

SADLAK INDUSTRIES LLC

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June 24, 2008

INSTALLATION FOR M14 TACTICAL MAGAZINE RELEASE LATCH

CONTENTS SHIPPED:

- 1) Sadlak Tactical Magazine Release Latch
- 2) Replacement Pivot Pin, 1/8 dia. X 5/8L Med. Coil Pin,
- 3) Installation Alignment Taper Pin
(#2/0 Taper X 1-1/2 Long), Soft Steel
- 4) Installation Instructions with Picture Tutorial
- 5) Drawing of Hardwood Installation Block

TOOLS REQUIRED:

- 1) Small hammer (Brass or Hard Plastic)
- 2) Taper Pin (supplied).
(Large end = .141" dia., Small end = .105" dia.)
- 3) Hardwood Installation Block, Customer supplied and
manufactured (See drawing attached for dimensions)
- 4) Tweezers or Small Needle-Nose Pliers
- 5) Bench Vise

DISASSEMBLY:

1. REMOVE TRIGGER GROUP:

- a. Pull Trigger Guard toward rear until it unlatches (Fig.1).
- b. Then pull down and swing out (Fig.2).
- c. Pull straight down to disengage from the receiver (Fig.3).

NOTE: The receiver does not have to be removed from the stock. This is important if your rifle has been Bedded.

2. REMOVE EXISTING PIVOT PIN

- a. Place customer supplied Installation Wood Block (see diagram on back sheet) tightly in vise as shown (Fig.4).
- b. Place Trigger Group with right-side up on block with pivot pin aligned over hole in wood block (Fig.5).
- c. Gently tap small diameter of Taper Pin thru until existing pivot pin falls out of the trigger housing (Fig.6).
Use pliers to remove old pin from housing if required (Fig.7).
- d. Remove Taper Pin.
- e. Remove original USGI magazine latch (Fig.8). Leave spring in Trigger housing.

RE-ASSEMBLY:

3. INSTALL NEW COIL PIVOT PIN

- a. Install new Sadlak Tactical Mag. Release Latch between housing sides and over spring (Fig.9).
- b. Turn Trigger Housing over to position Left-Side Up (Fig.10).
- c. Compress Mag. Latch and spring against corner of wood block (Fig.11) until holes line up.
HELPFUL HINT: Pull on thumb tab while compressing spring to help alignment.
NOTE: If using Oak Floor board, the "tongue" portion works excellent to help compress spring (Fig.12).
- d. Once aligned hold it steady and insert small diameter of the Taper Pin into hole on Left-Side of Housing (Fig.13).
Insert thru Mag Latch until it aligns with the hole and protrudes out the opposite (right) side of the housing (Fig.14).
You are ready to install new Pivot Pin.
- e. Turn Housing to position Right-Side up and insert Taper Pin (sticking out bottom of housing) thru hole in wood block. Rest housing on block (Fig.14).
- f. Using tweezers or needle-nose pliers, position new Pivot Pin (1/8 x 5/8L Med. Coil Pin) (Fig.15) over Taper Pin on Right-Side (Fig.16). Taper Pin will keep parts aligned and act as a guide for the Pivot Pin (Fig.17).
- g. Tap Pivot Pin while holding Taper Pin from falling out the bottom until Pivot Pin is flush to Right-Side.
HELPFUL HINT: Use large diameter of Taper Pin to seat Pivot Pin flush to Right-Side housing (Fig.18).

4. RE-INSTALL TRIGGER GROUP

- a. Carefully align square key on Left-Side of Trigger Housing (Fig.19) to square groove cut in receiver (Fig.20)
- b. With Trigger Guard open, push Trigger Housing into receiver until flush with stock (Fig.21).
- c. Swing Trigger Guard rearward until it snaps closed (Fig.21).

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TACTICAL MAGAZINE RELEASE LATCH

