



Installation Instructions

Rev: 06/18/14

Tools needed

- Power Drill
- #29 cobalt drill (.136")
- Drill Bushing
- #8-32 tap
- hex key
- Safety glasses



Caution: Always make sure that firearm is completely unloaded before performing any work. These instructions provide gunsmiths and home builders with useful tips for installation. This is a relatively simple task but does require careful, patient work and a certain amount of mechanical skill. Please consider returning the kit for a refund or taking it to a gunsmith to install if you have any doubt as to whether you are capable of performing the installation.

This kit allows you to drill and tap 2 holes in the top cover of a PAP M85 or M92 pistol for mounting an accessory rail.

Instructions

Secure the gun in a vice clamping carefully so that nothing is bent, dented, or scratched.



Place the rail over the top cover hinge arm between the hinge and rear sight block.

*** EXTREMELY IMPORTANT *** Position the rail so that the two holes will miss the spot welds on the cover. Not only would drilling the welds out weaken the hinges attachment to the top cover but it is also almost impossible to drill and/or tap through the metal where it has been welded.



Put the drill bushing in one of the mount holes of the rail.

Place the drill through the bushing and cut down until you have the tip of the drill well into the metal. Run a moderately fast drill speed (about 1400 RPM).



Remove the rail and bushing. Then drill the one hole through using the previously drilled spot as a guide.

**** Run the drill only fast enough to cut freely. Too high of a speed can wear the drill out quickly and may work harden the material so that only carbide tools will be able to cut further.



Once this hole is cut, go ahead and thread it with the supplied tap. A good tap handle and cutting fluid, such as Tap Magic ®, are very helpful for this step. Make sure to keep the tap straight in line with the drilled hole and go slow, applying firm downward pressure while cutting, and occasionally unscrew it back a little ways to clear chips.

** A small chamfer on the hole will also help get the tap started right. If you have a larger drill, you can use it to chamfer the edge of the hole before tapping.

Once the 1st hole is tapped, you can put the rail back on, screw it into place, and repeat the above procedure for the second hole.



Great luck with your build and thanks for your business!

CNC Warrior Product Development

WARNING!

The determination of the suitability of any product for certain specific use is the responsibility of the purchaser.

All firearms are potentially dangerous and can cause personal injury or death.

IT IS YOUR responsibility and legal obligation to properly handle, load, unload, use, transport, maintain, and store your firearm in a safe manner so as to prevent its accidental discharge. Likewise, parts for firearms are also potentially dangerous if installed improperly and can cause your firearm to malfunction and accidentally discharge.

Appropriate eye protection must be worn before attempting to work on any firearm.

No liability is expressed or implied for the damage or injury as a result of improper installation or use of this product.

Warranty is limited to the replacement of this product only.