



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

# **The Underground 3d-Printed Glock System!**

**The Step-By-Step Guide For  
True Patriots Showing How To Get  
A 100% Private 3d-Printed Glock  
That's Completely  
"Off The Books"!**

**The Underground 3d-Printed Glock 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 by showing you how to 3d-print your own Glock-compatible handgun!

This powerful guide will show you how to get this Glock compatible firearm completely “off the books” by building it yourself, so 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. **This is extremely important**, because in recent years, states such as New Jersey and California have either passed or attempted to pass laws to outlaw 3D gun printing and building your own guns. Do your research!

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>

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

## WHY IT'S SIMPLE TO BUILD A GLOCK-COMPATIBLE HANDGUN

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

Here's the key thing to remember: the 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 handgun is just “parts”.

The rest of the handgun 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.

In fact, you can order all the other parts right from the mail and have them delivered to your doorstep and there's absolutely no problem with that because that's totally legal.

And that's another good point too:

The “after market” support is HUGE for the Glock platform which means there are plenty of parts for you to build a Glock-compatible handgun!

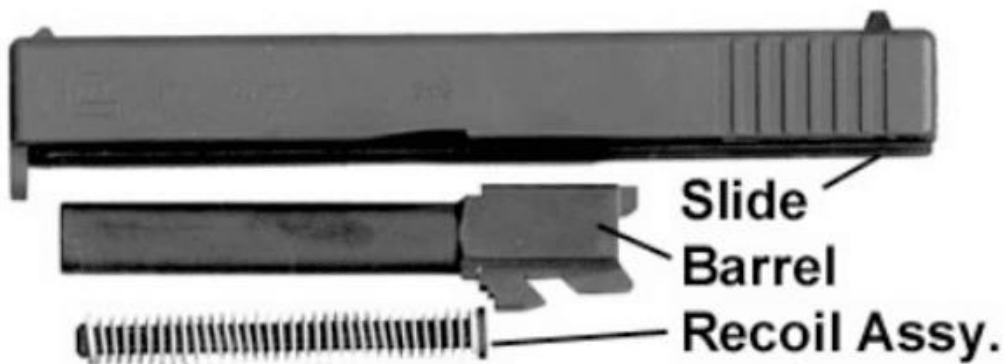
You can choose to build your handgun in whatever way you may desire – but I suggest simply starting with the Glock 19 compatible handgun because it's the “basic” build ... and ... I also recommend building from a kit of parts that are MEANT to go together to make it easier on yourself.

Let's review ... a Glock is basically comprised of two main parts:

1. LOWER RECEIVER/FRAME - and the parts inside it (this is considered the firearm) as pictured below...



2. UPPER RECEIVER – this is the slide, and parts inside it (this is not a firearm)



... 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 Glock this is the part called the "receiver" or "frame".

So basically, you just have to acquire or build the receiver yourself...

## **Why It's 100% LEGAL To Build Your Own Gun "Off The Books"**

Many Americans don't realize that it's totally and completely legal at the Federal level to build your own firearm (a Privately Made Firearm (PMF)) for your own personal use.

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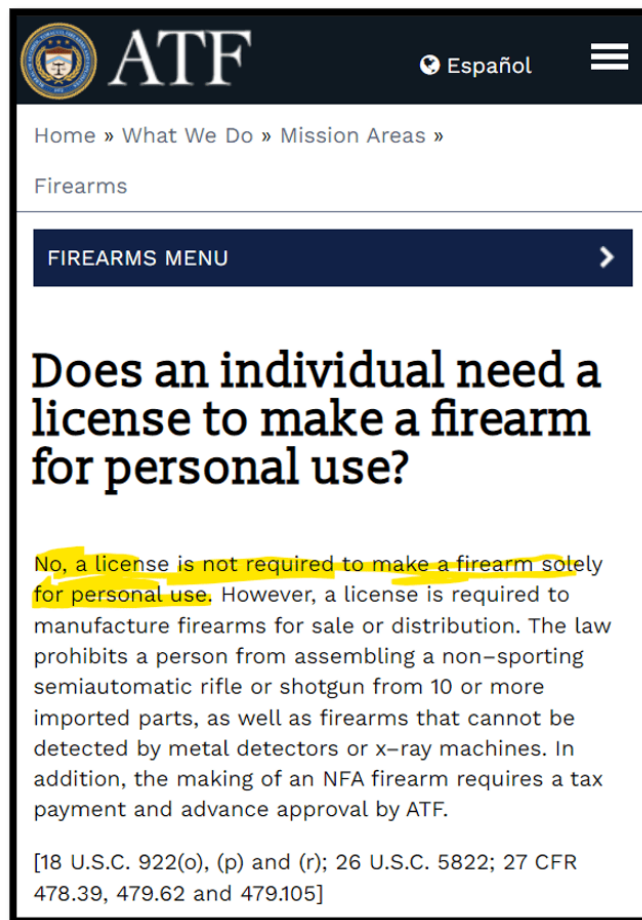
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This, of course, means that ANY method of building your own firearm -- from welding together parts, milling unfinished receivers, and 3d-printing -- is legal!

That's because the Federal laws that apply in every single U.S. state are covered in the Gun Control Act of 1968...

The Bureau of Alcohol, Tobacco, and Firearms and Explosives (ATF) is in charge of enforcing these Federal laws...

**Here's a screenshot from the ATF's own website that explains it's legal to build your own guns at home...**



*This screenshot from the ATF website says "No, a license is not required to make a firearm solely for personal use."*

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Even though I believe the fundamental human right to keep and bear arms does not come from the government...

And even though the “right to bear arms” is guaranteed by the constitution (and as such we don’t need any laws qualifying that right) ...

**The fact is, the current laws on the books make it clear that you can build your own firearm at home...**

- With no license...
- As long as you’re already LEGALLY allowed to purchase said firearm...
- And as long as you’re not intending to build guns to sell them (because then you’d be considered a “manufacturer” and be subject to following a ton of other laws) ...

In other words...

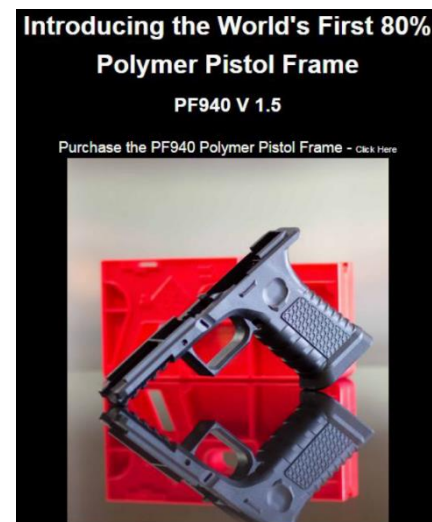
**If you can legally go down to your local gun shop and purchase a particular firearm in your state...then... you can legally build the same exact style firearm at home.**

## What’s The Solution For The DIY Patriot?

In the past, with this ruling by the ATF in mind, several manufacturers sold firearm receivers that are called 80% because they meet the not-finished rule, and the ATF actually evaluates their respective designs, granting them the ability to legally sell these incomplete firearm 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 parts kit installed in it (the trigger, etc that makes it function!)





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Now, for a long time you could buy 80% receivers like the Polymer80 kit shown on this page

Even though, by any and all definitions of a firearm, these 80% kits are NOT firearms...

And even though they require a good amount of work to complete them and turn them into firearms...

1. Drill holes
2. Mill slide guide rails
3. Mill the barrel bridge
4. Mill the top rails of the receiver.

And more... they were so popular that many anti-gun state governments tried to pass laws to make it hard for people to build them.


Fast forward to 2022...

## **[2022 UPDATE] It's Still Legal To Build Your Own Privately Made Firearm (PMF)**

Biden and his gun-grabbing friends are doing their best to make it harder for you to build your own firearms privately...

But even after changing the definition of the word "firearm" - the updated ATF guidelines reveal that it's still completely legal to build your own "Privately Made Firearm (PMF)"...



In fact, here's another screenshot from the ATF clarifying that it's still legal...



## PMF

**The final rule:**

- **Does not** prohibit an individual from making their own PMF.
- **Does not** mandate unlicensed persons mark their own PMF.
- **Does not** require an FFL to accept unmarked PMFs into their inventory.
- **Does not** apply to firearms marked and registered pursuant to the NFA, [26 U.S.C. 5842](#) and [27 CFR 479.102](#), upon approval of an [ATF Form 1](#).
- **Does not** apply to firearms manufactured or made before the effective date of the Gun Control Act of 1968, October 22, 1968, unless remanufactured after that date.



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*[Handwritten red text:]* [2022 Update] Still legal! ←

The bottom line is that you can still build your own firearm, at home, and it's 100% private...

However, over the years, the ATF has continually changed their minds on their own rules – issuing letters and making life harder for **manufacturers** – eventually in 2022-23, they really tried to crack down on 80% kit makers like Polymer80...

In short, they're trying to make it more and more difficult to build your own handguns from these 80% receiver kits, by going after the SOURCES – the manufacturers—of the 80% receivers and build kits...

Luckily, for us, technology always outpaces tyranny and home-based 3d-printing manufacturing has really taken off and you can now skip having to buy unfinished receivers and 3d-print them yourself.

## WHY IT'S NOW SIMPLE TO 3D-PRINT YOUR OWN FIREARM!

In the last 10 years there have been MASSIVE advances in the world of home-based, consumer-level 3d-printing.

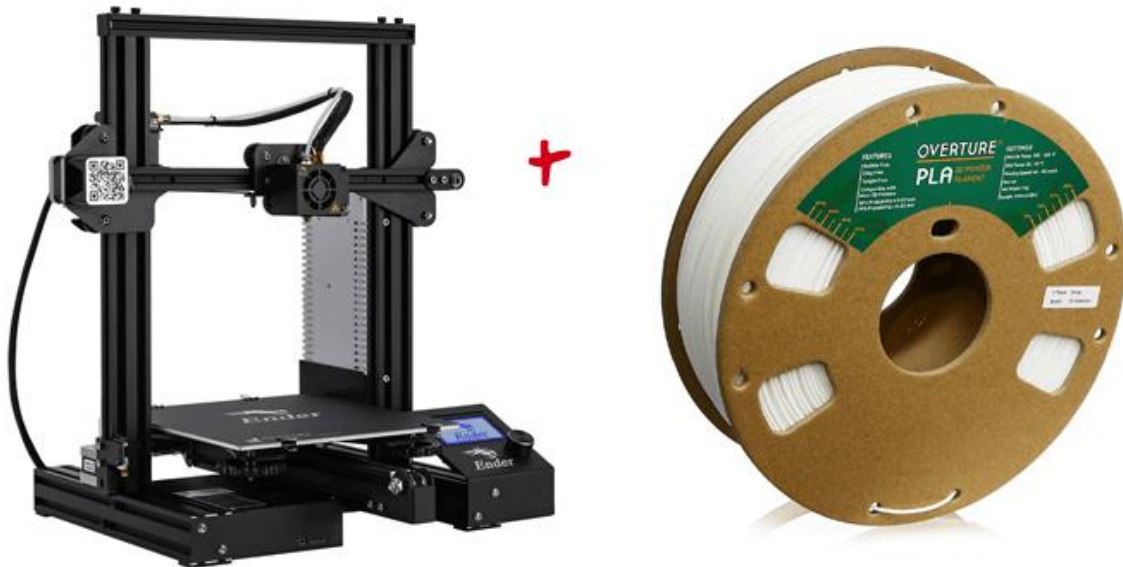
In short, the quality and capability of 3d-printers have gone up, while the price has gone down (like most technology).

