



FORWARD

DPH ARMS is proud to introduce an extremely well made user-friendly jig that will provide years of service. This product was tested and evaluated prior to its introduction into the market because *we always strive to supply quality products at a good price.*



As a condition of purchase, the buyer/user of the AK Flat Bending Jig accepts all responsibility for its use, including, but not limited to: **complying with all local, state and federal law, regulations and statutes regarding the use, manufacture, and possession of an AK Flat Bending Jig and the manufacture of any AK type firearm as well following safety guidelines.**

In purchasing this product the buyer/user of the "DPH ARMS" AK Flat Bending Jig accepts all responsibility for its use, including, but not limited to: **accepting individual responsibility for following safety regulations and procedures and specifically accepts individual responsibility for any injury associated with the use of this AK Flat Bending Jig.**

Make sure that you visit the ATF's web site and read their regulations regarding the manufacture of firearms for personal use. The user must make sure that they understand what the law requires when building a firearm for your "OWN" use as well as complying with 992r requirements on U.S. compliance parts.

ATF Website: <http://www.atf.treas.gov/>



PARTS DESCRIPTION

1. (2) 1/4" SIDE PLATES (milled to clear the mag dimples)
2. (1) 3/4" CENTER (two sides bolt directly into the center)
3. (1) BOTTOM PIECE

flat stock drilled for 1/4" countersunk bolts and has two precision made pins) that bolts up into the 3/4" centerpiece with four 1/4-20 grade countersunk bolts. The part has two pins that will slip into guide holes on the bottom of the 3/4" center piece

NOTE: use extreme care so as not to damage these pins in any manner which will have a direct effect on the quality of your end product

4. (1) ANGLE IRON BOX

To minimize dragging the hammer and trigger holes inside since they are located on the very bottom edge where the 90 degree bend occurs is flycut, which means that *it is not only smooth but trued as well.*

NOTE: Figure 1 is of the first jig; jigs that are now being made and shipped do not have the grooves in the angle iron box. This is due to the sidepieces not having the steps in them and also using a countersunk allen (hex) head bolt instead of regular bolts. Figure 2 is of the newer jig.

Figure 1

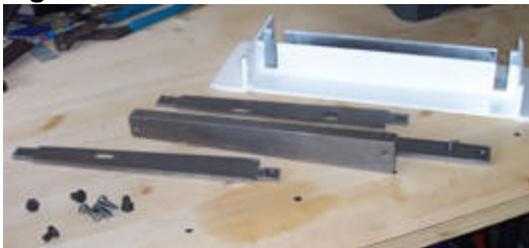
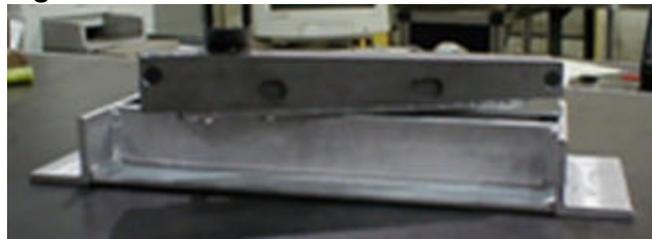


Figure 2





INSTRUCTIONS

STEP #1 – Attach unbent flat to the center

The CENTER PIECE is dual purpose and not only holds the bending to the correct internal dimensions of an AK type receiver but also you to bend the top rails.

Loosen the two (2) bolts (on each 1/4" side plate) at each end of the centerpiece and leave them loose. Remove the bolts from the bottom plate of the centerpiece and remove the bottom of the centerpiece paying attention to the position of the alignment pins (where flat is to be attached).

You will see that the two alignment pins will slide through the two small holes on the flat located at the center of the flat. You simply drop the pins through the flat and then slide the pins into their corresponding guide holes that are located in the center 3/4" piece.



Once you have done this make sure that your magazine dimples are facing inward where they will be once you've bent the flat. Also check to make sure that the magazine hole bent lip is up into the cutout on the bottom of the 3/4" center. Once this is done and the flat is positioned up against the 3/4" piece of the center you simply snug it up- good firm pressure.

Make sure that you wipe this product down and remove any debris or foreign matter that might change the dimensions or mar the surface of your bent flat. *also make sure that the guide holes for the pins are free of debris. This will serve to minimize**

any damage to the flat or this product!

NOTE: use caution when handling the flats because the edges are sharp and can cause a nasty cut

Once the flat is bolted up firmly to the bottom of the center piece it is time to make sure the 1/4" side plates are sitting flush on the unbent flat then tighten the two bolts on each plate. Make sure that the center three pieces- two 1/4" side plates and the 3/4" centerpiece are down against the unbent flat-before proceeding.





