

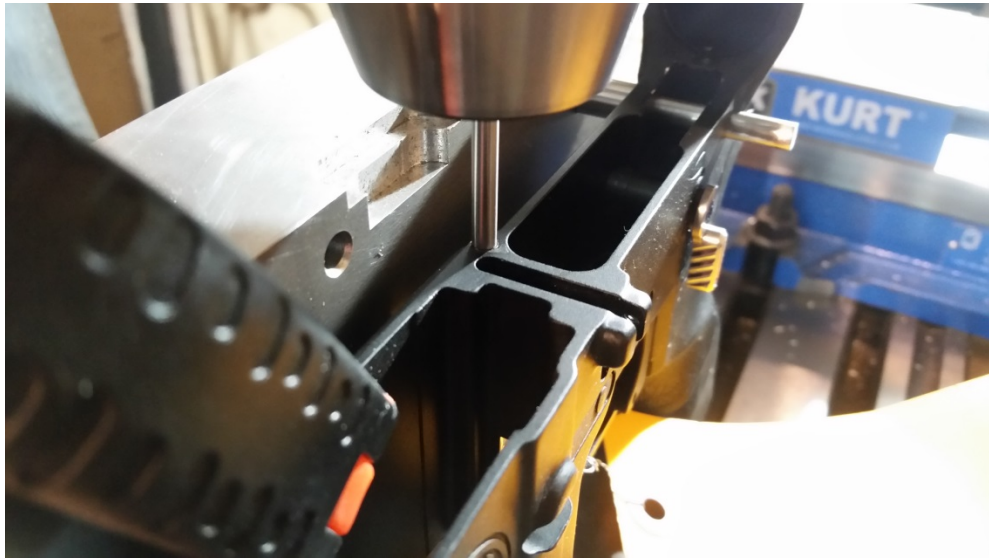
DRILLING OF LOWER RECEIVER

Drilling of lower should be done by a qualified gunsmith

Tools needed: #2 or #3 center drill, #42 jobber drill, #21 stub or jobber drill
10-32 plug tap, .190" Diameter Pin, 3/32 Allen wrench

- 1) Secure lower in mill and indicate flat and square (fixture not included but recommended)
- 2) Find location of hole to be machined into lower from print provided. Before drilling any holes make sure there is material to be removed (*picture-1*)
- 3) Center drill to spot hole
- 4) Drill .0935 dia. hole using small pecks to 1.00" deep, be careful when breaks thru wall (*picture -2*)
- 5) Drill .159" dia. Hole .825" deep be careful when breaks thru wall (*picture -2*)
- 6) Tap hole with 10-32 plug tap .125 full length of thread. Optimal depth is when setscrew bottoms on threads and is flush with top of receiver.
- 7) Install mag release button onto gun "without" spring
- 8) Rerun .159 drill to notch side of mag button at .825 deep (*picture-3*) Ensure mag catch is held flush to receiver as no spring is present. External force required.
- 9) Remove button and clean all chips and deburr holes
- 10) Screw 10-32 set screw into threaded hole to check depth of tapped hole should be flush to top of lower when snug.
- 11) Install spring, plunger and set screw from California modification package
- 12) After all work is done check with mag and upper make sure all functions of added parts work properly

Battle Arms Development Inc. is not responsible for any damages that occur from improper modification, installation, assembly or the misuse of our products.



(Picture-1) Verify material available using pin matching or larger than thread Diameter .190"



(Picture-2) Note: Both drills break through walls into pocket.



(Picture-3) Note: Drill notch on mag button. This cut creates locking / wear surface for pin.