For example, back in 2013 – when Cody Wilson was first making waves for 3d-printing guns – the kind of printers that could do the type of work we’re talking about could cost \$20,000 or more!

Now, you can buy the “gold-standard” Creality Ender 3 right off Amazon and print your own guns at home for less than \$200!

In fact, you only need 3 things...

**1.) An inexpensive Creality Ender 3 3d-Printer (\$199 or less on Amazon!) with Plastic Filament (\$19 or less on Amazon!)**



*Pictured is Creality Ender 3 3D Printer and spool of PLA Filament*

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## 2.) The 3D-printing computer file and software (FREE!)



*Pictured is 3D Printer Glock File you download and free software to "slice" the 3d file for printing*

## 3.) And a Glock parts kit with rails (\$349 or less)...



*Pictured is full Glock 19 parts kit, plus rails for 3d-printed frames*

That's it!

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That means the total upfront cost is less than the retail price of a brand-new Glock!

And the great news is...

### **You Only Have To Buy Your 3D-Printer Once, And After That You Can Print A Glock Frame For As Little As \$3.00 In Costs!**

Once you buy the 3d-printer, you can use it for as many gun builds as you like in the future - and it's really the only big purchase you need...

And the PLA plastic filament is dirt cheap - often you can get it for \$19 per kilogram...

Which means you can print an entire Glock lower receiver for about \$3.00 per print!

And do it over and over again!

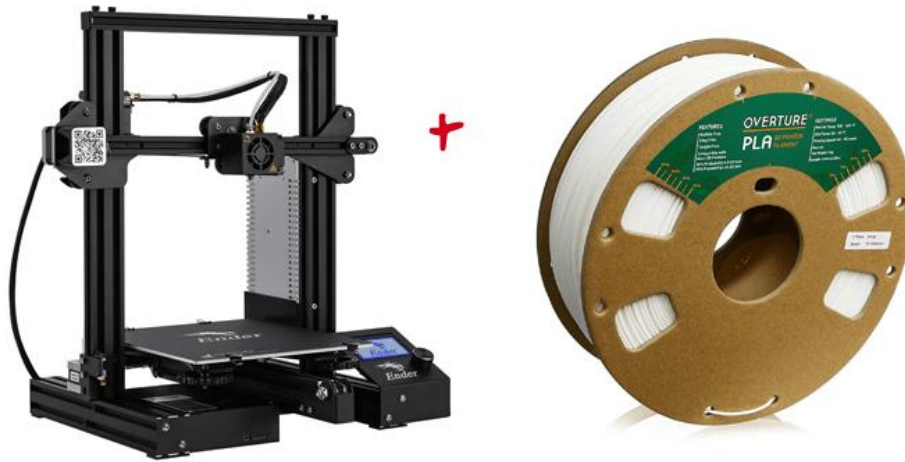


*Pictured are multiple different 3d-printed Glock frames alongside a commercial P80 frame for comparison - each 3d-printed Glock frame costs as little as \$3.00 in filament to print!*

Let's go through each of these step-by-step to get you started now.

## WHAT 3D-PRINTER & FILAMENT DO YOU NEED?

The Creality Ender 3 Printer is listed everyday for \$199 or less on Amazon (as of 2022/23 prices) with Plastic PLA Filament (\$19 or less for a kilo on Amazon!)



*Pictured is Creality Ender 3 3D Printer and spool of PLA Filament*

The technical “nerd name” for what these printers do is fused deposition of material (FDM). But basically, these printers simply melt and deposits plastic as it moves around in a computer-controlled path.

While there are other types of 3d-printers, they are beyond the scope of this guide...

FDM printers are the cheapest and most accessible and perfect for 3D printed guns.

Like we discussed, the machine prints parts layer by layer. Each successive layer is built up upon the previous one...

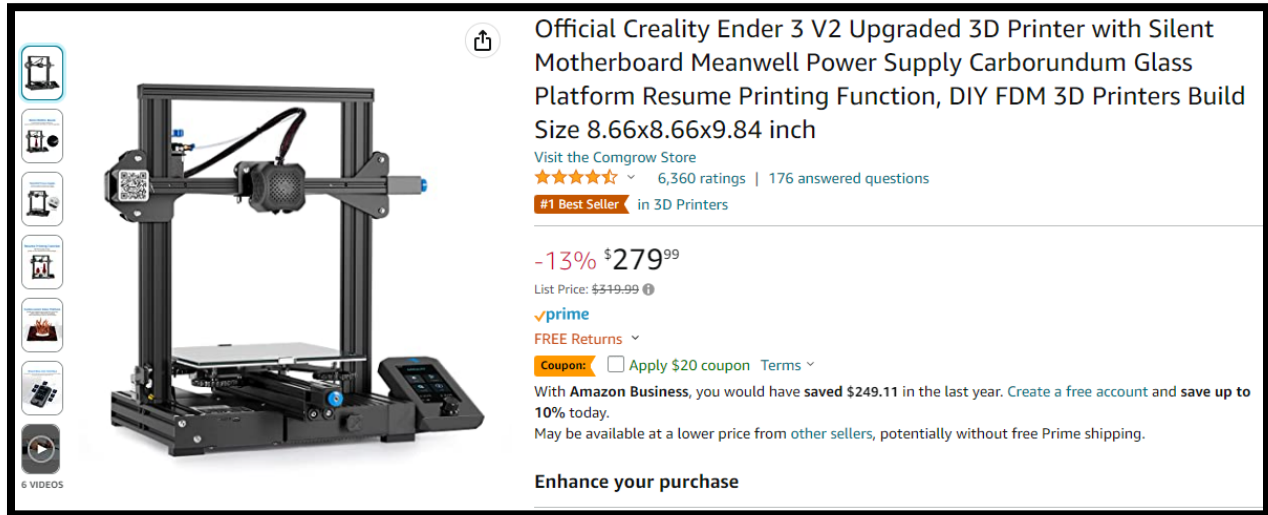
It’s printed on the big square part called the “print bed”, and a computer file tells the machine how to move the hot end of the nozzle that extrudes the melted plastic with three-axis movement, and it does all this itself, once you stick the right computer file in it.

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The exact printer I recommend is the Official Creality Ender 3 V2 Upgraded 3d printer, it can be found on Amazon at this link:

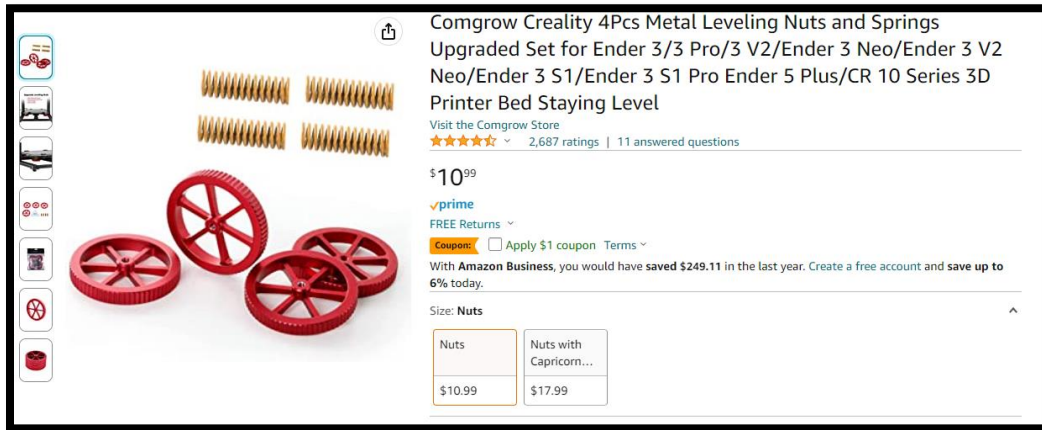
<https://www.amazon.com/gp/product/B07FFTHMMN/> It looks like the screenshot below:



*Pictured is the recommended 3D Printer – it varies in price, with the time of the writing of this manual showing \$279 but it has been on sale for \$199 or less!*

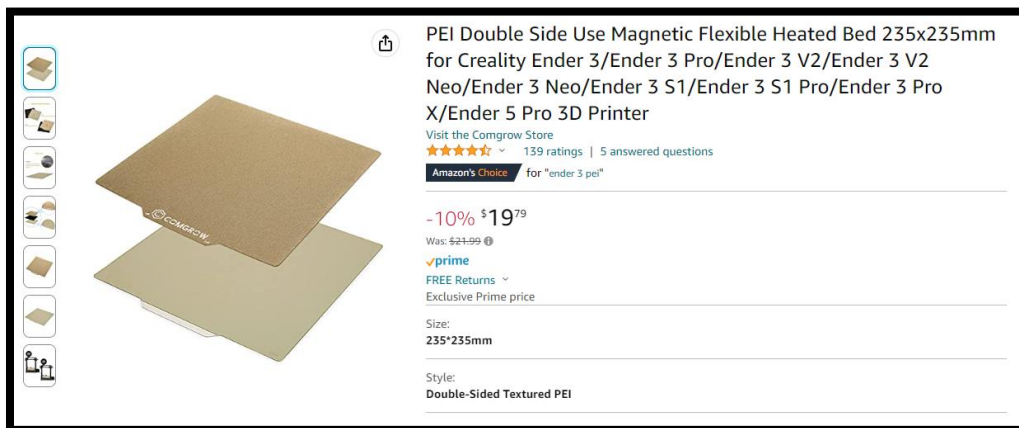
Based on the recommendation of my friend who you will meet in this training series, at the same time, I also ordered upgraded leveling nuts and springs for \$11 – this exact model: <https://www.amazon.com/gp/product/B082PC59BP/> screenshot below:

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*Upgraded leveling nuts/springs shown.*

Finally, I also ordered an upgraded print bed also based on his advice. This is the exact model from Amazon: <https://www.amazon.com/gp/product/B09TVGDJYP/> screenshot below:



*Pictured is upgraded print bed for \$20*

And that's all you need for the printer. Let's now talk about the plastic.



## PLASTICS

One of the best things about 3d-printing is you can print with many types of plastics...

3d-printers use plastic in the form of filament, a long string of plastic wrapped around a spool. The printer feeds the plastic in slowly as it prints.

The type of plastic filament we will focus on in this guide is PLA filament.

PLA is a cheap, easy-to-print polymer that is super popular...