Assistance Tool

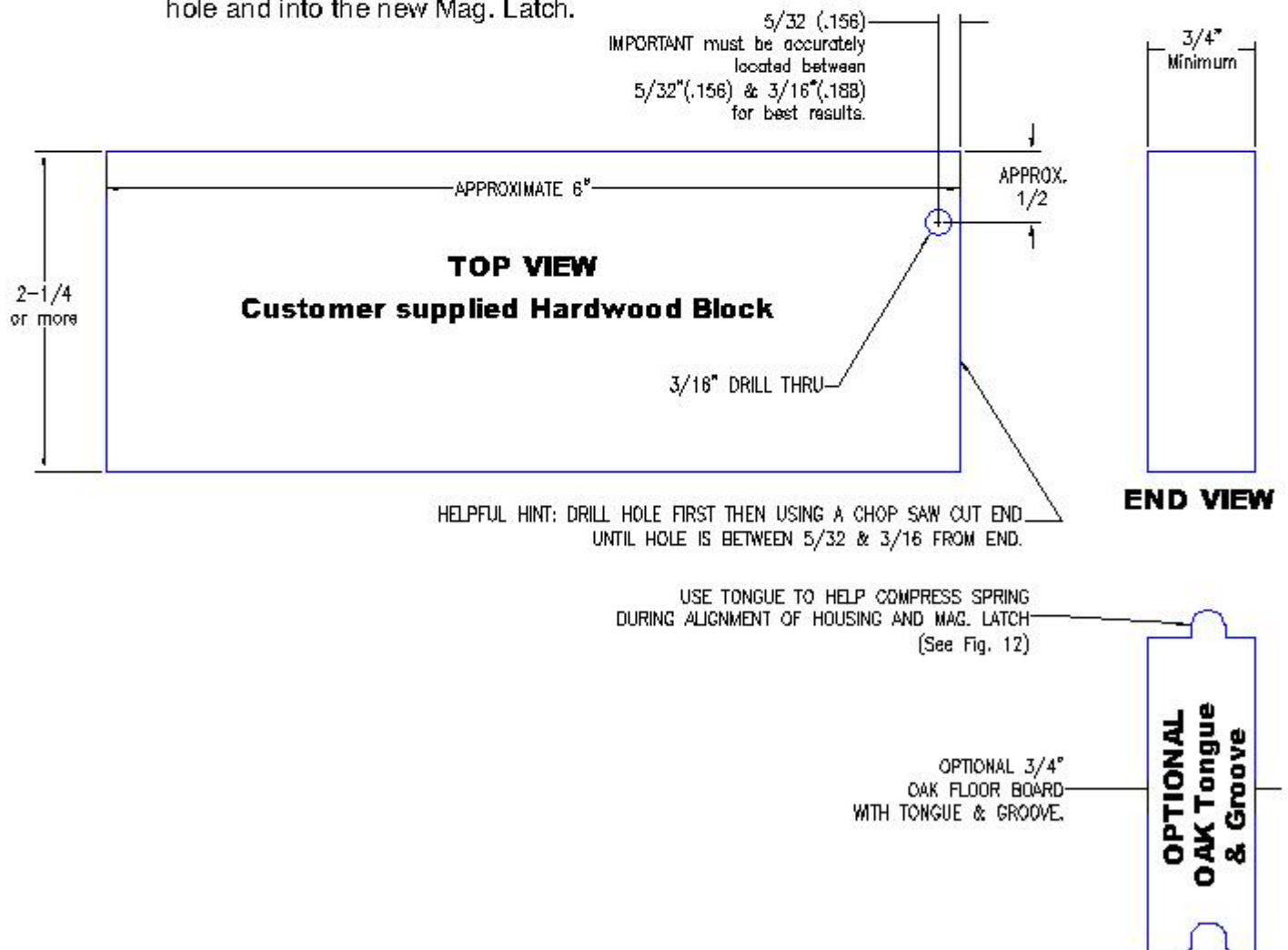
INSTALLATION WOOD BLOCK

Customer supplied

SUGGESTION: Make the simple wood block below to assist in removing and installing the pivot pin. A piece of hardwood is preferred over spruce or kiln dried 2 x 4.

Oak floor board with tongue and groove works best (as show in installation pictures) because it locks into the "V" groove in some vise jaws preventing the wood from twisting during pin installation.

Also, the tongue on the oak floor board is excellent for compressing the spring (see Fig. 12) to insert the taper alignment pin thru the housing hole and into the new Mag. Latch.



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Fig 1 - Pull Trigger Guard Toward Rear to Unlatch



Fig 2 - Pull Down and Swing Out



Fig 3 - Pull Trigger Group Straight Down



Fig 4 - Make Wood Block with 3/16 Drilled Hole located 5/32 from End (See Attached Drawing)

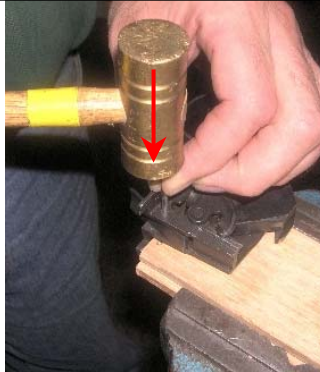


Fig 5 - Align Trigger Housing Over Hole In Wood Block and Drive Pivot Pin Out Using Small End of Taper Pin



