



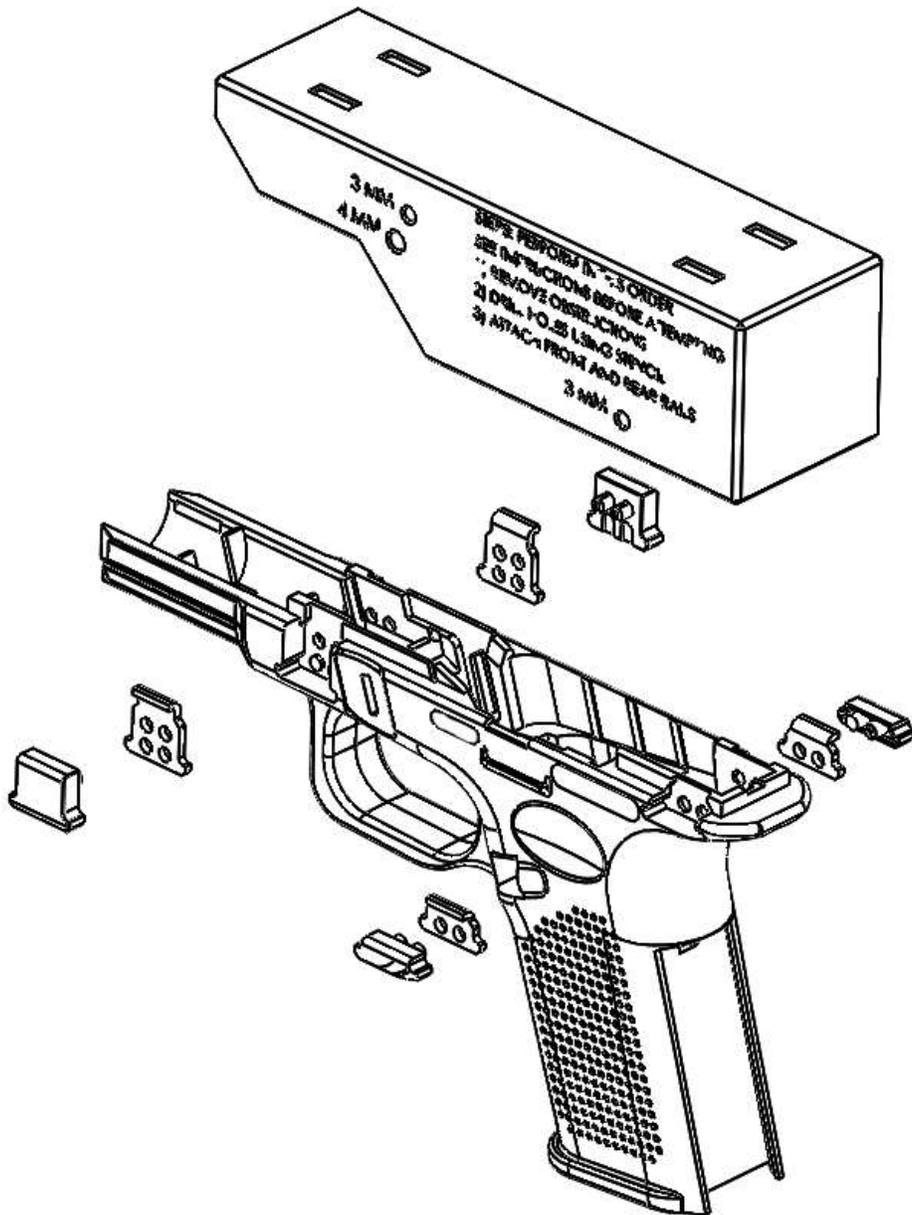
Freedom Wolf 80% Instructions

PLEASE READ INSTRUCTIONS BEFORE ATTEMPTING ANY
WORK.

Introduction:

The following content is critical for understanding the details on how to complete your new Freedom Wolf. The instructions within this document supersede any video or documents found **outside of** the Lone Wolf website.

The instructions will be a step by step process on how to complete your new frame. They will detail the procedures for drilling the pin holes along with the removal of the indicated impediments. As there are many methods that can produce the same result, we recommend that you follow the instructions as indicated. Failure to do so will result in voiding the warranty.



Warranty:

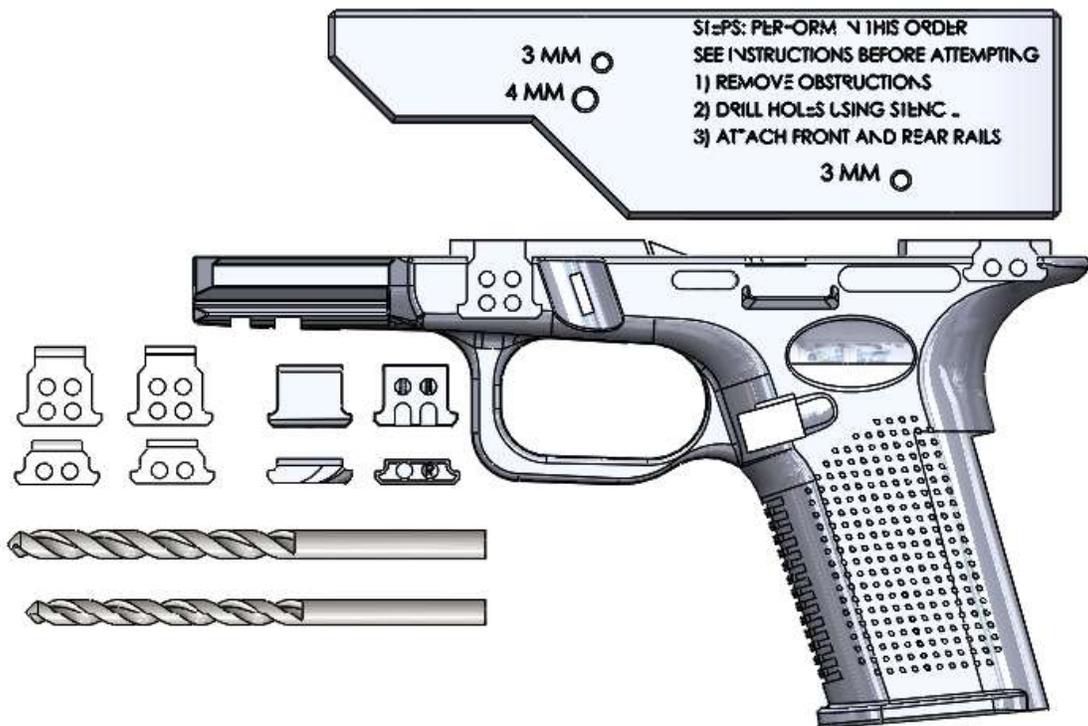
There are limits to our warranty coverage, particularly when the customer damages the product through poor craftsmanship or improper control during the milling process, and when they drill holes using the wrong tools. Additionally, after the milling is completed, the build process seems to be where most people get into trouble, particularly during assembly and cleaning. Here are key areas that you need to watch for:

1. Drill the pin holes using the stencil provided in the Lone Wolf kit. Use a drill press and the drills provided in the kit. DO NOT use a hand drill either with or without a drill press vise or cross slide vise to drill your holes.
2. Only use the adhesive that is provided in the kit. This is designed for contact with polymer-based products. Super Adhesive versions are not to be used on the polymer.
3. Take care to know what chemicals you use on the polymer frame. DO NOT USE ACETONE FOR ANY REASON, or products that contain acetone i.e. Break Free®. Please review ingredient lists of any chemical products you plan to use prior to using them.

