

SADLAK INDUSTRIES LLC.

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INSPECTION KIT

Includes instructions and precision pins to inspect receiver to determine if the left side groove is within USGI specifications. For accurate results, carefully follow instructions below.

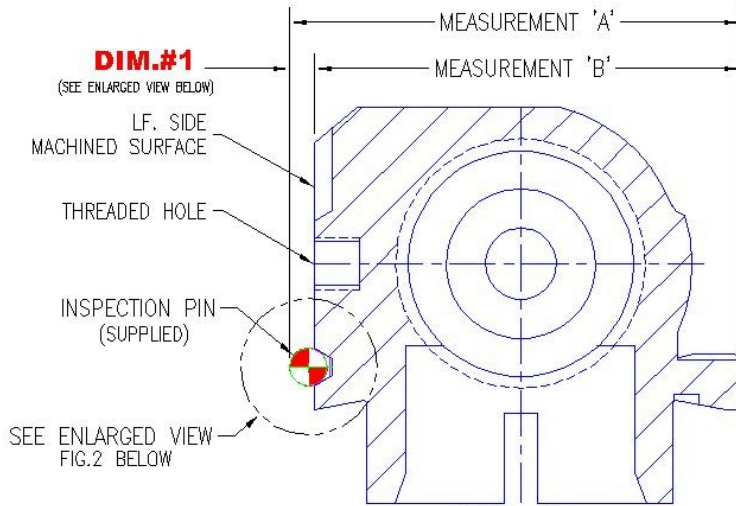




FIG. 1

LEFT SIDE GROOVE CROSS-SECTION
 VIEW LOOKING TOWARD FRONT SIGHT.
 CROSS-SECTION AT CENTER OF LEFT-SIDE #12-32 THREADED HOLE

PRECISION GROUND INSPECTION PINS

 SMALL PIN: 9/64 (.1410) DIA.

 LARGE PIN: 5/32 (.1563) DIA.

THESE PINS ARE USED TO ACCURATELY MEASURE THE LF. SIDE RECEIVER GROOVE TO DETERMINE IF THE GROOVE MEETS USGI SPECIFICATIONS.

INSPECTING THE GROOVE IS USEFUL WHEN TROUBLE-SHOOTING PROBLEMS WITH SCOPE MOUNT INSTALLATION THAT COULD BE CAUSED BY AN OUT-OF-SPEC GROOVE ON M1A RECEIVERS.

ASSEMBLY INSTRUCTIONS

1) SELECT THE APPROPRIATE SIZED PIN AND PLACE IN LEFT SIDE GROOVE (FIG.1). TO DETERMINE WHICH PIN SIZE WORKS BEST SEE FIG.3 ON Sht.2. THE PIN SHOULD REST ON THE ANGLED FACE INSIDE THE GROOVE (Fig.3a) WITHOUT TOUCHING THE GROOVE BOTTOM (Fig.3b) OR CONTACTING THE CORNERS ON THE WIDEST PART OF THE GROOVE (Fig.3c). OFTEN THE SMALL PIN WORKS BEST WHEN THE GROOVE DEPTH (DIM.#2) IS LESS THAN .055" OR THE GROOVE TOP WIDTH (DIM.#4) IS LESS THAN .135".

HELPFUL HINTS: FIRST MEASURE DIM.#2 & DIM.#4 (SEE STEPS 6 & 7 BELOW) TO HELP DETERMINE THE BEST PIN SIZE. USE A FLASHLIGHT OR HOLD UP TO A LIGHT TO SEE IF THE PIN IS CONTACTING THE GROOVE BOTTOM. THE BEST WAY TO HOLD THE PIN IN PLACE WHEN MEASURING IS TO USE 1 OR 2 RUBBER BANDS AROUND THE RECEIVER WITH THE BANDS NEAR EACH END OF THE PIN. ACCURATE MEASUREMENTS CAN NOW BE TAKEN ON THE UNOBSTRUCTED PIN CENTER.

2) USING A 6" DIAL CALIPER (GOOD) OR 2" MICROMETER (BEST) FIND MEASUREMENT 'A'. NOTE: MEASUREMENTS 'A' & 'B' MUST BE TAKEN AT THE SAME CROSS-SECTION LOCATION AS SHOWN IN FIG.1.

