

SCOTTWERX LLC

FUN GUN KIT ASSEMBLY INSTRUCTIONS

Tools Needed:

Medium Flat-blade Screwdriver

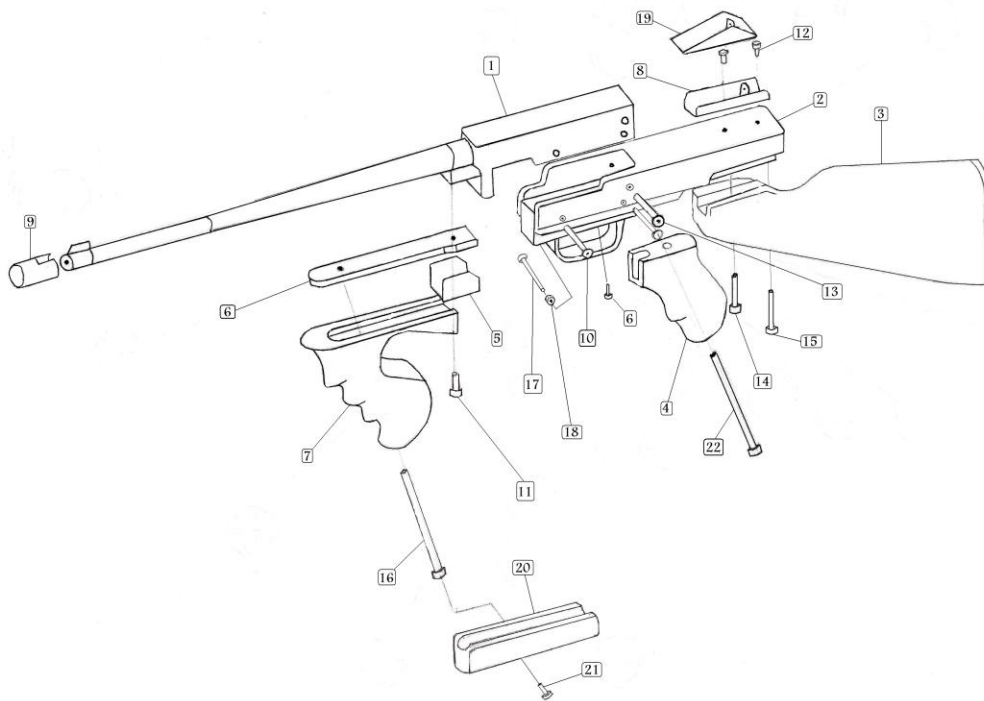
Small adjustable wrench

Flat tip Punch

Small Flat-blade Screwdriver

Small Hammer

Hex Wrench Set (included)



#	Description	Qty
1	10/22 barreled action	
2	Receiver Extension	1
3	Butt Stock Assembly	1
4	Rear Grip	1
5	Front Grip Mount Cover	1
6	Front Grip Mount	1
7	Front Grip, Chicago	1
8	Rear Sight, Chicago	1
9	Muzzle Tip, Chicago	1
10	Screw, 10/24 x 1 3/4"	2
11	Screw, 12/24 x 5/8"	1
12	Screw, 8/32 x 3/8"	2
13	Screw, 1/4-20 x 1 3/4"	1
14	Screw, 1/4-20 x 1 1/4"	1
15	Screw, 1/4-20 x 1 1/2"	1
16	Screw, 4/40 x 1/4"	2
17	Screw, 4/40 x 1"	1
18	Nut, 4/40	1
19	Rear Sight SL	1
20	Front Grip, SL	1
21	Screw, 1/4-20 x 3/8"	1
22	Screw, 1/4-20 x 4 1/2"	1

If you think you may be unable to comply with the instructions, please seek the assistance of a gunsmith.

- BE SURE THE GUN IS NOT LOADED!** Put the safety "on", remove the magazine, then pull and hold the bolt handle completely to the rear. Check the chamber and action to be sure there is NO AMMUNITION! Do not lock the bolt to the rear, let it move forward and close. Do not pull the trigger, the hammer must remain cocked.
- Turn the rifle upside down. Push the safety button side-to-side into a position where it sticks out equally on both sides, half-way between "safe" and "fire". Using the medium flat blade screwdriver, back out the screw located just in front of the magazine well (counter-clockwise to loosen). The screw, when loosened, will only back out a little more than half way, allowing the metal barrel / receiver / trigger group assembly (barreled action) to be separated and lifted out of the stock.
- See **Figure 1** below. Remove the two steel cross-pins that hold the trigger group to the receiver by pushing them out from side-to-side either way. Also remove the bolt-stop cross-pin. The pins may be loose and slide out easily, others may have a tighter fit so a tap on their ends may be needed to get them moving. The pins are not reused when assembling the Kit.
- See **Figure 2** below. Install the two 4/40-1/4" screws (#16) into the bottom of the Receiver Extension (RE) (#2).
- Install the barreled action with trigger group (#1) into the RE by sliding the barreled action backwards into the front of the RE until the three holes in the trigger group and receiver line up with the three holes in the RE. Use the three 1 3/4" long socket head screws (# 10 and #13). Place a small drop of gun oil on the screw threads at the tip to help prevent possible thread galling at a later time. Put the two thinner screws all the way through the small holes in the RE and barreled action and start them into the threads on the far side of the RE but do not tighten them fully yet. Next, thread in the third thicker upper screw until almost snug. Then tighten all three screws evenly...you can feel them "bottom out" and stop turning, this is tight enough!