Fig 6 - Taper Pin Shown Fully Inserted with Pivot Pin Driven Out Thru the Hole in Wood



Fig 7 - Remove Pin with Pliers



Fig 8 - Remove Old USGI Mag Latch

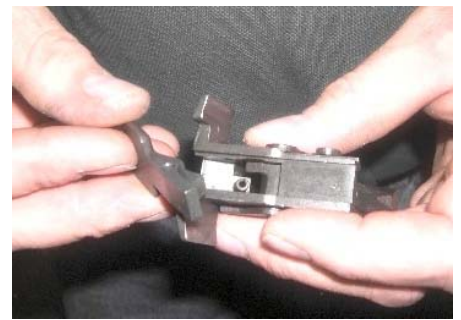


Fig 9 - Install New Mag Latch Over Spring



Fig 10 - Use Taper Pin Inserted In Left Side to Align New Mag Latch



Fig 11 - Compress Spring Using Corner of Wood Block and Align Housing and Mag Latch Hole

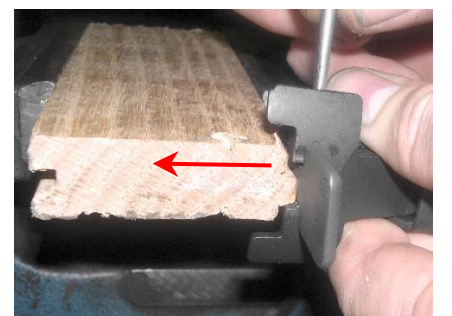


Fig 12 - (Alternate Compression Technique) Using tongue of Oak Floor Board

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Fig 13 – Insert Taper Pin on Left Side to Keep Parts Aligned



Fig 14 – Small End of Taper Pin Shown Protruding on Right Side of Trigger Housing



Fig 15 – Old Split Pin on Left, New Medium Coil Pin on Right

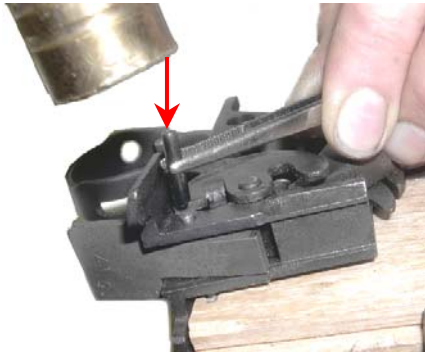


Fig 16 –Using Taper Pin as Guide, Align the New Pivot Pin for Insertion

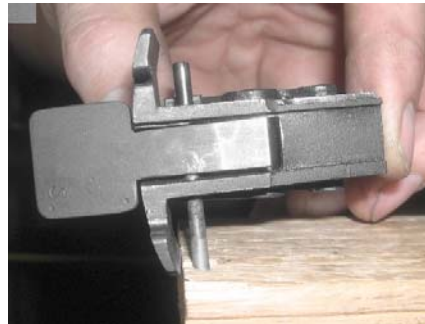


Fig 17 - Pivot Pin Partially Inserted on Top and Taper Pin Shown Aligning the Mag Latch and Housing on Bottom

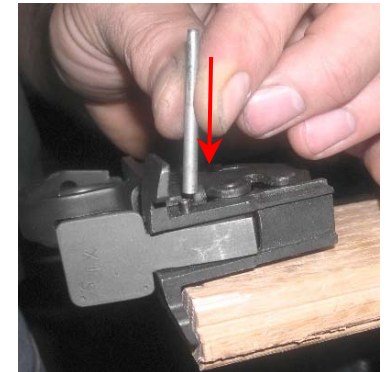


Fig 18 – Seat Pivot Pin Flush to Housing Using Large End of Taper Pin

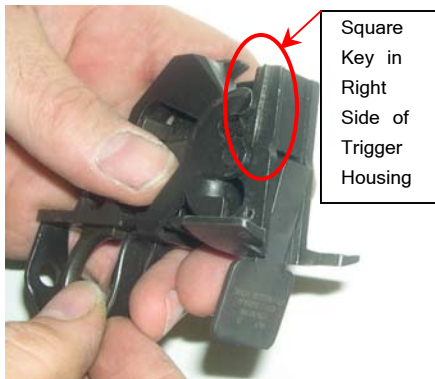


Fig 19 – Square Key In Trigger Housing



Fig 20 – Align Square Key in Trigger Housing with the Sq Groove in the Receiver



Fig 21 – Insert Trigger Group Until Flush to Stock and Snap Trigger Guard Closed



Fig 22 – Completed M1A with New Tactical Magazine Release Latch



Fig 23 – Removing Magazine Using Newly Installed Mag Latch



Fig 24