

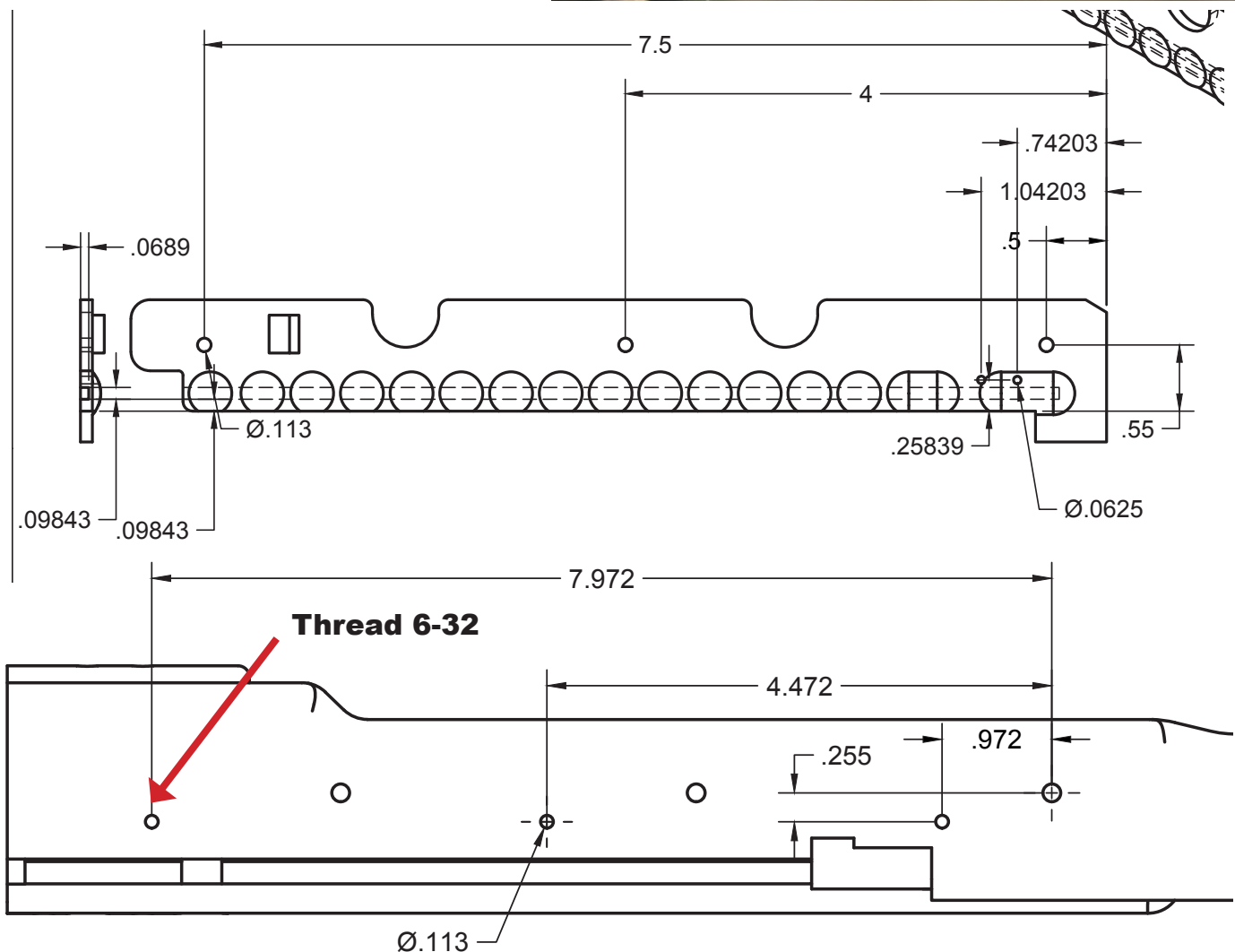
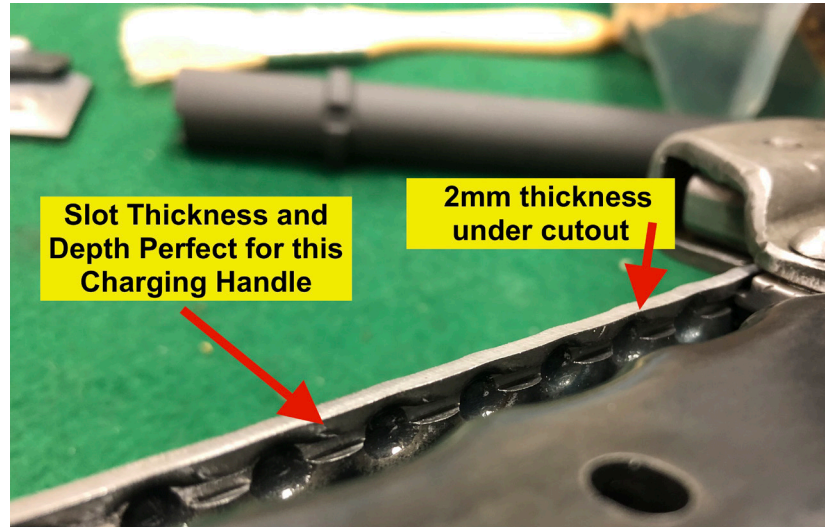
Ratchet Plate Removal