Bill of Materials:

Below are the parts and tools that will be provided when you purchase a Lone Wolf Freedom Wolf 80% lower. Additional tools will be required and will be expanded upon in the next section.

PART DESCRIPTION	QUANTITY
Lone Wolf Freedom Wolf 80 % Frame	1
Mold Cooling Fixture (installed where locking block will go)	1
Flat Backstrap	1
Swelled Backstrap	1
Magwell	1
Front Rail Insert	2
Rear Rail Insert	2
Front Rail Cap	2
Rear Rail Cap, Left	1
Rear Rail Cap, Right	1
Rail Cap Adhesive	1
High-Speed Steel Drill Bit 3mm Size	1
High-Speed Steel Drill Bit 4mm Size	1



Procedure for Finishing the Frame:

These instructions will act as a guide as you work to complete your Lone Wolf Freedom Wolf 80% Lower. We understand that there are multiple methods and techniques that can be utilized to complete the frame. The instructions that follow are a proven technique to fulfill the operations to complete the frame. We will not expand on any other methods (i.e. using a milling machine) besides what is laid out in this document.

After completing all steps, you must let the item sit for 48 hours before attempting to fit and function the frame. This ensures the adhesive is completely cured.

Within the instructions the goal is to complete the following:

- 1) Remove Mold Cooling Fixture from area where Locking Block will be installed.
- 2) Remove rear obstructions to allow for the installation of Trigger and Locking Block.
- 3) Drill holes (from both sides) for Trigger, Locking Block, and Fire Control Housing Pins.
- 4) Remove front obstructions to allow for Dust Cover to be installed.
- 5) Remove middle obstructions for Recoil Rod to be installed.
- 6) Install Front Rails and Inserts.
- 7) Install Rear Rails and Inserts.
- 8) Wait 48 hours for adhesive to cure completely.

Throughout this document we recommend using a variety of tools some of which will not be provided in your Lone Wolf Freedom Wolf 80% Lower. We recommend the following:

- 1) Dremel hand tool (or likeness) with a sanding drum
- 2) Pair of needle nose pliers
- 3) Drill press
- 4) 4-inch drill vise
- 5) Sandpaper 220 grit or higher
- 6) Paint brush size #3 from a craft store

NOTE: Some of these tools can destroy your frame if used improperly. We recommend that they be operated under an experienced and steady hand.

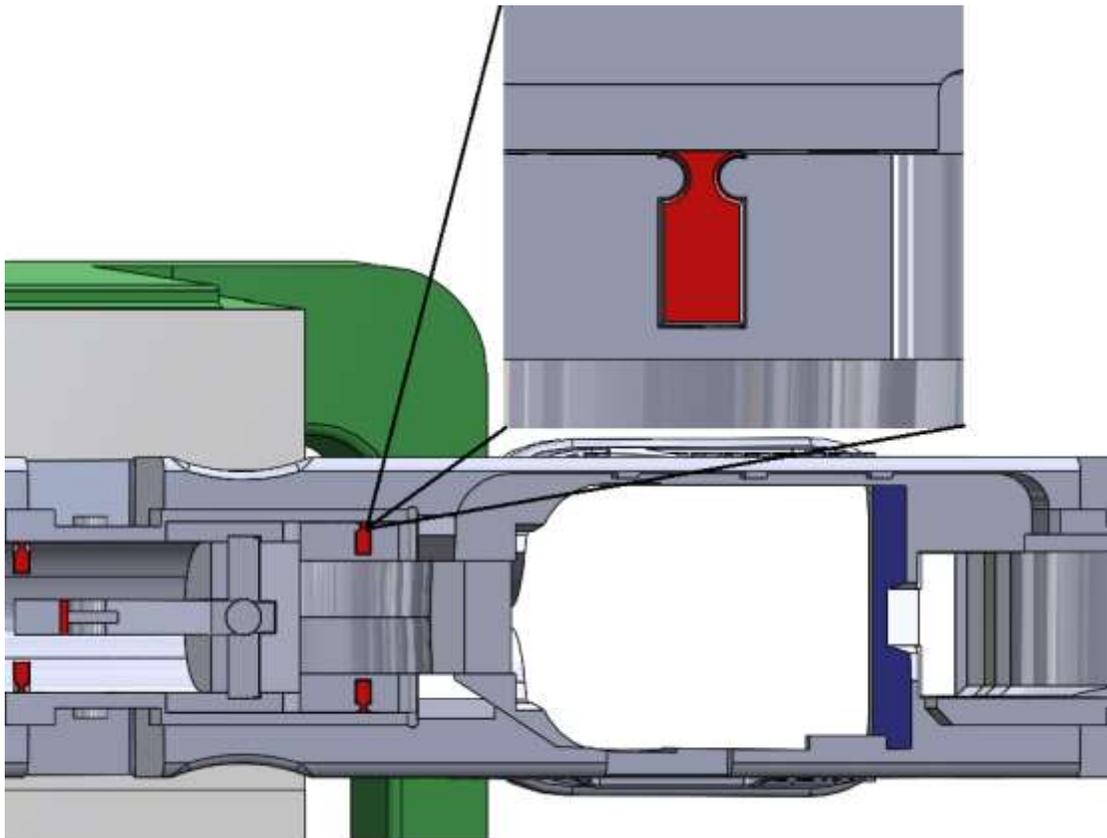
STEP 1

LOCKING BLOCK OBSTRUCTION REMOVAL

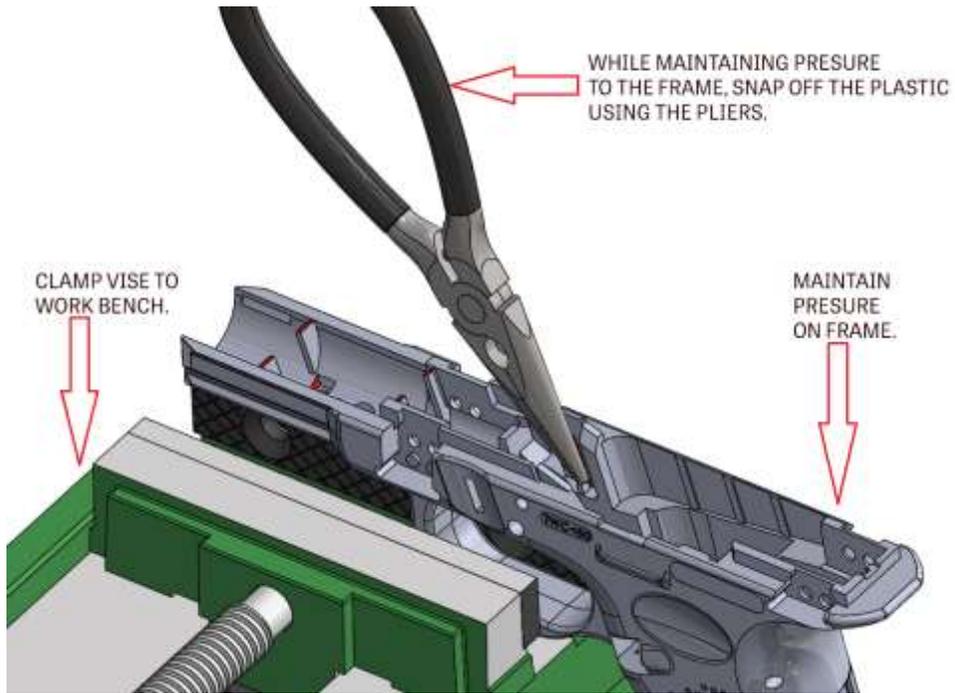
Locking Block Obstruction Removal:

To remove the obstructions, you will need a pair of needle nose pliers, a Dremel hand tool and some sandpaper. First, using pliers, remove the Mold Cooling Fixture. This piece is not permanently affixed to the frame and should not require force to remove. Simply use pliers to pull the piece up, paying attention to the angle as to not damage your Freedom Wolf.

