screw holes in router base, loosely install (4) Router Adapter Screws, then tighten.



A1 -5 Installation Method 2. Align Router Adapter with 2 screw holes in front of router base, and loosely install (2) Router Adapter Screws. Loosely install Router Adapter Side Block to accessory attachment hole on back of router with (1) Router Side Block Screw. Use the appropriate size for your router. Loosely install (1) Router Adapter Screw into the Side Block through the Router Adapter. Tighten (2) front Router Adapter Screws. Press Side Block against router and tighten (1) Router Side Block Screw.





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