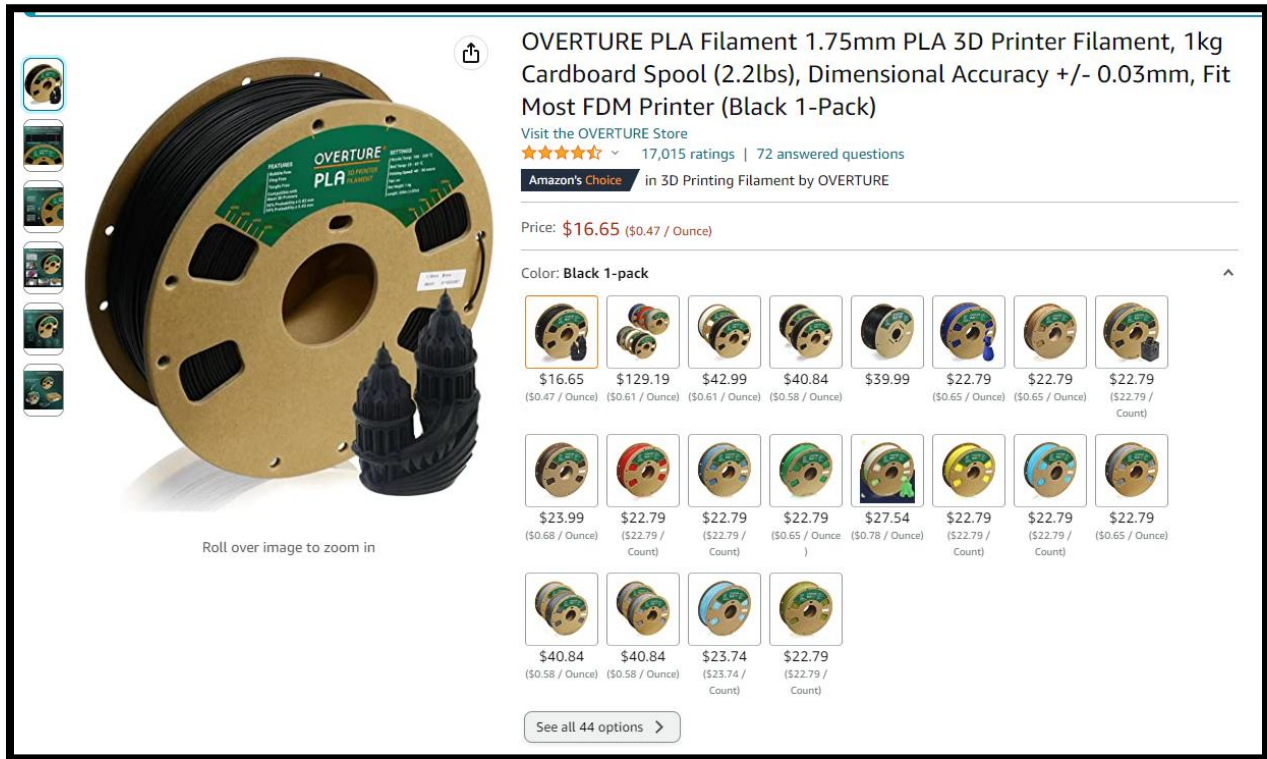
It strong and has high stiffness, but the only thing to be aware of is it has a relatively low melting temperature—people report that if you leave your PLA sitting in a hot car it can deform...

So, it's worth noting that very hard use of PLA-printed guns can overheat them if not allowed to cool – people report doing a mag dump of 100+ rounds in 3d-printed Glock frames and heat from the chamber can melt parts of the frame

Luckily, PLA is SUPER cheap.

Here is the exact PLA filament I ordered off Amazon – less than \$17 gets you a kilogram roll which is 2.2 pounds – meaning you can print a ton of Glock lowers at a cost of about \$3 each! <https://www.amazon.com/gp/product/B07PGY2JP1/> is the link and screenshot below:

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*Pictured is the black, PLA filament that I chose for this 3D Glock build – but you can order practically any color filament that you want!*

And that's basically all the supplies you need to start printing your own firearm.

## WHAT 3D-PRINTER FILES DO YOU NEED?

The way that 3d Printers work is you put a little SD card into them that contains the special 3d printing file that tells the printer what to print.

Simple enough...

So you need two things:

1. You need the actual 3d file which is basically like a CAD drawing replica of the item you want to print. In this case, it's a 100% exact model of a Glock 19.
2. You need special 3d printing software to "slice" this file, and setup the exact printing settings you want your printer to print the gun with.

So, let's talk about the file you need first.

For this project, we are printing a Glock 19 firearm. There are actually 3d files for both the Gen 3 Glock 19 and the Gen 5 Glock 19, but I had more spare parts for the Gen 3 Glock 19, so that's what this guide shows you.

The 3d Printing file you need is the "FMDA 19.2" file.

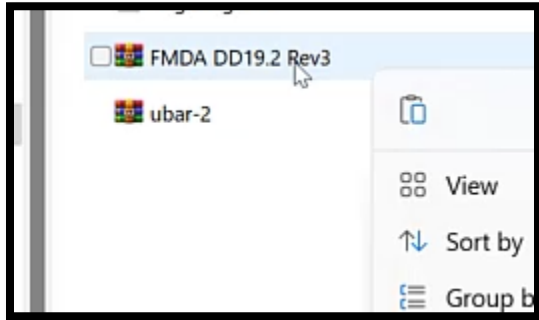
Now, you can find this popular file all over online. Use a search engine and search for the exact name in quotes above.

At the time of writing, you can find it at this URL <https://ctrlpew.com/dd19-2-3d-printable-frame/> and a direct link on the site Odysee (a version of Youtube that's built around freedom-of-speech) here: <https://odysee.com/@TheGatalog-PrintableFramesReceivers:9/The-FMDA-DD19.2-3D-Printable-Glock-Frame:0>

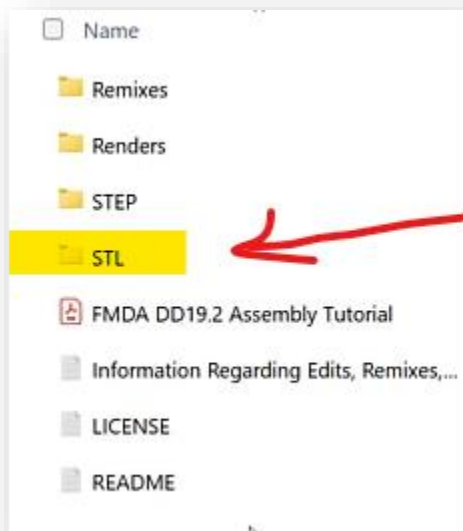
Once you download it, it will be a simple zip file like many you have used on your computer before, screenshot below:

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You simply right click the zip file – like opening all zip files— and “unzip” it to reveal the contents in a folder on your computer. Inside that folder, as shown in the screenshot below, you’ll see a few files. One of these is the README file – which you should as the name implies go ahead and read – but the 3d printing file you need is a STL file which is in the STL folder which I’ve highlighted and drawn a red arrow pointing to in the screenshot below:



At this point, now that you have the file you need – you just need the software to “slice” it so we talk about that next.

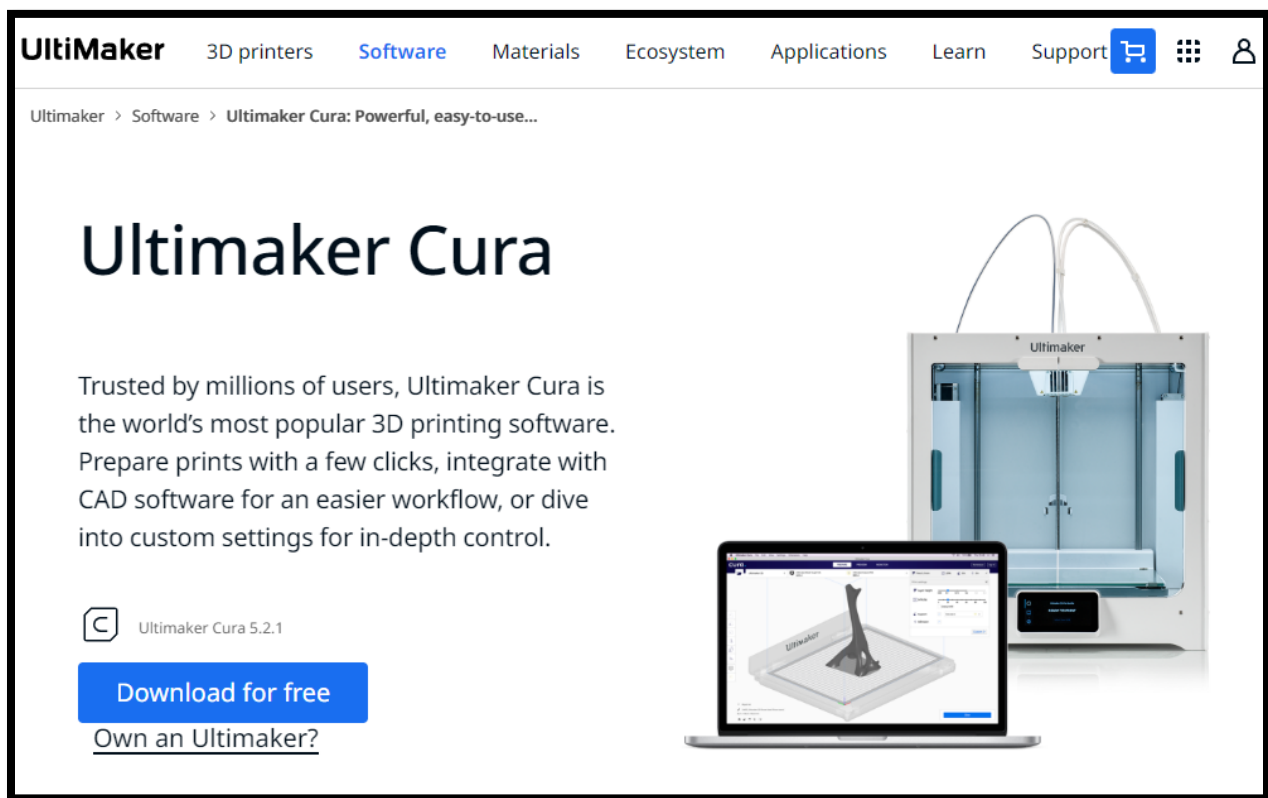
## WHAT SOFTWARE DO YOU NEED?

The way that 3d Printers work is you put a little SD card into them that contains the special 3d printing file that tells the printer what to print.

You already downloaded the file in the last step.

Now, you need to “slice” the file, and save it with the proper settings so your 3d printer operates how you want it to, at the right temperatures, etc to print it the way you want for best results.

The good news is the 3d Printing Software you need is free. It’s called Ultimaker Cura and you can find it at this website: <https://ultimaker.com/software/ultimaker-cura> screenshot below:



Simply download the free software and we’ll get started...

## WHAT OTHER PARTS AND TOOLS DO YOU NEED?

Let's briefly cover what you need to complete your build...

Once you 3d print the Glock frame, you'll need to remove the support structures that were printed and then you'll need a Glock parts kit along with rails to finish assembling your new firearm.