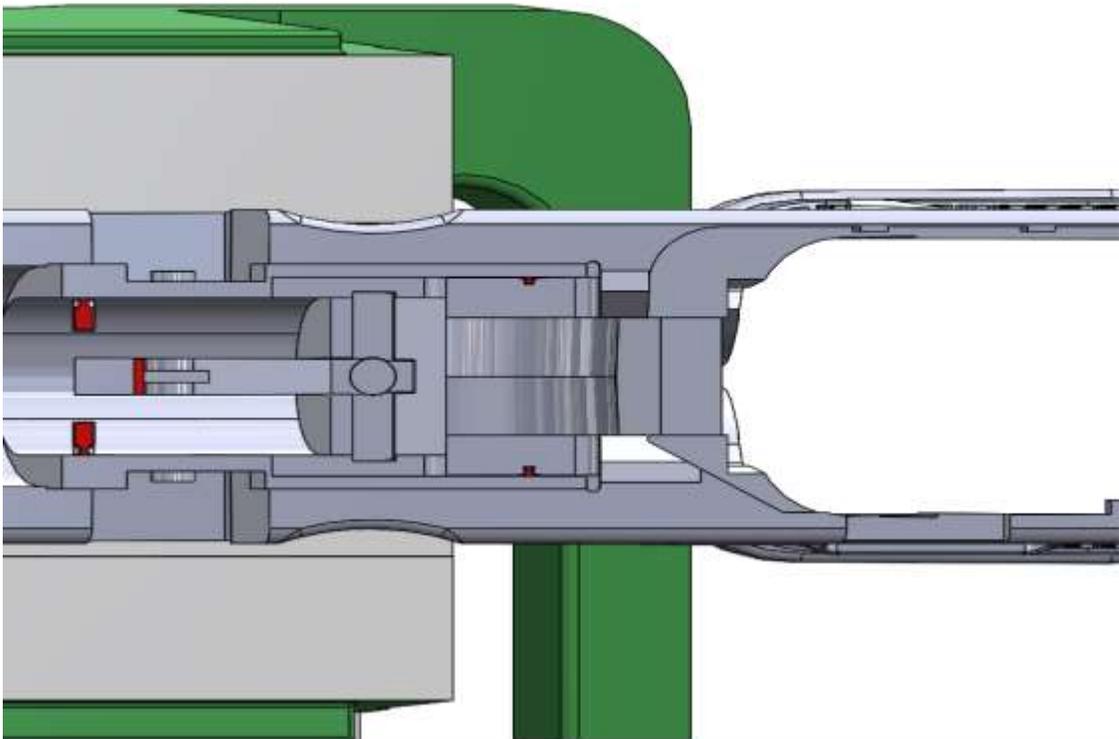
When examining the frame, you will notice snap features (shown below). These are designed to allow the user to remove most of the obstruction with pliers. You will first use the pliers to remove the obstruction, the Dremel to clean up any residual plastic and finally some sandpaper for finishing touches.



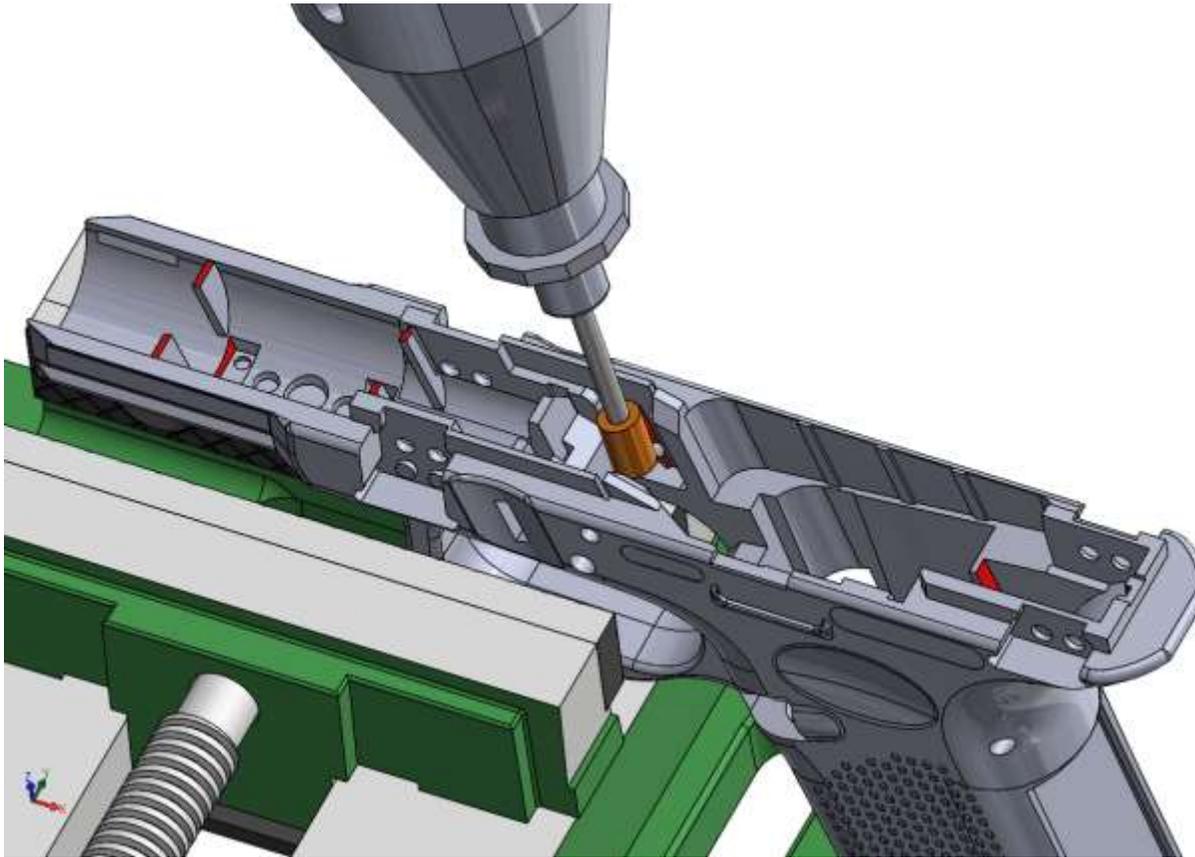
- 1) Place the frame into the vise in an upright position. Clamp to a stable work bench.
- 2) Using the pliers break away the obstructions on both sides.



