

## Custom Defensive Products

### MAGJIG™

1911 Magazine Base Pad Drilling Fixture  
For Magazine Base Pads with .550" on center spacing

#### Instructions for Use

1. Disassemble the magazine by removing the follower and spring.
2. Place the magazine in the jig with the front edge facing the tensioning screw.
3. Turn the tension screw until it makes contact with the nose of the floor plate (**Fig.1**)  
Once contact is made, tighten the screw 1/4 turn or ONLY until the magazine is held firmly in place.

**DO NOT OVERTIGHTEN THE TENSION SCREW.**



Figure 1



Figure 2

4. We recommend placing the magazine and jig in a bench vise for easier drilling. Use soft jaws or a leather or rubber pad against the magazine body. Place the jig **on the top edge of the vise jaws.** (Fig. 2)  
Close the vise jaws to just enough make contact with the magazine body to prevent movement. **DO NOT OVER-TIGHTEN THE VISE ON THE MAGAZINE.**  
The jig will securely hold the magazine, resting on the top edges of the vise jaws.
5. **NOTE:** Many older blued and military magazine base plates are HARDENED and may require an additional step to help the drill bit start cutting. **Mec-Gar** brand, **Nickel plated** and many newer Stainless magazines will be more difficult to drill **because the bases become weld-hardened in the manufacturing process.**  
  
**For these, we recommend using a Dremel #952 Aluminum Oxide Stone to grind a small dimple at the point where the holes will be drilled, to expose the un-plated base metal. This will allow the cobalt drill bit to cut easily through the base.**
6. Using an electric hand drill and the #43 cobalt drill bit provided, drill the holes in the magazine using the holes in the MAGJIG as a guide **Use a LOW to MEDIUM motor speed** to start, with an even, constant downward pressure, while drilling.
7. Attach the base pads using #4-40 Stainless Steel **thread cutting** screws, or tap the holes with a 4-40 tap.
8. Thoroughly clean the inside of the magazine body to remove any remaining oils or metal shavings before reassembly.

#### TIPS FOR USING THREAD CUTTING SCREWS

- When using Thread Cutting screws, use them just as you would use a tap.
- **DO NOT ATTEMPT TO DRIVE THE SCREWS IN ALL THE WAY.**
- Place a drop of oil on the tip of the screw and turn the screw in, applying a firm, constant pressure for the threads to begin cutting.
- Turn the screw cutting inward about 1/2 turn, then back out. Cut inward a 1/2 turn more, then out again.
- When turning the screw becomes very difficult and wants to stop, back the screw out to clear the shavings that are being created.
- Wipe away the debris from the tip of the screw.
- If necessary, apply a bit more oil, then continue, using the same back and forth method. Cut a little way in and back out again, until finally through the floor plate.
  - Many older 2-toned color, military contract magazines have case-hardened base plates and the process will be even slower.
  - ALL **Mec-Gar** magazines, especially Nickel plated and newer Stainless Steel magazines may be more difficult to drill and drive the screws into.
  - Older Stainless Steel magazines should not be anymore difficult than regular blued steel if using the guidelines mentioned above.

**If you break a screw off and cannot remove it, file the screw flat and flush with the magazine base and drill out the screw using the MAGJIG.**

**If you are still having difficulty please contact us.**

(775)-392-3151

Sales@customdefensiveproducts.com

**You can send the magazine(s) to us by First Class mail.  
We will repair the hole and install the base pad and return the magazine to you at no charge.**

**Please contact us first if returning items for repair.**

**Custom Defensive Products  
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Gardnerville, NV 89410**

**Be sure to include your return address inside the package.  
Write your name on the magazine using masking tape or a magic marker.**