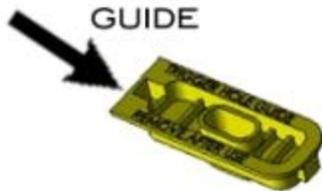


# FINISHING INSTRUCTIONS FOR THE LIBERATOR RECEIVER BLANK



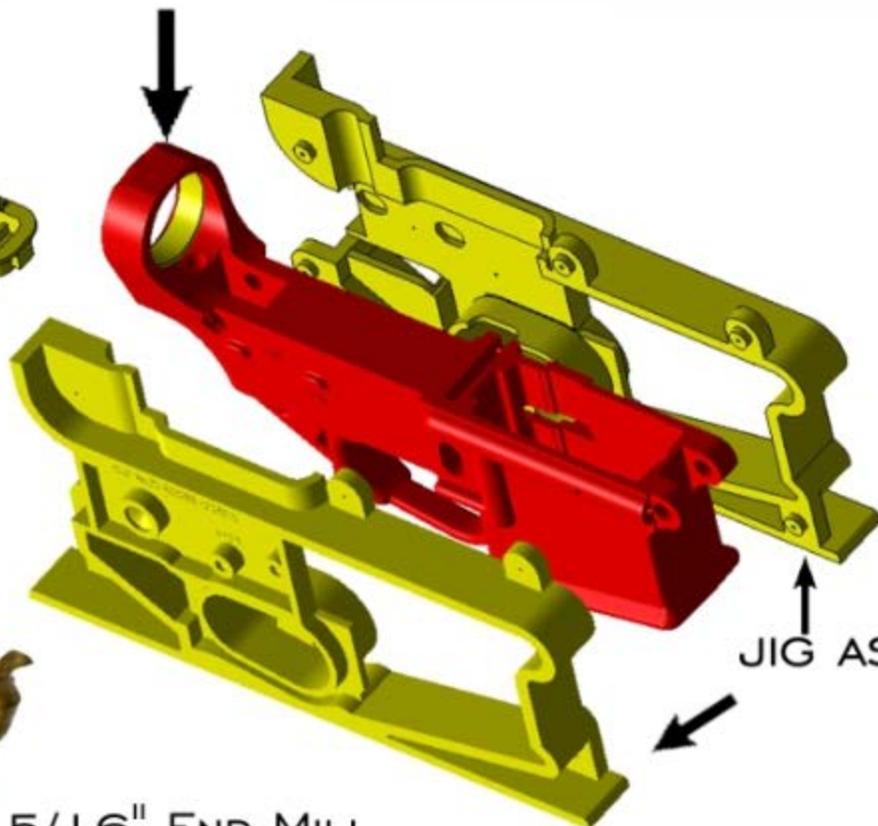
TRIGGER HOLE  
GUIDE



JIG  
HARDWARE



5/16" END MILL  
5/16" DRILL BIT  
3/8" DRILL BIT  
5/32" DRILL BIT



JIG ASSEMBLY (L/R)