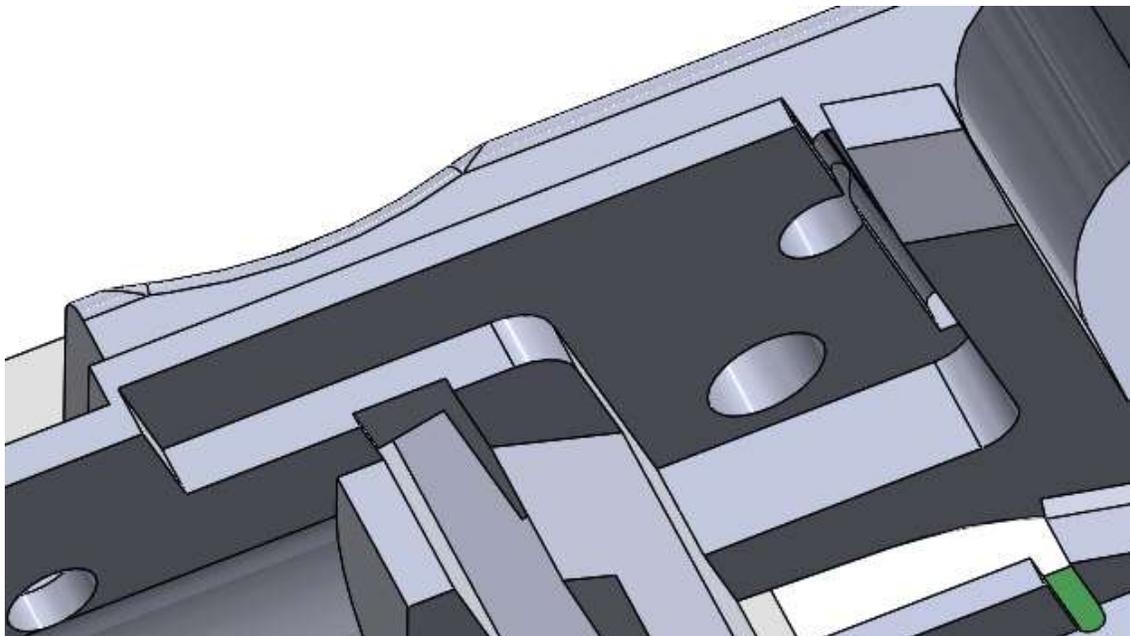
Results should be like this.



- 3) Using the Dremel and sandpaper, remove any remaining plastic until a locking block will fit smoothly. This will require a steady hand. Do not be too aggressive.



You are looking for the following result:



STEP 2

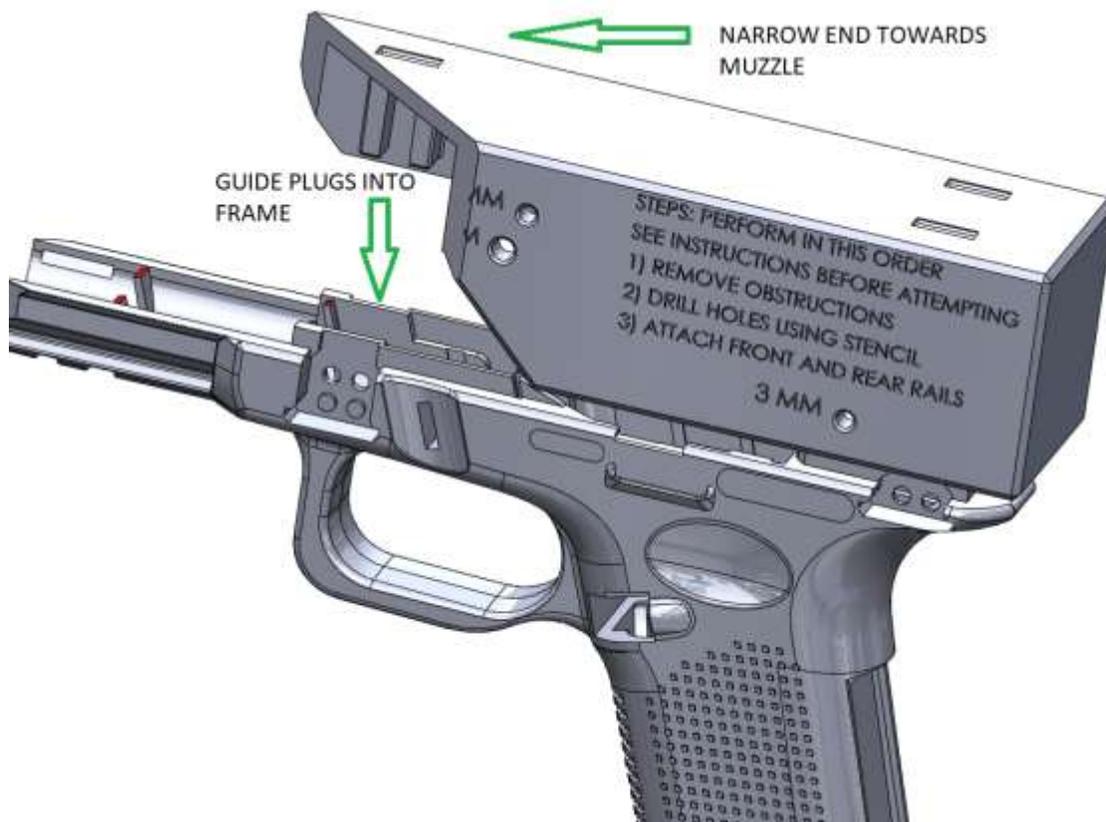
DRILLING THE HOLES

Drilling the Holes:

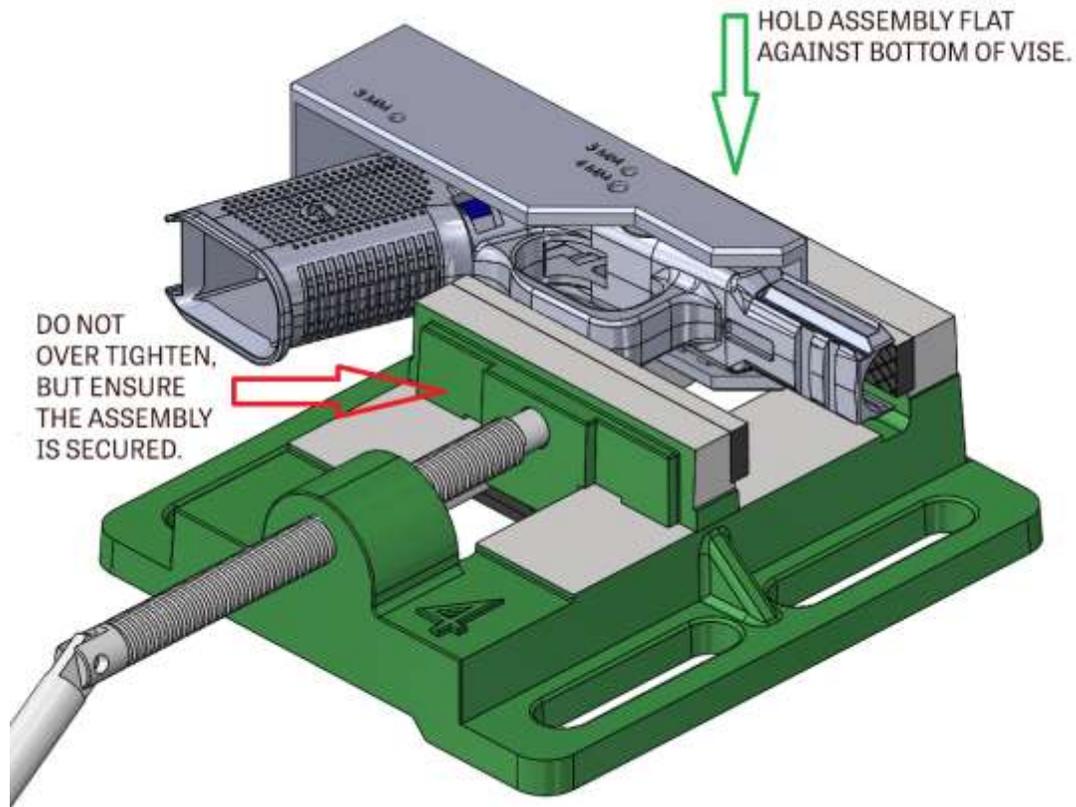
In this operation you will be drilling holes for the trigger, locking block and fire control housing pins. You will be drilling from both sides of the frame. Drill the stencil from both sides. **DO NOT drill all the way through from one side.**

Use only the stencil and drill bits provided. Do not attempt to drill holes without the stencil. Doing so will result in poor hole placement, will cause failures, and will void the warranty on this product.