- Setup in mill as pictured with 1/2" endmill
- Set 0 at each cut on top of ratchet plate at the spot weld
- Z down .100
- Pry off
- Drawl file with coarse file

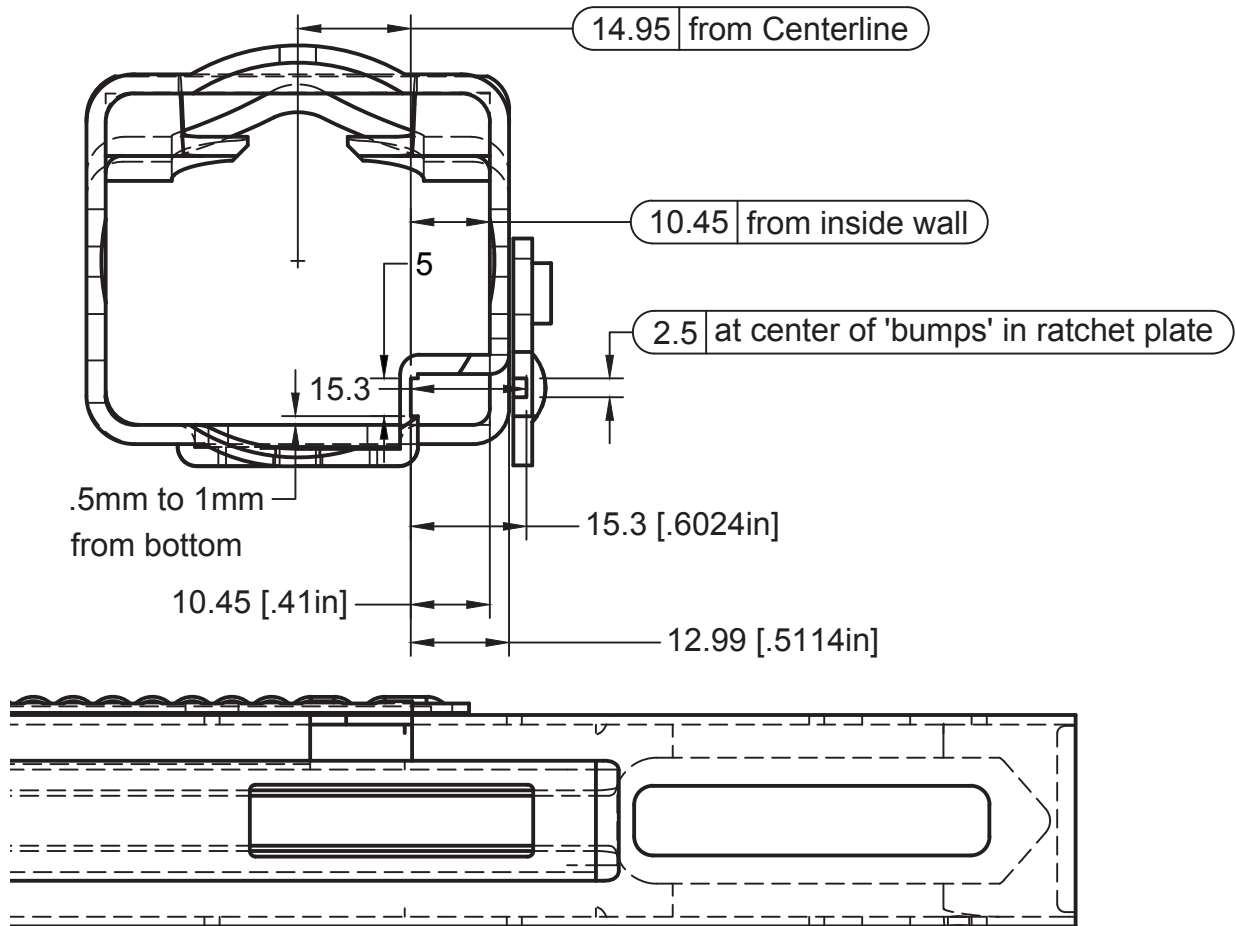


Ratchet Plate Installation

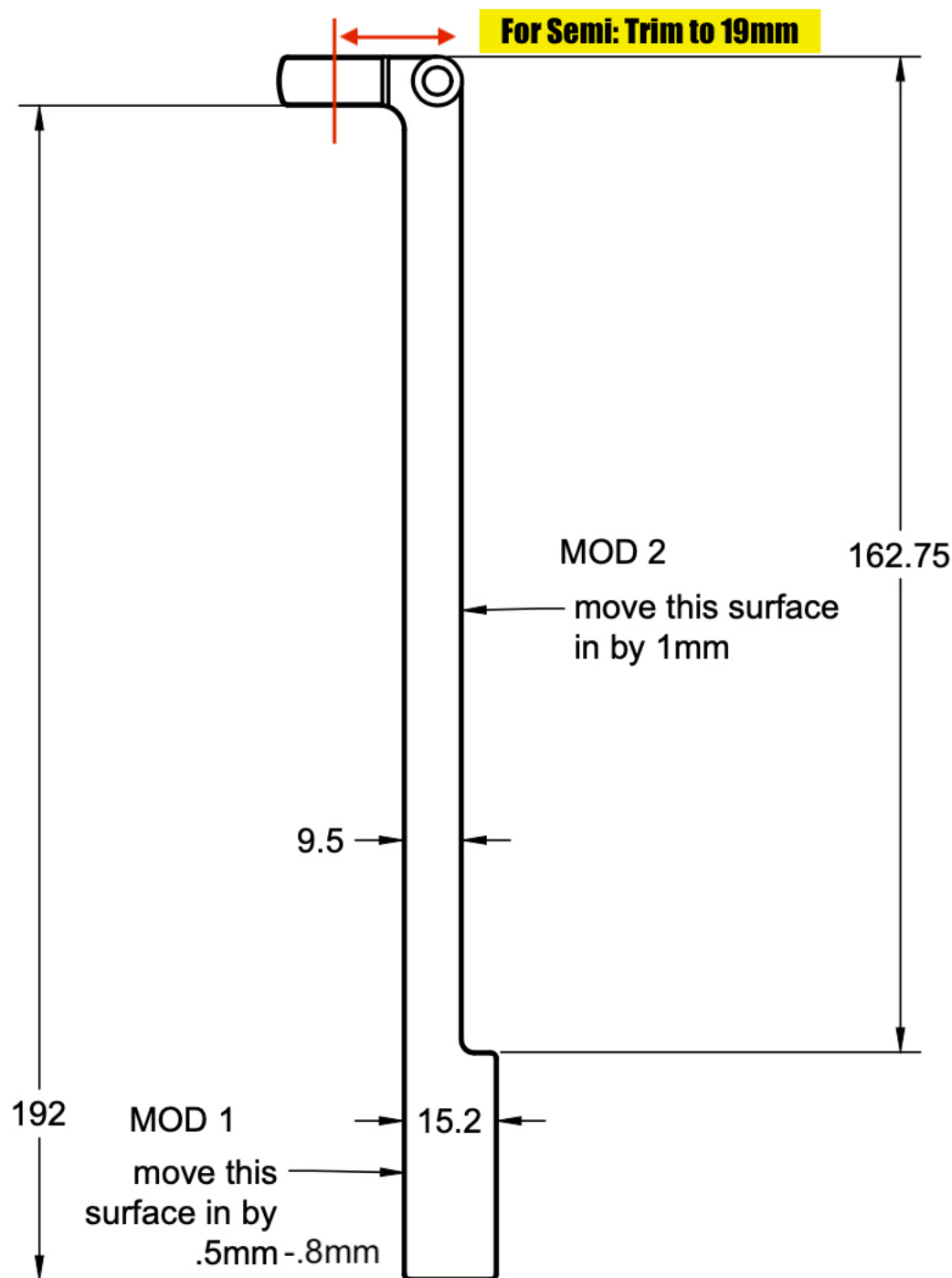
- For installing the ratchet plate, we recommend doing the preliminary installation using 6-32 countersunk screws in the locations below.
- Thread the holes in the receiver then countersink the holes in the ratchet plate. This way you can easily remove and reinstall this part while working on the charging handle movement. This is also very useful if you need to put spacing washers between the outside of the receiver and the inside of the ratchet plate for adjusting the charging track.
- For machining the charging track on the ratchet plate, you can do this while installed on the gun using a key seat cutter but it will be easier to do off the gun using an endmill.
- When you are ready to permanently attach the ratchet plate, you can weld the edges of the ratchet plate to the receiver or drill a pattern of 1/4" holes on the ratchet plate, then resistance weld the holes. With the screws firmly securing the ratchet plate to the receiver, it will not shift from the welding process ensuring the opposite sides of the charging track remain parallel.