### Tools:

- Drill bits and drill (cordless/battery powered is fine)
  - 3mm drill bit
  - 4mm drill bit
  - Screwdriver, flat head
  - Punches help
  - Some type of hammer/mallet – gunsmith type is best
  - Needle nose pliers
  - Small cutting style pliers is best
  - Sand paper in multiple grits – 120 and 220 should work

And that should be it...

You really don't need that many tools, and much of what you would already have in a workshop should be enough.

### Glock Parts Kit

The most expensive parts you need is a full Glock Parts Kit. The file we're printing with this guide is a Glock 19 Gen 3 – so those are the parts you need.

This should include the upper receiver, complete, and the parts needed to fit in the lower receiver.

You can use an OEM (made by Glock) parts for all this if you can find them...

Depending on the political environment when you read this, these parts may be simple or harder to find – if things heat up with gun control all guns and parts tend to sell out quickly...

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When it's not bad politically, they're very, very common as Glock handguns are some of the most popular in the world.

You can also use aftermarket parts kits too.

So, the complete list of Glock 19 Gen 3 compatible parts you need is this:

- Glock 19 gen 3 slide
- Glock 19 gen 3 barrel – 9mm
- Glock 19 gen 3 slide parts kit
- Glock 19 gen 3 lower parts kit
- Glock 19 gen 3 magazine

But because this is a 3d printed gun you also need a few parts specific to this build to finish the frame.

## 3D Printed Glock Specific Parts

Because you are printing your lower receiver/frame, it does not have metal rails installed like a factory Glock, so, you need:

- FMDA type Front and Rear Rail Set
- Front and Rear rail pins to hold in the rails
- Glock Gen 3 Style **Locking Block**

Locking block is bolded in the list above, because sometimes when you order a complete Glock parts kit – they will not be included. So, make sure to pick one of those up.

## Where To Purchase Parts

As I said earlier, you could find all the Glock specific parts to complete a normal Glock on various websites such as Brownells.com, MidwayUSA.com, or Glock specific sites like Glockstore.com.

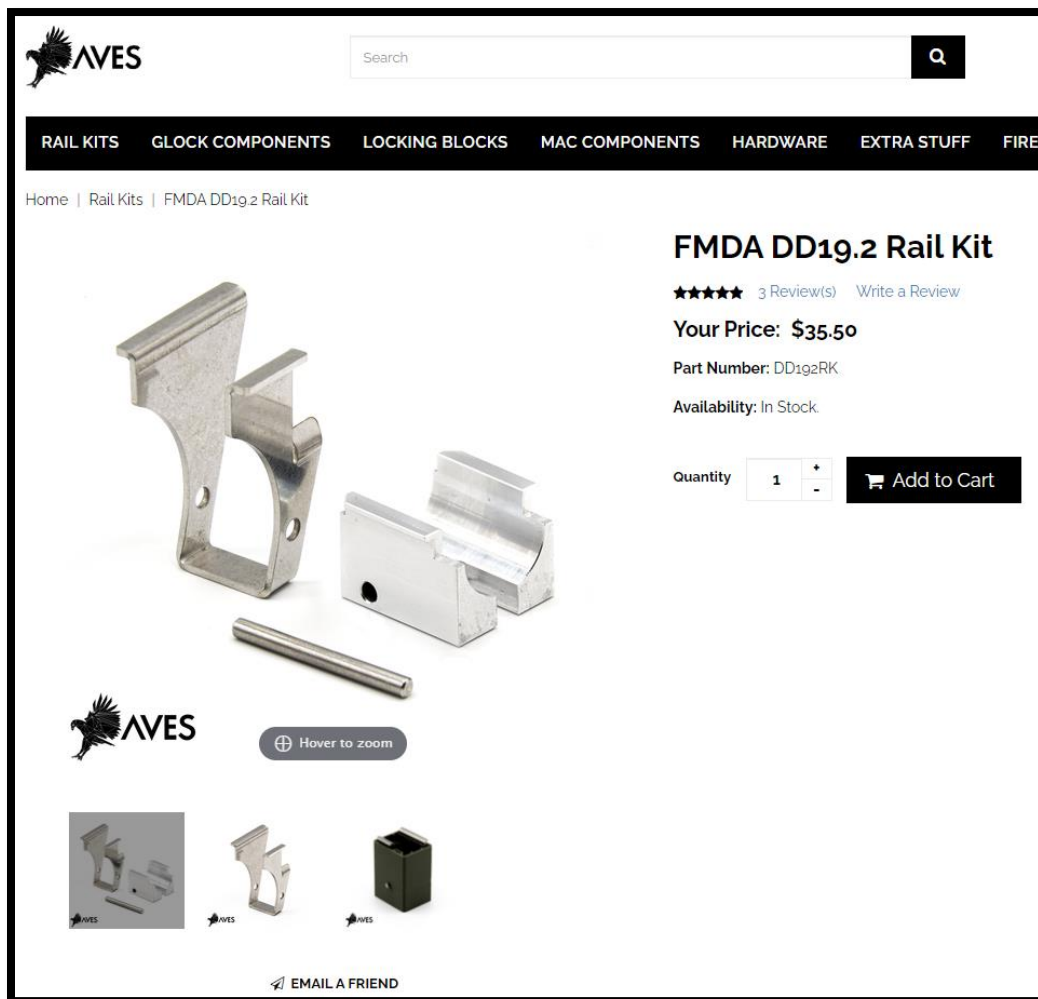
For the Glock Rails Kits, there are many vendors – the most important thing you need to keep in mind because there are many different 3d printed Glock files available is that you are looking for rails that advertise they are “FMDA type” or “FMDA DDxx.2

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compatible” (where “xx” is the Glock model you are building—in this case we’re building a Glock 19 so you want FMDA DD19.2).

It’s also important to note, that depending on where you buy the rails, you will need a 3mmx28mm pin/screw to hold the front rail in the frame – some will sell this with the rail, or you can buy separately from Amazon or any other supplier. Some people have used roll pins and some have even cut down bolts that were the correct size.

Other builders have verified that Avesrails.com and Riptiderails.com are the most popular. Here is a screenshot from the direct link [https://www.avesrails.com/FMDA-DD192-Rail-Kit-\\_p\\_29.html](https://www.avesrails.com/FMDA-DD192-Rail-Kit-_p_29.html) where you can get the complete rail kit you need from Aves:



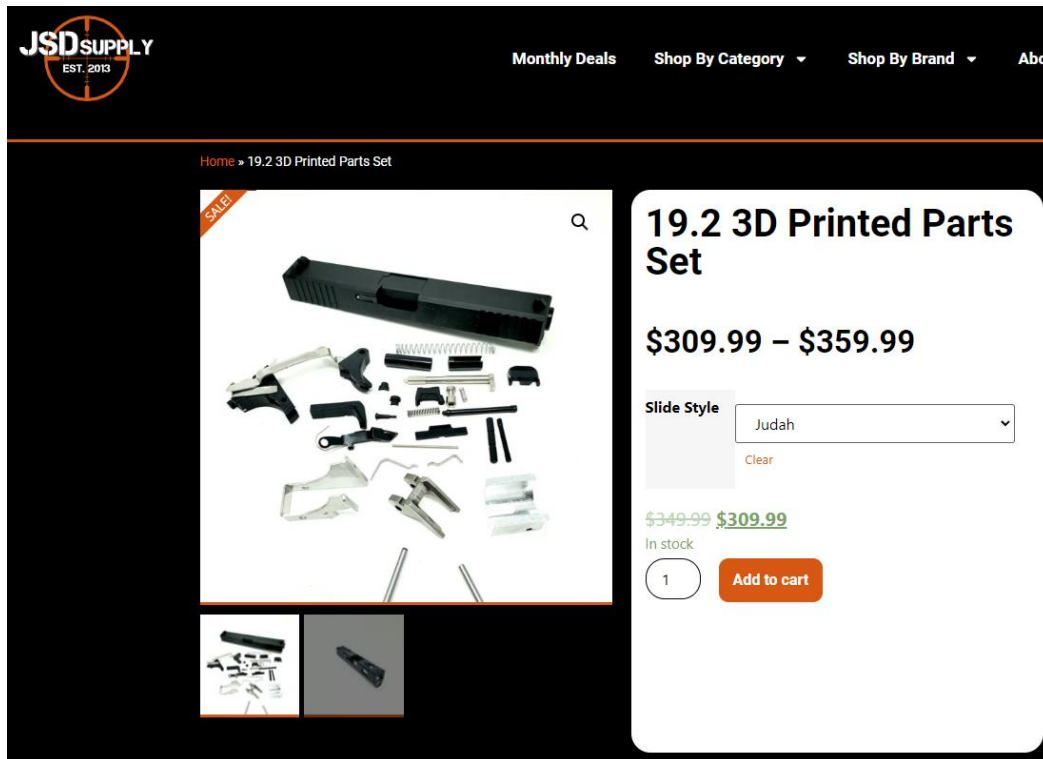
Now, you can certainly purchase these all separately...



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However, for this build and instructional course, we went the extremely simple route and purchased all supplies from one source. I've used their parts in the past for other builds too. The good news is that this supplier has everything you need, all in one place.

You can get the complete kit for everything you need from JSDSupply.com. The exact link at time of publishing is <https://jsdsupply.com/shop/19-2-3d-printed-combo/> screenshot below:



As you can see it comes with everything you need, and all you have to do is print your Glock frame and provide a Glock magazine.

From their site description:

What's Included:

- Patmos Arms Slide - G19 Compatible
  - Judah (Option)
  - Revelation (Option)
- Patmos Arms Barrel - 9mm

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- Patmos Arms Slide Parts
- Patmos Arms Lower Parts Kit
- FMDA type Front and Rear Rail Set
- Glock Gen 3 Style Locking Block
- Front and Rear Rail Pins

What's Not Included:

- Frame - You will print your own frame using FMDA 19.2 files (search for FMDA19.2 - The files are free)
- Magazine - Try to use a Glock OEM G19 magazine for initial break in

Simple!

Now that you have all the tools and parts you need to complete your build, it's time to get to it!

**\*\*\* 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! \*\*\***

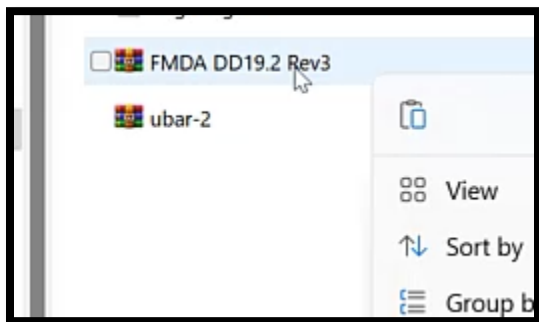
## Step 1: Download The 3d File You Need and The Software You Need

The 3d Printing file you need is the “FMDA 19.2” file.

Now, you can find this popular file all over online. Use a search engine and search for the exact name in quotes above.

