



-UFS GEN 3 UNIVERSAL 80% Lower Receiver Jig Instructions-

Please begin by reading this document in its entirety and making sure you have all necessary components and tools. This document is intended to give a basic direction or guidance when completing or finishing a UFS 80% Lower Receiver. Always remember to wear proper PPE (Personal Protective Equipment) and practice proper machine tool safety when finishing any 80% lower receiver. Unique Firearm Solutions, L.L.C. is not responsible for any machining errors or bodily injuries that may occur while using this jig to complete an 80% lower receiver.

PROCEED AT YOUR OWN RISK.

Provided Components:

ITEM #	DESCRIPTION	QUANTITY
1	Jig side plate1	1
2	Jig side plate 2	1
3	Jig top drill plate	1
4	Router/mill plate	1
6	¼"-20 SHCS 1-3/4" long	1
7	¼"-20 SHCS 1-1/2" long	1
8	¼"-20 SHCS 1/2" long	4
9	5/32" Locating Pin	1

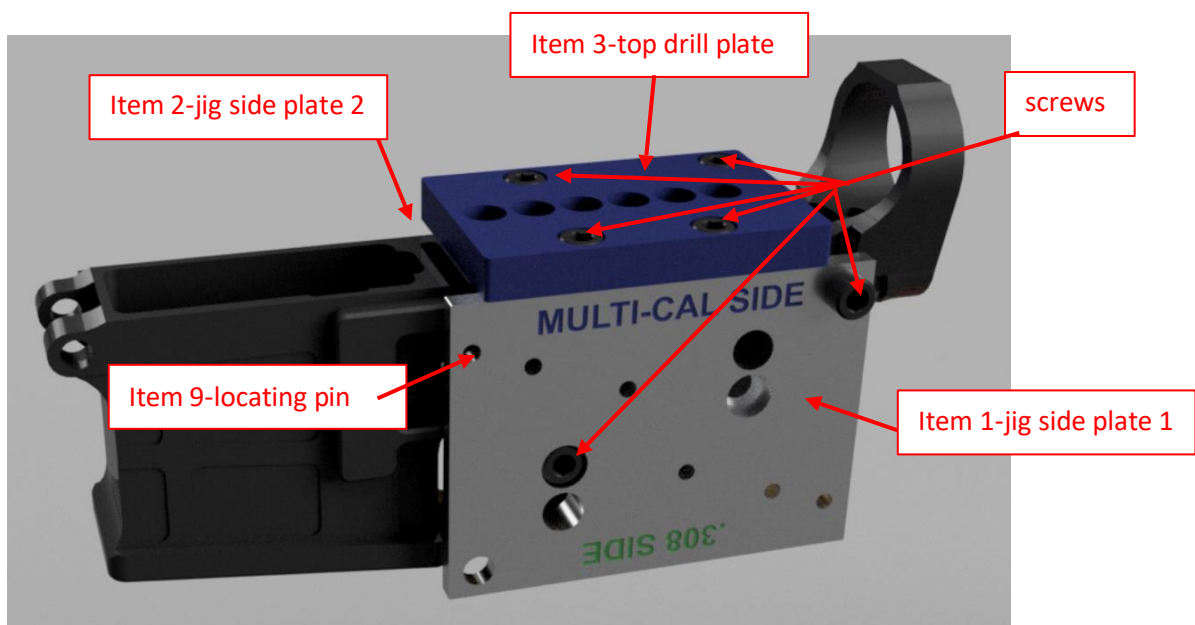
Other Needed Components Not Provided:

ITEM #	DESCRIPTION	QUANTITY
1	3/8" Drill Bit	1
2	5/32" Drill Bit	1
3	Drill Press, Router, Milling Machine, Dremel, ...etc.	