6. See **Figure 3** below. Place an empty magazine in the rifle. Hold rifle upside down. Take the 4/40 x 1" screw (#17) and push it through the magazine catch pin hole, pushing out the original magazine catch pin with the end of the new screw going in. Install the self-locking 4/40 nut (#18) on the screw and tighten until just snug. Do not over tighten. Remove the magazine.
7. Next, get the Rear Pistol Grip (#4) and ¼-20 x 4½" screw (#22). Turn the barreled action with attached RE upside down. Put the screw through the hole in the grip from the bottom. Carefully start the screw into the hole in the RE (about ½" behind the trigger guard) with the grip held back, up and away from the receiver extension and trigger guard. This screw goes in at a 20° angle, so take it easy and start it in carefully to avoid damaging the threads. Once started, tighten the screw slowly, pushing the grip forward and down around the rear of the trigger body. Be sure the cut-out area of the pistol grip is aligned evenly behind and on both sides of the trigger group body as you tighten the screw down.
8. Now for the Front Grip (FG)(#7) or (#20). See **Figure 4**. Get the FG, FG mount (#6), front cover (#5), ¼-20 4½" screw (#16) for Chicago or ¼-20 x 5/8" screw (#21) for Squad Leader. Use the screw (#16 or #21) to attach the FG to the FG mount. The screw threads into the mount at a 15° angle. The threaded hole in the FG mount is angled to match. Be sure to put the FG mount on the front grip so the angled hole in the mount lines up with the angle of the hole in the grip. (The rounded edge at the rear of the grip mount faces up when the gun is assembled and held). Next, slide the wide rear end of the front mount inside the front cover. The clipped-corners end of the front cover goes towards the receiver. Put the 12/24 x ⅝" screw (#11) through the cover and then through the mount. Use only finger pressure to start the screw into the threaded hole in front of the magazine well on the receiver. Check the fit here carefully, the cast receiver dimensions do vary slightly, and sometimes the bolt hole in the receiver is not perfectly centered. Do not damage the receiver threads trying to force start the screw in. This is the only place where minor filing of the receiver or the front grip mount bolt hole may be needed. Be sure the cover and mount are all the way down and flush against the receiver surfaces when tightened.
9. The Butt Stock (BS) (#3) is next. Find the BS and the two screws to attach it (#14 and #15), one is 1¼" long, the other 1 ½". Get both screws started into the holes first, short screw goes in the front, long in the rear, then tighten both down evenly.
10. Install the Rear Sight (#8 or #19) using the two 8-32x 3/8" (#12) screws.
11. Using the flat tip punch, drive the rear sight off the barrel sideways, from left to right.
12. Last item is the Muzzle Tip (MT) (#9). The MT is included with the Chicago Kit and optional for the SL. Align the notch in the MT to go around the front sight and push it on. Install the small set screw in the threaded hole on the bottom and tighten.

Figure 1. Cross pins to remove.



Figure 2. 4/40 x1/4" screw location

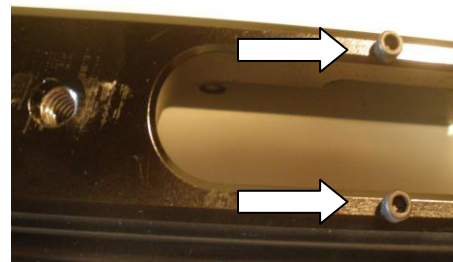


Figure 3. Replace Magazine Catch Pin.

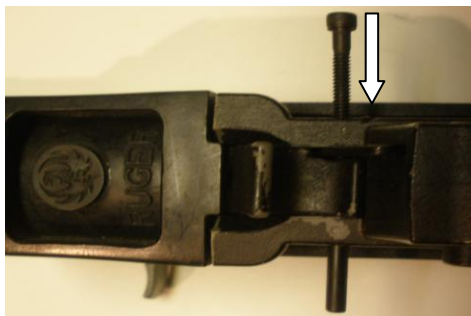


Figure 4. Front mount



Check tightness of all fasteners after the first 100 rounds and periodically thereafter.

Questions? 818 248-1139

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