



PN 26535

PAP Buttstock Drill Kit

Installation Instructions

Rev: 06/18/14



Tools needed

- Power Drill
- 1/8" starter drill bit
- 3/8" drill bit
- Hole Locating jig
- 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 mounting a CNC Warrior folding hinge system on a PAP M85 or M92 pistol.

Instructions

Secure your gun by some means such as clamping in a vice



Place the locating jig on the back of the receiver, using the milled steps to locate it from the 2 sides and lower receiver surface



Drill the small hole at a fairly high speed (about 1500 RPM)
After sinking the point of the small drill in, you can remove the jig



Drill the rest of the way through without the jig in place



Using the small hole as a guide, drill through with 3/8 drill at a slow speed (about 700 RPM)



Deburr the hole inside and out as well as you can. Use a cold blue solution to make the machined surface rust resistant if desired.



IMPORTANT NOTES

*** Don't run the drills "wide open". Use the slowest spindle speed possible as long as metal chips and shavings are flowing.

*** Apply a good amount of downward pressure while drilling. Just not so much that it would possibly bend the drill. But when the large drill just starts to "break thru" (see photo) lighten up on your downward pressure quite a bit and run a higher speed to get through the final depth. The drill will tend to grab at this point and could hurt your wrist if you are not ready for it, so use caution.

*** If you can squirt water or some other cutting fluid on the drill while drilling it will help keep the drill sharp.

*** The receiver is made from 4140 material. As it gets hot, it can work harden and possibly become too hard to drill without carbide tools. So avoid running high RPMs on the large drill or trying to force a dull bit to finish a 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.