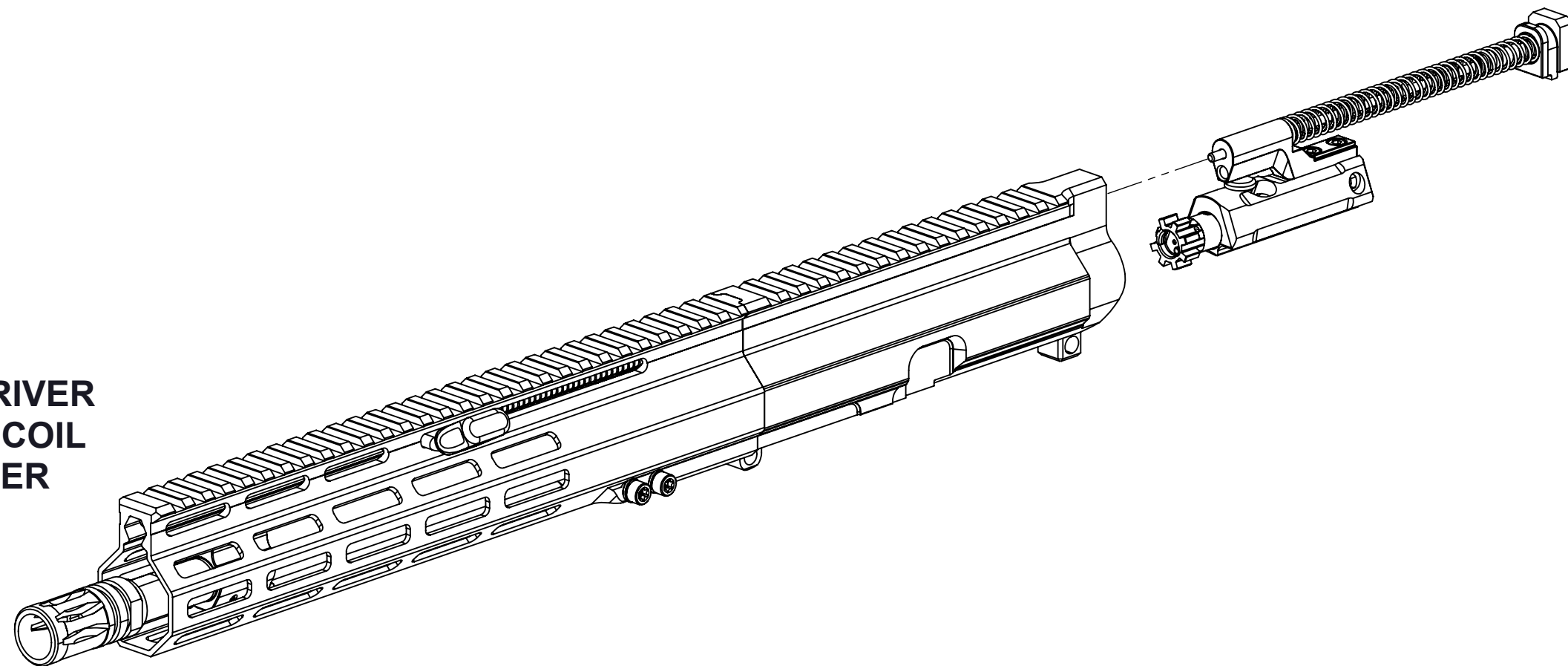


TOOLS REQUIRED

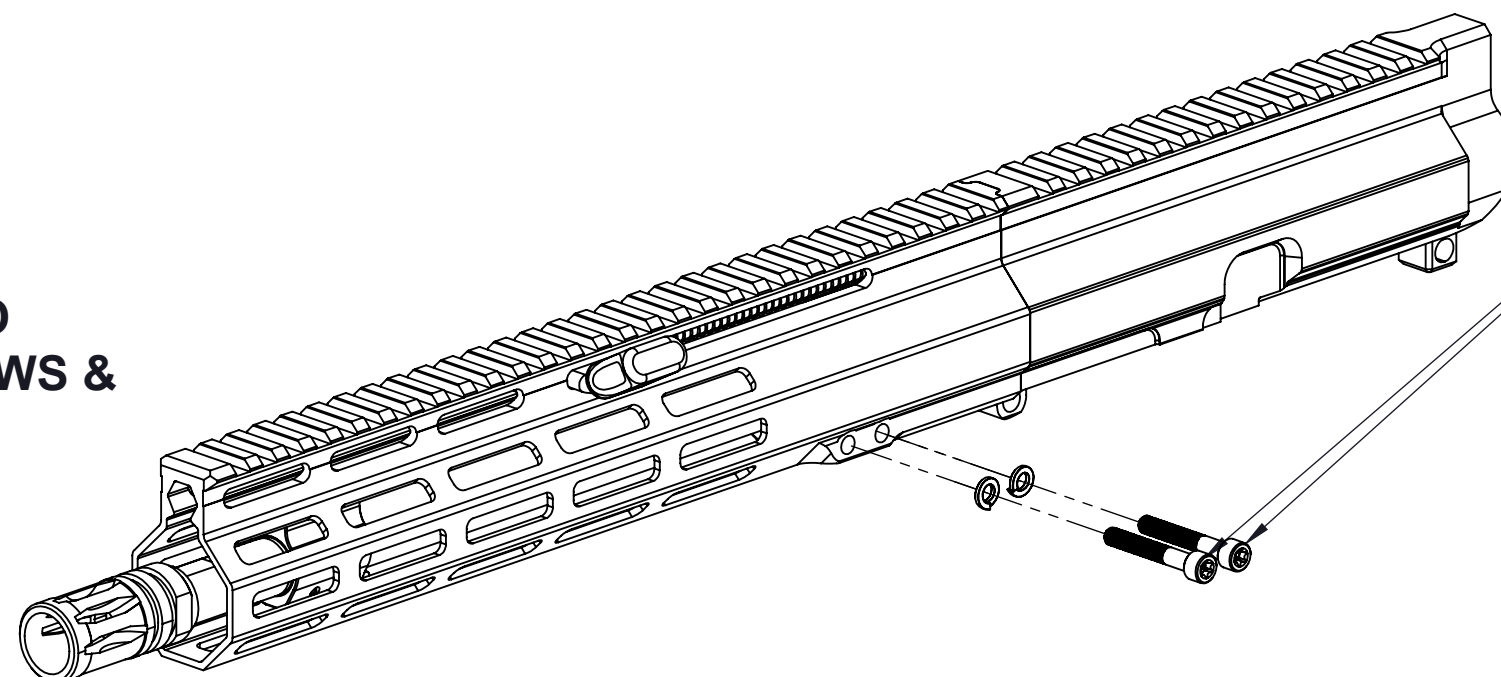
- 1. FLAT HEAD SCREWDRIVER OR 1/8" PUNCH (STEP 1)
- 2. IP27 TORX DRIVER (STEP 2)
- 3. 7/32" WRENCH (STEP 4)
- 4. LONG 3/32" HEX KEY (STEP 5)

| REV. | DESCRIPTION | DATE | APPROVED |
|------|---------------------|--------|----------|
| A | PRELIMINARY RELEASE | 9/5/23 | A. TROUT |