At the time of writing, you can find it at this URL <https://ctrlpew.com/dd19-2-3d-printable-frame/> and a direct link on the site Odysee (a version of Youtube that’s built around freedom-of-speech) here: <https://odysee.com/@TheGatalog-PrintableFramesReceivers:9/The-FMDA-DD19.2-3D-Printable-Glock-Frame:0>

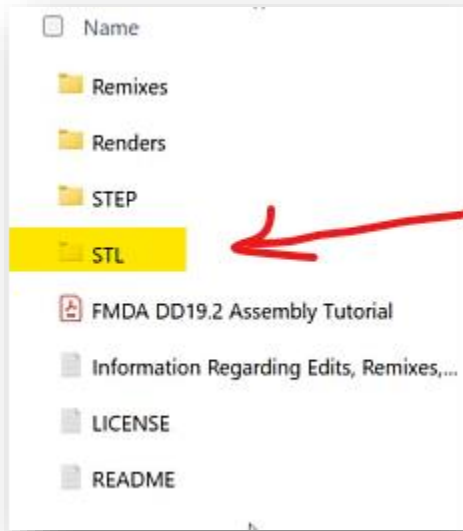
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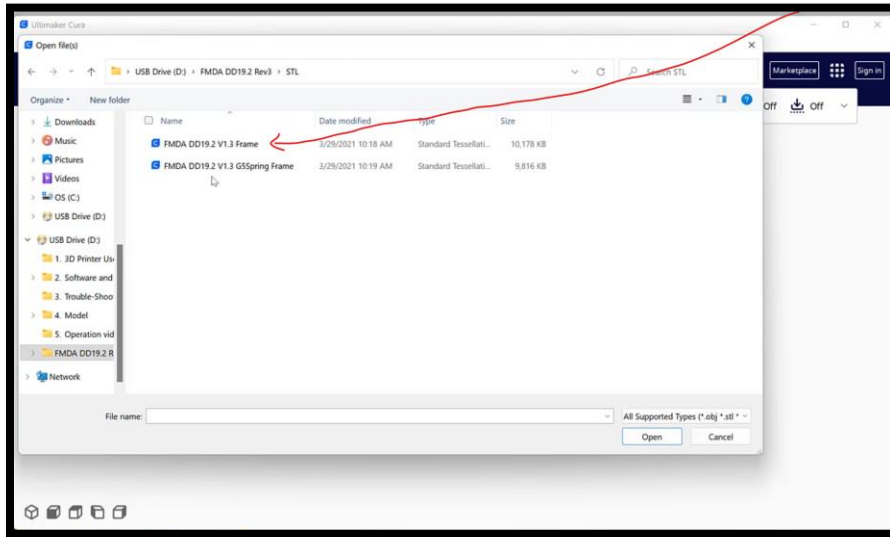
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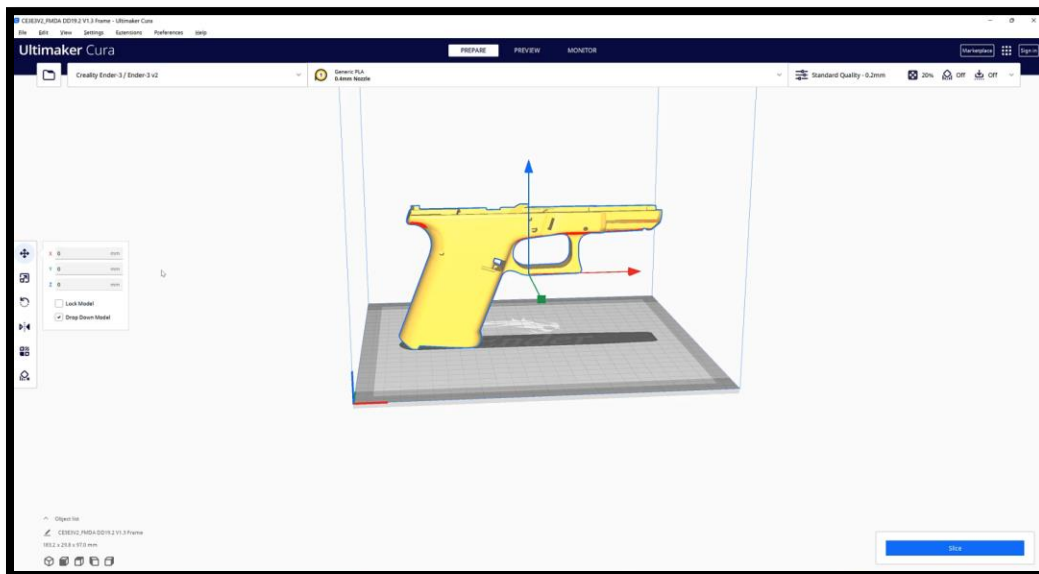
# The Underground 3d-Printed Glock Manual

## Step 2: Slice The 3d File with Ultimaker and Set the Correct Print Settings

Open the Ultimaker Cura software and open the file you need, which for this build is the **FMDA DD19.2 V1.3 Frame** file, as shown in the screenshot below:



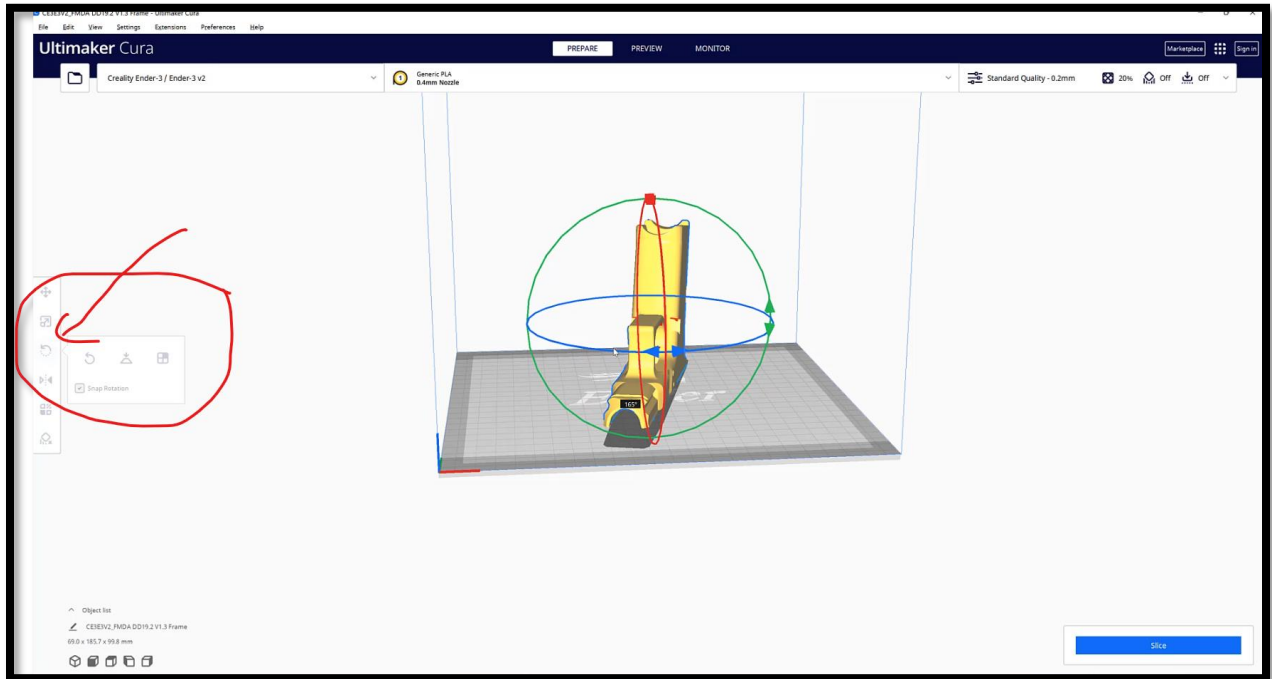
When the file loads it will look something like the screenshot below:



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You can 3d print your handgun on any direction you want, but what we did for this build is print the gun upside down, so that it sits on its rails. There are different opinions on this as to how to do it best, but it seemed like this created the least amount of extra plastic material we had to remove later, and supported the gun print the best. So using the option on the left side of the screen, you click that then click the gun and rotate it around so it sits on its frame to print, like screenshot below:

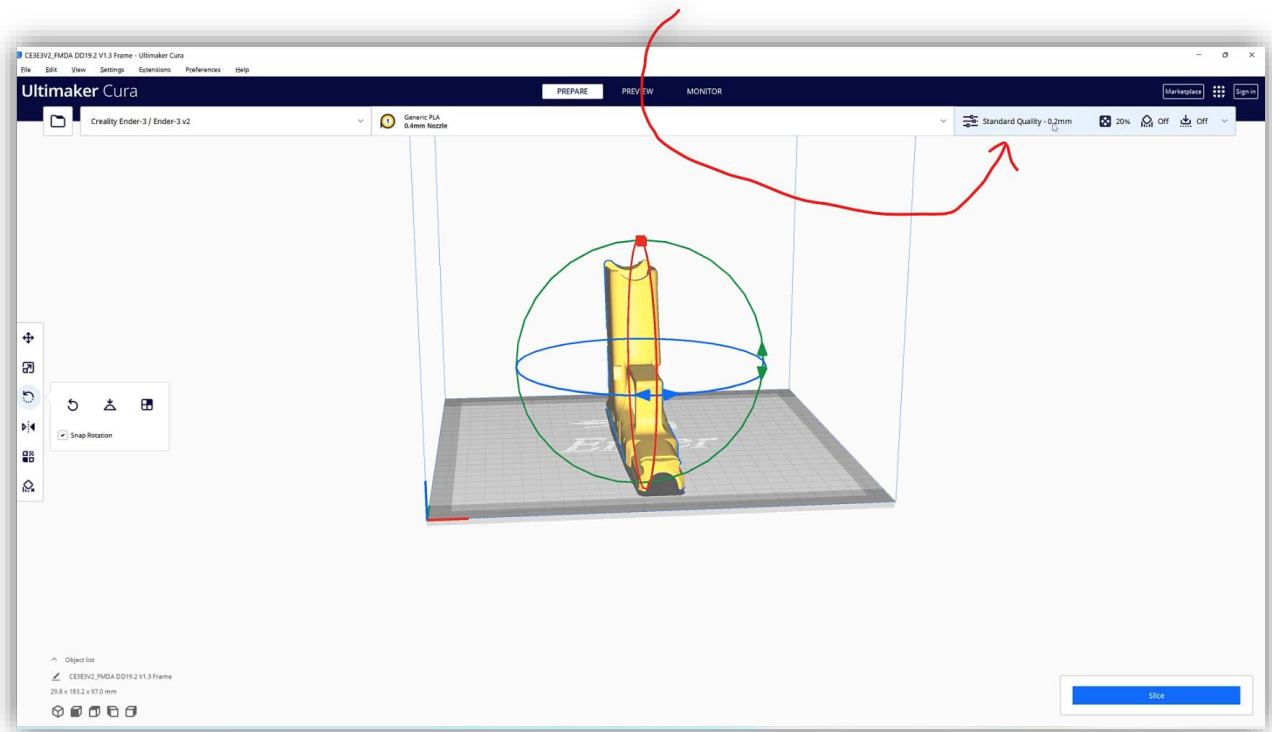


Then you click the center button labeled “LAY FLAT” to lay it flat on the bed when it prints.

