

SADLAK INDUSTRIES

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Steel Front Rail

Install Instructions

(Note: for multiple part numbers)

Each Front Rail includes a specialized nutplate and screw lengths depending on stock type.

STEEL FRONT RAIL

- 1400620 Universal Steel Front Rail (All stocks., Some fitting required)
- 1400621 Steel Front Rail (USGI Fiberglass Stock)
- 1400622 Steel Front Rail (USGI Wood Stock)
- 1400623 Steel Front Rail (Springfield Armory Synthetic Stock)
- 1400640 Steel Front Rail (Supermatch, M21, McMillian Stock)

STEEL FRONT RAIL with QD POST

- 1400630 Universal. Stl. Fr. Rail w/QD (All stocks. Some fitting req'd)
- 1400631 Steel Front Rail w/QD (USGI Fiberglass Stock)
- 1400632 Steel Front Rail w/QD (USGI Wood Stock)
- 1400633 Steel Front Rail w/QD (Springfield Armory Synthetic Stock)
- 1400650 Steel Front Rail w/QD (Supermatch, McMillian Stock)

Each Front Rail Assembly contains the following Hardware:

(Refer to attached diagram)

- Item 1) Steel Front Rail or 5) Rail with QD Post
- 2) Internal Oval Nut Plate (type vary depending on stock)
- 3) Two Soc. Hd Cap Scr #10-32 x 3/8Lg
- 10) Two Soc. Hd Cap Scr #10-32 x 1/2Lg (Included with Universal Fr Rails or Supermatch only)
- Additional Hardware for Rails with QD posts
 - 7) QD Post, #10-32 x 1/4Lg threaded stud
 - 8) One or Two Thick Disk Lock Washer, Belleville-type
 - 9) One or Two Thin Serrated Lock Washer

Tools Required to Install Internal Nut Plate:

- 1) Standard drill bit 9/32 (.281") (Note: dull tip to prevent cracking wood stock. See options below)
- 2) Drill press (best) or hand drill
- 3) Disc grinder, Dremal tool or hand drill (to remove rivets)
- 4) Loctite 222MS or 272 or equivalent thread locker
- 5) 5/32 Hex Key

Optional Tools:

(Available from Sadlak)

- 1) Drill bit 9/32 (.281") with pre-dulled tip (P/N:900050)
- 2) Devcon steel bedding epoxy (P/N:900070)



Part 1400620 Steel Front Rail with Sling Swivel sandwiched between stock and rail.



Universal oval nut plate shown in st'd USGI wood stock. Some fitting with Dremal tool may be required to clear Operating Rod. Epoxy bond Nutplate to stock for increased durability.

Note: USGI Sling Swivel NOT Included



Part 1400630 Steel Front Rail with QD Post Installed

Note: USGI Sling Swivel NOT Included



Customer supplied USGI Sling Swivel fits into groove in rail

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1. Remove Receiver and Barrel from Stock

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

2. Remove Front Sling-Swivel from Stock

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. After grinding, lightly tap rivet thru stock. DO NOT use too much force or stock may be damaged.

CAUTION: DO NOT overheat rivets during grinding. This could cause melting of fiberglass or burning wood stock.

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. After grinding, lightly tap rivet thru stock. DO NOT use too much force or stock may be damaged.

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. Prepare Stock - Drill Out Two Holes

- Carefully drill thru two existing rivet holes in stock using a 9/32 (.281") Drill Bit with dulled tip.

CAUTION: To avoid cracking stock caused by a sharp drill bit "grabbing" and ripping thru the hole, a drill bit with the cutting edges slightly dulled with a file or stone is highly recommended. Using a drill press will help control drill feed and reduce this problem. More caution should be used when using a hand-held electric drill. They have the least amount of control and rigidity, and are more likely to grab and cause a problem. Wood stocks crack easier than fiberglass stocks.

Notes: On fiberglass stock, if nut plate does not rest flush against inside of stock, carefully remove high spots using Dremal tool. On wood stocks, nut plate should rest flush; if it is too high and the op rod rubs against it, carefully mark the oval perimeter, remove nut plate and use a dermal tool and hand grind a small pocket to lower the nut plate in the wood stock.

4. Install Oval Nut Plate

- Install oval nut plate into the stock.

Tip: It is best to use a Bedding epoxy (suggestion: Devcon or JB Weld metal epoxy) to permanently secure the nut plate to the stock for additional strength. The benefit is more flexible use of the nut plate by allowing future assembly or removal of the Front rail or QD post etc from the outside without disassembling the receiver from the stock.

5. Install Front Rail

- Place USGI Sling Swivel in front rail and place both on stock with holes aligned.
- Apply loctite 222MS (purple) or 272 (blue) or equiv. to screw threads.
- Insert two soc. hd screws into counterbores on front rail and thread into Oval Nut Plate.
- Using a 5/32 hex key and Torque screws to approx. 35 in-lbs

6. Re-assemble Rifle

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