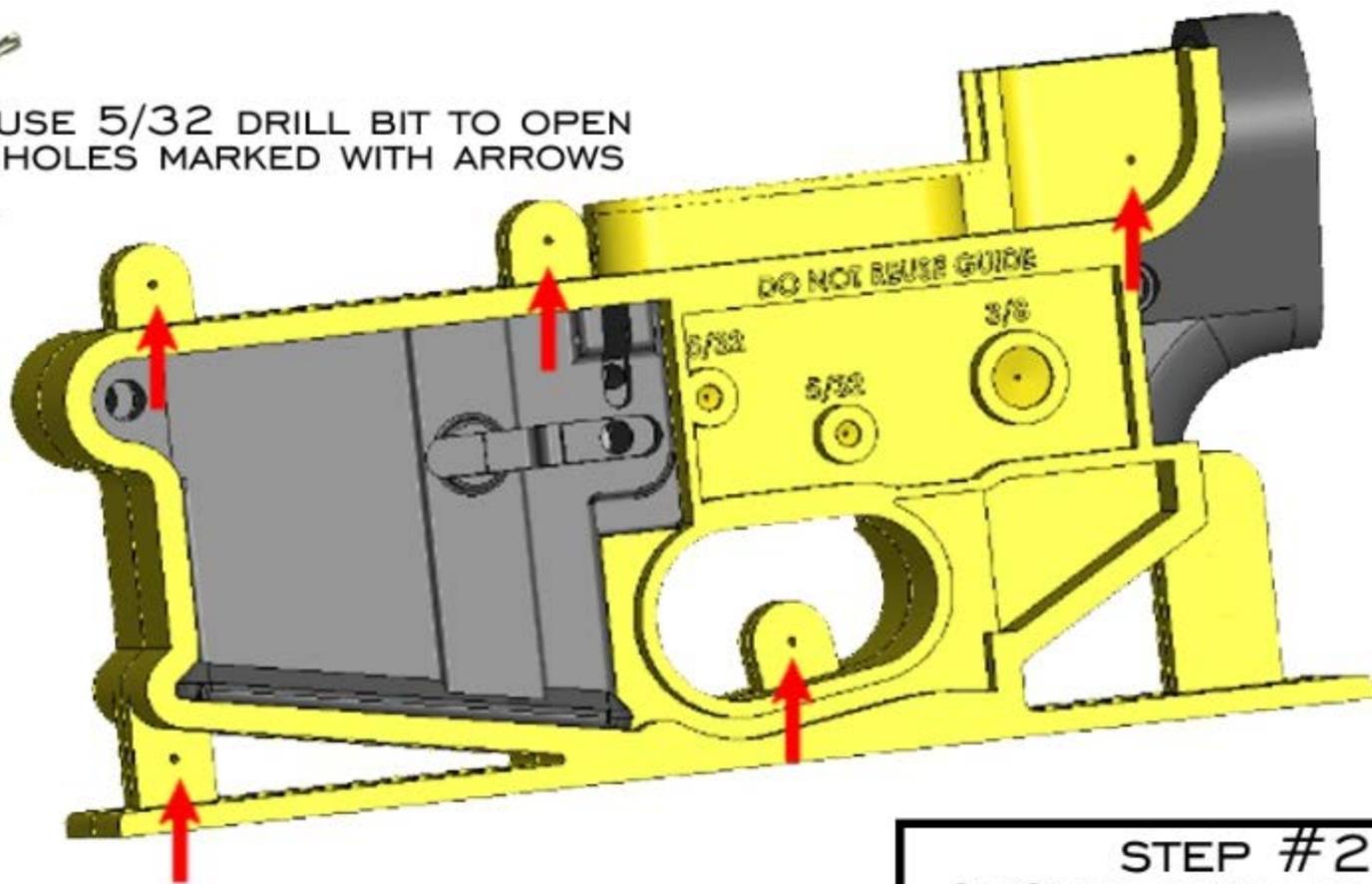
STEP # 1  
MAKE SURE YOU HAVE  
EVERYTHING YOU NEED

# FINISHING INSTRUCTIONS FOR THE LIBERATOR RECEIVER BLANK



USE 5/32 DRILL BIT TO OPEN  
HOLES MARKED WITH ARROWS

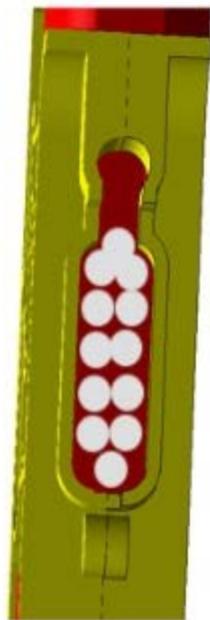
5/32  
DRILL BIT



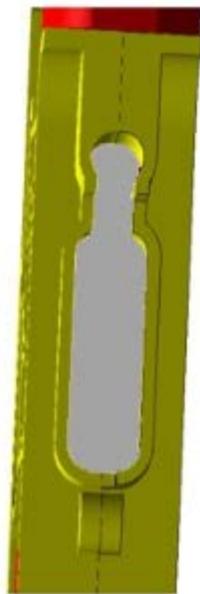
SECURE THE JIG TOGETHER  
WITH THE PROVIDED HARDWARE

**STEP #2**  
SECURE THE BLANK IN  
THE JIG.  
CLAMP JIG INTO  
VISE(OPTIONAL)

# FINISHING INSTRUCTIONS FOR THE LIBERATOR RECEIVER BLANK



USE THE 5/16" DRILL BIT TO REMOVE 5/8" OF NYLON LIKE THE PATTERN SHOWN LEAVING A SMALL MARGIN FROM THE JIG WALL TO ALLOW A SMOOTH FINISH FROM THE END MILL



USE THE TOP OF THE BLANK AS YOUR "ZERO" MARK

KEEP YOUR "RPM" BELOW 1800 TO REDUCE CHATTER AND EXCESS FRICTION AND HEAT

USE YOUR END MILL TO REMOVE THE REMAINING MATERIAL. THE EDGE LEFT FROM THE FIRST STEP CAN BE REMOVED NOW.