3) REMOVE PIN FROM GROOVE AND FIND MEASUREMENT 'B'

4) CALCULATE DIM.#1 BY SUBTRACTING MEASUREMENT 'A' FROM 'B'.

5) FIND DIM.#2 BY MEASURING THE DEPTH OF THE GROOVE USING A 6" DIAL CALIPER OR DEPTH MICROMETER (BEST) (SEE FIG.2). MEASURE DEPTH AT THE SAME CROSS-SECTION AS STEP 2 ABOVE.

6) FIND DIM.#3 & DIM.#4 USING A 6" DIAL CALIPER.

NOTE: THESE DIMENSIONS ARE DIFFICULT TO MEASURE PRECISELY DUE TO SMALL CORNER RADIUS AND/OR CORNER BREAKS BUT ARE STILL A GOOD REFERENCE WHEN COMBINED WITH DIM.#1 & #2.

7) IF DIM.#1 & #2 ARE WITHIN THE DIMENSIONS SHOWN THEN THE LEFT SIDE GROOVE IS MADE TO USGI SPECIFICATIONS.

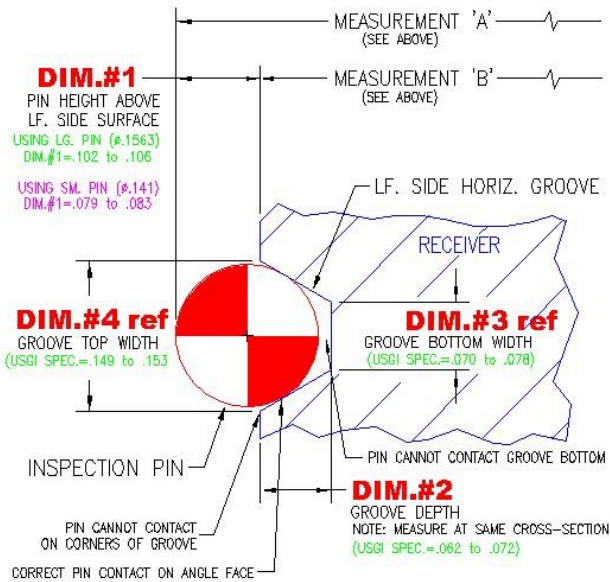


FIG. 2

ENLARGED LEFT SIDE GROOVE

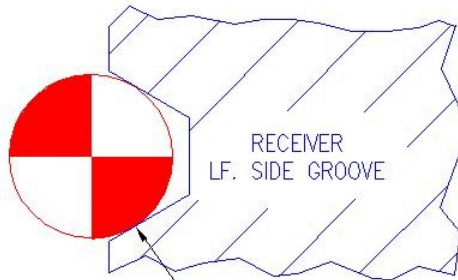
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PROPER ENGAGEMENT OF INSPECTION PIN WITH LF. SIDE GROOVE

Depending on the size and depth of the left groove on an M1A receiver, select either the large or small inspection pin so that it correctly seats on the angle faces inside the groove as shown below in Fig 3a.

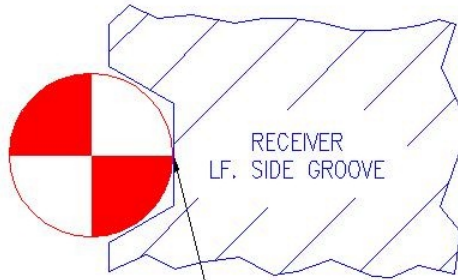
CORRECT
FIG. 3a



RECEIVER
LF. SIDE GROOVE

PIN CONTACTS ANGLE FACE
BUT DOES NOT TOUCH GROOVE BOTTOM
(PIN IS SIZED CORRECTLY FOR GROOVE)

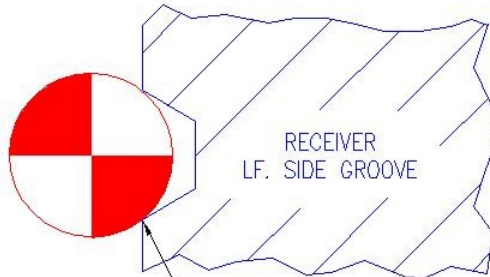
INCORRECT
FIG. 3b



RECEIVER
LF. SIDE GROOVE

PIN CONTACTS BOTTOM OF GROOVE.
(PIN IS TOO SMALL FOR GROOVE)