- 1) Insert the Stencil into the frame. Ensure that the narrow end is facing forward (muzzle end).

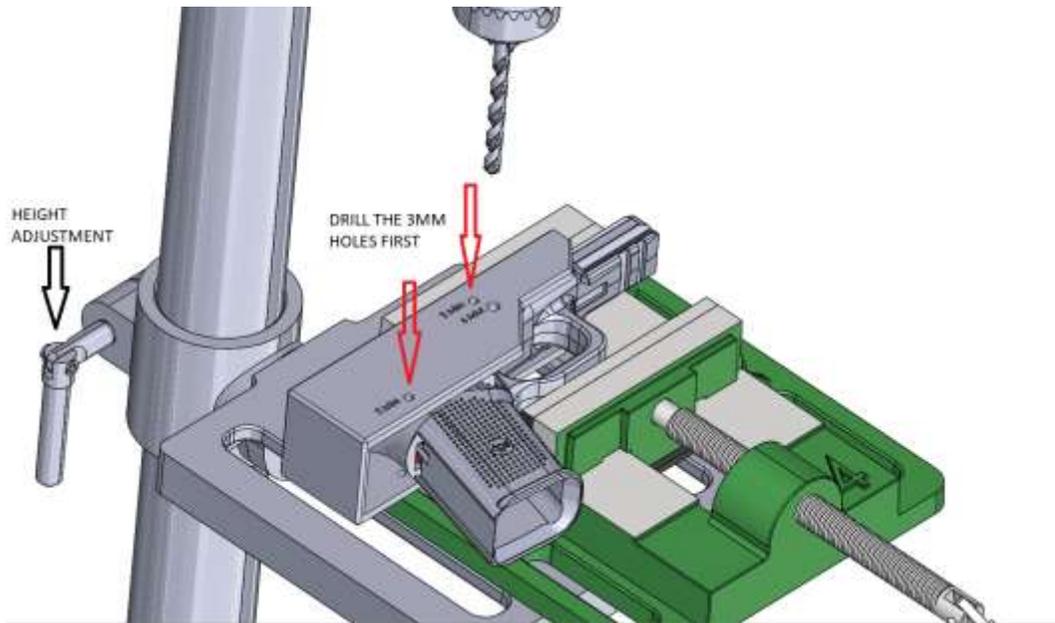


- 2) Clamp stencil and frame into a cross vise. Hold the frame and stencil firmly against the vise as you tighten the clamp. Be sure not to over tighten as it may deflect and cause issues with the holes.

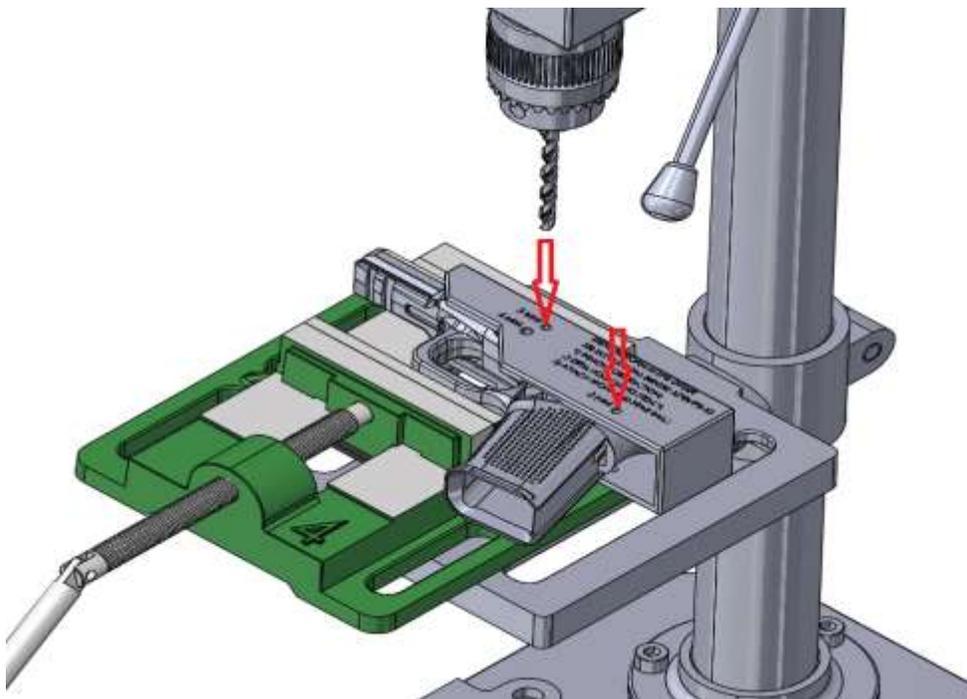


- 3) Load the 3mm drill into the drill press. Place the vise onto the drill press table and adjust the height until the end of the drill is 3" from the stencil. Keep the vise free moving to ensure the drill can self-center in the stencil. It may help to rotate the vise for the FCH pin hole to make sure you are drilling over the drill press table. DO NOT ATTEMPT TO DRILL THROUGH THE STENCIL.

- a. Remove the 3mm drill and replace it with the 4mm drill.



- 4) Flip the assembly and perform step 3



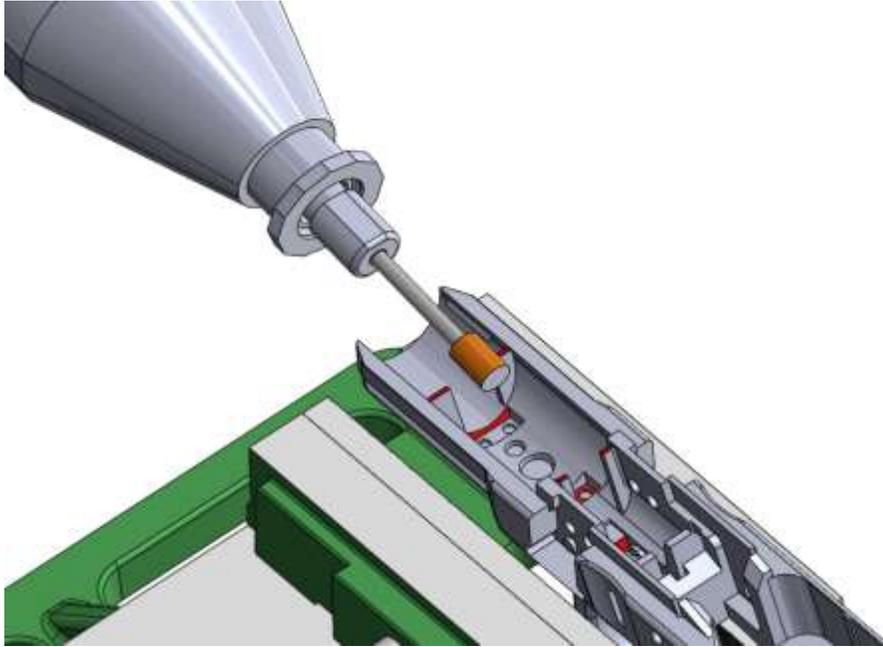
- 5) Remove the frame from the vise and the stencil. Deburr to remove any lingering polymer.

