

Rudius Jig Assembly

1 Assemble the Rudius into the Jig as shown in Figure 1.

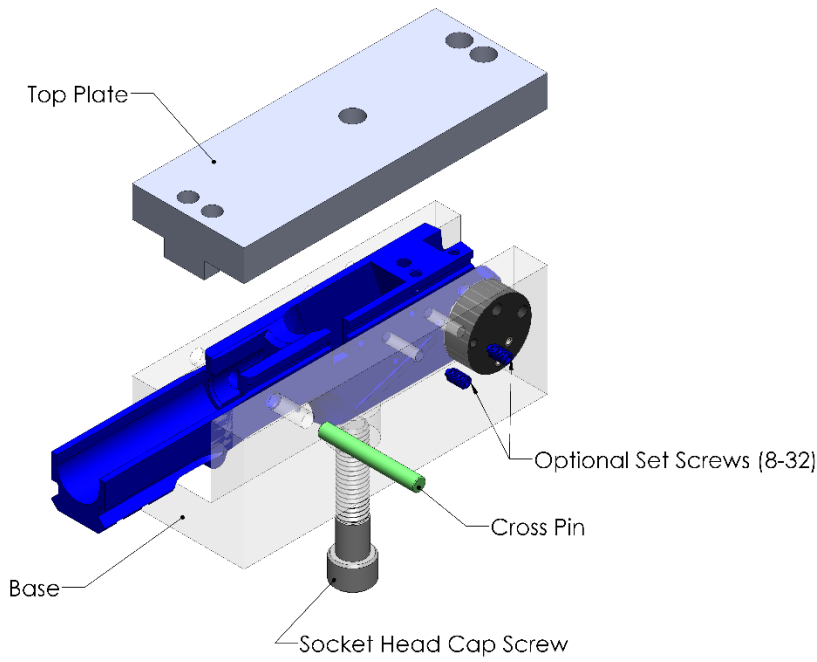


Figure 1. Rudius Jig Assembly.

2 Place the Rudius Jig Assembly into your drill vice, with the drill plate facing up as shown in Figure 2.

3 Drill each of the holes listed below through both sides of the Rudius. You will need the following drill sizes (See Figure 2):

- 3.1 [A], #35 Drill, 0.110in
- 3.2 [B], #22 Drill, 0.157
- 3.3 [C], 5/32 = .1563, for the 0.1558 diameter hole

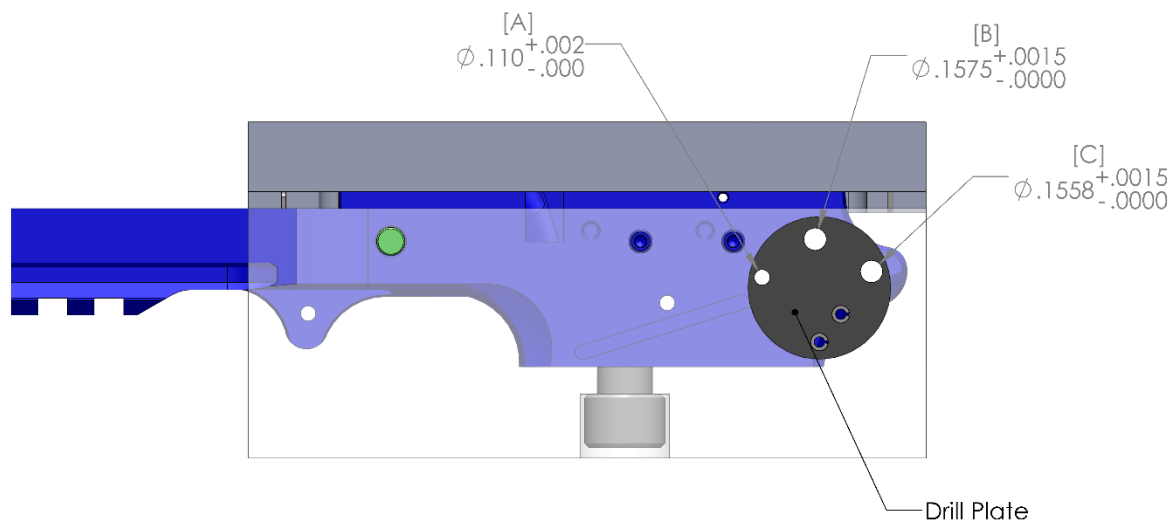


Figure 2. Drill Sizes. This Face Up.

