



**\*\*\* MAIN MANUAL \*\*\***

# **The Underground AR-308 System!**

**The Step-By-Step Guide For  
True Patriots Showing How To Get  
A 100% Private AR-308 That's  
Completely "Off The Books"!**

**The Underground AR-308 System  
By Caleb Lee**

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## INTRO

Welcome fellow Patriot!

I'm extremely excited to introduce you to an exciting new opportunity to exercise your God given rights of self defense ... and ... your Second Amendment rights to firearms by showing you how to get your own AR-308!

This powerful guide will show you how to get an AR-308 completely “off the books” so that Big Brother keeps its eyes off your business!

### **Important Note About Laws:**

This guide is for purely informational purposes only. I am not responsible for anything you do with this information. It is provided “as is”. By reading this guide you agree to these terms.

Additionally, I am NOT a lawyer and in no way am I qualified to tell you what is legal Federally or on a state level as it pertains to you.

I am simply telling you “what I have heard” about the legality of all things I write about in this book and I'm exercising my First Amendment rights.

You are fully responsible to know the laws Federally and **Locally** as they pertain to you.

Here are some links about building your own gun pertaining to federal laws. If you are unsure about anything I encourage you to do your own research before attempting anything in this guide.

<http://www.atf.gov/firearms/faq/general.html#gca-manufacturing>

<http://www.atf.gov/files/publications/download/p/atf-p-5300-4.pdf>

<http://www.atf.gov/firearms/faq/firearms-technology.html#commercial-parts-assembly>

Now that the Lawyers are satisfied, **let's get into it!**

## WHAT IS AN AR-308?

In the most simple of terms, the AR-308 is basically an AR-15 that's chambered in .308 caliber instead of the standard .223/5.56 NATO caliber.

But that doesn't tell the whole story, because unlike other AR-15 alternate calibers (like .300 blackout, 6.8 SPC, etc) – which uses the same receivers -- the .308 AR is actually a bigger rifle.

So it's different from the ground up.

In fact, this excellent article by the good folks at GroundZeroPrecision.com (which, as you will see in a minute, I bought a parts kit from) explains the history and origin of the AR-308 very well (emphasis mine).

### **A Nutshell History of the AR-10 & The Rise Of The DPMS Profile .308**

Blogs have been written, Internet forums have been founded and populated, opinions have been opined. Everyone talks about building an AR platform .308 rifle... all the way up to the point where they start trying to get all of the parts together. Then come the questions, and then the questions multiply like breeding rabbits. The thing is that building your own custom AR platform .308 rifle isn't as easy as building an AR-15 where the biggest common considerations are mil-spec vs. commercial spec, to free-float or not to free-float, barrel length & twist rate.

**"Why is that?" you may ask. What is it about the .308 AR that makes building one from parts so much more difficult?** The answer is multi-faceted but can be simplified as follows; historically, lack of general (civilian) interest (or exposure) created a lack of standardization. Where there is no interest there is no market and where there is no market there is no need for standardization.

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**"NO MARKET???", "What the heck man?"... Read on.**

It all began in 1955 when the U. S. Army went looking for a lighter weight alternative for the M1 Garand and Eugene Stoner, machinist and chief engineer for Armalite (then a division of Fairchild Engine and Aircraft Corporation), designed the AR-10 rifle as Armalite's submission.

Looooong story short; the U. S. Army didn't see the value of Stoner's radical new design opting instead for the more "conventional" T44 design submitted by Springfield Armory which would go on to become the infamous M14 Battle Rifle.

Between 1955 and 1959 Armalite produced less than 10,000 "original design" AR-10 rifles, most of which were sold by contract to foreign militaries making an "original" AR-10 one of the most sought after and prized additions to some of the more "well-heeled" collections today.

What caused the most significant change, why I am writing these words and why you are reading them, was Armalite's 1957 re-design where they substantially modified and re-scaled the AR-10 to fire the .223 Remington. Armalite gave their new creation the designation AR-15 (Armalite 15, not Assault Rifle 15!), some licensing agreements happened, some high dollar contracts were signed and the result is what we now know as the M16 and modern AR-15.

So what happened to the AR-10 design after 1957? We're still talking about it today so something must have happened right? Well, kind of... With its design licensed and re-licensed all over the world the AR-10 just kind of plodded along for a long time seeing action with several foreign militaries and having slight design modifications made, most of which were never seen on U. S. soil. It continued to just sort of

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plod along right up to 1996 when Mark Westrom, a former Army Ordnance officer, purchased the Armalite brand and formed Armalite, inc. Seeing an opportunity Armalite, Inc. introduced the AR-10B which they'd designed not based on the original AR-10 but instead on a more popular and more modern version of the AR-15.

## **Enter 'the market'.**

While Armalite, Inc. continues to hold the U. S. trademark on the name "AR-10" a growing number of companies produce rifles based roughly around the AR-10B design.

## **Enter lack of standardization.**

Lack of standardization left the market wide open for interpretation and firearm manufacturers large and small have filled it with proprietary components in attempts to carve out as large a share of the market for themselves as possible. There have been some good concepts that made it to market and there have been some bad. The voice of a free market spoke, market share was divided and at the end of the day two similar but different platform configurations stood clearly above all of the others. The Armalight AR-10 and the DPMS LR308.

## **Standardization? Almost.**

Powered by the Freedom Group, part of Cerberus Capital Management, DPMS grew quickly through mergers and acquisitions to become an industry powerhouse which gave the company a significant advantage over many of the smaller companies competing for .308 AR market share.

## **Adapt or die.**

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What we're essentially left with is the "AR-10 profile" and the "DPMS profile" .308 rifle designs with the DPMS profile commanding a reported 87% of the market.

**87% of the market isn't too shabby and that's why you'll find that our .308 AR product line and all of our .308 project kits are geared generally toward the "DPMS profile".** Are there some variants of each profile we need to address? Yes, and we will address those variants as clearly as possible in the product's description.

Are there some parts that are common between the AR-10 profile and the DPMS profile? What about common parts between the AR-15, AR-10 profile and/or DPMS profile??? Yes and Yes. We've addressed those as well and even custom tailored our search function to make viewing those common parts as easy as a mouse click.

Thank you so much for reading! Now get to shopping!

Y'all take care,

Philip Bennett, *President & CEO, Ground Zero Precision*

## **The AR-308 We Are Building Is a "DPMS Profile" ...**

As you can see from the short story on the history of the .308 AR development, the most common AR-308 is the DPMS profile style which is why we are building this type.

The fact is that "custom" guns are neat and cool and all, but when you are building what could be a "combat" rifle, I would rather have a LOT of parts be common to the market which means they can be easily found in the future, in a crisis, or replaced as they wear ...

So we are building a DPMS spec AR-308 in this guide.

## **Why would you want an AR-308?**

For most Patriots, the answer for wanting an AR-308 is "because I want one!" and that's just fine by me. It's why I want one.

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But also, if you're a hunter – the AR-308 platform is a great starting point for a reliable, good-looking hunting rifle because with more power than the .223 of a standard AR-15 you can use it to reliably hunt big game all over North America.

If you want to get involved in competitive shooting – the AR-308 platform is popular in 3-gun matches and especially long-range shooting competitions ...

If you want a great Home Defense Carbine – the AR-308 can be a wonderful choice in some situations (I'm thinking a rural or otherwise big property where long-distance shooting could occur). And YES, the 25-round standard magazines are quite useful for this purpose—as you don't want to run out of ammo if you have to defend yourself!