This alignment is needed to insure that you get a nice degree bend on the bottom edge of the flat!



Once the flat is attached and all the pieces are tightened firmly and the bottom seems to be in alignment you are ready to proceed

STEP #2 – *Preparing and bending the flat*

Make sure that all debris and junk is wiped off of the parts and lubricate the exterior of the unbent flat where it will contact the outer box, this is especially important for the bottom edges where the 90 degree bends will occur. A quality grease or lubricant such as Lithium grease, wheel bearing grease, Rapid tap, or similar quality lubricant, is recommended.

DPH does not recommend the application of a spray type lubricant such as liquid wrench, spray Teflon, WD40, or similar product because you need to use something that has a more defined base and will provide a layer of a friction-reducing material!

Orient the bending jig so that your press will exert pressure down at or near the center of the jig this will allow the flat to be pressed as evenly as possible. To keep the flat pressed evenly, you may need to adjust the position of the press as you go.



You will see letters on both the top of the center piece and the end tabs of the outer box, i.e., R or B for rear or back and a F for front, the ends are so marked because the stops that are welded in the box will allow you to bottom out in the box and still leave enough exposed out of the top to allow access to the top rail area so that they can be bent prior to removing the center from the box. In other words you will press it to the bottom forming your two 90 degree bends and then while it is in the box you will bend the top rails before removing the center out of the box. The bolts on each of the two sides plates should slide down into their corresponding slots in the box (this is not present on the newest version of the DPH ARMS jig).



Pressing the center down into the outer box you will notice some resistance initially but once the first bends start it should move relatively easy all the way down to the internal stops!



Once it feels like it has bottom out, stop applying pressure so you don't over exert pressure on this product. The centerpiece now holds the flat, which has been bent into a U-shape. The flat is now ready to bend the top rails.



STEP #3 – Bending the top rails

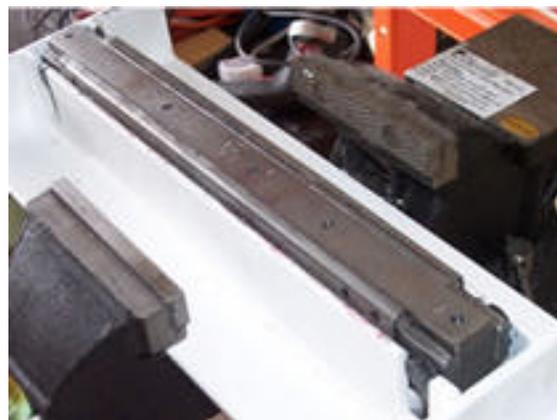
The internal stops in the box allow your flat to stop short of dropping in flush this will allow you room to bend the top rails before removing the center and bent flat from the box.



With a brass hammer, large hard rubber mallet, or other hammer and bucking bar, slowly and carefully hammer the top edge of the flat over the edge of the centerpiece to form the top rail. For best results, gradually hammer over small areas until the rail has folded over and stopped on the top of the center support. Repeat the process and bend the other rail over the top of the centerpiece. ****A large hard rubber mallet can be used because it will not mar the top rails, but you can also try your favorite plastic headed dead blow hammer or a 3 lb. hammer and bucking bar (experiment and see what you prefer).*

The flat has now been bent into its final configuration and needs to be removed from the centerpiece.

Remove the centerpiece from the outer forming box by driving the centerpiece out of the bending jig. The use of a brass bar or wooden block is recommended to act as a buffer and prevent damage to the centerpiece.





STEP #4 – Remove bent receiver from CENTER PIECE

Removing your now bent receiver from the centerpiece is easy and quick!



Simply remove the bottom bolts from the plate that has the pins and set it aside, then take all four of the bolts out of both 1/4" side plates. Once this is done the 3/4" centerpiece will slide or lift free and the two side plates will fall inward away from the magazine indentions.

*****do not try to hammer or pry the center out of bent receiver because you will not only damage your receiver, but more then likely the center pieces of the product! This is designed to fall away once all of the bolts have been removed!**

Once you have removed your bent receiver it is time to clean and oil your DPH jig and box to prevent rust! It is up to you how you care for this product, but proper storage and care will lead to years of use! We recommend that you wrap the product in wax paper or some other somewhat non-absorbing material so that what ever oil you select to apply will not be absorbed! We also recommend this item be stored in a stable environment that is free of moisture! The last thing we want is for this produce to rust up and become useless! Remember if you need to do any type of abrasive clean-up use something very fine (0000 steel wool or scotch brite pad) so as not to alter the dimensions of the quality U.S. made product!



Once again I would like to thank you for your purchase of your DPH ARMS flat bending jig.

Scott @ <http://www.dpharms.com/>