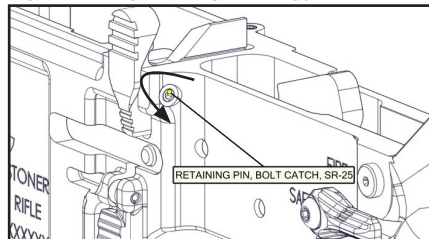


AMBIDEXTROUS BOLT RELEASE PLUNGER SPRING REPLACEMENT

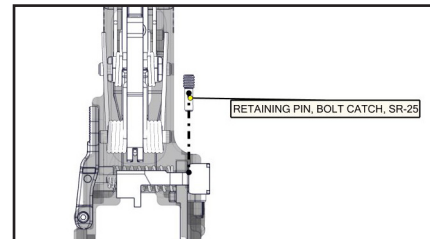
Note: The Plunger Head Compression Spring must be replaced with the stronger P/N: 30199 Spring when converting the rifle with the 7.62mm Carbine Buttstock Kit (P/N: 25951).

TO REPLACE THE SPRING:

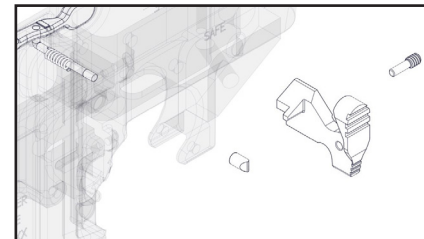


1. Remove Bolt Catch Retaining Pin with 1/16" Hex Key.

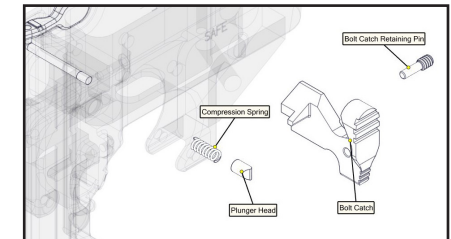
CAUTION: If screw is hard to turn, heat screw with heat gun prior to loosening, or the wrench will strip the hex head of the screw.



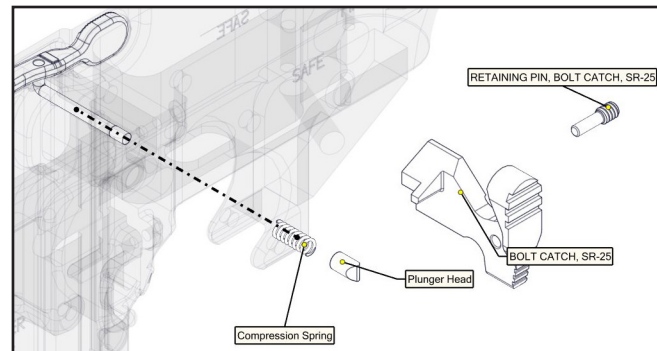
2. Withdraw Bolt Catch Retaining Pin while maintaining control of bolt catch. After retaining pin is removed, pull bolt catch away from receiver.



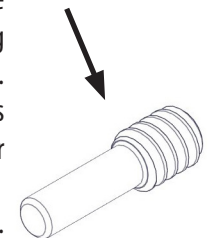
3. Use Special Plunger Head Turner Tool (KAC P/N: 20577, loosen plunger head counter-clockwise and remove plunger head and original spring while pressing on ambidextrous lever assembly from the opposite side.



4. Using the plunger head removal tool, turn the ambidextrous plunger head clockwise into the threaded end of the bolt catch plunger. Screw in ambidextrous plunger head until the back edge of the taper is flush and parallel with the lower receiver. This will ensure proper adjustment.



5. The threads of the Retaining Pin require a very small amount of Medium Strength Loctite (#242) once the final adjustment is made & inspected. Do not over-tighten the Retaining Pin because the bolt catch will not move freely on the retaining pin shaft after the Loctite dries (24 hours). The Loctite will hold the pin properly when its hex socket head is just at flush with the receiver or slightly below flush.



Free rotation of this control is the final inspection step.

REASSEMBLY & INSPECTION NOTES: The plunger head adjustment on the threaded shaft must allow full travel of the bolt catch by the lever from the other side of the receiver. To test, insert unloaded magazine, depress bolt catch. The bolt catch should move all the way down as does the ambidextrous lever.

Final Check: assemble to upper receiver assy. and re-inspect proper function on both modes of bolt release. (Important: You may find that the plunger head requires another half-turn for both releases to function properly with the rifle reassembled)



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