Next, you are going to set the actual settings for the 3d print using the menu on the top right, with the red arrow pointing towards it from the screenshot below:

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Click the button labeled “CUSTOM” and then you can adjust the settings.

Under profile, select “Dynamic Quality – 0.16mm” and then use these settings – most were pretty standard – we simply changed a few:

QUALITY – make sure it’s layer height 0.16mm

WALLS

Wall thickness – 0.8mm

INFILL

Infill Density – 100%

SPEED:

Print Speed – should be set at 50.0 mm per second



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## MATERIAL:

Printing Temperature – minimum 200.0 Celsius (see note below, we finally settled on 215 Celsius as the proper temperature)

Build Plate Temperature – 260 Celsius

## SUPPORT:

Support Overhang Angle – 51.0

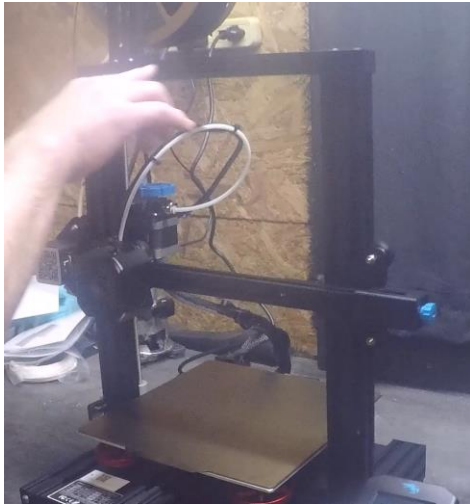
Then click the big blue button that says “SLICE”

Save the file to your SD Card that goes into the printer (the SD Card is included with your Creality Ender Printer).

**NOTE:** The original settings in our video, our first print failed because the ambient temperature in the room overnight caused the printer bed to be too cold with our original print settings. So, we went back and upped the temperature to 215 Celsius and that fixed the problem for us. So, you may have to play with printing temperature!

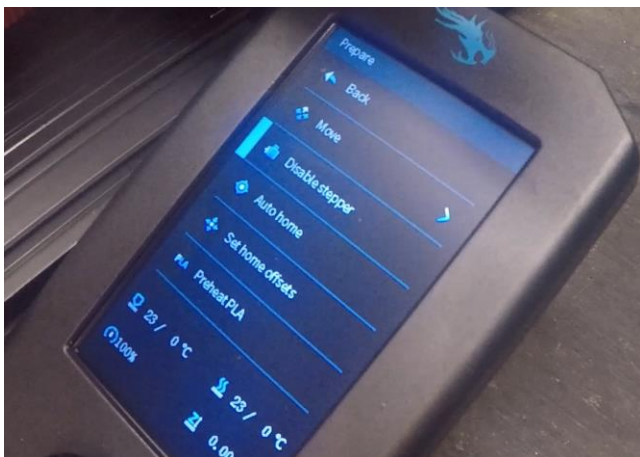
## Step 3: Setup Your 3d Printer If You Haven't Already, and Level/Clean The Bed

You'll need to assemble the 3d Printer according to the instructions that come with the printer. You can also find tutorials for this online and on YouTube if you get stuck. It should be all setup like this when you're ready to level the print bed:



You also want to clean the bed that you will print on both the first time you use the printer and every time after finish printing a project. Use isopropyl alcohol and wipe it down and you should be good to go...

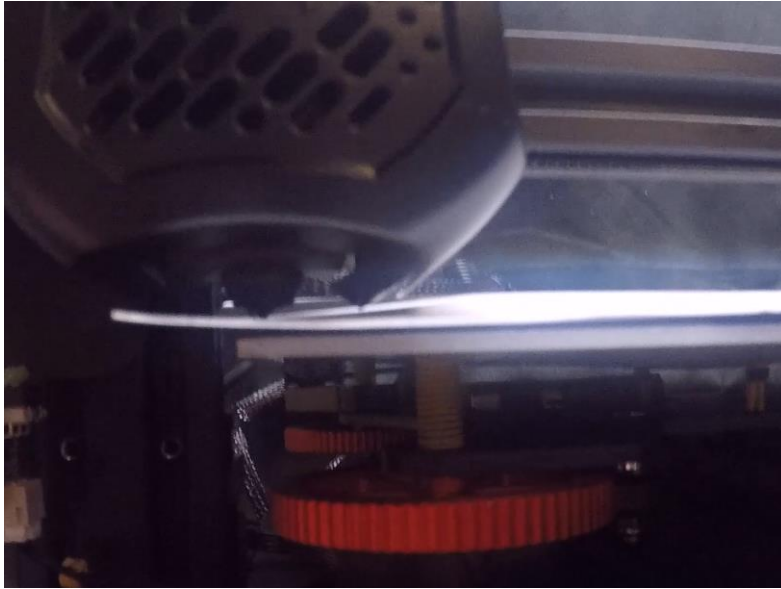
Use the control panel to select Disable Stepper



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This allows you to lower the stepper down to the lower level, then all you're doing is using a sheet of paper, and put it on each corner of the print bed and adjusting the height of each corner so that the nozzle just barely touches the paper – but is not so tight that it's dragging the paper around all over the place



This is done by simply adjusting the red knobs underneath the printer bed to get the correct height – I used a red arrow to point to this below:



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Quick Tip: It's recommended once you have a successful print, with the particular color and type of filament that you're using – go ahead and write down on the filament the print temperature settings that you used that were successful right on the bundle of filament (this is because different color filaments could potentially need different temperatures for a successful print):



Finally, we found that with certain models – ours included – you turn the printer off, then install the SD card – then turn it back on and you simply go to PRINT > Choose the FMDA file to print and click it.

## **Step 4: Start The 3D Print and Leave It Alone For 24 Hours Or However Long It Takes - This Is The EASY Part!**

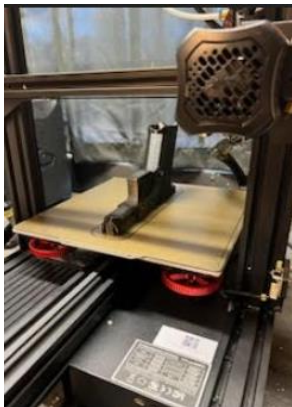
At this point, the printer is going to do the job for you – and all you have to do is wait!

As shown in the video that comes with this manual- we had our first attempt a print fail.

What happened was the print said it would take over 24 hours, so we left it going overnight and left the shop area where it was printing. The ambient temperature of the room dropped lower than expected overnight, and when we returned in the morning we had this failed print scene:



It happens sometimes, so as you hear explained in the video, we simply opened the file again in the slicer software and changed the temperature setting from 200 Celsius to 214 Celsius, while we also turned the heat on in the room the printer was in overnight, keeping it in the 60's and that did the trick. The next print attempt worked perfectly (pictured below but not shown on the video training)



## Step 5: Trim And Prepare Your 3d Printed Receiver/Frame

When you print your new lower, it will have filament “support” all over it to support the object you’re printing. All 3d printed products have this, not just guns. Here’s a few examples of how the supports could look:



As you can tell there is extra material around the base of the print, to help keep it from falling over. Also, inside the trigger guard there is material to keep that part strong during the printing process. You’ll of course need to remove that material. Plus, you’ll see all the holes you’ll need to drill for the trigger pins, etc

Remove ALL supports from your printed frame. I discovered that you can view everywhere supports will be printed on your frame by viewing the layer-by-layer view in

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your slicing software. Every place that your slicer indicates is support material should be removed to finish your firearm.

Another thing to make sure of before starting is to look at the top of your frame (the area the slide will sit above) and ensure that it's not warped – it should be very close to perfectly flat.

Now, the fact is that you need to remove all the support materials but there are a few sections you really want to pay extra attention to because otherwise you won't be able to install some critical parts:

1. Rear pocket (will contain trigger block)
2. Front rail pocket (will contain the front rail block)
3. Middle pocket (will contain the locking block)

Using tools like your needles nose plyers and little cutting tools, also flat head screwdriver, you can cut and scrape away all these materials:



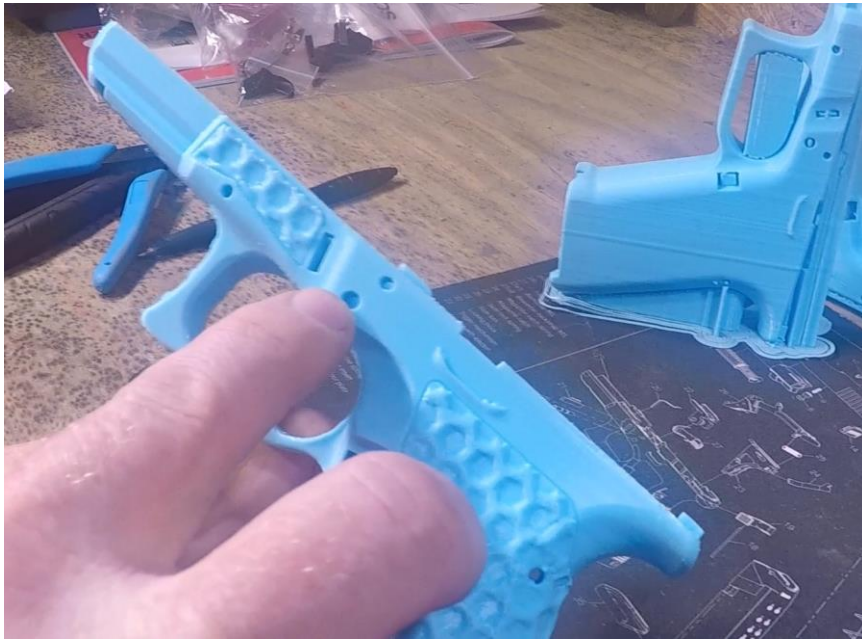
If you have a LOT of support on your frame, then you can speed up removing a lot of material by using a drill to drill through the support material first, then trim the rest off

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During this step, you'll also want to drill all your pin holes too. Take your drill and use the 4mm bit to drill this big hole that's the bottom hole being pointed at with the finger.