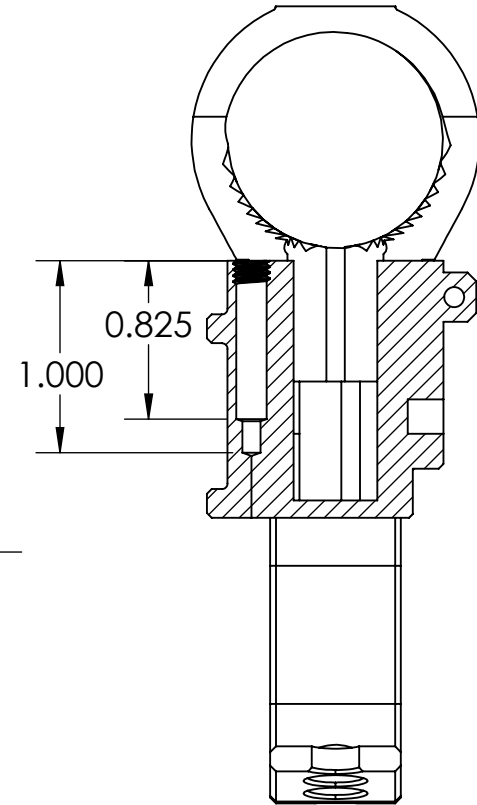
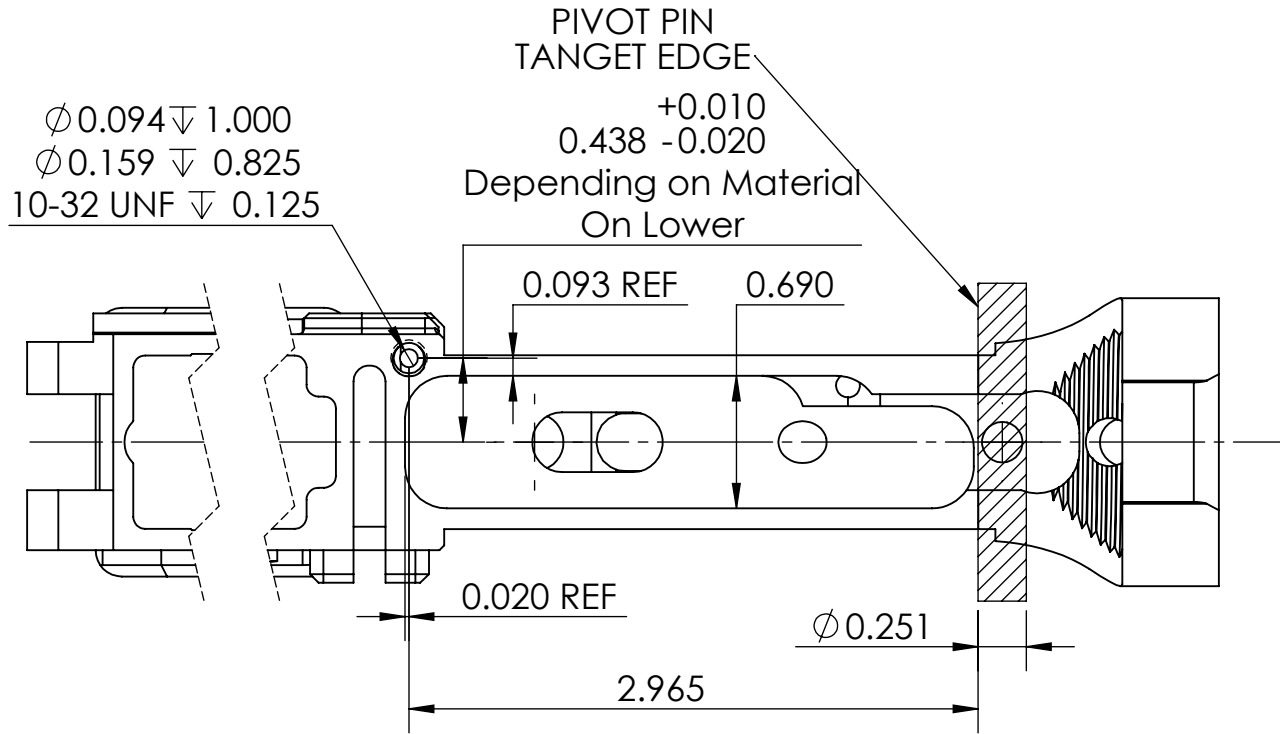
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REVISION	DESCRIPTION	DATE
REV-0	CREATED	MAY 2016
REV-1	MOVED HOLE FORWARD	5-15-2017
REV-2	UPDATE PRINT TO REFF REAR PIN + CENTERLINE	12-21-2017

B

B



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PROPRIETARY, CONFIDENTIAL INFORMATION
 The information contained within this drawing is the sole and proprietary property of Battle Arms Development, Inc. and may not be copied, disclosed to others or used for the purpose of component fabrication without the prior written consent of Battle Arms Development, Inc.

UNLESS OTHERWISE SPECIFIED:
 DIMENSIONS ARE IN INCHES
 TOLERANCES:
 ANGLES: ± 30°
 BREAK SHARP CORNERS .010 MAX RADIUS
 THREE PLACE DECIMAL ±.005
 SURFACE FINISH TO BE 63 ✓

MATERIAL --
 PLATING --
 FINISH --
 HEAT TREAT --

	NAME	DATE
DRAWN		
CHECKED		
ENG APPR.		
MFG APPR.		
Q.A.		

COMMENTS:
 ALL NUMBERS ARE POST ANODIZE MODIFICATION.
 PRE ANODIZE HOLE SIZES MAY REQUIRE UPDATING FOR SIZE AND TAP DEPTH TO ACCOUNT FOR BUILD UP



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TITLE:
Cali Mag Lock Pin RS 5.56 cal, Lower

SIZE	DWG. NO.	REV
A		2
SCALE: 1:1	WEIGHT:	SHEET 1 OF 1

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