Ratchet Plate Slot Finish Dimensions

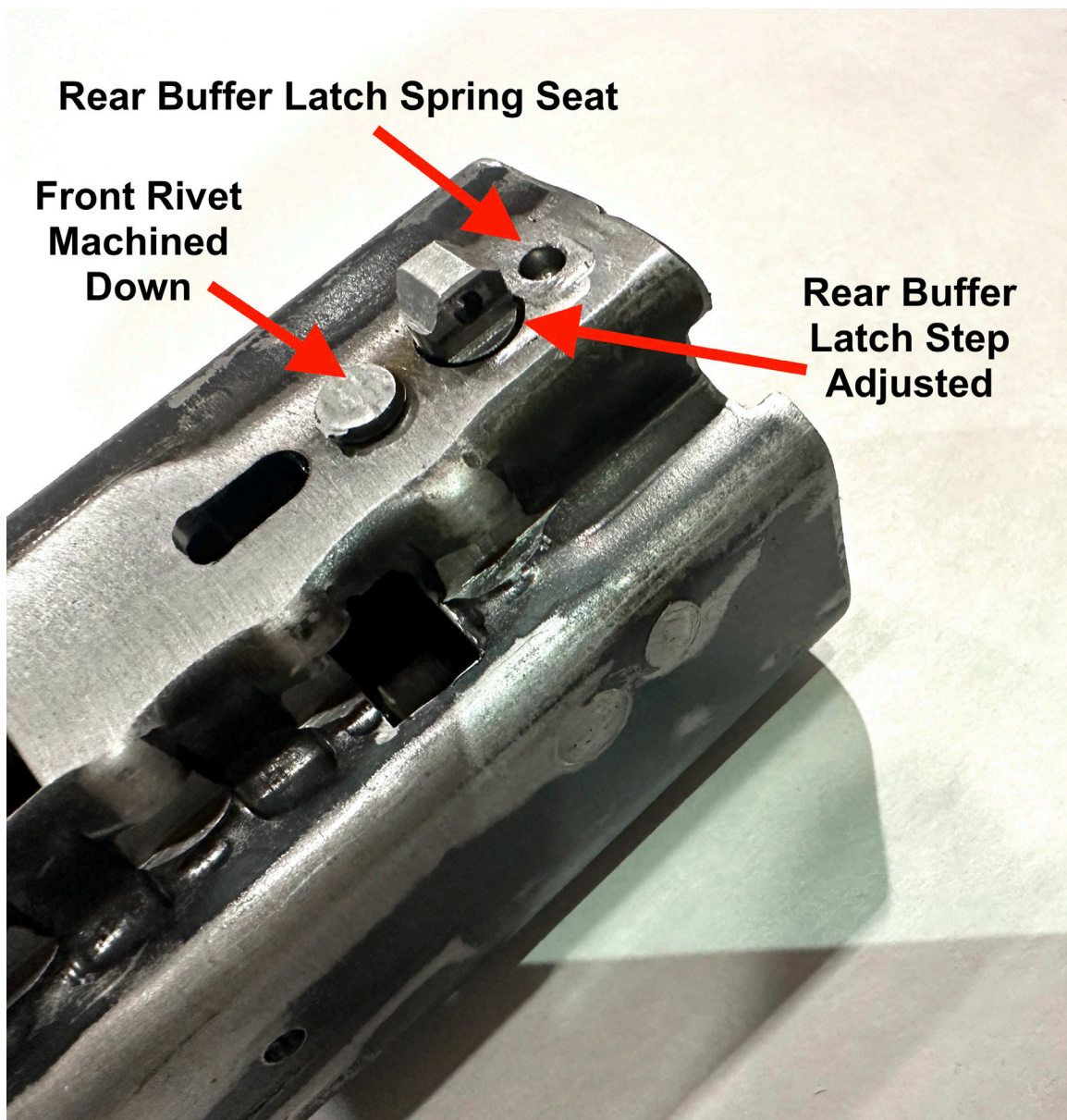


Charging Handle Mod



Rear Buffer Latch Machining

- Lower the buffer latch stud step as necessary to allow for proper buffer latch pivot
- Machine down front rivet heads as necessary to allow for buffer latch movement.
- The rear rivet head should be machined flat to accommodate the buffer latch spring seat hole.
- Locate the center for the spring hole at approximately at the center of the rear rivet. You can center on the rear dimple on the latch. Use an 11/64" drill can Z -.18 from the sheet metal to get the hole depth for the spring seat.



Straightening Sheet Metal Front

- These are pretty easy to bang out using a steel bar braced inside the receiver and supported by an arbor press, then hammering the bar to move the sheet metal flat.



**Hammer
Strike**

**Arbor
Press
Support**

Steel Bar