STEP 1: USE FLAT HEAD SCREWDRIVER OR 1/8" PUNCH TO FIELD STRIP RECOIL SPRING ASSEMBLY & BOLT-CARRIER GROUP PER MANUAL

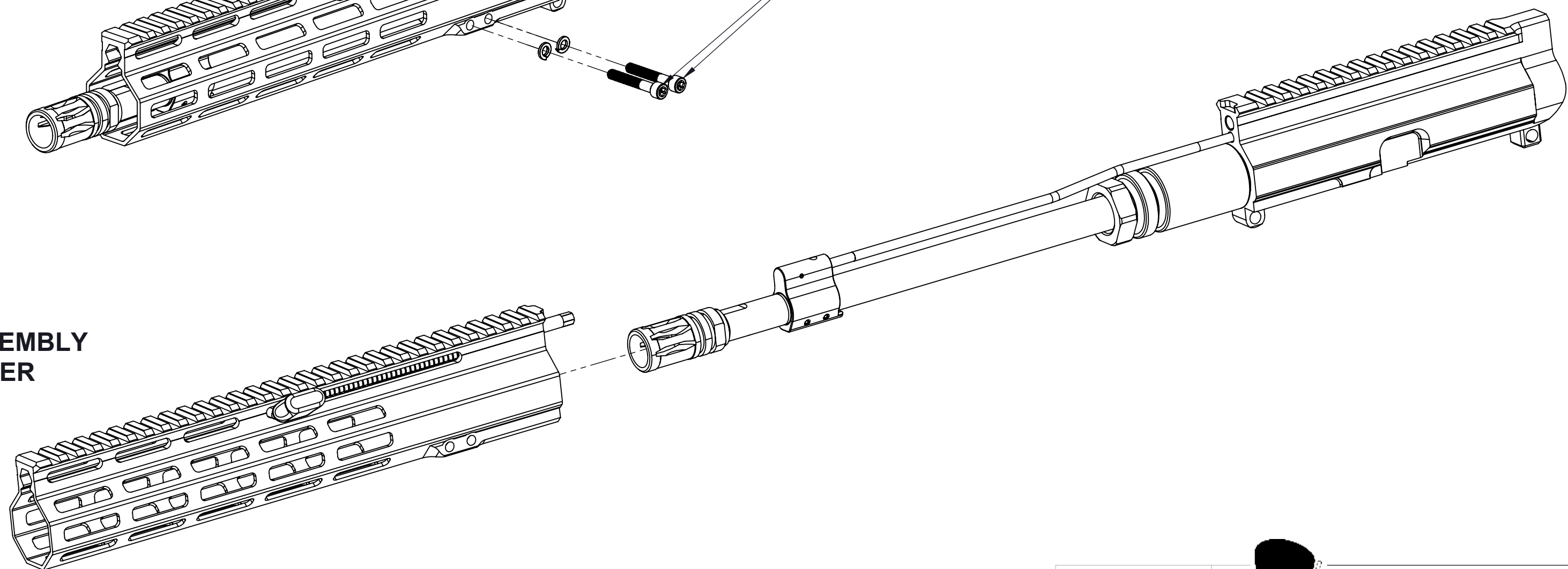


STEP 2: USE IP27 TORX DRIVER TO REMOVE TWO HANDGUARD SCREWS & SPLIT WASHER



**DO NOT EXCEED 20 IN/LB DURING REASSEMBLY
EXCESSIVE TORQUE CAN CAUSE THE THREADS IN THE HANDGUARD TO TEAR OUT AND RENDER THE HANDGUARD INOPERABLE**