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- 4 Next, place the Rudius Jig Assembly into your mill with the drill plate and slot facing up. Use an end mill to cut the slide cuts. See Figure 3 for dimensions.
 - 4.1 Note you will need to machine one slide cut and then flip the Jig over to cut the other slide cut.

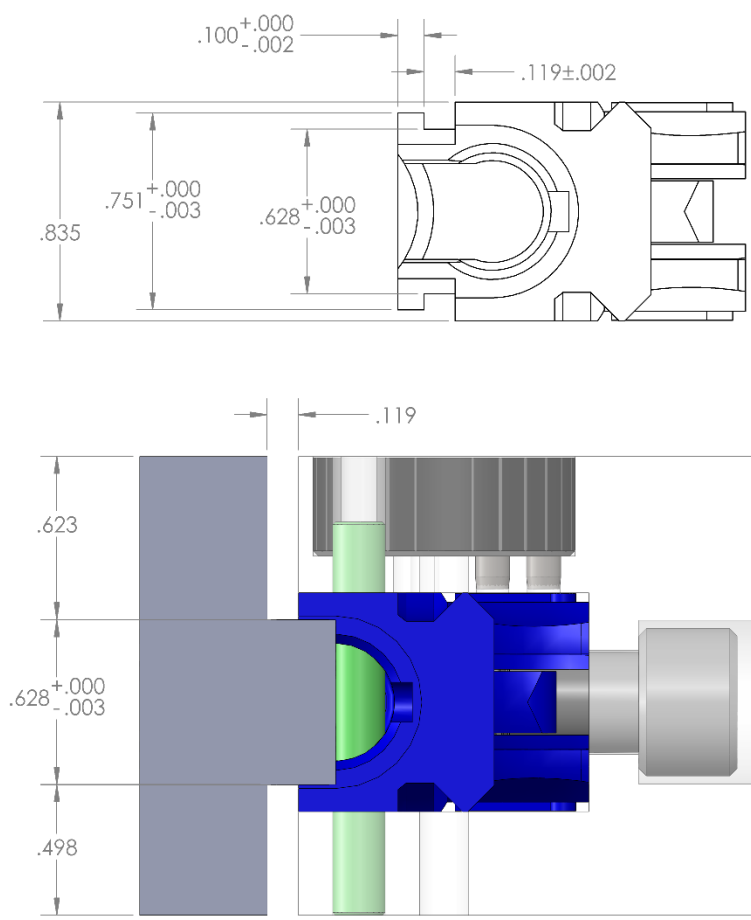


Figure 3. Slide Rail Cut Dimensions.

- 5 The next step is to cut the Barrel Seat. The Barrel Seat is measured from the Slide Catch Pin Hole (The hole that the cross pin is placed through for the Jig).

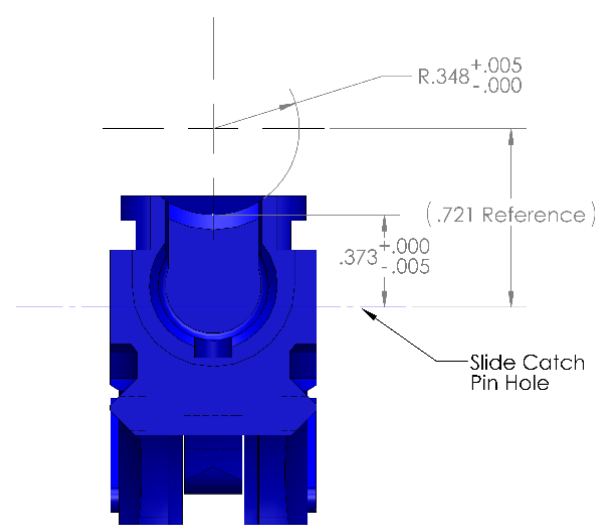


Figure 4. Barrel Seat Dimensions.