STEP 3

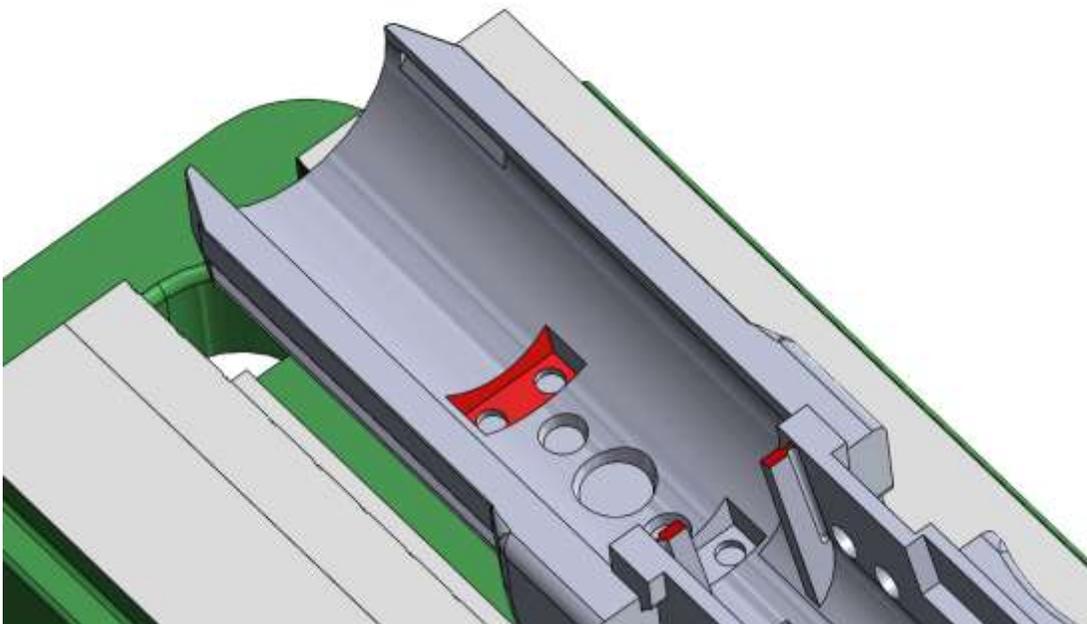
DUST COVER OBSTRUCTION REMOVAL

Dust Cover Obstruction Removal:

- 1) Using the same steps in the Locking Block Obstruction Removal step, remove the plastic obstructions.
- 2) Using the Dremel remove and smooth out the dust cover obstructions.



You are looking for the following result:



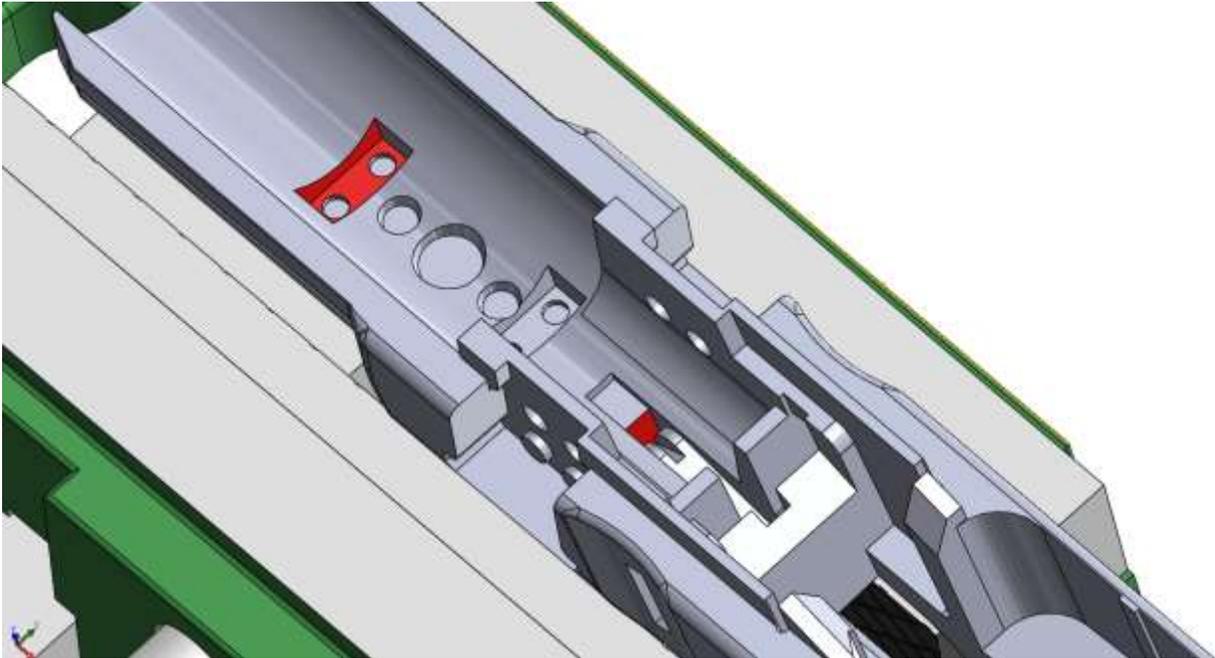
STEP 4

RECOIL ROD OBSTRUCTION REMOVAL

Recoil Rod Obstruction Removal:

- 1) Using the same steps in the “Locking Block” and “Dust Cover” Obstruction Removal steps, remove the plastic obstructions.

You should get a result like the following



Review all the areas where obstructions were removed and ensure that there is no remaining plastic, debris or burrs. Loose debris may cause issues with the next steps.

