Dimensions are based off the take-down pin hole which will be easier for most users to locate off. Mil-spec is based off the pivot pin hole. Using the take down pin hole should be fine since the take-down & pivot pin holes are machined to within .001 location to each other.

Dimension shown in ( ) are for reference.

Locate and zero X & Y axes off the center of the take-down pin hole.

Mil-spec tolerance for hole locations are tight, so only use high quality, stub length, 135 deg split tip drill bits.
These dimensions are for milling out the fire control pocket and trigger slot.

Drill trigger, hammer, and selector holes first, then mill the fire control pocket and trigger slot.

Dimension shown in ( ) are for reference.

Locate and zero X & Y axes off the center of the take-down pin hole and the left side face.