And finally, if you just like the act of shooting (like me!) then the AR-308 is hard to beat! You can put a lot of lead down range in a short time – and that's always a good time ☺

## **Why would you want to get an AR-308 that can't be traced to you?**

Simply because the future doesn't look good for us semi-automatic gun lovers—especially for AR-style pattern guns. At every turn, and at every opportunity – the gun grabbers in politics seek to use every power they have to pass laws to get these guns outlawed.

They succeeded with the first Assault Weapon Ban (AWB). From Wikipedia:

“There are no federal restrictions on the ownership of AR-15 rifles in the United States. During the period 1994–2004 variants with certain features such as collapsible stocks, [flash suppressors](#), and bayonet lugs were prohibited for sales to civilians by the [Violent Crime Control and Law Enforcement Act of 1994](#), with the included [Assault Weapons Ban](#). Included in this was a restriction on the [pistol grip](#) that protrudes beneath the stock, which was considered an accessory feature under the ban and was subject to restrictions. Some rifles were manufactured with a grip not described under the Ban installed in its place. Those AR-15s that were manufactured with those features, as well as the accompanying full capacity magazines, were stamped "Restricted Military/Government/Law Enforcement/Export Only". The restrictions only applied to guns manufactured after the ban took effect. It was legal to own, sell, or buy any gun built before 1994. Hundreds of thousands of pre-ban ARs were sold during the ban as well as new guns redesigned to be legal.



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Since the expiration of the Federal AWB in September 2004,<sup>[22]</sup> these features became legal in most states.<sup>[23]</sup> Since the expiration of the ban the manufacture and sale of then-restricted rifles has resumed completely.

At least two states regulate possession of AR-15 rifles either by the restriction of certain features or outright bans of certain manufacturers' models.”

In some super left states – they’ve already banned them AGAIN! Look no further than California or New York to see some of the most draconian gun laws in existence ...

... The same gun laws that put innocent, law abiding civilians in danger because they ensure that the only people with these so called “assault weapons” are the criminals!

With all this in mind, to protect yourself, you might want to get an AR-308 with no way to trace it back to you.

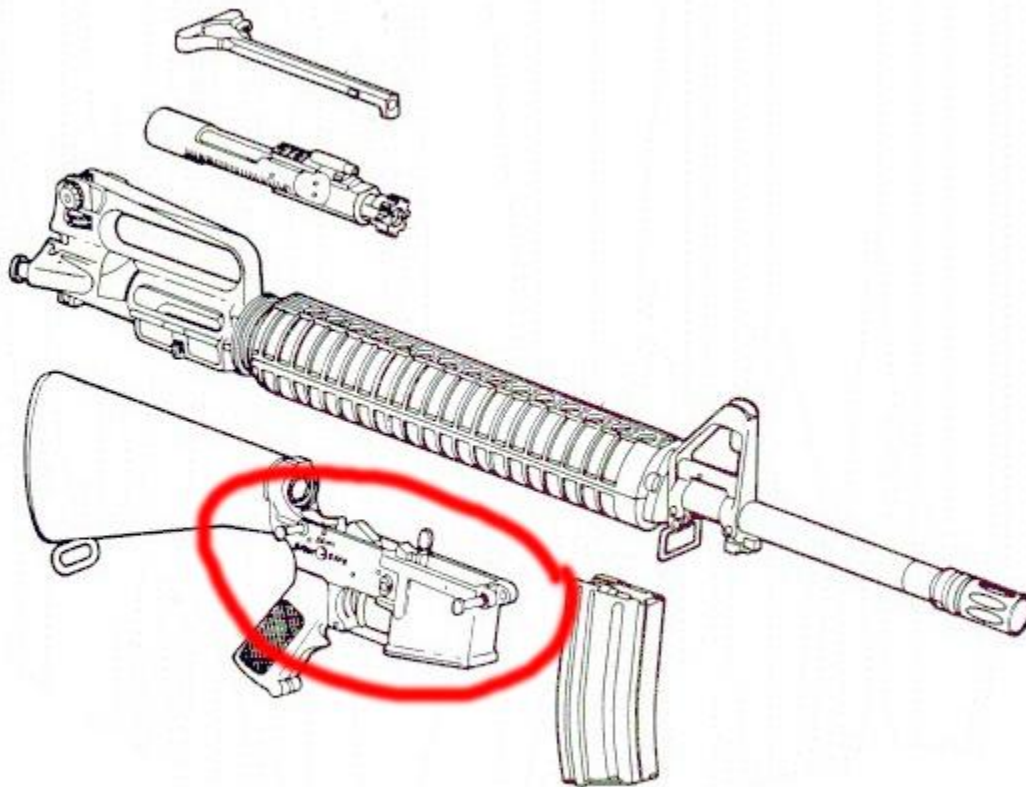
That’s what this short – yet extremely powerful guide will teach you!

## HOW DO YOU GET AN AR-308 WITH NO WAY TO TRACE IT TO YOU?

First, when we are talking about the AR-308 we have to know what we are talking about.

An AR15 is basically comprised of four main parts: **lower receiver, upper receiver, barrel assembly, and stock.** As defined by the BATF, because many weapons these days have modular barrels and other parts, the part or assembly that contains the trigger is the *registerable* part, or basically the firearm itself. In the case of the AR-308 this is the part called the "lower".

This is the actual "Gun" according to Federal Laws – it's called the receiver (shown here with a pistol grip and buttstock already attached):



Now, it's this small part – the lower receiver that's considered the actual “gun” by US Law.

First, let's make sure we cover some definitions (using AR-15 pictures just because it's easier to find what I want to demonstrate):

## Stripped Lower Receiver:

The image to the right is called a “Stripped Lower” – that's because it is stripped of the fire control group, there's no grip, no buttstock and in this case there is no trigger guard:

Yet, this unassuming piece of aluminum is considered the firearm by U.S. law – and as you can see it has a serial number engraved on it. That is so it is traceable. Stripped receivers are usually the cheapest way to build an AR through conventional means. And if you can get one in a private sale – with no paper work – that might be a way to go for you.



## Complete Lower Receiver:

This is what's called a complete lower because it's the stripped lower you just saw – but has been completed with the Fire Control Group (FCG). The buttstock and the pistol grip.

From here, it's very simple to finish your rifle – just slap on an upper receiver and you're good to go!



Again, if you can obtain one of these through a good private sale or through inheritance – then it might be a good way to get your rifle without anyone knowing about it.

From this point, you can see how easy it is to complete the rifle – you just pop the upper receiver on with the barrel, pop a mag in there and you're good to go!

### **But How Can You Guarantee You Get An AR-308 Lower With No Way To Trace It?**

The answer is something that I think all of us Patriotic, DIY, red-blooded Americans would love ... You build it from scratch!

## WHY IT'S NOT THAT COMPLICATED TO BUILD AN AR-308

Luckily for us DIY people, who want nothing more than complete and total privacy and the satisfaction that our AR-308 will be “off the books” forever – building your own AR-308 from scratch is not as hard as it sounds!

The AR-308 is so popular so there is PLENTY of information out there on how to complete your firearm.

And here's the key thing to remember: the lower receiver is the important part. **You only need to find a way to get this one single part without any paperwork because it's the actual “firearm”**—the rest of the rifle is just “parts”.