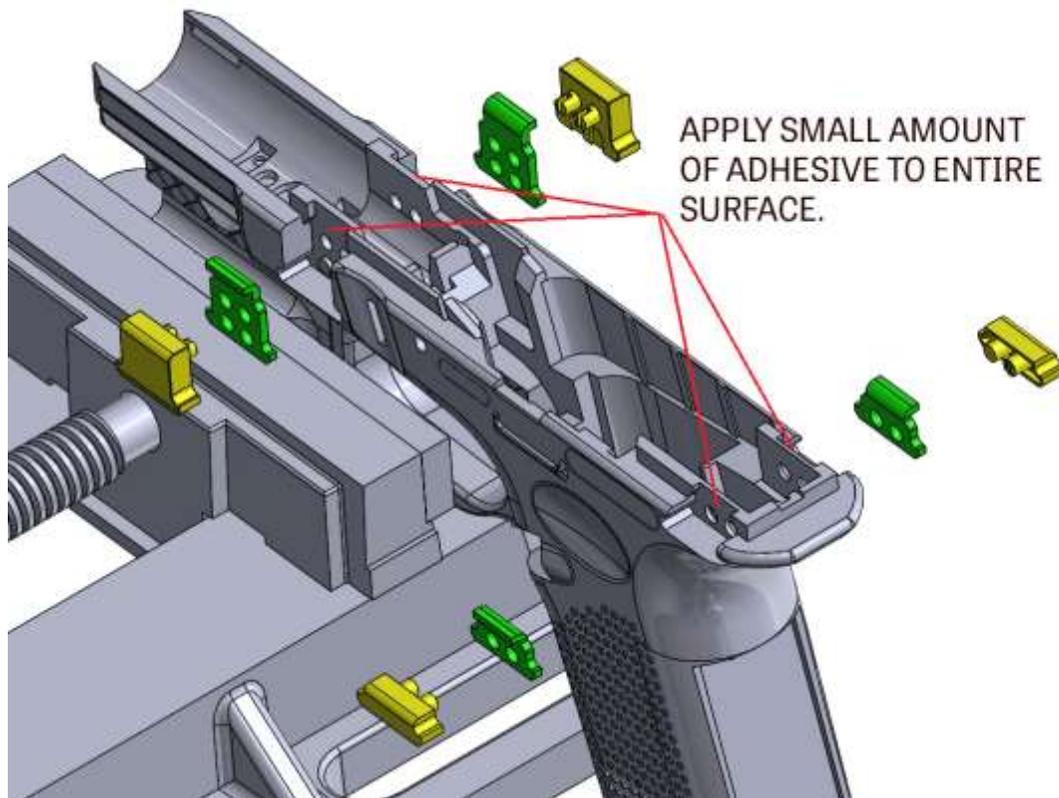
STEP 5

FRONT AND REAR RAIL AND INSERT INSTALL

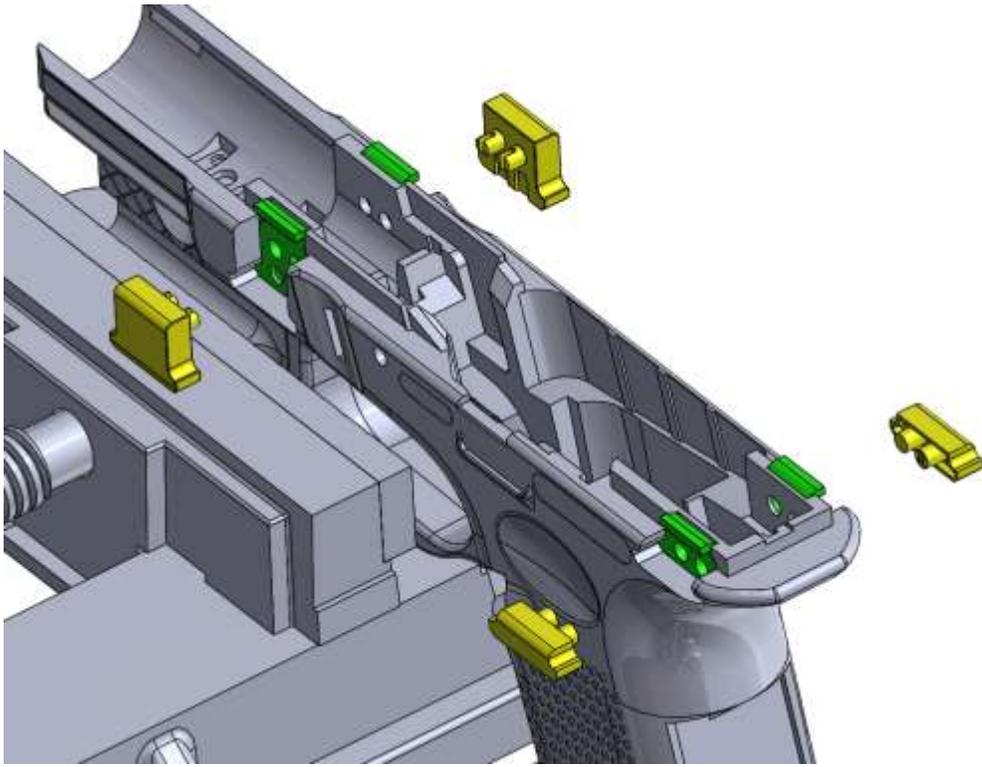
Front and Rear Rail Install:

Once again ensure that there is no left-over debris from sanding. Leave the frame upright in the vise. Here, you will be able to finalize the installation of the rails.

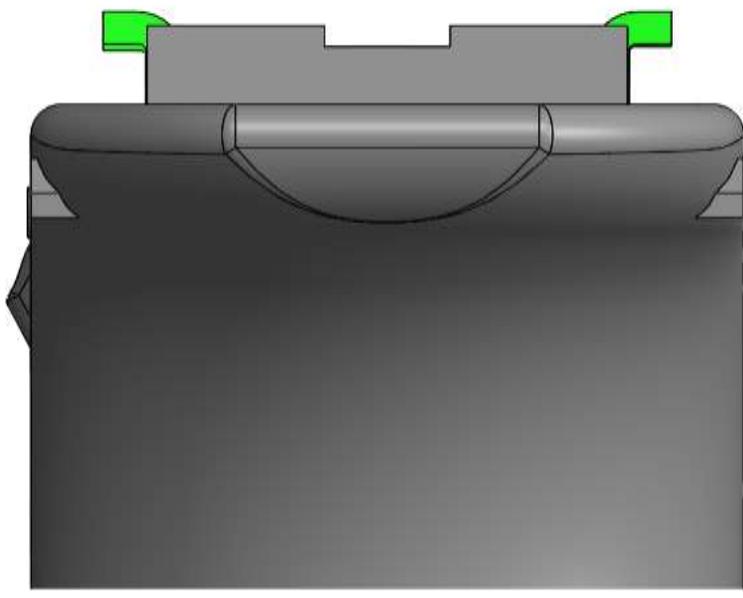
- 1) With the frame secured in the vise apply a small amount of the adhesive (provided in the kit) to the pockets of the frame. A small brush (like brush size #3 from a craft store) will help coat the entire surface.



- 2) Now slide the rails into each pocket. Note that the rail should be facing away from the center of the frame.

