

## Colfax Tactical

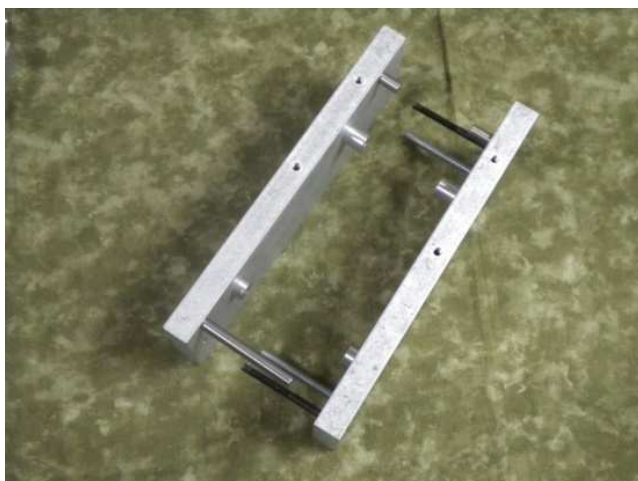
### 308 jig

The 308 jig was designed for the builder with moderate experience. Although it can be done, it was not designed for a drill press. It was designed specifically for the Colfax Tactical 80%er.



There is a right and left half to the jig. The image above is viewed from the left side. The buffer will sit to the right as shown in the above image. There is a long dowel pin and two short dowel pins. The longer pin will be used in the pivot pin holes and the shorter two pins will be used in the take down holes.

The left half includes the hammer, trigger, and selector guide holes. They are 5/32, 5/32, and 3/8 respectively.

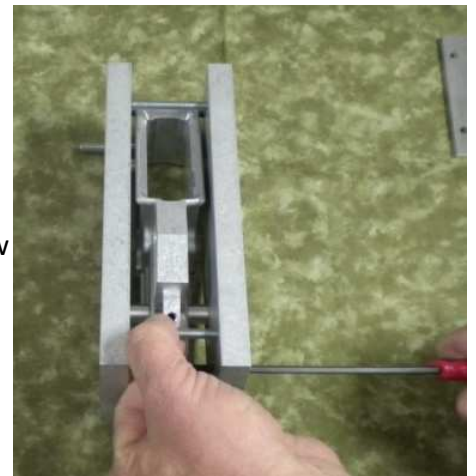


The image to the left shows the two halves with the standoffs in place, two 10-32 socket head cap screws, the long dowel, and the two shorter dowel pins.

The image to the right show the jig viewed from the right side. We recommend the use of low adhesive painter tape on the side of the lower to protect the anodized surface from the standoffs.



These two images show the tightening of the 10-23 cap screw while adjusting the ¼-20 push screw. The goal is to square sides of the jig.

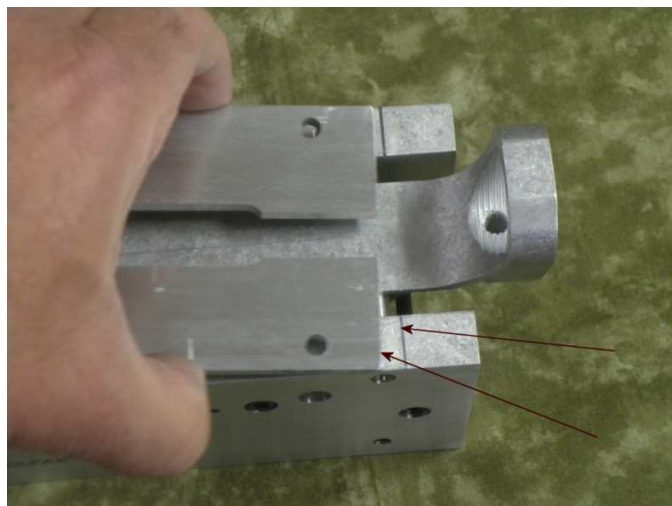


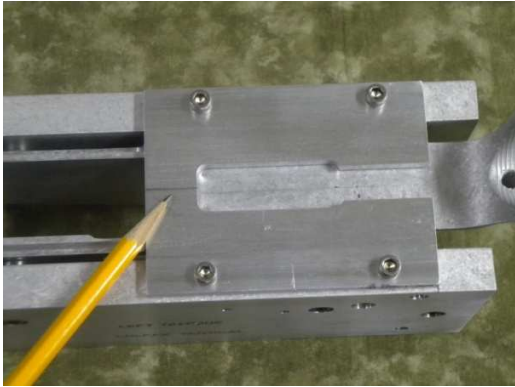
Measure as you adjust to insure parallel sides.

The next step is to scribe the center line of your forging. This is necessary because due to the nature of forgings, they will vary from one to another. A simple method is as follows: Measure the upper rim width of the fire control body area. Divide that number by two. Set your calipers to that number. Scribe the line as shown below.



Line up the right edge of the top plate with the scribed lines on top of the jig sides.



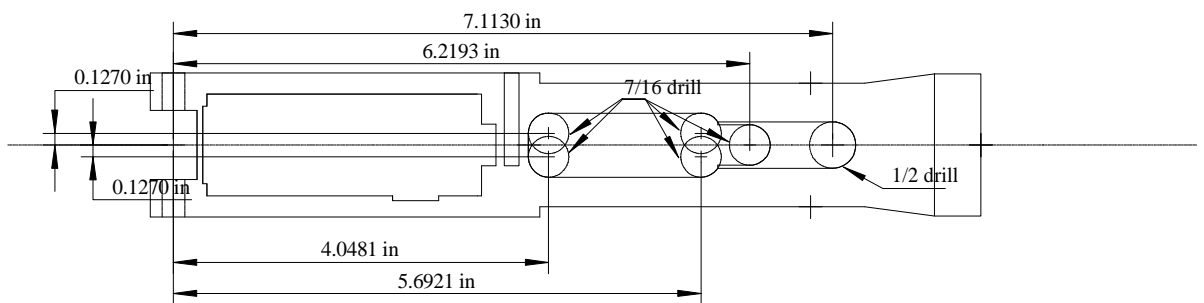


Line up the top plate scribed line with your scribed forging line. You will see that the top plate holes are slotted. This is because no two forgings are exactly the same width. As such, slight adjustments are necessary to center it.

You are ready to machine!  
Below are some basic measurements.

The coordinate origins are as follows:  
X = 0 in the center of the pivot pin (the diameter is 0.2770")  
Y = 0 in the center of your specific forging.

You can pre drill the five 7/16" holes and the 1/2" hole for easier milling. The coordinates are shown.



The remainder of the coordinates are self explanatory and may help the builder with moderate machining skills.