For Multi-cal Receivers

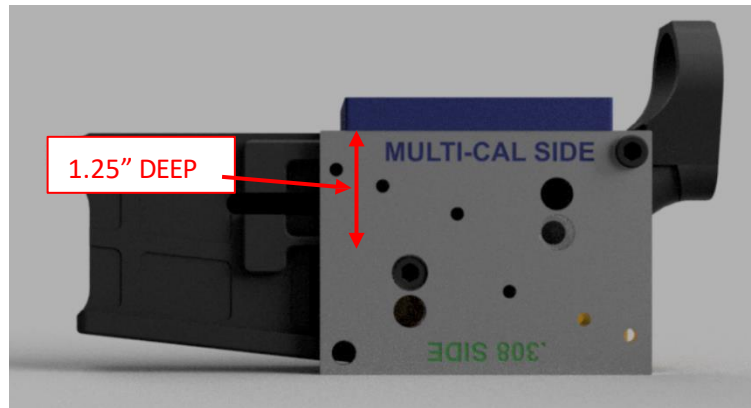
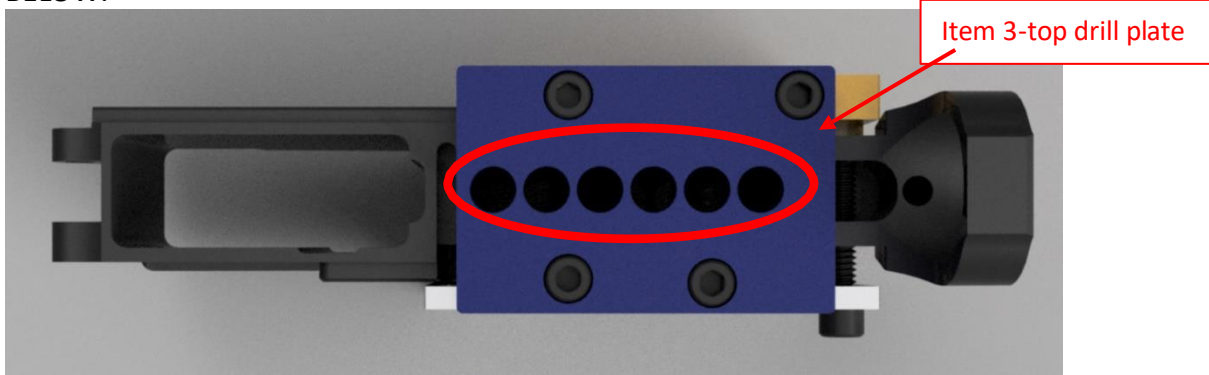
MAKE SURE MULTI-CAL SIDE IS UP ON BOTH SIDE PLATES!!

Step 1: Assemble Item #s 1,2, & 3 as shown in image below using screws 6, 7, & 8. There will also be a 5/32" pin or item #9 that will go in the jig and into the bolt catch plunger hole.

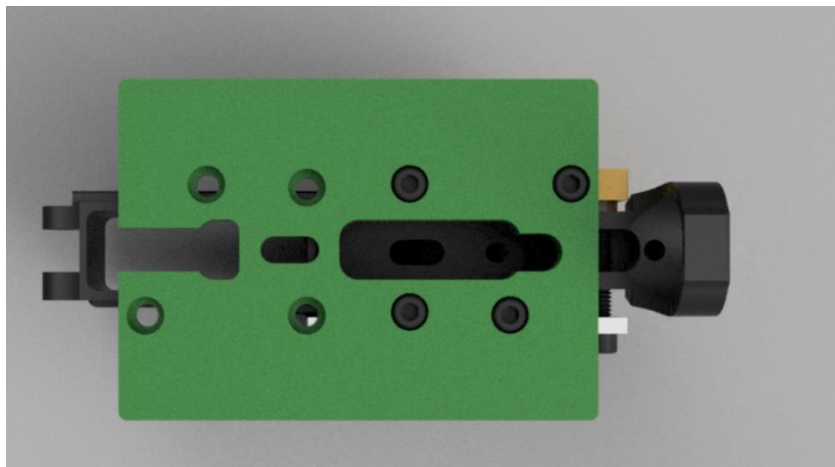




Step 2: DRILL OUT EACH OF THE 6 HOLES IN THE ITEM 3 OR TOP DRILL PLATE WITH A 3/8" DILL BIT TO A DEPTH OF 1.25" **FROM THE TOP OF THE LOWER RECEIVER**. PLEASE SEE IMAGE BELOW.