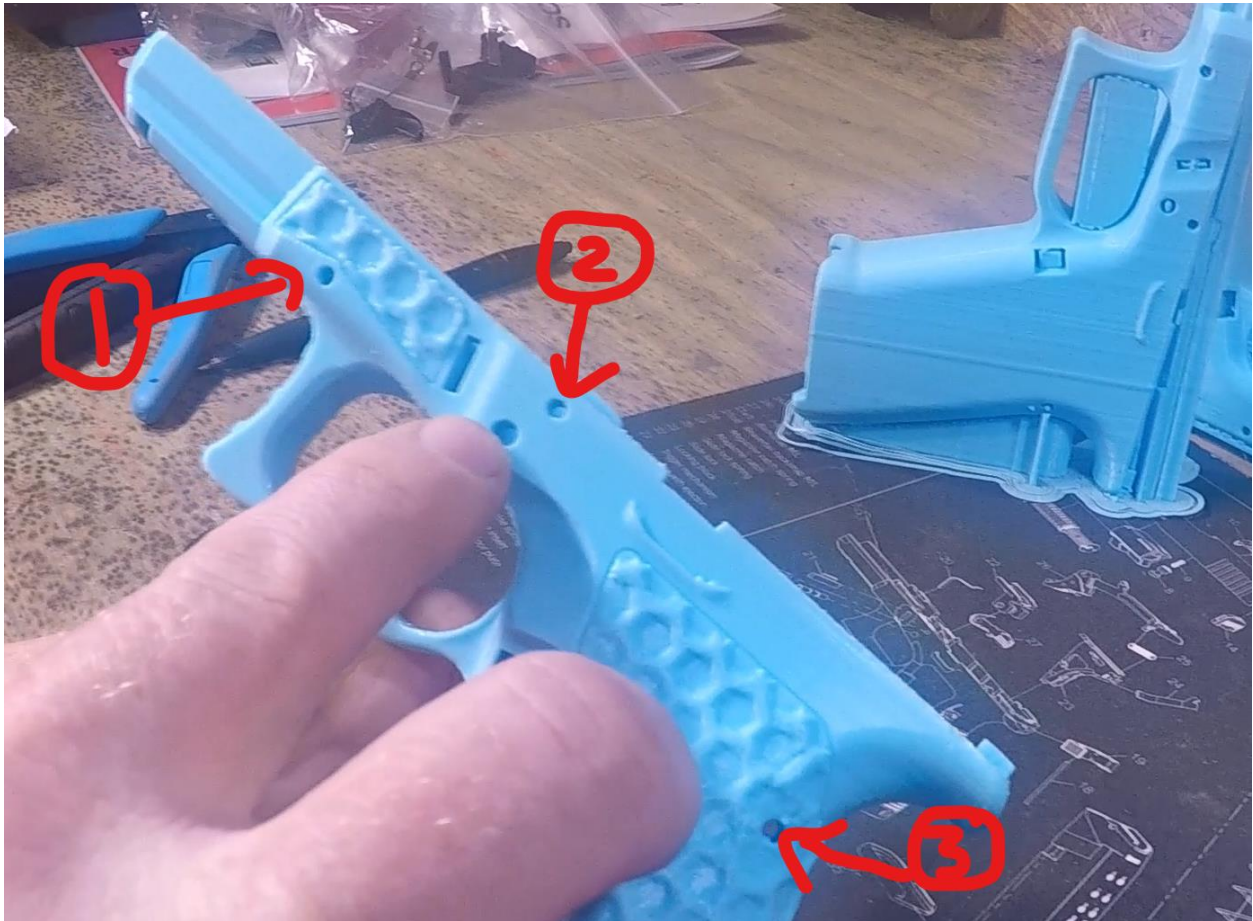
Take the largest pin from your glock parts kit and it should slide in both sides of this hole easily when you're done drilling it. You don't need to widen it just make sure it's clear and the correct 4mm size.



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For the rest of the holes, with the red arrows pointing at them labeled 1,2,3, you will use the 3mm drill bit to drill those out. The small polymer pin should fit in all these holes easily to check after drilling.



You've now created a real "firearm" according to the Feds. You have a stripped receiver at this point.

Now, it's time to assemble it...

## Step 6: Assemble Your Glock Handgun!

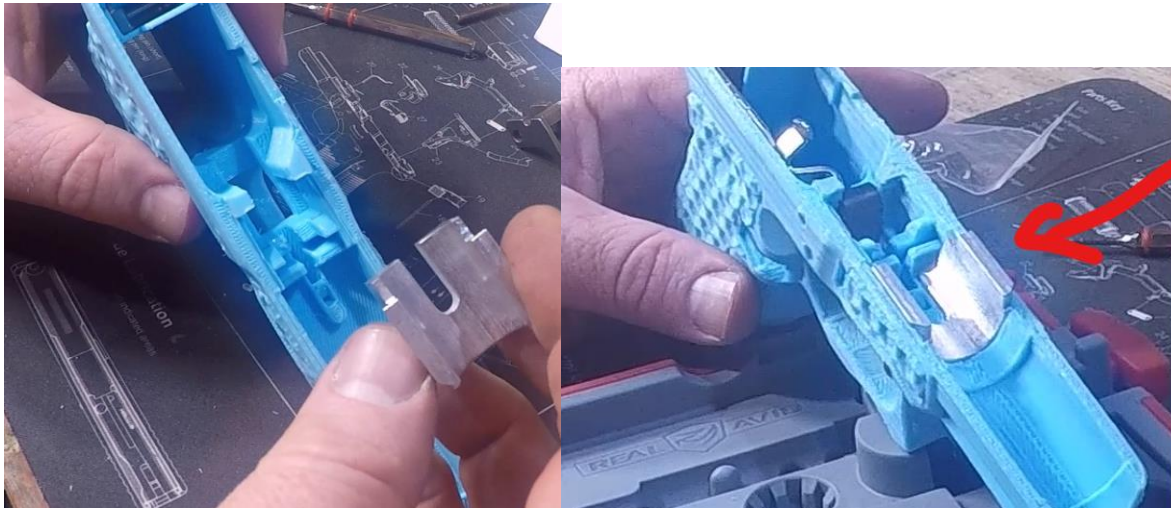
You're now ready to assemble your handgun with the parts kit!

This is the same as assembling any completely stripped Glock 19 gen 3 receiver, with the only difference being the installation of the front and rear rails.

That said, you can follow along with these instructions and the video too. I've tried to circle the components from the kit and then the instructions for how to install them next.

1. **Install the front rail block** – it just fits right in with the U shape being filled by the frame pointed towards the rear of the gun. The pin that comes with the front rail fits in the side hole to hold the front rail in.





## 2. Install rear rails and trigger block



Install the rear rails next, then the trigger assembly...



NOTE: I saw a guy who put the two together and installed them that way (the same way they fit together in the rear pocket hole) and that seemed like a good trick that might make installation easier.

Also note that this rear pin hole is the one many people have trouble with. This is an issue with P80 80% frames as well, because different companies are making all the different parts – and there’s so many needing to line up – this is one area where they may not all line up. Luckily, ours all lined up fine, but if needed you may use a 3mm drill bit to drill through all these while lining them up as best possible to make sure the pin fits through all 3 components and holds them in.

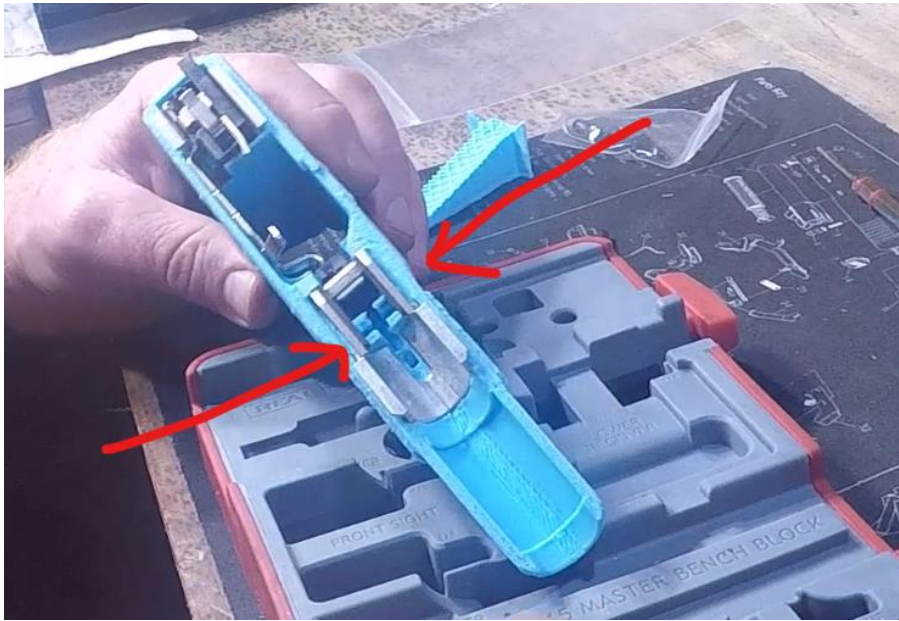
### **3. Install locking block**



Putting in the locking block is pretty simple, you just drop it in.

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Then you need to install the pin that's not for the trigger assembly (it has no grooves) to hold it.



And that pin goes in the top hole



Tap it in and you should be good to go.

#### **4. Install slide stop**



Now comes one of the trickier installations on all Glock lower parts kit. The slide stop lever, which has a little spring. And it's installed using the pin with the little notches on it. What you may have to do, that we had to do, is remove the locking block and using your 3mm drill bit go ahead and push it through the hole again. You'll want to make sure the trigger is held out of the way/back while you do this – the holes should mostly line up but you may need the drill to widen the hole a bit. You also want to come in from the right side of the frame.



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You install the slide stop/slide release between the left side of the trigger and the frame. The spring on the top of the slide stop will go UNDER the top pin in the locking block – it should be under that pin so that it has tension on the spring and works correctly.

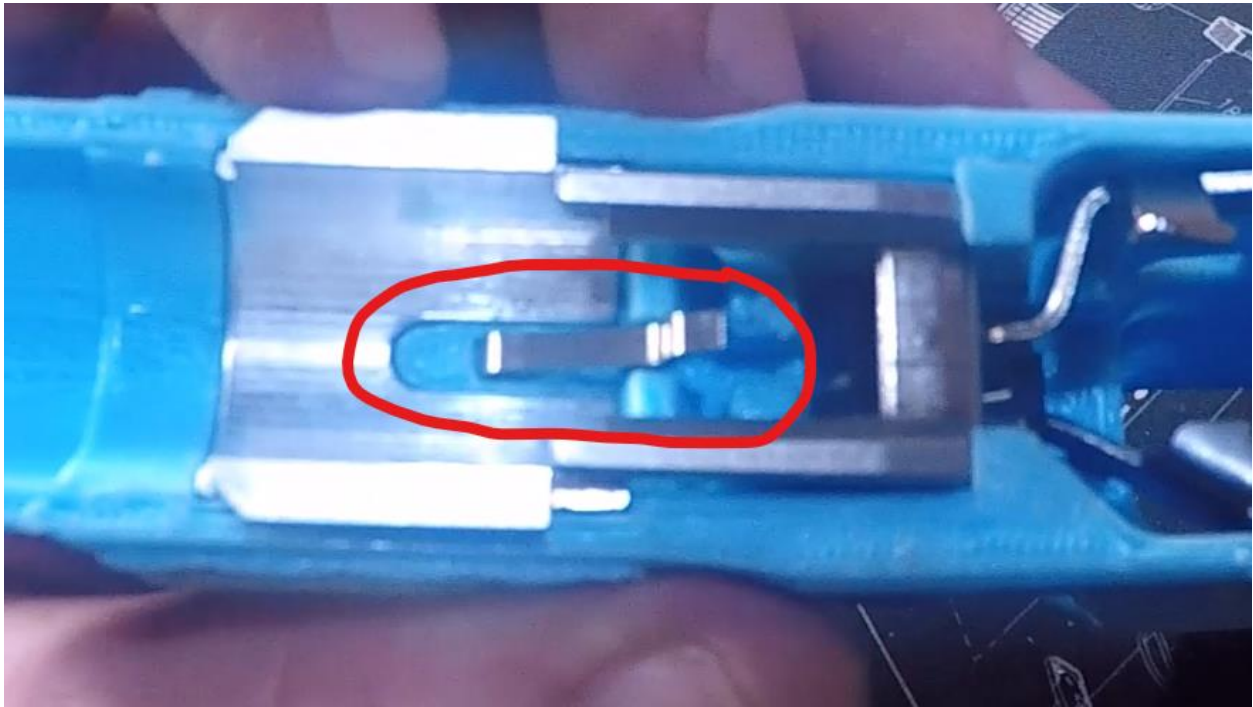


Again, take your time and you'll be fine, but it's often helpful to push up and down on the slide stop/slide release lever to take tension on and off this spring while you wiggle the pin in to get it to fit.