The rest of the rifle you can already buy and build from parts that are completely legal to own “off the books” and without background checks and there are no serial numbers on any other parts.

And that's another good point too:

The “after market” support is HUGE for this platform which means there are plenty of parts!

So what is the secret to building an un-traceable lower receiver yourself?

Let's review ... An AR-308 is basically comprised of four main parts:

1. lower receiver,
2. upper receiver,
3. barrel assembly,
4. and stock.

... As defined by the BATF, because many weapons these days have modular barrels and other parts, the part or assembly that contains the trigger is the *registerable* part, or basically the firearm itself.

In the case of the AR-308 this is the part called the "lower".

Furthermore, according to the BATF, if the firearm (the lower receiver) is at least 20%

**incomplete**, and the trigger cannot be installed, it is not, by definition, a firearm—it is a hunk of metal.

Basically an individual could *legally* whittle a firearm out of a block of metal and produce a legal firearm assuming it doesn't violate any other BATF specs such as rate of fire, etc.

The only condition is that this home-built weapon is not to be manufactured to be sold (otherwise you would then be considered a firearm maker and you would be in for a TON of red tape and licensing and other considerations because you're now a company like "Colt" who is a "firearm manufacturer"!)

Now, some people HAVE done this!

If you are a CNC machinist – and you have access to the HUGE machines that are super expensive – and plenty of blocks of aircraft grade aluminum -- then more power to ya!

Simply go grab yourself a chunk of aluminum, download some CAD drawings and get to work! You will have a simple time making your own stripped receiver 😊

For the rest of us though, without machining knowledge or the access or money to make our own from these machines ...

## **What's The Solution For The DIY Patriot?**

Enter the 80% lower 😊

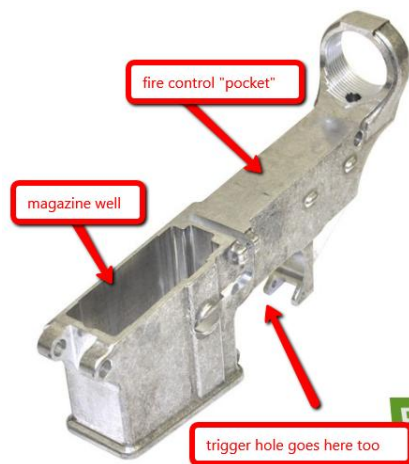
## WHAT IS AN 80% LOWER & WHERE CAN YOU GET IT?

With this ruling by the ATF in mind, several manufacturers sell AR-15 and AR-308 lower receivers that are called 80% because they meet the “incomplete” rule, and the ATF actually evaluates their respective designs, granting them the ability to legally sell these incomplete parts.

Just like the name sounds, they are about “80% complete” on the way to becoming a firearm (or “true” stripped receiver).

That means you have to finish the “Final 20%” to make them into a stripped receiver – which is capable of having the lower parts kit installed in it (the trigger, etc that makes it function!)

Here is a picture of an 80% lower:



As you can see, the magazine well has been drilled out already – but the holes for the trigger and firing components, and other important holes have not been drilled out – those are the final 20% of tooling you will have to complete before it is ready to use!

Here’s a top view of an 80% receiver on the left– you can see that next to the magazine well is milled out and completed.

But the fire control “pocket” where the “lower parts kit” goes (in simple terms: “all the stuff like the trigger and hammer that make the gun work”) needs to be milled out.

And also the hole for the trigger needs to be drilled out too

**NOTE:** you can buy lowers in a state that is before 80% -- such as 0% (block of aluminum), or 35% (where the magazine well isn't even milled out), but the simplest and most cost-effective way for the DIY Patriot is the 80% lower in my opinion, so that's what this guide focuses on.

## **Where to get an 80% Lower**

You can simply Google "80% lower for sale" but there are some sites that have always been recommended by gun builders online.

For the purposes of this manual, for building an AR-308, I highly recommend <http://www.modulusarms.com/> because that's where I bought the 80% lower that I used and also the specialized tools to complete the lower.

If at the time you read this – due to new pending regulations or panic buying or for whatever reason, the websites above are back-ordered you can always look for local sellers in your area OR visit the internet on sites like [gunbroker.com](http://gunbroker.com).

For example, here is a search for 80% lowers on [gunbroker.com](http://gunbroker.com):



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The screenshot shows the GunBroker.com search results page for '80% lower'. The search bar at the top contains '80% lower' and is highlighted with a red box. Below the search bar, there are filters for 'Narrow Your Search' and 'You Searched For'. The search results are displayed in a table with columns for Item, Title, Quantity, Bids, Price, and Time Left. The first item is 'Para Ord 80% Forged Lower Receiver AR15 unfinished' with a price of \$0.01. The second item is 'AR15 80% Complete Forged Lower Receiver No FFI' with a price of \$150.00. The third item is 'Valley Ordnance 80% Billet AR-15 Lower Receiver' with a price of \$160.00. The fourth item is '80 % AR-15 LOWER RECIEVER M4 TM-15 AR15(2) AR-15 7075-T6 LOWER RECIEVER AR15 M 4 (2)' with a price of \$545.00. A red box highlights the 'results!' text in the 'Narrow Your Search' section.

Item	Title	Quantity	Bids	Price	Time Left
329765456	Para Ord 80% Forged Lower Receiver AR15 unfinished NO FFL reciever forging ar 15 blank percent billet	1	1	\$0.01	22h 22m +
329118518	AR15 80% Complete Forged Lower Receiver No FFI	1	19	\$150.00	1d 1h +
329154129	Valley Ordnance 80% Billet AR-15 Lower Receiver	1	8	\$160.00	1d 9h +
329716348	80 % AR-15 LOWER RECIEVER M4 TM-15 AR15(2) AR-15 7075-T6 LOWER RECIEVER AR15 M 4 (2)	1	0	\$545.00	2d 4h +

Most likely, you will be able to find a private seller there who you can buy them if the above sites are back-ordered or out of stock.

Now you could use trial and error and download blueprints from the internet and use that method to figure out how to drill your lower to complete it ... but ... it's much easier to use a JIG.

## Where to Get A "Jig" to complete Your Lower

The one I would recommend is from <http://www.modulusarms.com/> -- they are both good quality jigs that will help you complete your lower and have good reviews by gun builders online.

**(I REALLY like the Modulas Arms jigs. If you want to do both a .308 AR and a standard AR-15 then I would highly recommend buying both those jigs from Modulas Arms. I have used at least three different types of jigs by different companies and the Modulas Arms jig is my favorite by far!)**

The reason I like the Modulas Arms Jig so much is because it allows you to use a standard router power tool to finish the milling work on your jig. This means you can do the milling work with a tool that is more like a milling machine ... and not ... a drill press (which is designed for drilling, not milling).

In short, you get a much, much better final product using a router with the Modulas Arms jig in my opinion!

Again, if you can't find it from the above sources you might be able to find a Jig by searching on the above auction sites like you did for an 80% lower.

Now what to do once you GET your 80% lower?

## HOW TO FINISH AN 80% LOWER

Now, there are a lot of ways to finish your lower. If you have access to CNC machines and you have experience there then that might be a way to go.

But for the DIY patriot like us – we can complete this rifle in our garage with little more than a drill and a drill press, some other simple tools, and some good old red-blooded American Elbow Grease!