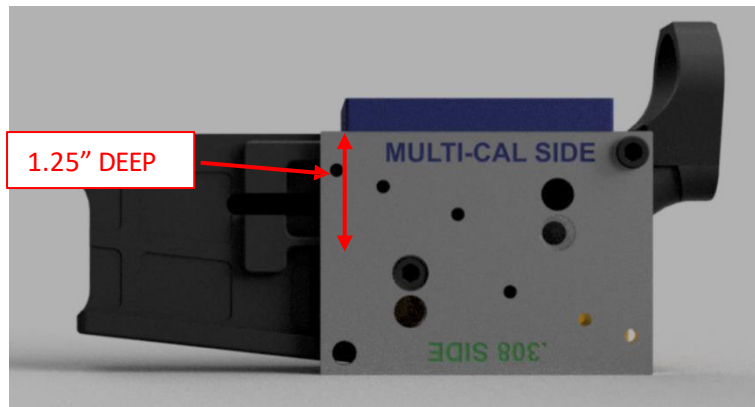


Step 3: REMOVE ITEM 3 OR TOP MILL PLATE AND INSTALL ITEM 4 OR ROUTER MILL PLATE AS SHOWN IN IMAGE BELOW.

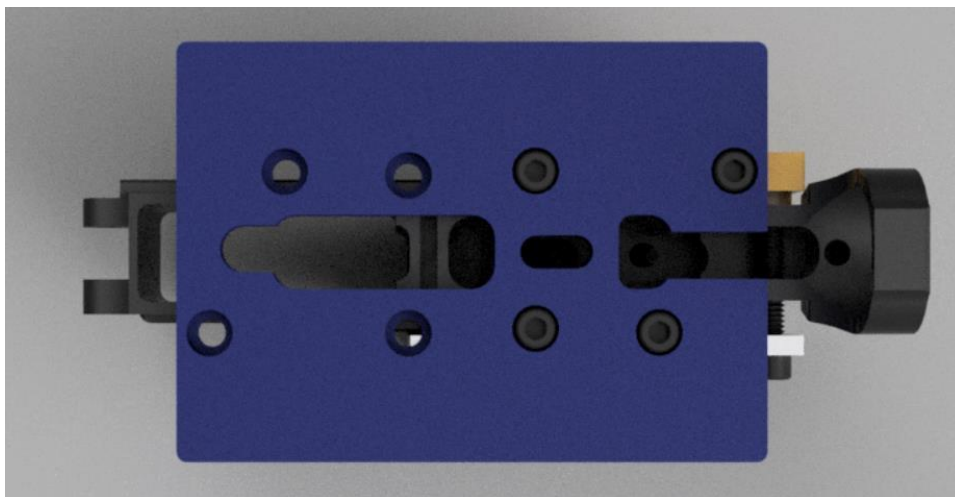




Step 4: NOW USE THIS PLATE AS A GUIDE TO REMOVE ALL MATERIAL THAT REMAINS FROM PREVIOUS DRILLING OPERATIONS. REMOVE THE REMAINING MATERIAL FOLLOWING THE PLATE TO A DEPTH OF 1.25" FROM TOP OF RECEIVER. YOU MAY USE MILLING MACHINE, DRILL PRESS, ROUTER, ROTARY TOOL, OR WHATEVER YOU HAVE AVAILABLE. IF USING A ROUTER, IT IS NOT RECOMMENDED TO USE OVER A ¼" DIAMETER END MILL. TAKE SMALL STEP DOWNS (0.015") TO START WITH. IN THIS STEP ALWAYS REMEMBER "YOU CAN ALWAYS TAKE MORE MATERIAL OFF, BUT YOU CAN'T PUT MATERIAL BACK ON". WITH THIS SAIDE TAKE YOUR TIME!