## 5. Install slide latch takedown system spring



First, you put in the spring which is the little bent metal piece circled in the picture below:



The short end of the L shaped spring goes down into that hole. It goes in at a little angle, so the end of the spring sticking up will be a little angled up-that's fine and the way it's supposed to go in.

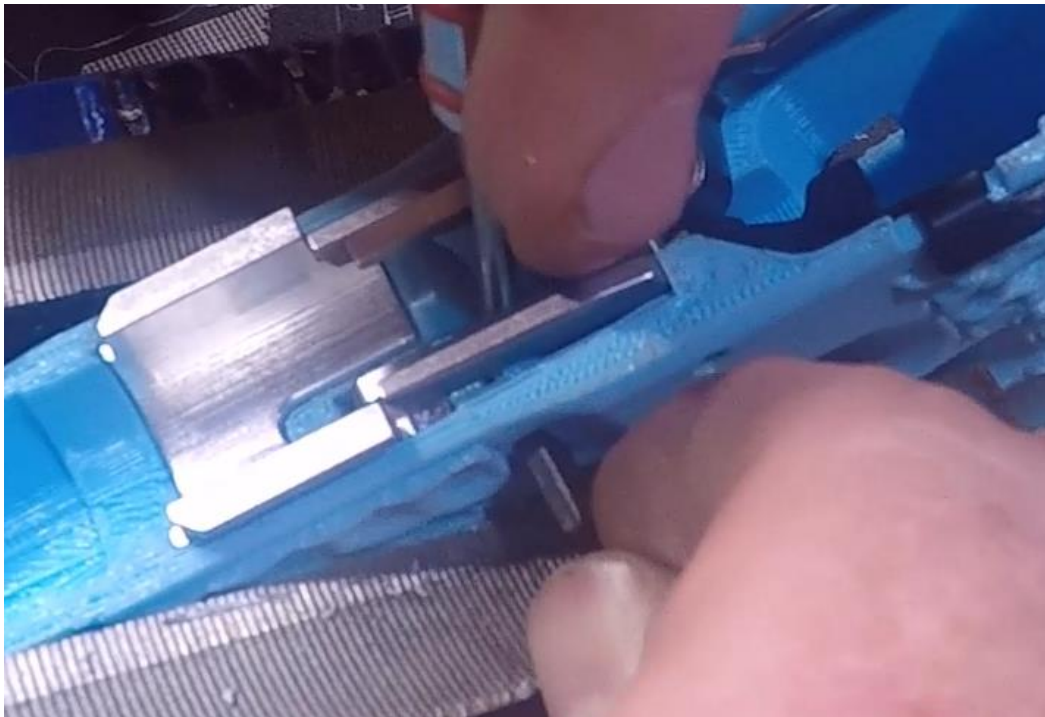
Then use a screwdriver or punch to hold it down under tension, then slide in the slide latch. The notch on this piece (highlighted in red in picture below) faces down and the "lip" side of it faces towards the back of the receiver (facing towards magwell side)

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Then you just slide it in from the side of the frame, in the semi-vertical slit in the frame



Once it's in place you can push down on it and it has tension on the spring mechanism.

## 6. Install magazine catch



This is another somewhat tricky install, depending on your frame, etc. As mentioned in the video, you may want to do this first, before installing other parts. But you can do it last like we did as well. There's a little indentation in the magwell, a deep v cut that is where you put the small piece of bendy metal:



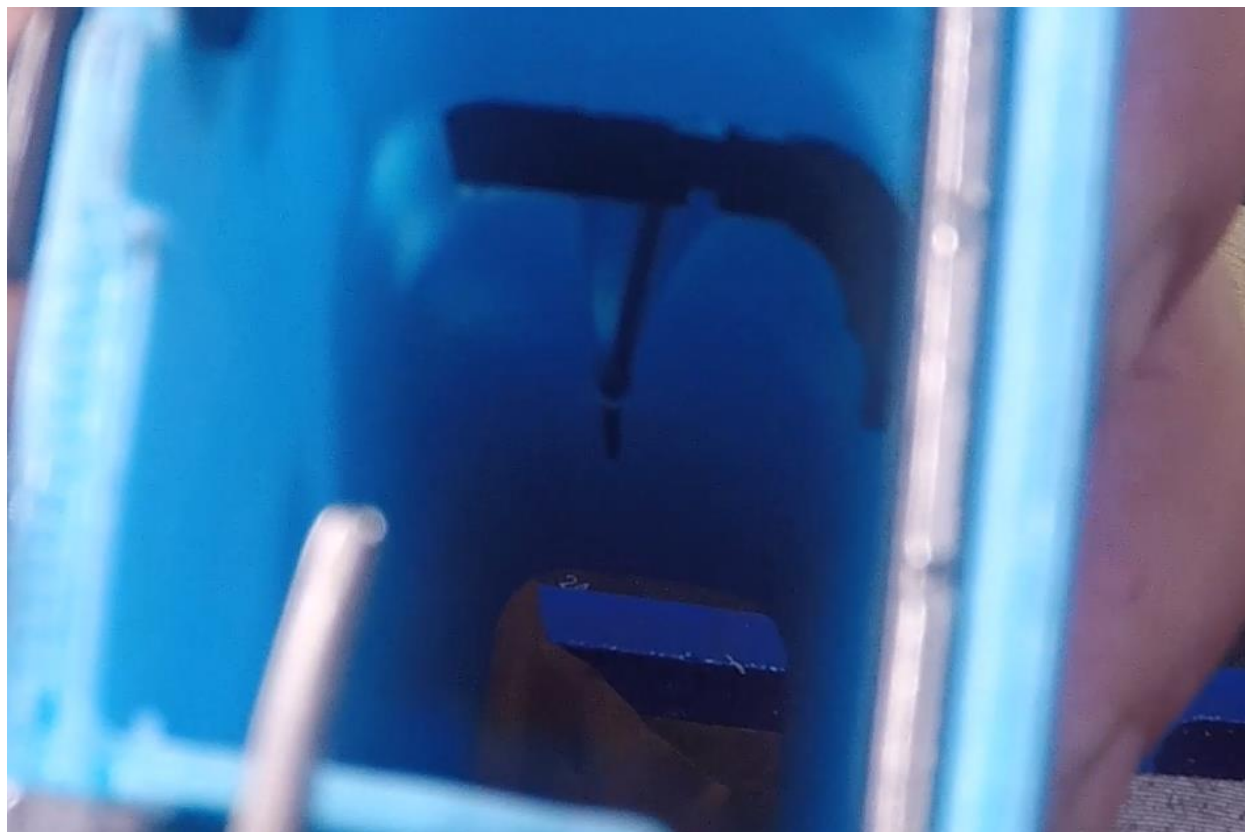
The other side of the bendy metal goes in the mag release button indentation as shown in the pic below, which you push in from the side:



We used the needle nose pliers and held the mag release spring and just push it down deep into the hole, then slide in the mag release button



Then use a flat head screwdriver to pry the pin/spring backwards and wiggle the mag button in until it drops into the indentation:



### **7. Slide the upper receiver on the rails**

The circled components below are the entire slide assembly, and it also shows all the parts that go inside the upper receiver/slide – but ours came assembled from JSD Supply – so it should all be inside the slide for you at this point...





Now, you take a complete upper receiver and slide it on the front, carefully guiding it on the rails:

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And it's on!



Now, you want to test fire it...

## Step 7: Test Fire and Do Any Final Modifications Needed To Troubleshoot Any Problems

You're now ready to test fire the handgun.

TIP: Use good quality ammo that you know works and is sufficiently powered. We used cheap Russian ammo I had sitting around and had a few failures to fire. I found out later the same weekend, this ammo had problems in some other factory built/new guns. So, use good ammo to eliminate variables.



Test fire...

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After firing a round our slide was jammed up, it was clear that it needed to be filed down better to function correctly...



So, you need sandpaper to do this...

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Start with the rougher sand paper – 120 in this example - and file along all the top of your printed frame where it contacts the upper receiver



Make sure to file both the front and the rear parts of the frame rails areas...

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We started with 120 grit sandpaper and then when it seemed smoothed down, switched to 220 grit sand paper for more fine sanding...

Keep going until the slide fits on the rails and moves freely, then reassemble (make sure to lube everything) and take it out to test fire again...

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And that's all it took for us! Just a little filing and patience and success!

## SHOULD YOU SERIALIZE YOUR LOWER?

Now, the main benefit to building your own gun from scratch is that there is no serial number... 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 firearm 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 firearm 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.
3. In the last few years, some states, such as California, have been trying to pass laws requiring that any homemade guns have a serial number created. Check your local laws, this may apply to you.

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 gun 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** (Glock or whatever you wanna call your gun)

**Caliber** (9mm or “multi”)

**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!

At this point it is up to you whether you want to serialize your receiver but again check your local and state laws – especially if you live in a state like California—because some states require this after building your own guns. The laws change all the time, so make sure you’re up to date on them.

I’m definitely not a lawyer, and nothing in this guide is legal advice, so you need to make sure you’re following all the rules yourself.

## ENJOY YOUR NEW GUN!

Congratulations Patriot!

You now have your own Glock handgun 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. More information can be found at: [home.nra.org/](http://home.nra.org/).

In recent years though, the NRA has been less than ideal – they basically sold us out by supporting a Bump Stock ban with Trump and I don't think you can really trust them anymore...

That's why I would also HIGHLY encourage you to join the **Gun Owners of America (GOA)** at [gunowners.org/](http://gunowners.org/). They are 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.

I also recommend **Firearms Policy Coalition** – FPC found at [FirearmsPolicy.org](http://FirearmsPolicy.org) and **The Second Amendment Foundation (SAF)** found at [SAF.org](http://SAF.org). Both these organizations are VERY active in suing and taking to court various local, state and Federal governments over their violations of our second amendment rights.

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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*. 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