What's more: because you can buy a jig to help you out – you don't have to be a whiz with measuring for where to drill. It's mostly done for you and pretty easy to use.

If you're into measuring/blueprints and the like – then feel free to search online for some blueprints and measurements and if you trust your skills enough you could make this work without a jig. For most of us though—I say use the jig!

In fact, depending on where you buy your Jig – it will probably come with an instruction guide and show you how to use it.

In the meantime, I will show you the basic process for finishing your 80% lower and making it into the base of your new AR-308!

### **The Simple method to finish your 80% receiver using a drill press & router:**

Now, if you already have a mill, then finishing your 80% lower will be easier. However, for most of us the price of a mill or availability of one is not really an option. That's why you can get this done with a simple & inexpensive drill press that

- 1.) Most people either have access to or
- 2.) You can buy cheaply.

And in fact, using the Modulas Arms jig kit, you can actually forego the drill press and use hand drills ... although it might be more work. I don't know because I had already bought a drill press to complete my AR-15's so I used that for the AR-308 as well.

With the drill press you will be taking out the majority of the material, then with the router you will be milling out the rest of the material and cleaning up the spaces.

It's pretty simple.

Please follow all normal safety precautions that a smart person would follow while using power tools and cutting/drilling equipment. The main thing is to take your time and don't try to rush.

## Tools required:

- Drill Press or hand drill.
- A Router (full size or laminate)
- A Vise (a drill press vise is fine)
- A set of allen wrenches (although I think you only need a 3/64" and a 3/32" allen wrench)
- Front take down pin from your lower parts kit (pin, detent and spring)
- A couple C-clamps for holding stuff down
- I also used a plastic tarp and a shop vac to help keep things clean. Use safety protection like goggles because you'll be sending sharp pieces of aluminum everywhere that could mess your eyes up.
- **Universal AR-308/AR-10 80% Lower Receiver Jig** from Modulas Arms (<http://www.modulusarms.com/universal-ar-308-ar-10-80-lower-jig/>)
- **"Jig Fabrication Tool Kit"** from Modulas Arms (<http://www.modulusarms.com/jig-fabrication-tool-kit/>) or you will need to buy these parts separately if you don't get them through Modulas Arms. Kit includes:
  - Solid Carbide End Mill Bit
  - 3/8" Drill Stop
  - 5/32" Drill Bit
  - 19/64" Drill Bit
  - 3/8" Drill Bit

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**NOTE:** The Modulus Arms Jig Kit comes with EXCELLENT instructions on how to complete your AR-308 lower using their equipment. You can find that here in addition to my instructions below and the video instructions that I filmed for you that come with this program. You can find Modulus Arms's instructions at this link:  
<http://www.modulusarms.com/jig-instructions-overview/>

**\*\*\* The Written Instructions Below  
Are Only Meant to Give a BRIEF  
Outline Of The Entire Process of  
Completing Your Lower -- PLEASE  
Watch The Videos Included With  
This Course for STEP-BY-STEP,  
More Detailed Instructions! \*\*\***

## Step 1: Mount Jig on Receiver

The Modulas Arms Jig kit that we'll be using makes this pretty simple, here's what it looks like when you get it:



And then you'll put on the front takedown lever, the rear buffer tube support, the side plates and the top plate ... All the parts are attached by Allen Wrench screws, making the entire kit very secure and solid:



## Step 2: Drill and Mill The Trigger Slot

The first thing you're going to do is install the trigger slot drilling attachment to the jig. Here's what it will look like:



Then you're going to drill those two holes for the trigger slot ...





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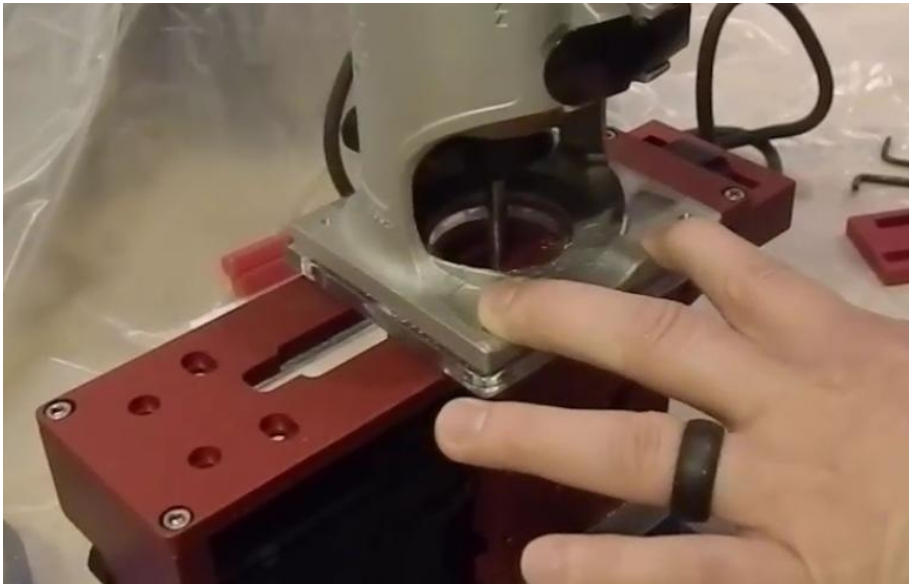
Your drilling will have created two nice holes all the way through the receiver (though not through the trigger guard, obviously)



Then using your router, and the included depth gauge – using the (A) slot – start milling at the first hashmark ...



When milling, you start at the first hashmark and drop the mill into one of your drilled holes. Then you slowly go in clockwise circular motions removing bits of aluminum and attempting to eliminate all the material in between the two holes with the mill.



Take your time, and when you remove all that you can at the one hashmark – you simply turn the router off **FIRST**, then remove from the jig and move to the next 1/8<sup>th</sup> inch hashmark and repeat the process. Here's what the milling is accomplishing, see how it removes the material between the two holes that you just drilled:



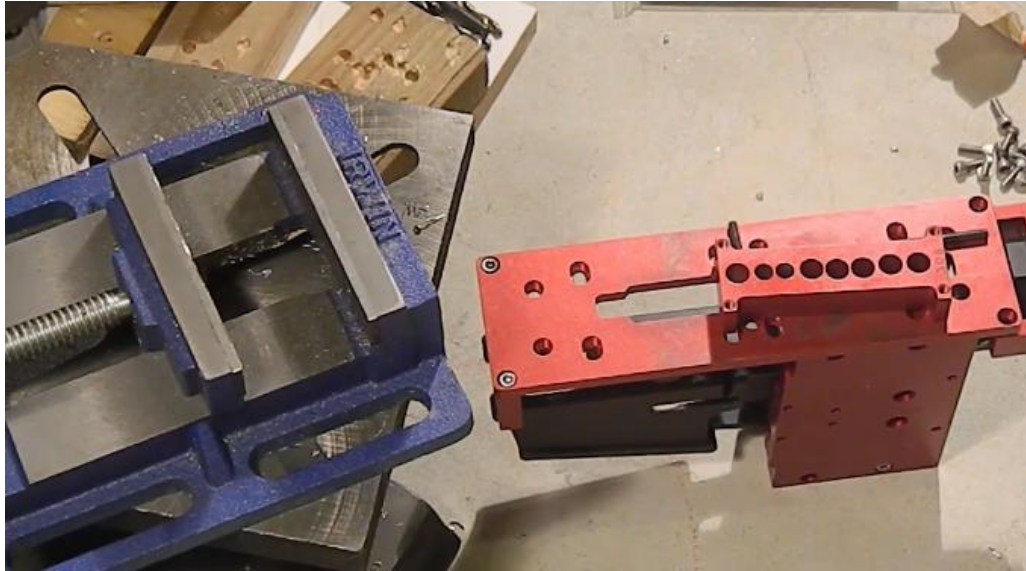
And by the end of the process, you will have drilled and then milled all the way through the receiver giving you a nice trigger hole as shown in the next picture:



When you have completed this step, you move onto the next step. Drilling and milling the rear shelf ...

