



Installation Instructions

Rev: 06/18/14

**Tools needed**

- Small Drill Press (a power drill can be used but may require 2 people)
- 5/32" drill bit
- Hole Locating jig
- Hardened Pin
- Hammer
- 3/16 endmill or short length drill (not included) is required for removal of pinned suppressor
- 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.

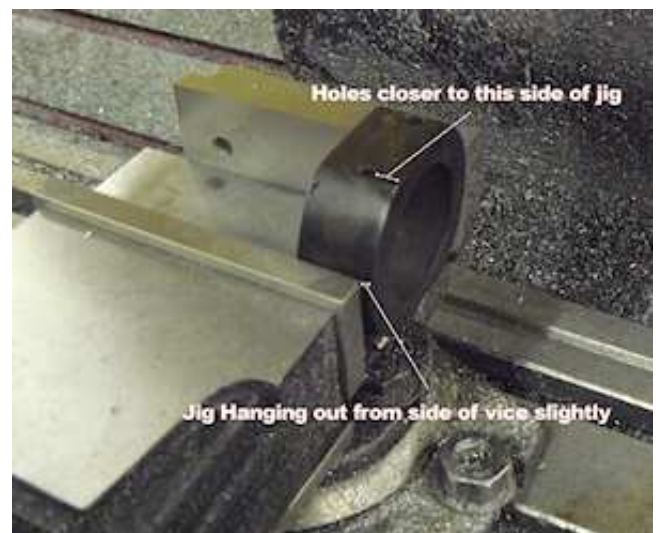
This kit allows you to drill a hole in the proper location and size for blind pinning a CNC Warrior fake suppressor to the muzzle of a PAP M85 or M92 pistol. When pinned properly, this meets ATF standards for a permanent attachment and extends the legal barrel length to the tip of the muzzle device.

Instructions

Clamp the jig in a vice making sure:

1. The jig is hanging out slightly beyond the side of the vice.
2. The guide holes in the jig are closer to the side that is hanging out.

*** As mounted here, the smaller (.156" 5/32) hole would be closest to you.

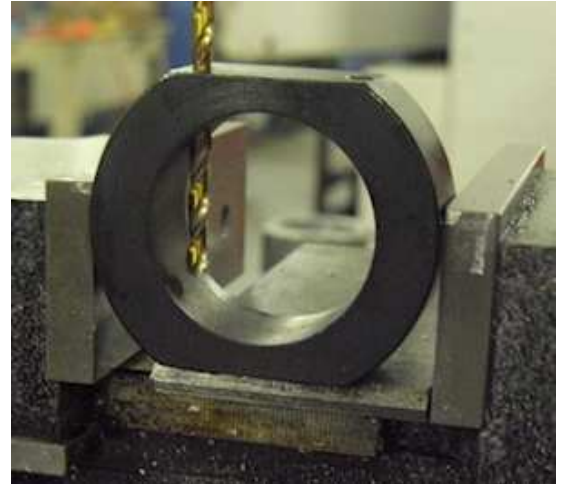


*** Installing Suppressor ***

Line up the 5/32 drill so that it is centered with the small hole in jig. Once it is very close to center turn the drill on and run it in and out of the hole looking carefully from side and front and adjust to minimize deflection.

Set the depth of the drill so that it will stop just short of breaking through the bottom side of the suppressor. If you are hand drilling or do not have a depth stop on your drill press, use a marker to color a stopping line on the drill bit itself.

*** Do not allow the drill to go through the back side of the suppressor. If you do, the ATF will not consider it permanently attached because it can easily be removed with only a hammer and punch.



Screw the suppressor onto your muzzle and tighten by hand.



Now is a good time to use an alignment rod to check concentricity of barrel with the muzzle device. Alignment rods are available in different calibers from CNC Warrior. Use whatever means necessary to make sure that the bullets will clear without striking the ID of the suppressor.

*** WARNING *** This alignment will almost never be perfect without modification. The suppressor threads are concentric with its ID within a few thousandths of an inch but you also have play in the threads, alignment of sight block, and other factors that come into play. It is the responsibility of builder to align it to his satisfaction. Please consider returning the suppressor and jig kit before cutting anything if you are unsure about making these modifications to your satisfaction. Used cutting tools and modified parts are not returnable.



Now place the suppressor into the jig positioning the gun horizontally so that you will cut the pin hole on bottom side of suppressor. Use a wood block or something to support the gun and keep it level.

Push the front sight block all the way against the face of the jig and hold it there firmly while drilling.



Use a fairly high spindle speed (1700 RPM) and "peck" drill cutting short depths and pulling all the way out multiple times. Blowing shavings away and/or applying coolant (water) each time the drill is pulled out will help keep it sharp.

**** DO NOT DRILL THROUGH BOTTOM SIDE ****



Check the depth of your hole to make sure that it is deep enough that the pin will go below flush when driven in. The pins that we supply are intentionally oversize for a tight fit. It will be helpful to sand or file the outside of the pin slightly to the point that it goes in about half way without hammering. Also, one side is intentionally smaller than the other so start that side into the hole first.



*** Suppressor Removal ***

The jig has a larger (3/16") hole that can be used for removal. You set everything up same as before but put the gun in with the selector side up. Then use a 3/16 (4 flute centercutting preferred) endmill or short length drill to drill through back side of suppressor until it hits the hardened pin. Then you can use a punch to drive the pin back out the way it came in.



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.