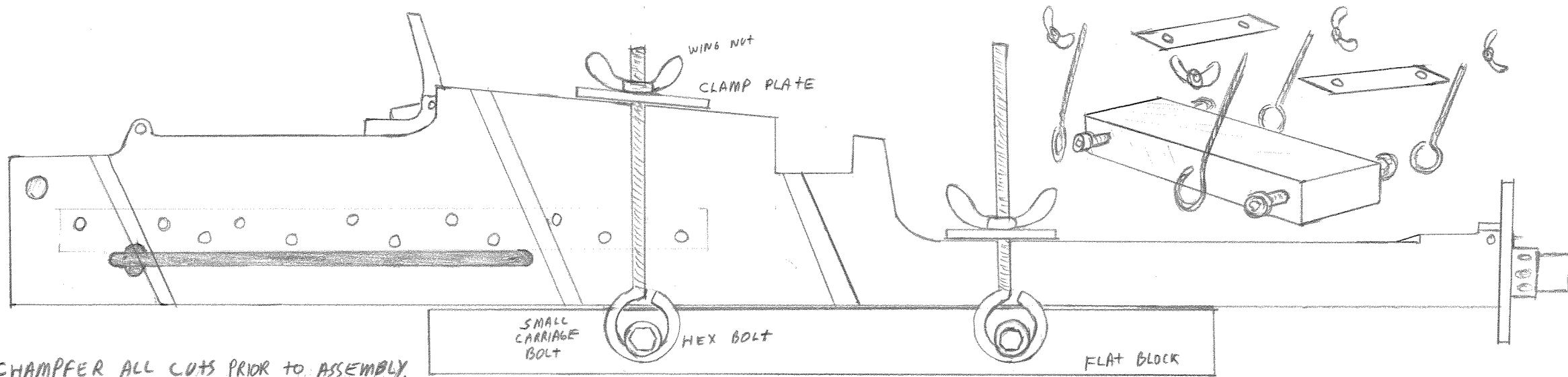


① WORK FROM FRONT TO REAR ON THE RECEIVER. USE THE BARREL LATCH FOR THE FIRST MEASUREMENT. ASSEMBLE WITH LATCH IN PLACE ON JIG AND SNUG DOWN CLAMPS. USING A STRAIGHTEDGE ALIGN EVERYTHING AND CLAMP DOWN TIGHT. REMOVE LATCH AND INSERT BOLT/CARRIER TO CHECK GASTUBE ALIGNMENT. THEN TIGHTEN CLAMPS AND WELD. ② SHIFT TO NEXT CUT. INSTALL BARREL W/ LOADED CARTRIDGE OR NEW CASE AND LATCH DOWN. REMOVE FIRING PIN FROM BOLT AND INSTALL ON CARRIER. INSERT CARRIER/BOLT BEING SURE BOLT FACE ENGAGES RIM OF CARTRIDGE AND LOCK UP BOLT. CLAMP FORWARD MAG WELL SECTION DOWN TIGHT AND SHIFT REAR SECTION FORWARD UNTIL YOU GET A FIRM LOCK UP. CLAMP DOWN TIGHT AND CHECK WITH A STRAIGHTEDGE AND WELD.



- * CHAMPFER ALL CUTS PRIOR TO ASSEMBLY.
- * INTERNAL JIG WITH WELD IN RAIL MUST BE INSTALLED WHEN WELDING THE REC. BODY

INSERT MAGAZINE TO ENSURE IT FITS. ③ THE REAR SECTION IS NOT TOO IMPORTANT. BE SURE YOU CAN INSTALL AND REMOVE CHARGING HANDLE. INSERT HANDLE AND SNUG DOWN CLAMPS. INSERT CARRIER TO ENSURE IT FITS SMOOTH AND REMOVE. CHECK ALIGNMENT WITH STRAIGHTEDGE THEN INSTALL AND REMOVE CHARGING HANDLE. REINSERT INTERNAL JIG AND WELD. AFTER WELDING FILL ALL HOLES TO FURTHER SECURE RAIL ON RIGHT SIDE. LIKE I SAID THE REAR PORTION IS NOT TOO IMPORTANT JUST BE SURE IT IS NOT MORE THAN 1/8" APART. I DID NOT TAKE ANY EXACT MEASUREMENTS, YOU SHOULD BE ABLE TO FIGURE IT OUT. I USED FLATS OF ALUMINUM SANDWICHED TOGETHER FOR A JIG WITH A SLOT ON THE RIGHT TO ACCOMMODATE THE RAIL. ONE PIECE OF COPPER WOULD BE BETTER.

Patrick Marts
EZFEED