

Thank you for your purchase.....

These instructions are not for action installation. The action should be installed by a competent gunsmith. Linkage adjustment may or may not be required but it is important to be properly set regardless.

If your action uses set screws to retain pivot pins, you will need to replace them with knurled pins. We have these available on our website. If your action has knurled pins, they can be used. The knurl pattern is usually visible on one end of the action pins.

Your new barrel has been nitride treated. This process will leave a brown/red residue on any or all nitride surfaces. This color will be seen on cleaning patches and may appear to be rust, it is not rust. It is not necessary or even beneficial to scrub the bore until this color no longer appears on cleaning patches. The last steps of the nitriding process involve taking the barrel at a high temperature and dropping it into a tank of water. The reaction is violent enough that any debris is flushed out of the barrel. They are then dipped into water displacing oil prior to returning to our facility. Shooting the barrel will clean the colored residue out over time.

If your barrel has a picatinny rail installed, we have already applied blue Loctite and torqued the mounting screws.

The breech plug must be headspaced after action installation. The variance in actions is why the adjustable breech plug is required. Adjustable breech plug instructions are available on our website. It is crucial the adjustable plug is not taken apart and cleaned constantly. This will eventually cause flame cutting. Leaving carbon around the bushing provides a seal to block hot gases from penetrating the small clearances that are present in a clean assembled plug. A 5/32 drill bit can and should be used to remove carbon accumulation from the flame channel frequently.

When the action is installed and snaps shut, the breech face should be parallel to the end of the barrel. There have been actions that will not snap shut without a primer while having a parallel breech face. In this case, the breech plug can be used to achieve the proper action position. If the action is not parallel, the primer or module will only contact on one side. With 209 primers, this can lead to leakage because the primer rim will bend and not stay compressed under firing.