

PY2AR DIY REINFORCEMENT INSTRUCTIONS



FOR USE WITH AR-9 AND AR-15 PLATFORMS

1. CUT REINFORCEMENTS

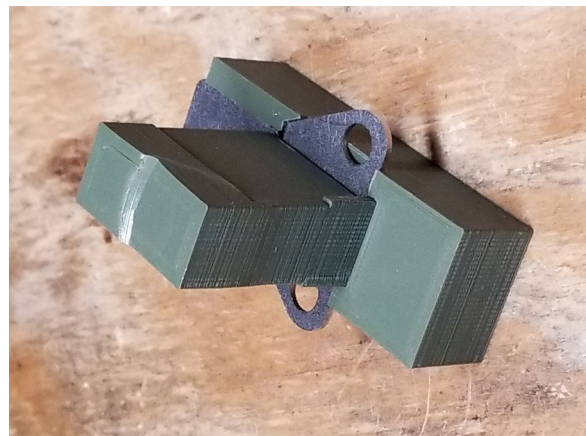
Using provided templates, cut reinforcements from 18 gauge steel (1.2mm). Recommended tools include; files, center punch, drill/drill bits, dremel, metal sheers, vise/press, C-clamp and patience Skip this step if using premade flats.

2. PRINT BENDING JIG

Print jigs on a well calibrated printer to ensure proper bends are made. Print jigs bottom down, 100% infill. Rear top die should be printed on it's side. Files are linked at py2a.com/files

3. FRONT TRUNION

Make sure front dies are used in order. Place front flat into 1st lower die, top die will be used with all lowers. **Note orientaion of top die**



Press jig until bottomed out. Take care not to exceed or dies will be deformed. Remove front trunion from 1st die and place into 2nd die.



Press again until die bottoms out. Remove front trunion and place into 3rd and final lower die.

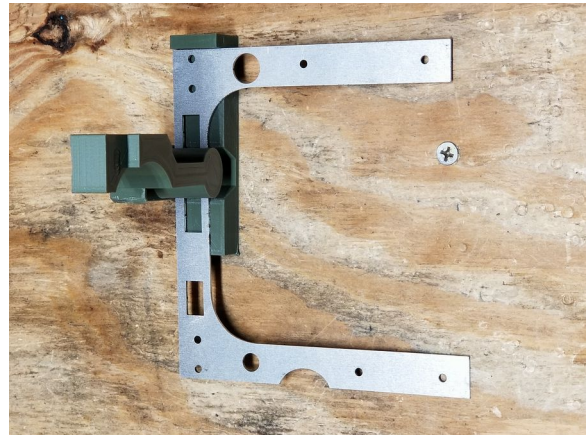
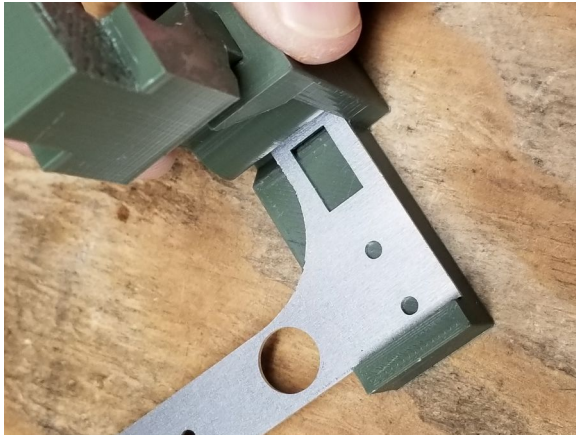


With last die bottomed out in the press or vise, use a C-clamp to squeeze the sides of the lower jig. This will help fold the sides up to their final shape. If a C-clamp is not available, the die jig can be removed from the press or vise, placed on its side and tapped with a hammer.

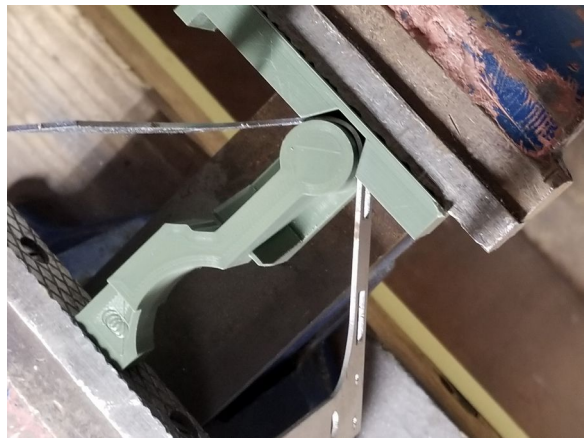


4. REAR REINFORCEMENT

Place rear with flat side against the right and rear rests of the rear bottom press jig as shown below. Insert top rear press die into bottom jig as shown



Using a press or vise, press jig until reinforcement is bent to 90°. Remove top die and bent reinforcement from bottom jig.



Place reinforcement into jig facing the opposite direction as the first step with unbent side against the flat. Bend again until 90°. **Note orientation of top die**

