

# Rudius Assembly

- 1 Assembly the Rudius into the jig as shown in Figure 1.

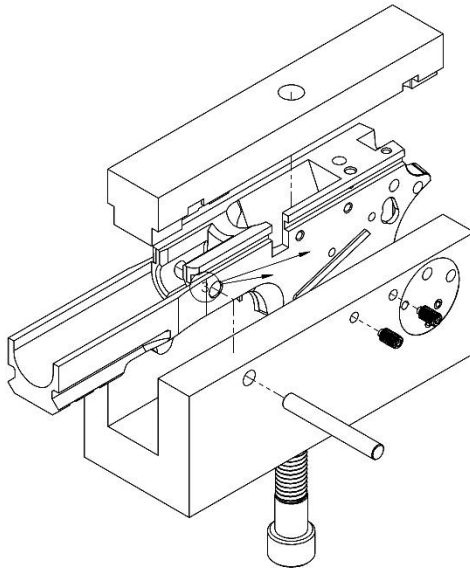


Figure 1. Rudius Jig Assembly

- 2 Place the Rudius Jig Assembly into your drill vice, with the drill plate facing up (See 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
  - 3.4

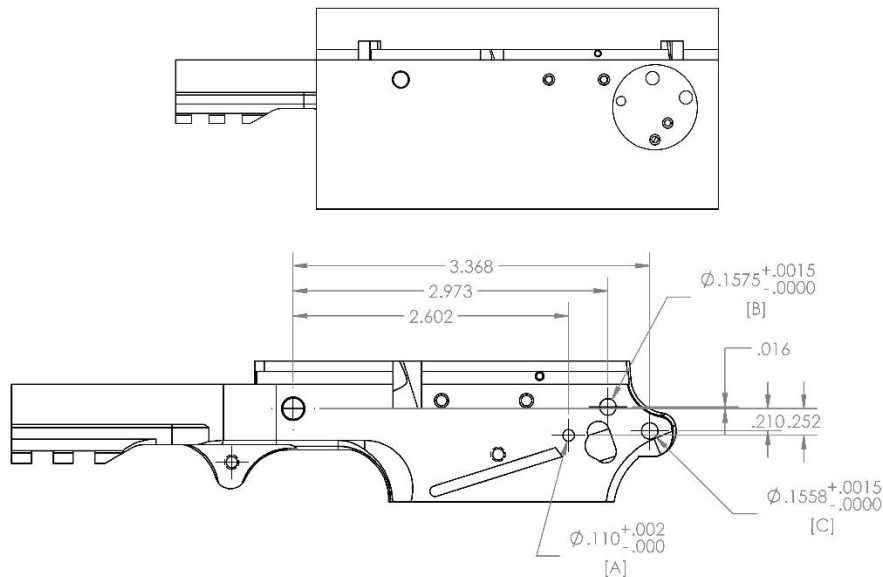


Figure 2. Drill Sizes. This Face Up.

- 4 Next, place the Radius Jig assembly into your mill with the drill plate and Slot facing to the side. Use ARES ARMOR special slide cutter (Figure 5). See Figure 3 for the dimensions.

4.1 Note you will need to machine one slide cut, then the other slide cut.

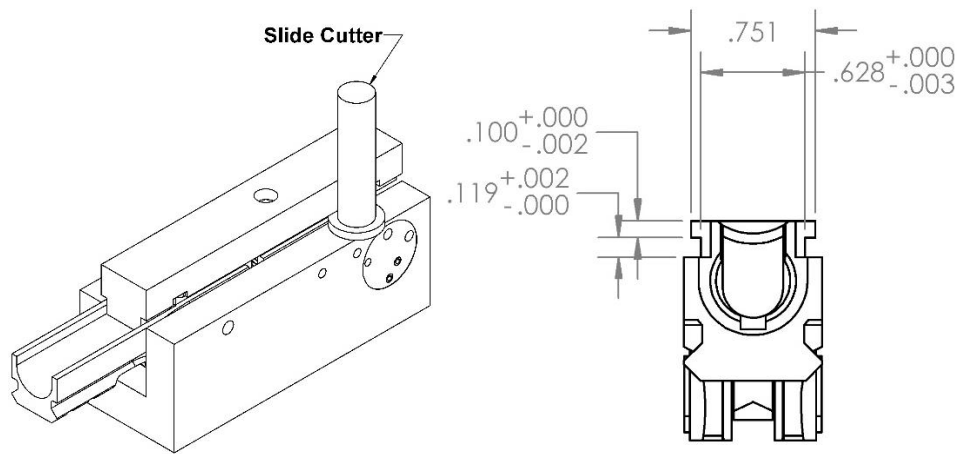


Figure 3. Slide Rail cut dimensions.

- 5 The next step is to cut the Barrel Seat. The Barrel Seat is measured from the top surface. It is recommended that you cut the barrel seat last, and test it with your barrel to ensure you do not over cut the depth. Use the ARES ARMOR Barrel Seat Ball Cutter (Figure 5).

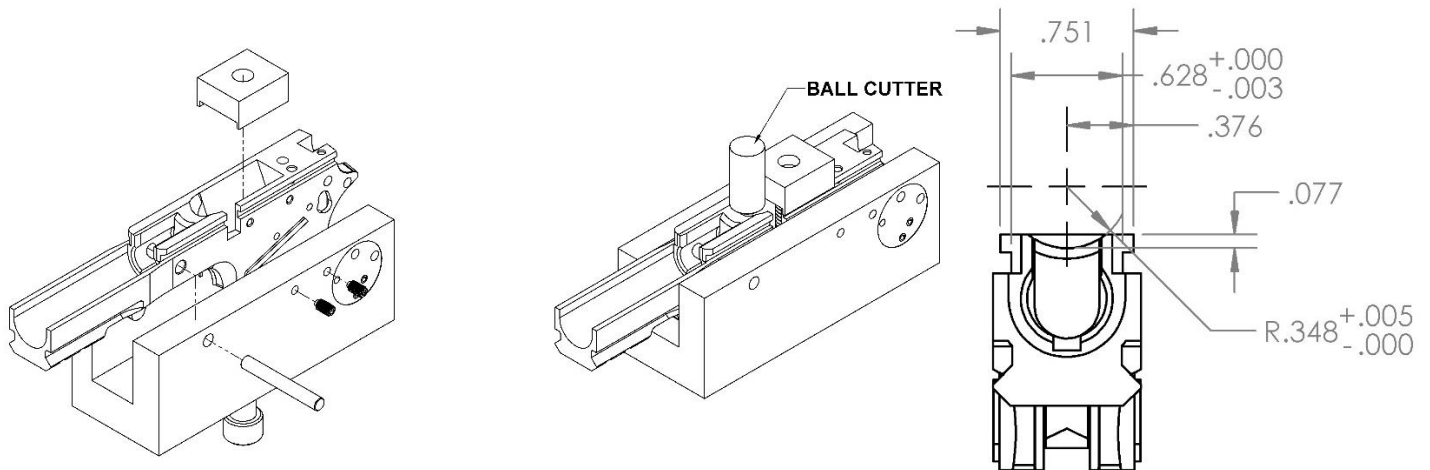


Figure 4. Barrel Seat Dimensions



Figure 5. 1911 Radius Tooling Kit