## Step 3: Drill and Mill The Rear Shelf

We're going back to drilling first, so you'll put the drilling template back on the jig to do the drilling of the rear shelf ...



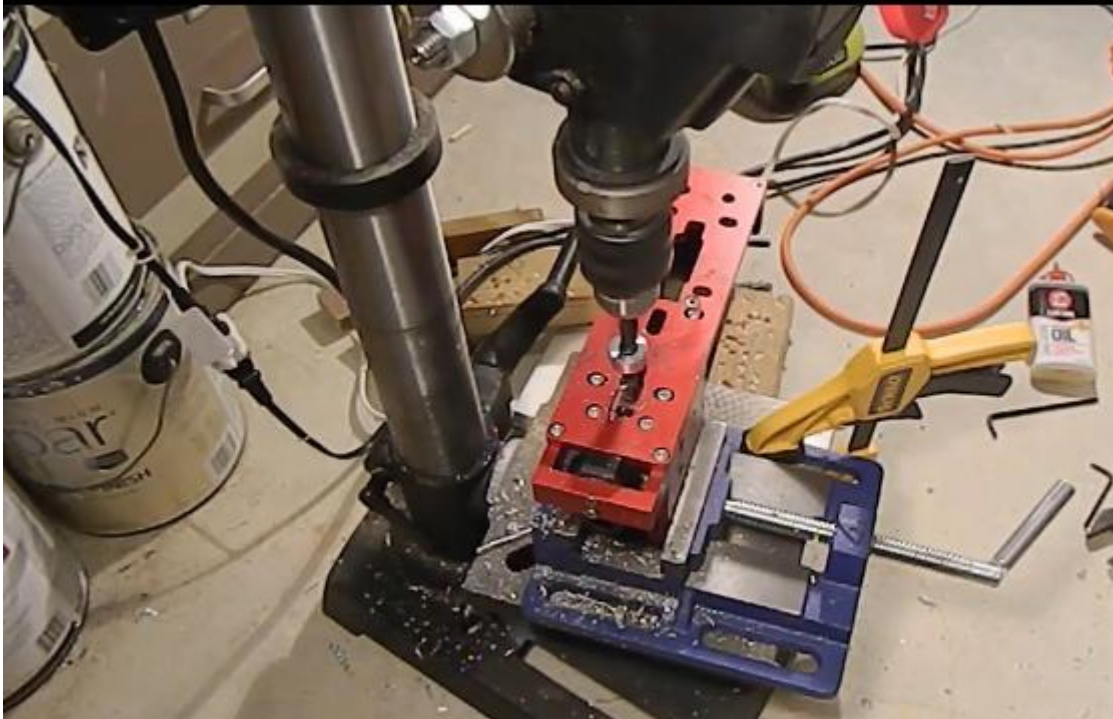
Using the (B) mark on the depth gauge, along with the drill bit stop, will set the proper depth for drilling ...



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... you'll drill to the proper depth to remove as much material as possible from the rear shelf, drilling in all three holes in the template ...



Then you'll remove the drilling template from the jig, and using the depth gauge again set your router end mill bit to the first hashmark of the (B) depth gauge ...



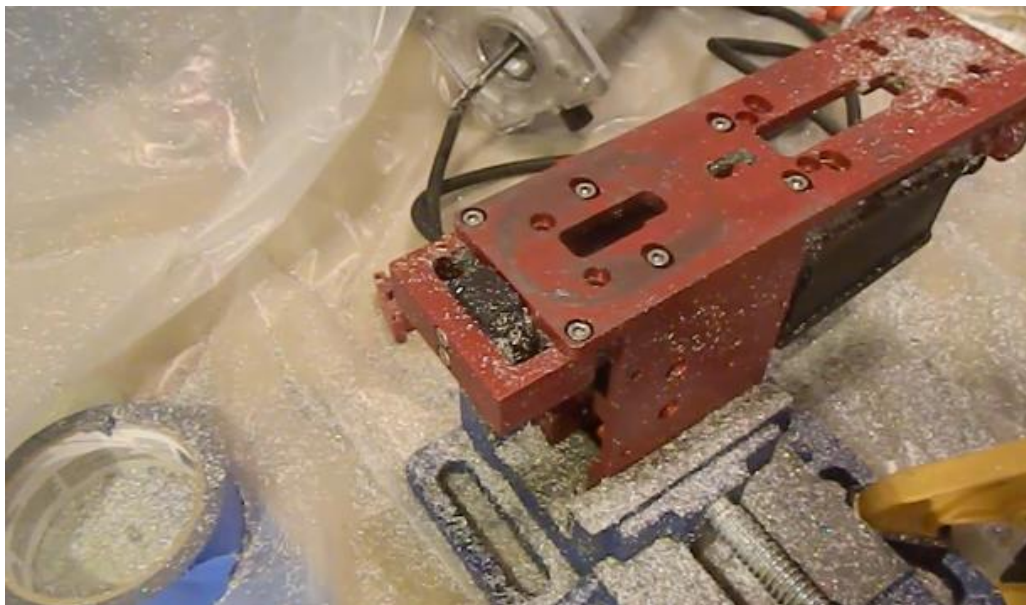
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And working in 1/8<sup>th</sup> inch increments, you'll continue to mill the rear shelf



Note, at this point, you will have realized there are a LOT of shavings of aluminum everywhere and you should be cleaning up in between depth passes of the router because it can clog the cutting part of the end mill and it just generally makes a mess. That's also why I put down the plastic tarp for the milling portions of the build ...



When you complete this step, you will see that the rear shelf is completely milled out and that the trigger slot and the rear shelf are now done!

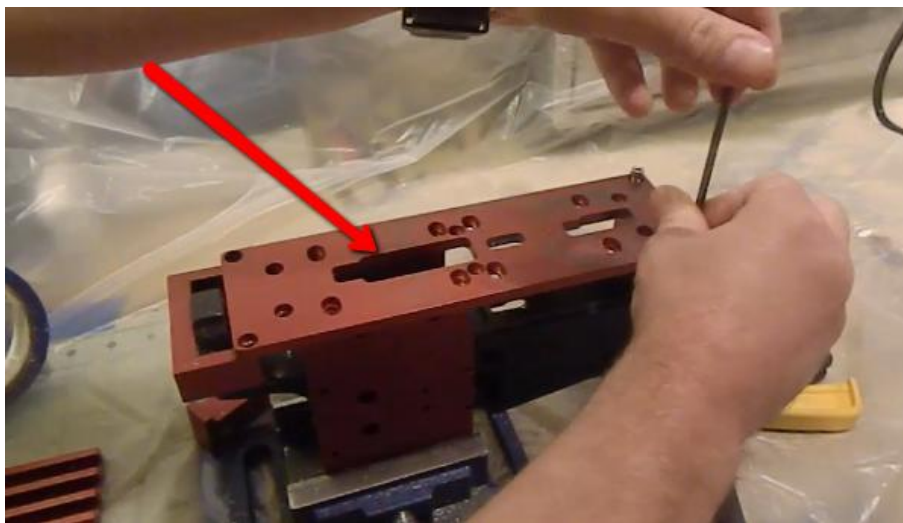


## Step 4: Drill and Mill The Fire Control Pocket

At this point, you'll have to switch around your milling template on the top of the jig so that the fire-control pocket template is now closest to the buffer tube. In the picture below, you see that the fire control pocket milling portion of the template (arrow pointing at it) has been sitting over the magazine well in all the previous steps:



