



WHERE POSSIBLE, USE A MILL. IF THIS IS NOT POSSIBLE, USE A VERY RIGID DRILL PRESS. A HAND DRILL IS NOT RECOMMENDED. PLEASE DO NOT ATTEMPT TO USE AN ENDMILL IN A HAND DRILL. IF YOU DO AND YOU GET HURT, IT IS YOUR OWN FAULT.

ALL JIGS SHOULD BE MADE IN RIGID HIGH TEMP MATERIALS WHERE POSSIBLE. PLA+ IS SUFFICIENT FOR THE BAR STOCK JIG, BUT THE BOLT CARRIER JIG SHOULD IDEALLY BE MADE OF ASA, NYLON OR SIMILAR.

THE BOLT CARRIER SHOULD BE CHOPPED AT THE BACK AND FILED SUCH THAT THERE IS NO CARRIER ARM REMAINING AND THE BACK OF THE CARRIER IS FLAT. REMEMBER TO REMOVE THE BOLT CARRIER INTERNALS BEFORE MACHINING THE BOLT CARRIER. WHEN DRILLING THE BOLT CARRIER, THE PART WILL GET HOT AND MAY MELT PLA+.

YOU WILL CUT YOUR GAS KEY SUCH THAT IT IS FLUSH WITH THE RECTANGULAR PIECE THAT ATTACHES IT TO THE CARRIER.

ALL HOLE TAPPING SHOULD BE DONE OUTSIDE OF THE JIG TO ENSURE HOLES ARE STRAIGHT AND TRUE. REMEMBER TO USE CUTTING OIL AND FOLLOW TAPPING BEST PRACTICES, TWO TURNS IN, ONE TURN BACK. IF YOUR DRILLING SET UP WIDENS THE EJECTION PORT SIDE M5 HOLE ON THE BCG, YOU CAN WIDEN AND RETAP WITH M6. SEE MODIFIED RIGHT SIDE LINKAGE.

TOLERANCE ON THE NYLOCK NUTS IN THE LINKAGES IS TIGHT. YOU WILL HAVE TO TAP THEM INTO PLACE. A PUNCH SET AND ARMORER'S HAMMER WORK WELL FOR THIS.

- A: LEFT SIDE BCG BAR JIG - DRILL W/ $\frac{1}{8}$ "**
- B: LEFT SIDE PUMP BAR JIG - DRILL W/ $\frac{3}{32}$ "**
- C: LEFT SIDE PUMP BAR - 4 M3X6mm, 2 M3x10mm**
- D: BOLT CARRIER JIG - DRILL W/ $\frac{3}{16}$ "**
- E: LEFT SIDE BCG LINKAGE - 2 M3 NYLOCK, 2 M6x12mm SCREW**
- F: EJECTION PORT BCG BAR JIG - DRILL W/ $\frac{1}{8}$ "**
- G: EJECTION PORT PUMP BAR JIG - DRILL W/ $\frac{3}{32}$ "**
- H: EJECTION PORT PUMP BAR - 2 M3x8mm, 4 M3x8mm**
- I: EJECTION PORT BCG LINKAGE - 2 M3 NYLOCK,, 1 M5x12mm, 1 M3x12mm**
- J: PUMP FOREGRIP**

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