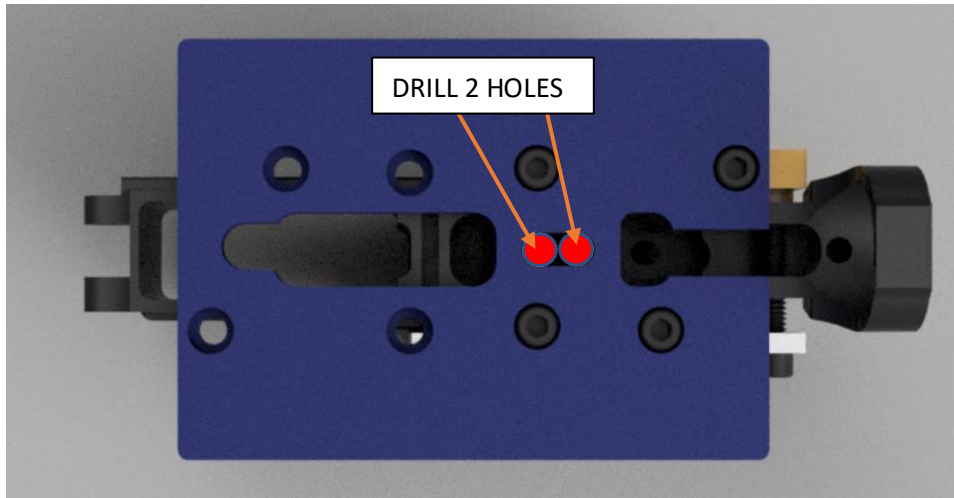


Step 5: NEXT ROTATE ITEM 3 OR TOP ROUTER/MILL PLATE 180 DEGREES AND INSTALL SCREWS AGAIN. PLEASE SEE IMAGE BELOW.

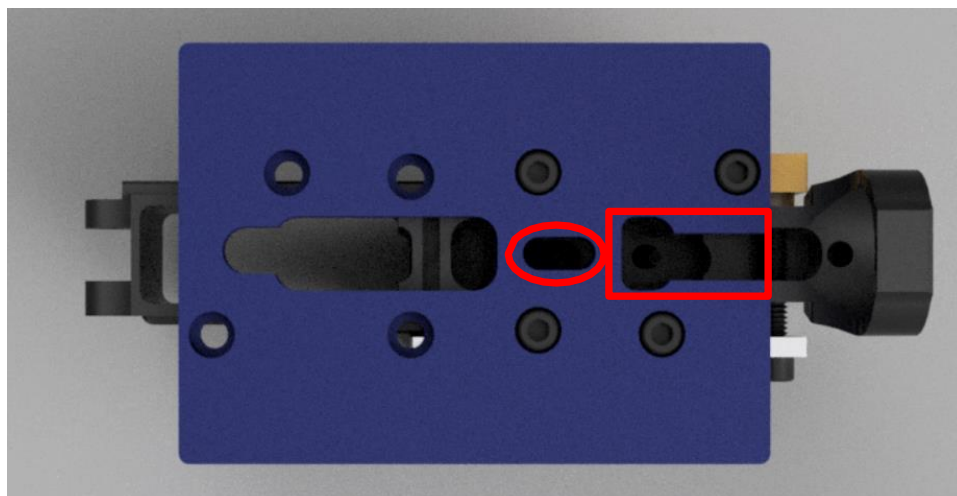




Step 6: DRILL TWO HOLES WITH A 3/8" DRILL BIT AT EACH END OF THE TRIGGER HOLE IN THE PLATE AS SHOWN IN THE IMAGE BELOW. PLEASE MAKE SURE TO DRILL ALL THE WAY THROUGH THE LOWER FLOOR.

