

# SADLAK INDUSTRIES LLC

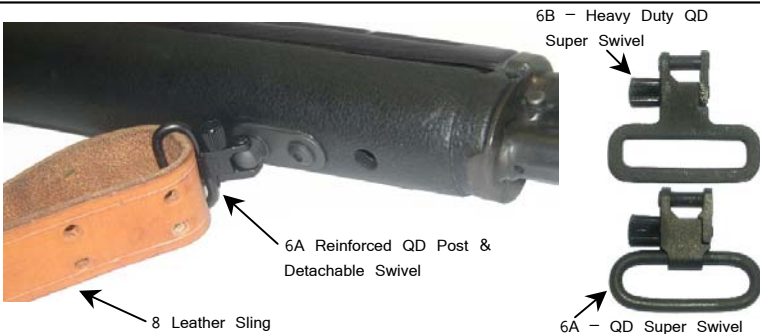
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## REINFORCED QD POST ASSEMBLY for M14 STOCKS

### Front Swivel Replacement for mounting QD-Type Bi-Pod Model QD-5F



M14 shown with (#7) Harris Bi-Pod and (#8) Turner NM Leather Sling Attached to Sadlak Reinforced QD Post #140050



The Reinforced Quick Disconnect (QD) Post Assembly replaces the stock M14 front swivel for a more rugged, durable Bi-pod attachment. To eliminate cracking of the stock during heavy recoil use or rough handling, the oval washer design has approx. 3 times the load disbursement over the standard single QD post. Designed for use with a Harris Bi-pod or other Bi-pods using the standard QD post. Once the QD post is installed you have flexibility of attaching a Bi-Pod or detachable QD Super swivel (optional accessories #6A, #6B see below). All hardware and screws have mil-spec. Manganese Phosphate finish. The internal Nut Plate can be further supported by permanently bedding it into the stock using Devcon Steel Epoxy or other bedding compound.

#### 140050 Assembly Includes:

- #1: Interior Oval Nut Plate
- #2: Exterior Oval Washer Plate
- #3: QD Post, #10-32 Thread
- #4: Disc Lock Washer 2 ea
- #5: Button Screw, #10-32
- 1/8" Hex Key (Not Shown)

**Price**  
**\$48.<sup>00</sup>**

P/N:  
 140050

**Package**  
**Price**  
**\$ 220.<sup>00</sup>**

See Below

#### Optional Equipment:

- #6A: 1-1/4 QD Super Swivel, Detachable Steel Black #UMK14033 - \$8
- #6B: 1-1/4 QD Super Swivel, Heavy-Duty Steel Black #UMK14023 - \$15
- #7: Harris Bi-Pod Model SLM 9-13" legs - \$120
- #8: Turner Leather Sling (Shown) - \$75

#### Optional Tools:

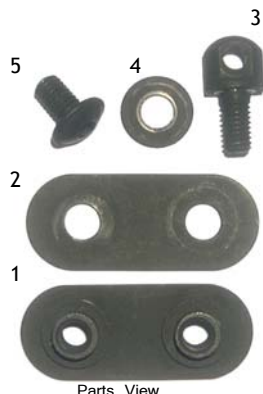
- #10: 9/32 Drill w/ Non-grab Cutting Edges- \$6 (Note: Standard drills may grab and crack stock)
- #11: Devcon Steel Epoxy Putty #S-6 - \$10

**Note:** M14 Stock requires enlarging existing holes to 9/32. Also, a wood router bit is required for Wood Stocks to recess oval Nut Plate.

#### QD Post Assembly



P/N 140050



Parts View



Bottom View



Inside View



Reinforced QD Post Assembly bedded to Black Fiberglass Springfield Armory Inc. Stock

**SAVE \$55 with Package Price:**

**\$ 220.<sup>00</sup>**

(Reg \$275)

1 pc ea - P/N 140050, #6B, #7, #8, #10, #11

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## INSTALLATION INSTRUCTIONS REINFORCED QUICK-DISCONNECT (QD) POST ASSEMBLY

### CONTENTS SHIPPED:

- 1) Internal Oval Nut Plate
- 2) External Oval Washer
- 3) QD Post with 3/8" Threaded Stud
- 4) Disc Spring Washer (2 pcs)
- 5) Button Head Screw #10-32 x 3/8L
- 6) 1/8" Hex Key
- 7) Installation Instructions

### TOOLS REQUIRED:

- 1) Standard Drill Bit 9/32 (.281") (Note: dull tip to prevent cracking stock. See options below)
- 2) Drill press (best) or Hand Drill.
- 3) Disc Grinder
- 4) Loctite 222MS or 272 or equiv.. thread Locker.

### OPTIONAL TOOLS

#### AVAILABLE from SADLAK:

- 1) Drill Bit 9/32 (.281") with pre-dulled tip. p/n:0900050
- 2) Devcon Steel Bedding Epoxy p/n:0900070

### 1. REMOVE RECEIVER & BARREL FROM STOCK

- a. Remove Trigger Group: Pull trigger guard toward rear until it unlatches.
- b. Pull guard down and swing out and away toward barrel.
- c. Pull straight down to disengage from the receiver.  
NOTE: The receiver does not have to be removed from the stock.  
This is important if your rifle has been Bedded.
- d. Turn stock upside down.
- e. Gently tap rear of stock against bench top. Stock will detach from receiver.
- f. Remove barrel from stock.

### 2. REMOVE FRONT SLING SWIVEL FROM STOCK

- a. Carefully grind the two Rivet Heads off using either a hand held disc grinder or bench top grinder.  
File or Dremal tool can also be used. CAUTION:DO NOT over heat rivet during grinder. This could cause melting of fiberglass stock or burning of wood stock.
  - i. TIPS: Stuff wet rag on inside of stock to keep stock and rivets cool from the inside.
  - ii. After grinding a little, use another wet rag to periodically dampen rivet heads. Perform this step often.
  - iii. Be careful not to hit stock when using bench top grinding wheel.
  - iv. Grind rivet heads flush of slightly below sling swivel bracket
- b. After grinding rivet heads completely off, lightly tap rivet thru. Do Not use too much force.

### 3. PREPARE STOCK – Drill Out Two Holes

- a. Carefully drill thru two existing rivet holes in stock using a 9/32 (.281") Drill Bit with dulled tip.
- b. CAUTION: a drill bit with the cutting edges slightly dulled with a file or stone is highly recommended to avoid cracking stock caused by a sharp drill bit "grabbing" and ripping thru the hole. Using a drill press will help control drill feed and will help reduce the problem: Hand held electric drills have the least amount of control and rigidity and are more likely to cause a problem. Wood stocks are more likely to crack than fiberglass stock.

### 4. INSTALL QD POST

- a. Place interior Oval Nut Plate inside existing drilled out holes.
  - i. NOTES: On fiberglass stock, if Nut Plate does not rest flush against inside of stock, remove and carefully grind high spots using dermal tool. Wood Stocks: Nut Plate should rest flush but in the event it is too high and the op rod rubs against it, Carefully mark the oval perimeter, remove Nut Plate, and hand grind using a Dremal Tool a small pocket to lower the Nut Plate in the wood stock..
  - ii. HELPFUL HINT: Once the Nut Plate is resting flush, using a bedding epoxy will permanently secure the nut plate to the stock for additional strength.
- b. Place Oval washer on exterior of stock (this can also be epoxy cemented in place). Insert QD Post thru Disc washer and thread into Nut Plate. Tighten until secure and aligned correctly.
- c. Place Button Head Screw into forward hole and thread into Nut Plate.

NOTE: Use a small amount of loctite thread locker on Post and screw to assure reliability.