INCORRECT
FIG. 3c



RECEIVER
LF. SIDE GROOVE

PIN CONTACTS ONLY CORNERS
OF WIDEST PART OF GROOVE
(PIN IS TOO LARGE FOR GROOVE)

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USGI LF. SIDE GROOVE SPECIFICATIONS*

*PER UNITED STATES GOVERNMENT ISSUED (USGI) RECEIVER DRAWING NO. 7790189 SHT. 1 OF 4
 NOTE: Dimensions in green box show the exact dimensions per the original government receiver blueprint.
 Dimension with "REF" have been added by Sadlak Industries LLC for clarification.
 Dimensions labeled with "DIM.#2,3,4" correspond to the inspection kit procedures.
 "DIM.#1" is not shown below because the original blueprint did not use gage pins for measuring groove spec.

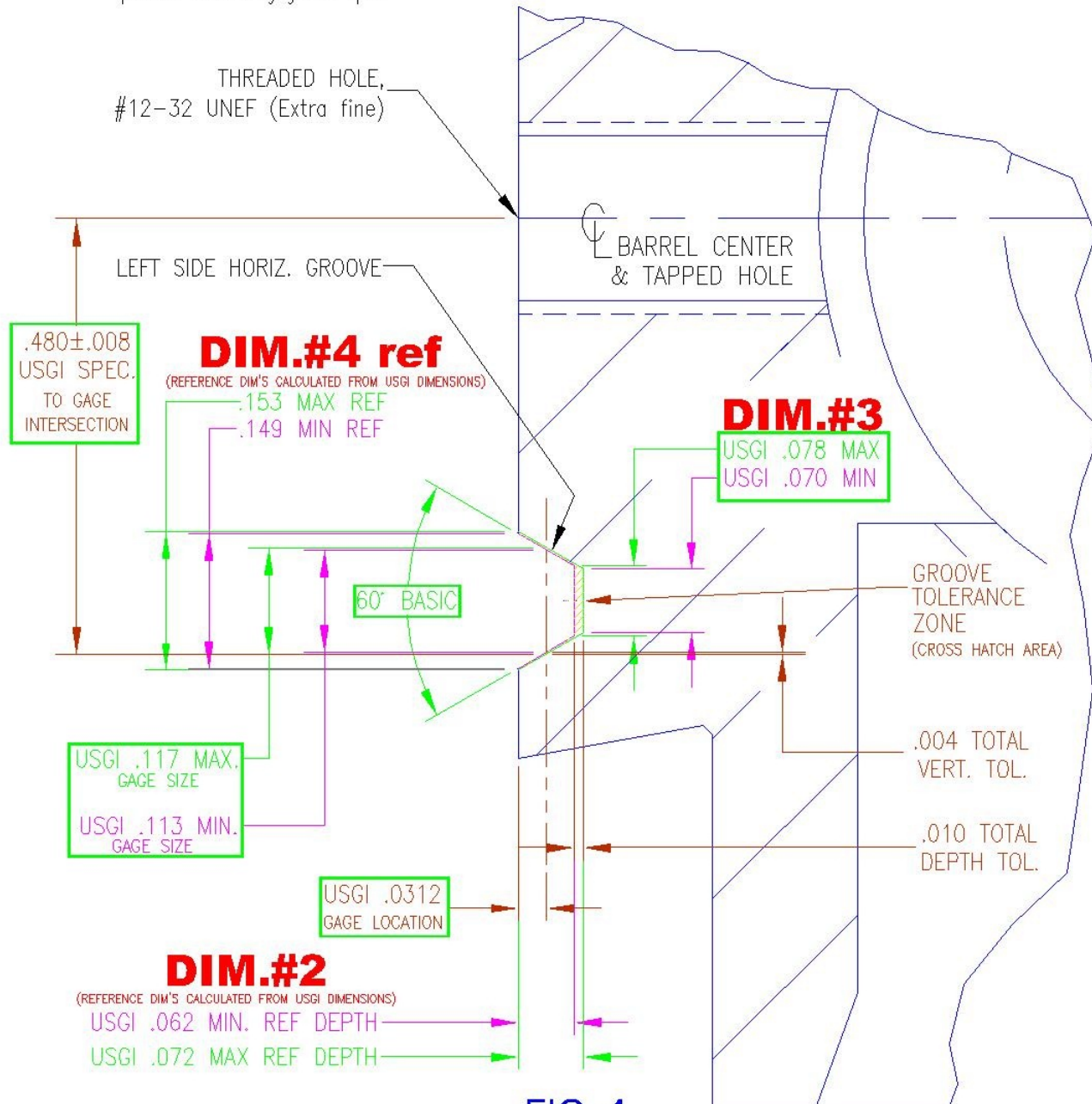


FIG. 4

LEFT SIDE GROOVE CROSS-SECTION