STEP 3: SLIDE HANDGUARD ASSEMBLY FORWARD OFF OF UPPER RECEIVER ASSEMBLY



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGULAR: ±1°
TWO PLACE DECIMAL ±.01
THREE PLACE DECIMAL ±.005



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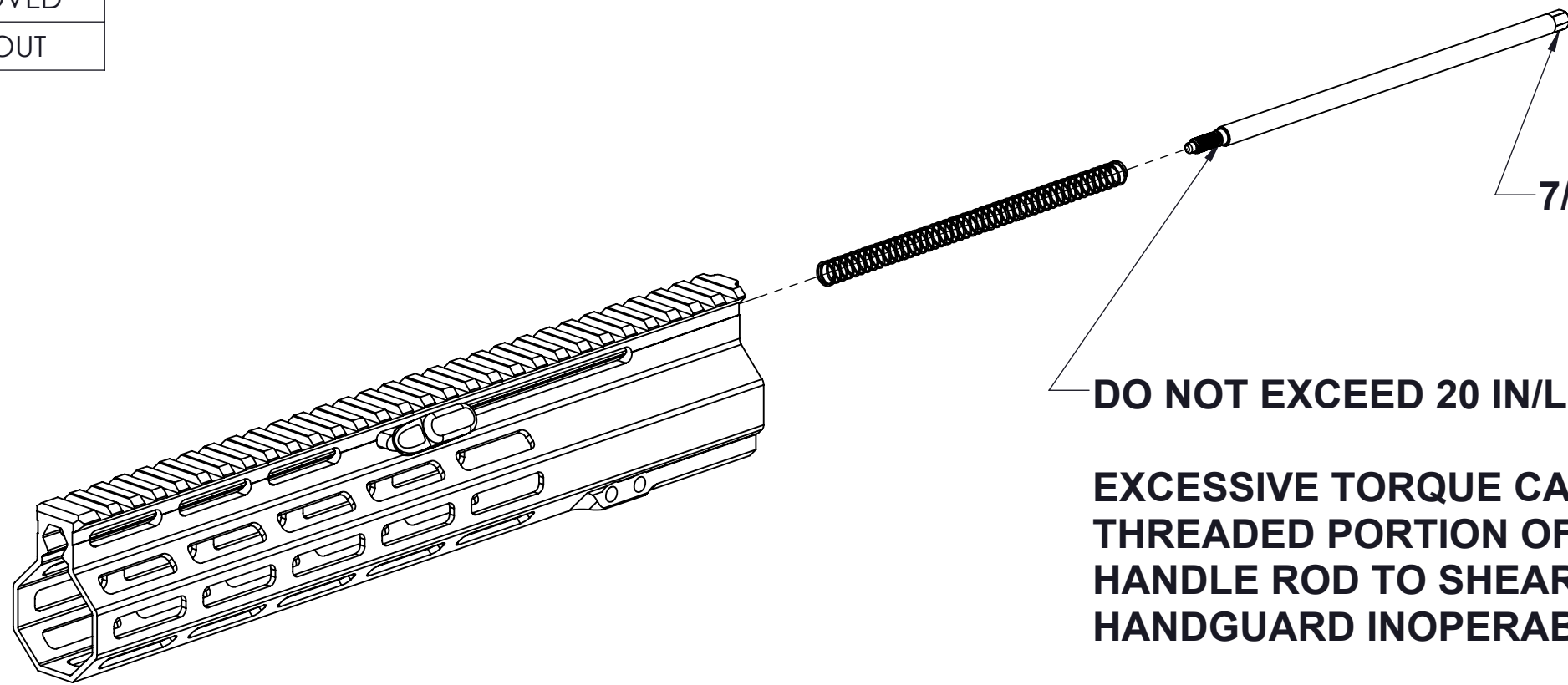
TITLE: **REVISED GEN 2 CHARGING HANDLE DISASSEMBLY INSTRUCTIONS**