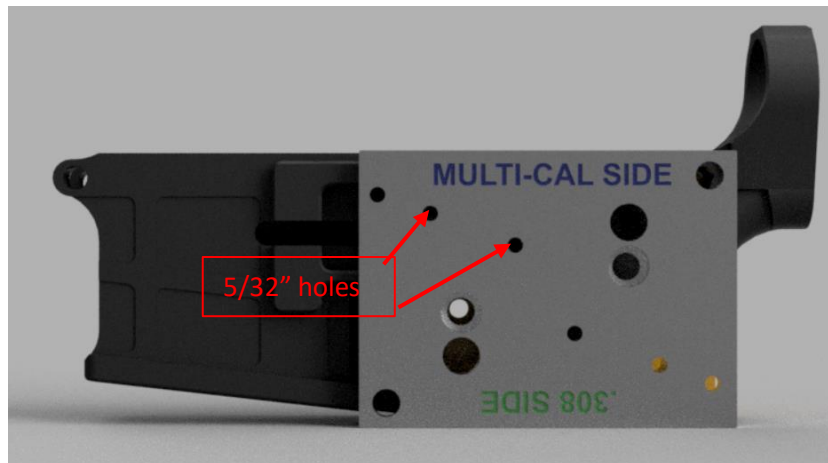


Step 7: USE OUTLINED AREAS BELOW IN ROUTER MILL PLATE AS A GUIDE TO REMOVE THE REMAINING BURRS OR SHARPS THAT MAY REMAIN FROM PREVIOUS DRILLING OPERATIONS. YOU MAY USE MILLING MACHINE, DRILL PRESS, ROUTER, ROTARY TOOL, OR WHATEVER YOU HAVE AVAILABLE. IF USING A ROUTER, IT IS NOT RECOMMENDED TO USE OVER A 1/4" DIAMETER END MILL. TAKE SMALL STEP DOWNS (0.015") TO START WITH. IN THIS STEP ALWAYS REMEMBER "YOU CAN ALWAYS TAKE MORE MATERIAL OFF, BUT YOU CAN'T PUT MATERIAL BACK ON". WITH THIS SAIDE TAKE YOUR TIME! REMOVE THE MATERIAL ON BACK SHELF TO AN OVERALL DEPTH OF **0.630"** FROM TOP OF RECEIVER. PLEASE SEE IMAGE BELOW. WHILE PLATE IS ROTATED IN THIS MANNER, DO NOT CUT LOWER THAN .63" ON BACK SHELF FOR ANY REASON OTHER THAN TRIGGER HOLE. IF SO, THE LOWER MAY BE RUINED. FOR TRIG HOLE, JUST CLEAN UP DRILLED HOLES FROM PREVIOUS STEP.

