

SADLAK INDUSTRIES

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Aluminum Front Rail Install Instructions

(Note: for multiple part numbers)

Part # 140066 Aluminum Front Rail

CONTENTS (Refer to attached diagram)

- Item # (1) 140066-01 Front Rail
(2) 140066-02 (2) Flat Hd Phillips Screw #10-32 x 1/2L
(3) 140066-03 (2) Special Flat Washer w/ Countersink

Part # 140067 Alum. Front Rail w/ QD Post

CONTENTS (Refer to attached diagram)

- Item # (4) 140067-01 Front Rail with Threaded Hole for QD Stud
(2) 140066-02 (2) Flat Hd Phillips Screw #10-32 x 1/2L
(3) 140066-03 (2) Special Flat Washer w/ Countersink
(7) 140063-03 QD Post, #10-32 X 1/4Lg Threaded Stud
(8) 140050-04 (2) Thick Disk Lock Washer, Belleville-type
(9) 140063-05 Thin Serrated Lock Washer

Tools Required:

- 1) Disc grinder, Dremal tool or hand drill (to remove rivets)
- 2) Phillips Screw Driver
- 3) Loctite 222MS or 272 or equivalent thread locker.

NOTE: if you are installing on a Springfield Armory Inc (SAI) synthetic stock, first remove the molded-in brass inserts using a long screw as a lever to work the brass back-and-forth while pulling. (Suggested screw #10-32 x 2" long).

Some Dremal work may be required to recess the Special Washers to allow clearance for Op. Rod.

Optional Tools:

(Available from Sadlak)

- 1) Devcon steel bedding epoxy (P/N:900070) or JB Weld Epoxy.

INSTALLATION

1. Remove Receiver and Barrel from Stock

- a. Remove trigger group. Pull trigger guard toward rear until it unlatches.
- b. Pull guard down; swing out & away toward barrel.
- c. Pull straight down to disengage from the receiver.
- d. Turn stock upside down.
- e. Gently tap rear of stock against bench top. Stock will detach from receiver.
- f. Remove receiver/barrel from stock.

2. Remove Front Sling Swivel from Stock

- a. METHOD #1 (External Grind) Carefully grind the two rivet heads off using either a hand-held disc grinder, bench top grinder, hand File or Dremal tool.
CAUTION: DO NOT overheat rivet during grinding. This could cause melting of fiberglass or burning of wood stock.
- b. After grinding, lightly tap rivet thru stock. DO NOT use too much force or stock may be damaged.

Tips 1) Stuff wet rag on inside of stock to keep stock and rivets cool from the inside. 2) After grinding for a short period, use another wet rag to periodically dampen rivet heads. Perform this step often. 3) Be careful not to hit stock when using bench-top grinding wheel. 4) Grind rivet heads flush or slightly below sling-swivel bracket.

Alternate METHOD #2: (Internal Grind, Saves sling swivel from damage). Drill or grind peened rivet end from the inside. Use ¼ or larger drill to remove most of the peened portion of the rivet. Remove washers. Followed by grinding with Dremal tool to remove any remaining rivet end leaving the rivet without excess metal on shank. Note: any flared portion that remains on the shank will prevent the rivet from being easily pushed thru the stock which may result in stock damage. This is especially important to wood stocks.

NOTE: SYNTHETIC STOCK made by SPRINGFIELD ARMORY INC

The removal procedures are different for Springfield Armory Inc (SAI) synthetic stocks. The sling swivel is secured by two button head screws threaded into brass inserts molded into the stock. To remove sling swivel, use a 1/8" hex key to remove screws, then remove the molded-in brass inserts using a long screw as a lever to work the brass inserts back-and-forth while pulling straight out from the stock. (Suggested screw #10-32 x 2" long available at any hardware store).

3. Install Alum. Front Rail

- a. Place USGI Sling Swivel into front rail slot and align holes.
- b. Apply one drop of loctite 222MS (purple) or 272 (blue) or equiv. to threads on flat head screws.
- c. Insert two flat hd Phillips screws with washers from inside thru stock and sling swivel. Thread into Alum Front Rail. Note: insert washers with countersink up to be nearly flush with flat head surface.
- d. Tighten screws using Phillips Screwdriver.

NOTE: Use epoxy to provide additional surface contact and bonding area. Apply a small amount between Sling Swivel and stock and under Special Washer.

4. Re-Assemble Rifle

- a. Install receiver/barrel into stock.
- b. Install and lock trigger guard into receiver.