SET YOUR DEPTH TO  $1\frac{1}{4}$  IN AND REPEAT STEP 3

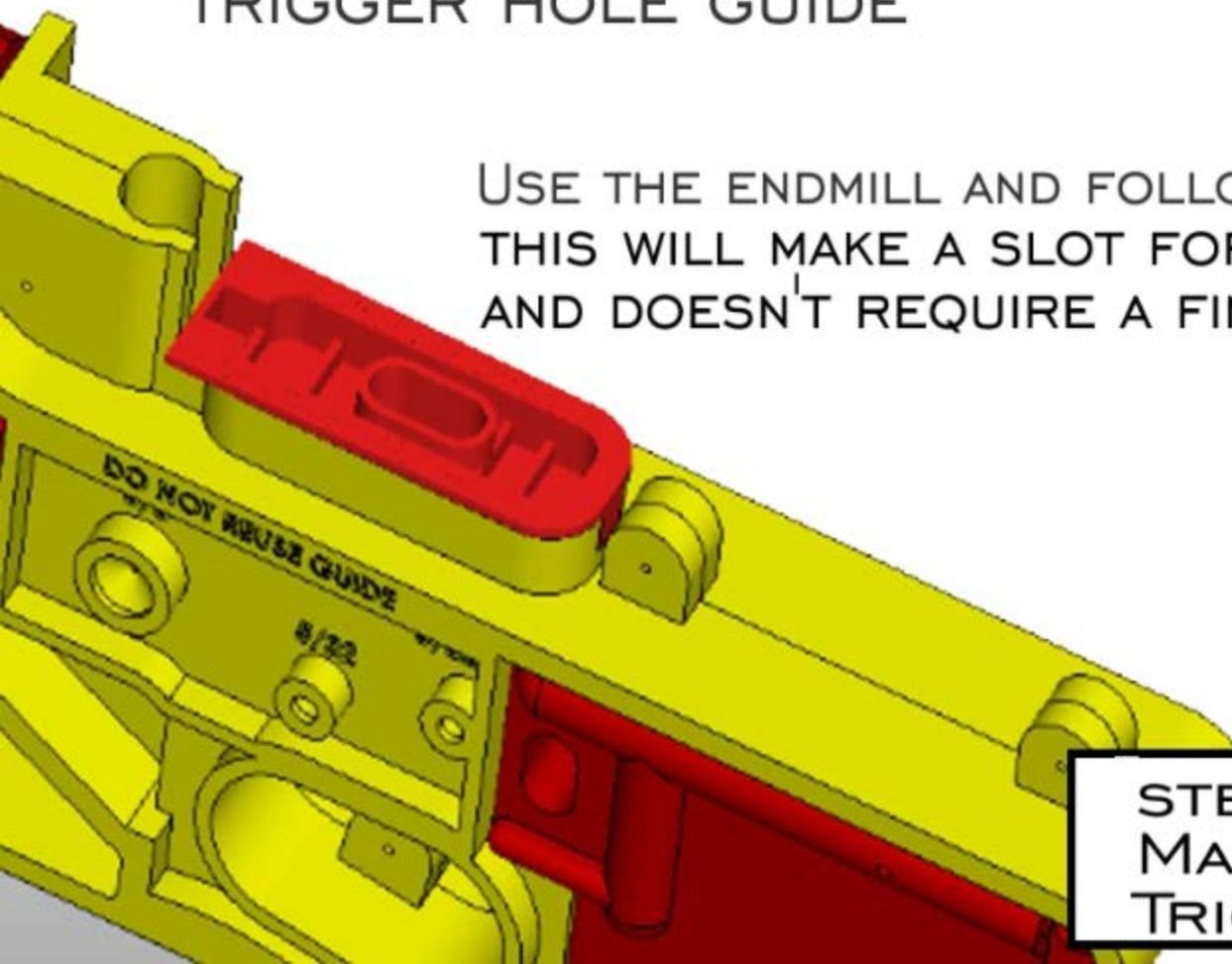
**STEP #3  
MILL THE  
TRIGGER POCKET**

FINISHING INSTRUCTIONS FOR THE  
**LIBERATOR RECEIVER BLANK**



WITHOUT REMOVING THE JIG ASSEMBLY FROM THE VISE, REPLACE THE TRIGGER HOLE GUIDE

USE THE ENDMILL AND FOLLOW THE POCKET. THIS WILL MAKE A SLOT FOR THE TRIGGER AND DOESN'T REQUIRE A FINISHING PASS.



**STEP #4**  
MAKE YOUR  
TRIGGER HOLE

# FINISHING INSTRUCTIONS FOR THE LIBERATOR RECEIVER BLANK



WITH THE JIG PLACED FLAT ON ONE SIDE, USE A 3/8" DRILL BIT TO DRILL THE SAFTEY SELECTOR HOLE AND A 5/32" BIT TO DRILL THE TRIGGER AND HAMMER PIN HOLES. DO NOT DRILL THESE HOLES ALL THE WAY FROM ONE SIDE TO THE OTHER. DRILL ONE SIDE THEN FLIP THE JIG AND DRILL THE OTHER. REMOVE THE LOWER FROM THE JIG AND FINISH BY DEBURRING WITH A SMALL FILE.

**STEP #5**  
**MAKE YOUR**  
**TRIGGER/HAMMER**  
**PIN HOLES**