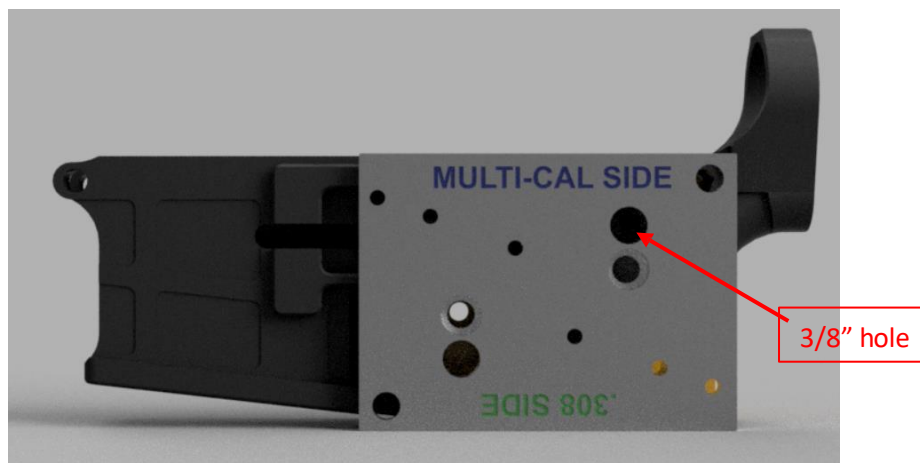




Step 8: REMOVE TOP ROUTER PLATE AND DRILL OUT TWO 5/32" HAMMER/TRIGGER PIN HOLES. YOU WILL NEED TO LAY PART ON IT'S SIDE AND BE SURE PART IS LEVEL IN VISE AND DRILL ALL THE WAY THROUGH LOWER RECEIVER (IT IS OK IF YOU DRILL INTO OTHER SIDE PLATE). PLEASE SEE IMAGE BELOW.

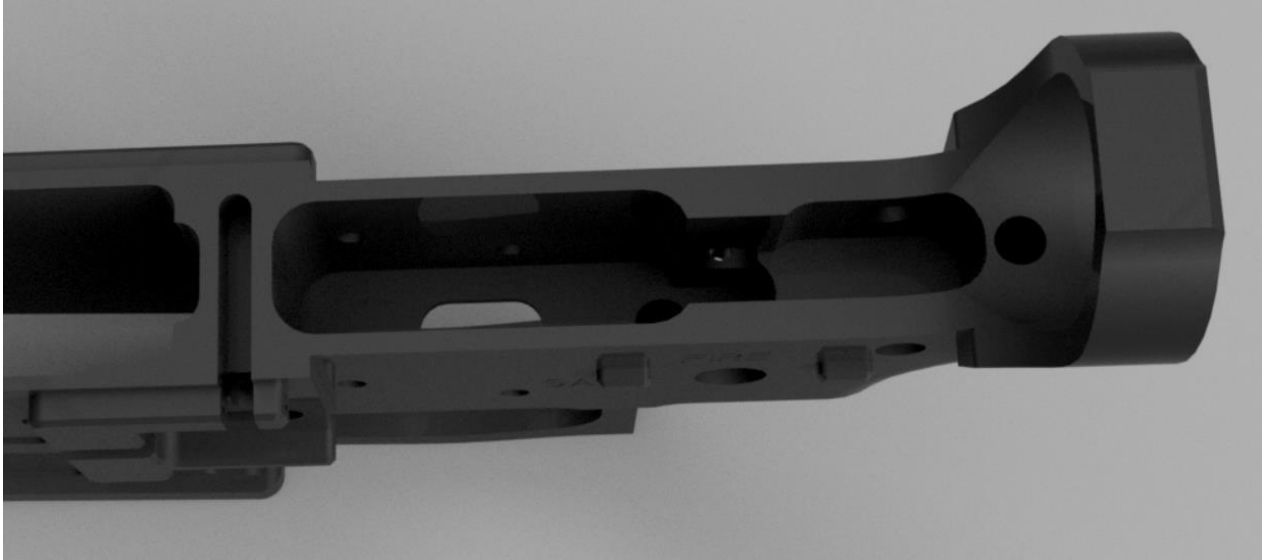


Step 13: DRILL OUT 3/8" SAFETY SELECTOR HOLE. BE SURE PART IS LEVEL IN VISE AND DRILL ALL THE WAY THROUGH LOWER RECEIVER (IT IS OK IF YOU DRILL INTO OTHER SIDE PLATE). PLEASE SEE IMAGE BELOW.





Step 14: REMOVE ALL JIG PLATES AND INSPECT YOUR WORK!! YOU LOWER SHOULD NOW LOOK SOMETHING LIKE THE IMAGE BELOW



For .308 Receivers

MAKE SURE .308 SIDE IS UP ON BOTH SIDE PLATES!!

All other instructions remain the same.