So you'll need to remove the screws and flip it around so that it now sits over the rear shelf/fire control pocket area (the area closest to the buffer tube, or left side of this picture), as shown below:





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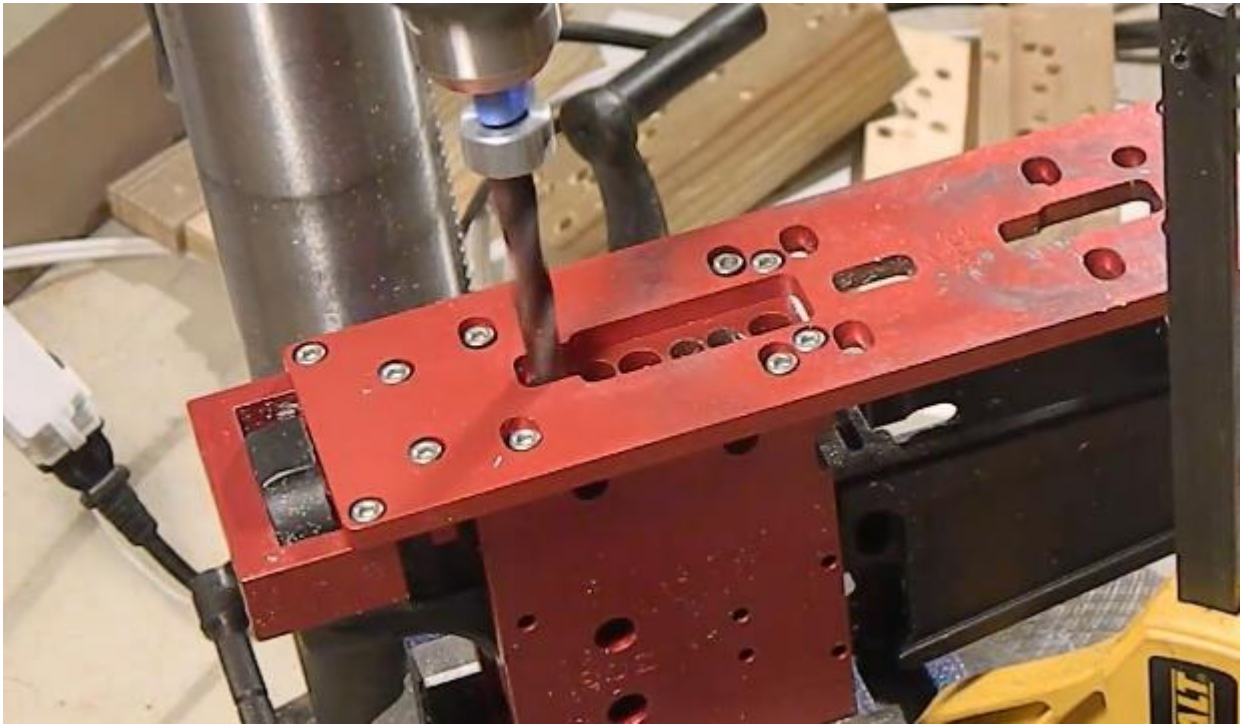
Now, you attach your drill template because the first step is drilling again ...



And drill the four holes with the 3/8<sup>th</sup> inch drill bit that's included set to the (C) slot of the depth gauge:



Simply drill all four of the holes ...



Making sure to stop every once in a while and make sure your drill bit stop did not come loose, so you're drilling to the proper depth – and also use plenty of oil to keep the bit from getting too hot and to help extract as much material as possible:



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When you're done, you'll have all your holes drilled as in the pic below and be ready to mill ...



Again, use the (C) slot of the depth gauge, and start with the first hashmark to set your milling bit to in the router, and using the 1/8<sup>th</sup> inch depth passes, start to mill the drill holes you just drilled in the fire control pocket ...





When you complete this step, the entire fire control pocket, along with the rear shelf will be milled and looking nice as in the picture below!



Notice the trigger hole which you did earlier ...

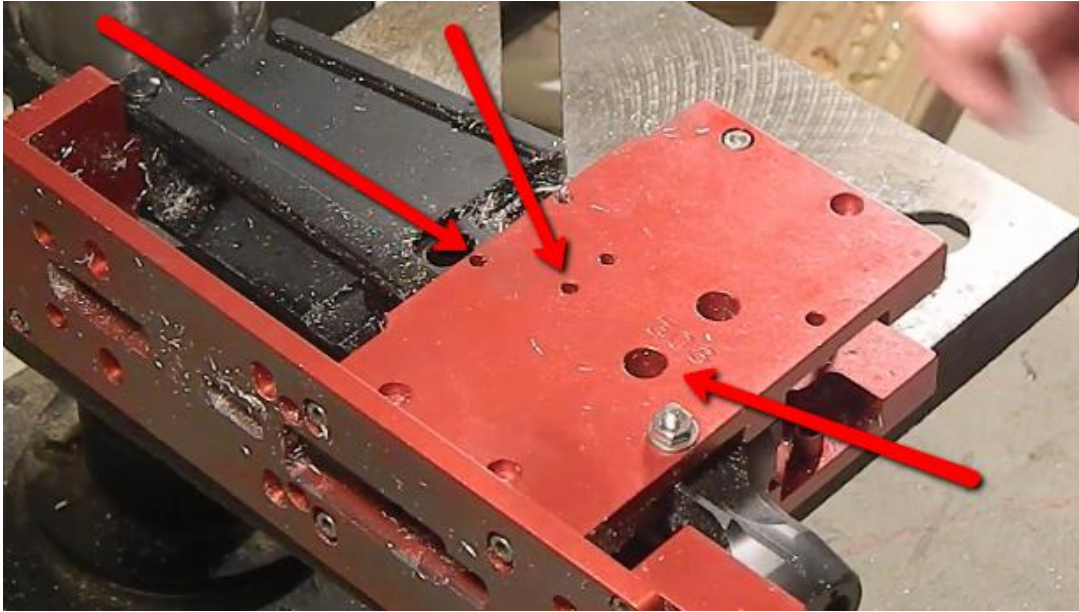


And the hole for the grip screw that will hold your handgrip on later.

Once you get the lower to this state, you're ready to move on to the final step!

## Step 5: Drill All Your Fire Control Pin Holes

This is the final step and you'll have to drill all the fire control pin holes as shown in the picture below with the red arrows I drew to point to them ...