VIEW LOOKING TOWARD FRONT SIGHT., CROSS-SECTION AT CENTER OF LEFT-SIDE #12-32 THREADED HOLE

United States Government Issued Specification
 DARK GREEN= MAX. DIM. PURPLE = MIN. DIM.

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CUSTOMER SELF-INSPECTION FORM

AFTER COMPLETING SELF-INSPECTION PROCESS PER INSTRUCTIONS,
 FILL-OUT BOXES BELOW AND FAX TO 860-742-4244.

DATE:

NAME:

ADDRESS:

TEL:

EMAIL:

RECEIVER MFG:

RECEIVER S/N:

PURCHASE DATE:

COMMENTS:

Approx. date for new purchase only

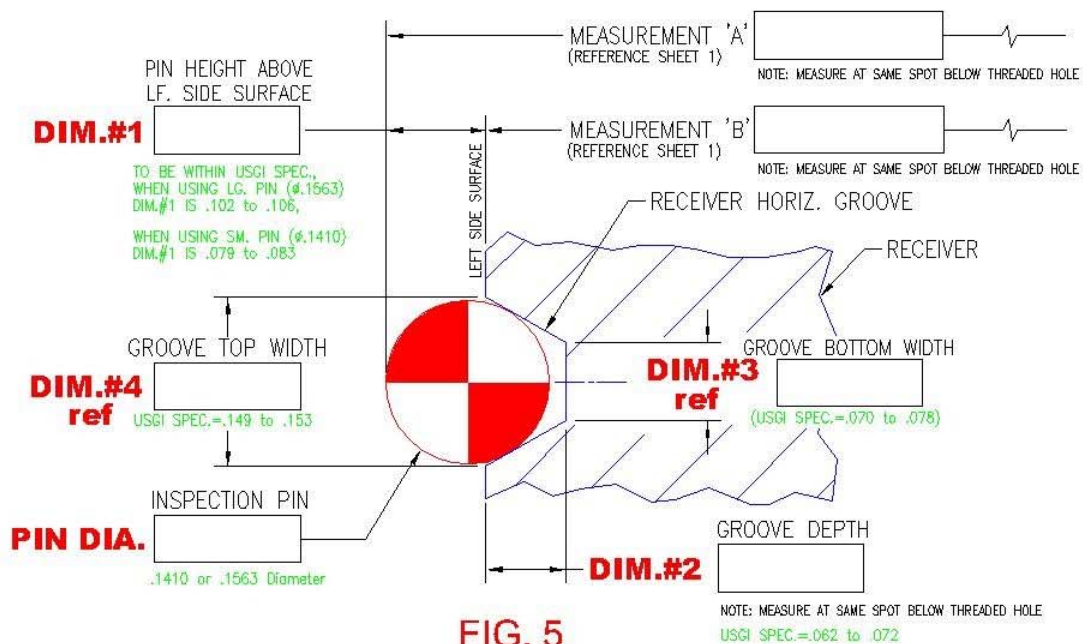


FIG. 5

ENLARGED LEFT SIDE GROOVE
 VIEW LOOKING TOWARD FRONT SIGHT

MEASURING INSTRUMENT USED:

Note: Using a 2" micrometer will be more accurate for obtaining Measurements A & B
 A 6" Dial Caliper is the next best option.
 Remember to make all measurements at the same spot below threaded hole.