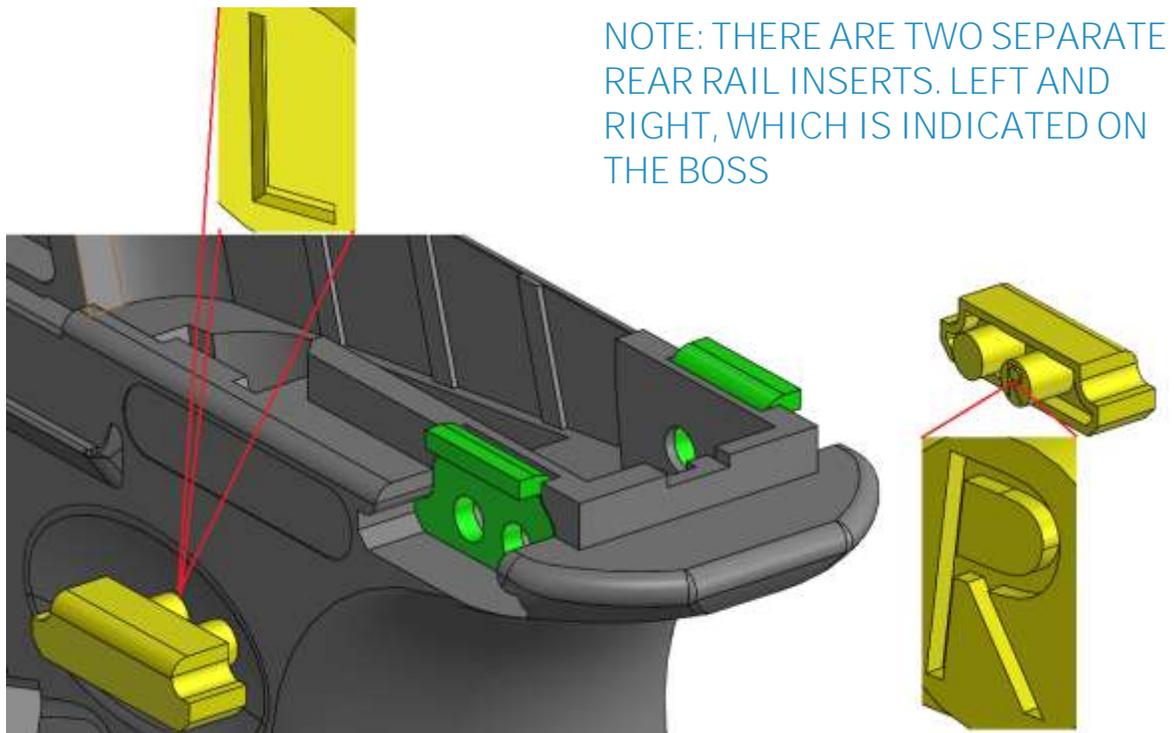
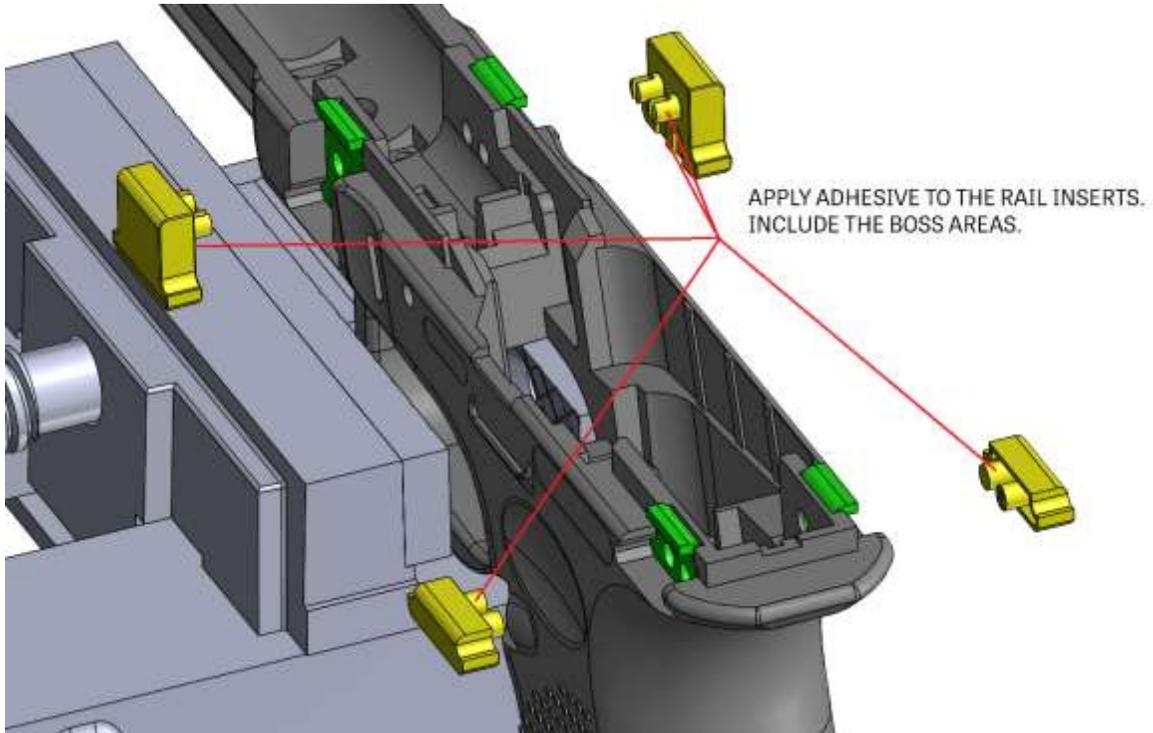


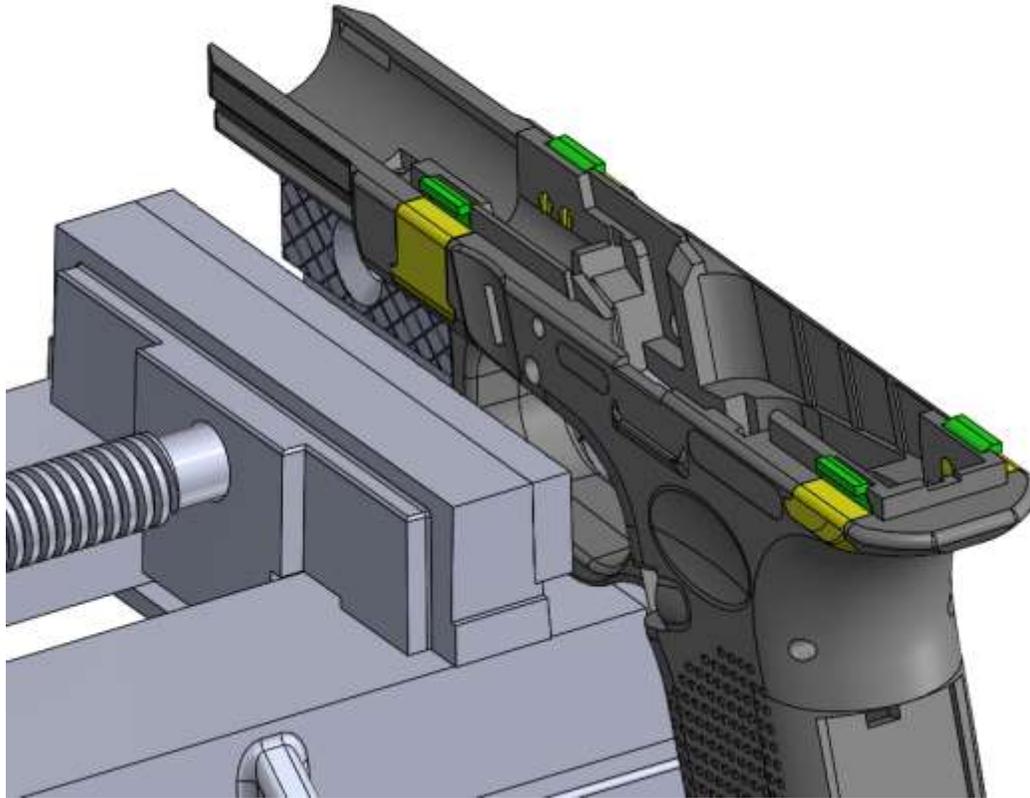
← RAILS FACING AWAY FROM CENTER OF FRAME →



Front and Rear Insert Install:

- 1) Apply adhesive to the faces of the rail inserts. Be sure to include a small amount on the bosses that protrude through the rail insert.





- 2) Press all four inserts firmly into the frame and hold. The adhesive will set quickly but will need **48 HOURS TO CURE**.

LET SIT FOR 48 HOURS BEFORE
ATTEMPTING TO FIT AND FUNCTION
THE FRAME.

After allowing the adhesive to cure, your Freedom Wolf is now ready to complete.

For more information, please visit www.LoneWolfDist.com/FreedomWolf.

Modified 4.1.21