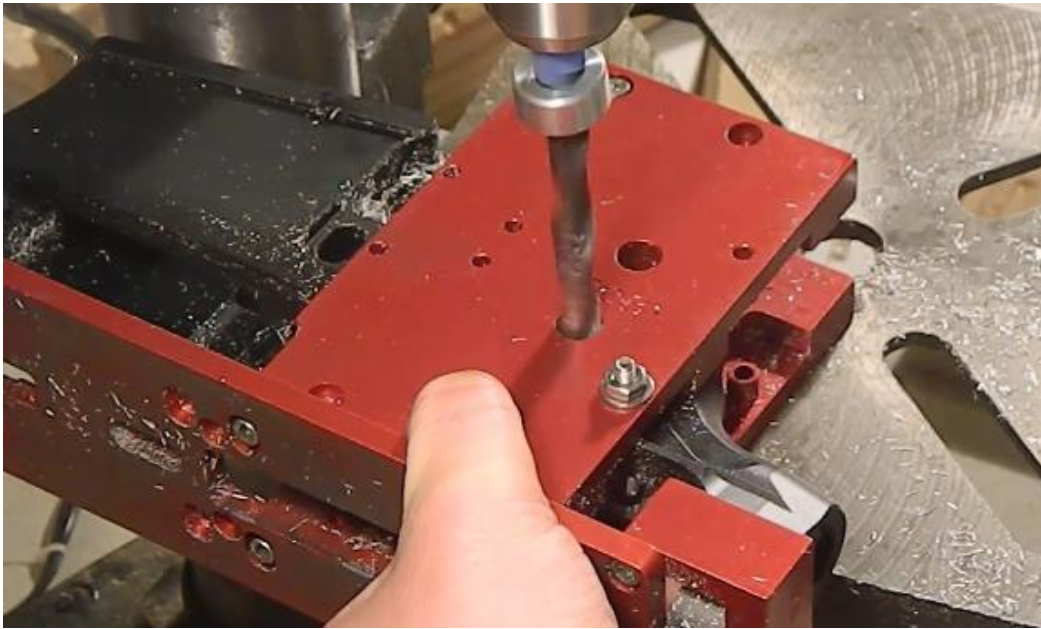


Be aware, you're not drilling ALL The holes in the template, just those three ...

Also, only drill one side at a time, then flip it over and do the other side to get as much help out of the jig as possible.

And also, you'll insert the rear takedown screw through the rear take down hole in the side plates and receiver and tighten it down before you start drilling (you could not use this screw in earlier steps because you would have drilled and/or milled into it!)

First up, is the big drill bit, the 3/8" drill bit for the safety selector (the big hole):



Then using the 5/32" drill bit, drill the trigger hole ...



And then the hammer hole using the same size drill bit ...



Then flip the jig over and repeat ALL three holes on the other side. Make sure that you are drilling the correct holes at the top of the jig template and that they all line up!



At this point, the entire work of drilling and milling for the 80% receiver is done!



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You should have a lower that looks somewhat like this, with the fire control pocket, rear shelf and trigger hole milled out ...



And your safety selector and trigger and hammer holes all drilled out:



In other words, CONGRATULATIONS! You just completed your firearm :)

## **Step 6: Test Fit**

This is the final step! You'll need a full "lower parts kit" which will include your trigger, hammer, safety selector and pistol grip. Attach and install them all and see that they fit and function the way that they should.

(Finishing your stripped receiver with the lower parts kit is covered in the next couple chapters)

Quick tip: you may not want to install the pivot and take down pin detents until you apply whatever finish you're going to give to the receiver because they can be hard to get out once you install them.

Congrats you now have a "stripped" lower receiver – a completely private AR-308 "Gun"!

## SHOULD YOU SERIALIZE YOUR LOWER?

Now, the main benefit to building your own AR-308 from scratch is that there is no serial number on your rifle ... there is no record of it “on the books” ... and nobody but you will know that you have it.

The fact that there are no markings or serial numbers on your weapon could also be a drawback as well ...

Consider these two possible reasons why you might want to serialize your lower:

1. You are using your rifle at the range, or hunting with it and you encounter law enforcement. They become suspicious that you have no serial numbers on your weapon and they assume that you filed off the serial numbers like a criminal would to make your weapon untraceable!

This is a serious offense and you could get in a lot of trouble. Many people would rather serialize their weapons themselves to avoid such a conversation/explanation.

2. Your rifle is stolen, and you want to report it to the police – you will want to report the serial numbers, make and “manufacturer” along with any other distinguishing marks so they know it is yours – that you reported stolen – if it ends up somewhere it’s not supposed to be.

For these reasons (and probably some more that you could think of) it might be a good idea to mark your lower receiver.

This can also be a great way to add your own unique and personal artistic “touch” to the rifle. Some builders on the internet have taken to making beautiful custom designs on their rifles – which you can do as well.

This could be especially cool if you intend to make the AR-308 that you built from scratch a family heirloom to pass onto your children—what a story that would be for them!

## What Should You Engrave On Your Lower?

It is up to you, but here seem to be some popular choices:

**Manufacture** (this could be your name)

**City State** (if you feel like it)

**Model** (AR-308 or whatever you wanna call your AR-308)

**Caliber** (.308)

**Serial #** (most people online recommend something like your initials and a number—example: CL—0001.)

NOTE: most sources suggest a max of 10-12 letters/numbers per line.

Another cool idea I saw, was a guy put a quote from the second amendment on his lower—very patriotic!

## How Can You Do It?

First, there are some people that you can send your 80% lower to and have them do it for you for a small fee. I know of one such person at [VaderTactical.com](http://VaderTactical.com) whose prices seem very reasonable.

Alternatively, if you know anyone in the laser etching industry—they might be able to help you out too.

Then of course, there is the DIY method we all love ☺

Your own serial numbers can be made with a sharp etching tool such as small chisels and other methods. Depending on your skill level, you can do it this way.

The other method is to etch your markings using electrical etching. This is a method that a lot of DIY knife makers like to rely on (as well as DIY 80% gun builders) to add designs and etching to their weapons and you can do it that way too.

## What Should You Coat Your Lower With?

The last step, after you've made any markings on your lower that you want is to coat it to protect it from the elements and to make it look better.

A common option is to anodize your lower with home anodizing kits. You can choose a variety of colors for this and because this is how most commercial lowers are finished—it will work great.

Another cheap and easy option is to just spray paint the dang thing!

Any good tough coating/paint that will bond to aluminum would work in this case. Some “purists” might cringe at the suggestion, but there are many people that finish their AR-308’s after building them with a “camouflage” colored paints – so it IS an option.

At this point it is up to you whether you want to serialize your receiver and how you want to coat it.

## HOW TO FINISH YOUR AR-308 NOW THAT YOU HAVE A “STRIPPED LOWER”

Ok, once you have your 80% lower turned into a real receiver—you are ready to finish it. At this stage it is the exact same as if you had bought a commercial “Stripped lower”.

Recall that a stripped lower is simply the lower receiver with none of the parts inside it—no fire control group, no nothing.

You will need all the parts that go inside to make it function – these are titled “lower parts kits”.

### The Easiest Option ...

It might be easier if you just purchased an ENTIRE kit at once that has everything you need, without shopping around.

If that sounds like you, then I highly recommend the DIY kits at GroundZeroPrecision. You can choose the barrel lengths you want, etc and many other options.

The ONLY things you’ll need if you go this route are:

- The stripped AR-308 DPMS profile lower receiver that you just built using your drills and mills ...
- A handguard to cover the barrel ...
- A stock that you can choose ...
- Magazines that you can choose ...

