

SADLAK INDUSTRIES

Div of Sadlak Manufacturing LLC

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QD POST ASSEMBLY Install Instructions

- #1400500 Universal (All stocks.. Some fitting required)
- #1400501 USGI Fiberglass Stock
- #1400502 USGI Wood Stock
- #1400503 Synthetic Stock (Mfg by Springfield Armory Inc.)
- #1400520 Super Match, M21, McMillan Stock.

Contents:

- (1) Internal oval nut plate
 - (2) External oval washer
 - (3) QD Post with #10-32 threaded stud
 - (4a) Disc lock washer
 - (4b) Serrated lock washer
 - (5) Flat head phillips screw #10-32 thread
- Install Instruction sheets

Tools Required:

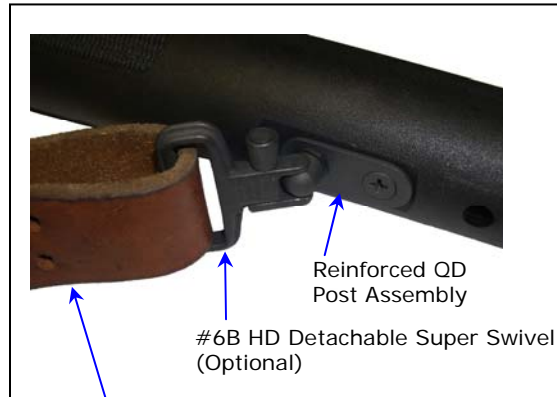
- 1) Standard drill bit 9/32 (.281") (**Note:** dull tip to prevent cracking wood stock. See options below)
- 2) Drill press (best) or hand drill
- 3) Disc grinder, Dremal tool or hand drill (to remove rivets)
- 4) Loctite 222MS or 272 or equivalent thread locker
- 5) #2 Phillips screw driver

Optional Tools:

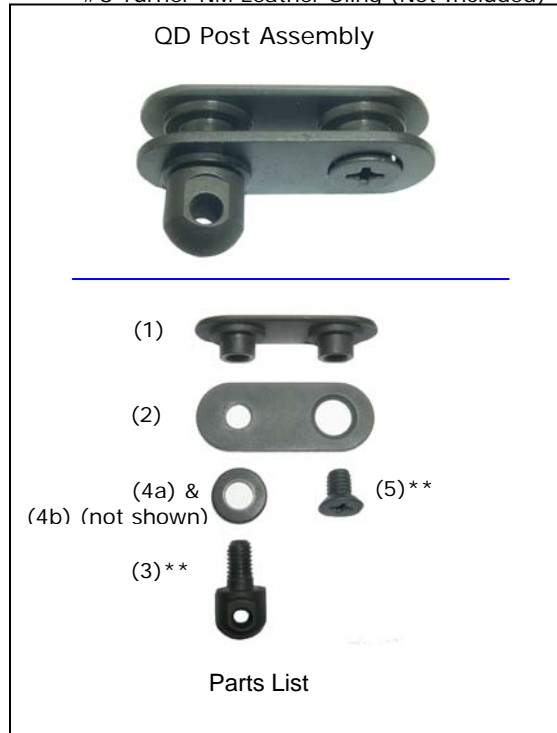
(Available from Sadlak)

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

**Thread lengths for 1400501, 1400502, & 1400503 Assemblies are: QD post stud 3/8"Lg & Flat hd screw 5/16"Lg. Thread lengths for 1400520 Assembly (Supermatch) are: QD post stud 1/2"Lg, Flat hd screw 1/2"Lg. P/N 1400500 Universal has both lengths of screws and posts



#8 Turner NM Leather Sling (Not Included)



Parts List



Inside View:
Internal oval nut plate shown epoxy bedded to USGI fiberglass stock

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Installation: QD Post Assembly

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 rivet during grinding. This could cause melting of fiberglass or burning of wood stock.

TIPS:

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

Alternative METHOD #2: (Internal Grind, Saves sling swivel from damage). Drill or grind peened rivet end from the inside. Use a 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 on 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 (SAI)

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.

4. Install QD Post

- Place interior oval nut plate inside existing drilled out holes. Additional fitting with Dremal tool or round file may be needed to slightly enlarge holes for a proper slip fit.

NOTES: On **fiberglass stock**, if nut plate does not rest flush against inside of stock, remove and carefully grind 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, mark the oval perimeter, remove nut plate and, using a dermal tool carefully hand grind a small pocket to lower the nut plate in the wood stock.

TIP: Once the nut plate is resting flush, using a bedding epoxy (suggestion: Devcon or Weld-it metal epoxy) will permanently secure the nut plate to the stock for additional strength.

- Place oval washer on exterior of stock (this can also be epoxy cemented in place). Screw QD post with disc lock washer into nut plate. Tighten until secure and aligned correctly.
- Place flat head Phillips 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.

5. Install Harris bi-pod

- Unscrew knurled thumb screw
- Spread arms apart and hook both small pins into QD post.
- Tighten knurled knob

6. Re-assemble Rifle

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