That is why I highly recommend these kits if this is your first time building an AR-308 because you can get all the essentials from Ground Zero Precision and then you can choose the stuff like the handguard, stock and grip to make your rifle look the way YOU want it to!

Basically, this is the “easy button” solution!

The kit I went with was the **“16” .308 AR (DPMS Profile) Project Build Kit - 308-BA-AERO-KIT-16-1** found here <https://www.groundzeroprecision.com/collections/ar-10->

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[1r-308-build-it-yourself-project-kits/products/16-308-ar-dpms-profile-project-build-kit-308-ba-aero-kit-16-1?variant=8256313729](https://www.ballisticadvantage.com/products/16-308-ar-dpms-profile-project-build-kit-308-ba-aero-kit-16-1?variant=8256313729)



Here is the description from their page, so you can see how complete this kit is!

Building your own custom .308 AR rifle is a snap when you have all of the right parts. It's even easier when someone has already done the legwork to source all of the components, made sure they are of the highest quality and fit and then put them all into a nice little package for you and it's a complete no-brainer when they do all of that and then offer it to you at a price you cannot beat if you tried putting it all together yourself AND THEN offering to ship it all to you FOR FREE!

Well that's exactly what we have done and we guarantee you're going to like it!

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**Just add the DPMS profile stripped .308 lower receiver, hand guard, stock & mag of your choice and you're ready to go. This kit has everything else you need.**

This project kit includes all of the following high-quality parts:

- 16" Ballistic Advantage .308 SOCOM, Medium Tapered Barrel, 1:10 Twist, Mid-Length Gas System, QPQ Nitride (Black) Finish, Threaded 5/8 X 24, Magnetic Particle Inspected, 4150 Gun Quality Steel
- Aero Precision M5 .308 Upper Receiver - 7075 T6 Aerospace Grade Aluminum, Black Anodized Finish to MIL-A-8626 Military Specifications, Forward Assist and Ejection Port Cover Pre-Assembled
- Aero Precision M5 .308 / 7.62 Complete Bolt Carrier Group, 8620 Steel, Mil-Spec Phosphate Finish, Chrome Lined, Forward Assist Serrations, 9310 Bolt, Magnetic Particle Inspected (MPI), High Pressure Tested (HPT), Properly Staked Gas Key
- Ground Zero Precision Stainless Steel .750 Low-Profile Gas Block - Natural Stainless Finish
- Seamless Stainless Steel Mid-Length Gas Tube with Roll Pin
- Mil-Spec A2 "Birdcage" 5/8 X 24 Flash Hider - with Crush Washer - Matte QPQ Nitride (Black) Finish
- Mil-Spec .308 / 7.62 Charging Handle with Extended Latch - Black Hard Coat Anodized 7075 T-6 Aerospace Grade Aluminum
- Nitride Enhanced Mil-Spec .308 Lower Parts Kit with Mil-Spec Fire Control Group and Next Level Armament Extended Magazine Release Button for .308
- Mil-Spec Dimension .308 6-Position Carbine Buffer Tube - 6061 Aluminum, Black Hard Coat Anodized, Threaded for DPMS Profile Lower Receivers
- .308 Carbine "Stubby" Buffer
- .308 Carbine Buffer Spring



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- Mil-Spec .308 Castle Nut - QPQ Nitride Finish (Black)
- Mil-Spec .308 End Plate - Phosphate Finish (Black)

You can find all their kits on this page:

<https://www.groundzeroprecision.com/collections/ar-10-lr-308-build-it-yourself-project-kits>

If you decided not to buy a complete kit like that ... then you will still need all those parts.

In fact, you can use their list of parts as a “shopping list” to find exactly what you want from other companies or look for sales or whatever.

## Tutorials For Assembling Your Rifle

It would be stupid for me to try and copy what has already been written about how to assemble your AR-308 rifle when there are experienced gun builders online who have already done it (and they're much more experienced and better at tutorials than I).

Here are two classic build guides from 308AR.com – a very resource full site:

**How To Assemble The .308 Lower Receiver:** [https://308ar.com/assemble\\_308\\_lower/](https://308ar.com/assemble_308_lower/)

**How To Assemble The .308 Upper Receiver:** [https://308ar.com/assemble\\_308\\_upper/](https://308ar.com/assemble_308_upper/)

(After building both the lower and upper, you just snap them together with your takedown pins)

Now because it's the internet age there are a TON of guides on YouTube showing how to assemble your AR-308 from parts. For example, here is a playlist (group of videos) showing the complete assembly process:

[https://youtu.be/N\\_AMFf0lKtI?list=PLoLU2tQ3RAP\\_aSaOdGBKWih3\\_UcIoWnVB](https://youtu.be/N_AMFf0lKtI?list=PLoLU2tQ3RAP_aSaOdGBKWih3_UcIoWnVB)

And there are many others, simply go to Youtube and in the search bar type: “How to build .308 AR” or a similar search term and you will see some great youtube videos!

## ENJOY YOUR RIFLE!

Congratulations Patriot!

You now have your own AR-308 that is completely “off the books” and just the way it should be – PRIVATE ☺

I hope you enjoyed this guide and I sincerely pray that it helps you reclaim your privacy, safeguard your freedom, and empowers your Second Amendment Rights!

Speaking of the Second Amendment ...

### A Suggestion ...

You may not think it, but your voice counts!

If you care at all about your rights, your freedoms, and fighting the anti-gun criminals in Washington – then you need to step up and join the fight ...

I would encourage you to join the NRA – the National Rifle Association if you haven’t already. They’re not perfect but they’re one of the biggest pro-gun lobbyists in Washington and are friends of us Patriots and the Second Amendment. More information can be found at: [home.nra.org/](http://home.nra.org/).

I would also encourage you to join the Gun Owners of America (GOA) at [gunowners.org/](http://gunowners.org/). They are also an excellent organization. The highest praise I can give them is from a Patriot I truly respect: “The only no-compromise gun lobby in Washington” – Ron Paul.

Another excellent group that I recently joined – and support monetarily – is the National Association for Gun Rights (NAGR) -- [www.nationalgunrights.org/](http://www.nationalgunrights.org/).

In addition, I encourage you to join whatever LOCAL groups there may be available to you – to get involved at the LOCAL level – as much headway can be made here for gun rights and your voice is sure to be heard.

Myself, I’m a member of the Virginia Citizens Defense League (VCDL) at [VCDL.org](http://VCDL.org). They are a grassroots organization. I believe this same organization model is in many

other states and I would encourage you to find the one nearest you and to join it (just Google “INSERT YOUR STATE + citizens defense league”).

Once you join these organizations – make sure you use your best email – and then they will alert you when there is anti-gun legislation coming up for votes at the local or federal level and you can respond with other Second Amendment supporters to encourage your representatives to fight these freedom robbing laws!

### **It truly is up to us!**

At no time in history (primarily because of the wonder of the internet!) has it been easier to get information on what the Government is doing behind closed doors ... to be notified almost immediately when freedom-stealing legislation is going to pass ... and ... to fight back so that the PEOPLE have a say in Washington!

If we all give up or think our voices won't matter – then it is a self-fulfilling prophecy and nothing will change.

But if we all let our voices be heard—then we can at best change the direction of the Nation for our future, our children's future and future generations ...

... And at worst – we can delay the power hungry politicians from taking away our freedoms one small bite at a time.

If you consider yourself a Patriot I encourage you to fight for the former!

All my best,

Caleb