| | | |
|------|----------|-----|
| SIZE | DWG. NO. | REV |
| C | 2308013 | A |

| | | | |
|----------------------|------------|---------|--------------|
| DO NOT SCALE DRAWING | SCALE: 1:2 | WEIGHT: | SHEET 1 OF 2 |
|----------------------|------------|---------|--------------|

| REV. | DESCRIPTION | DATE | APPROVED |
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| A | PRELIMINARY RELEASE | 9/5/23 | A. TROUT |

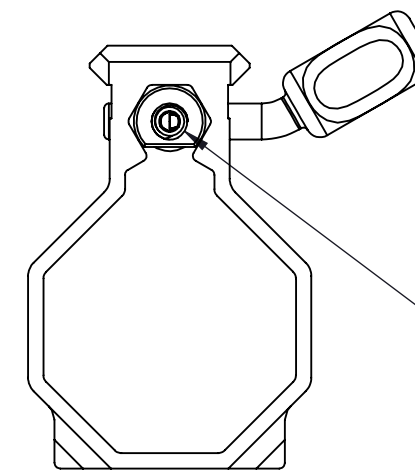
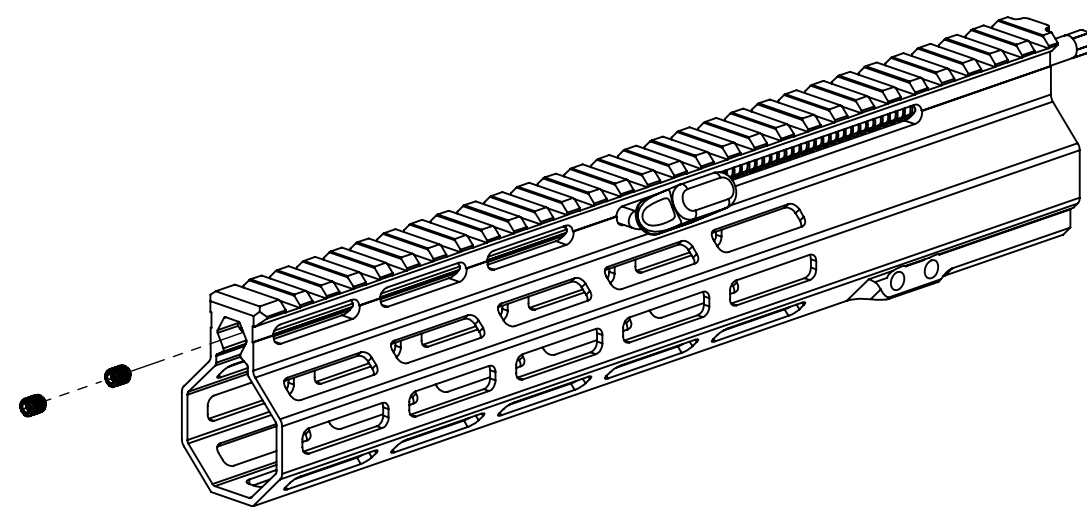
STEP 4: USE 7/32" WRENCH TO LOOSEN CHARGING HANDLE ROD. PULL ROD AND SPRING OUT FROM REAR OF HANDGUARD.



DO NOT EXCEED 20 IN/LB DURING REASSEMBLY

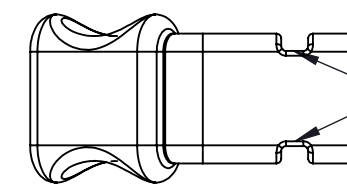
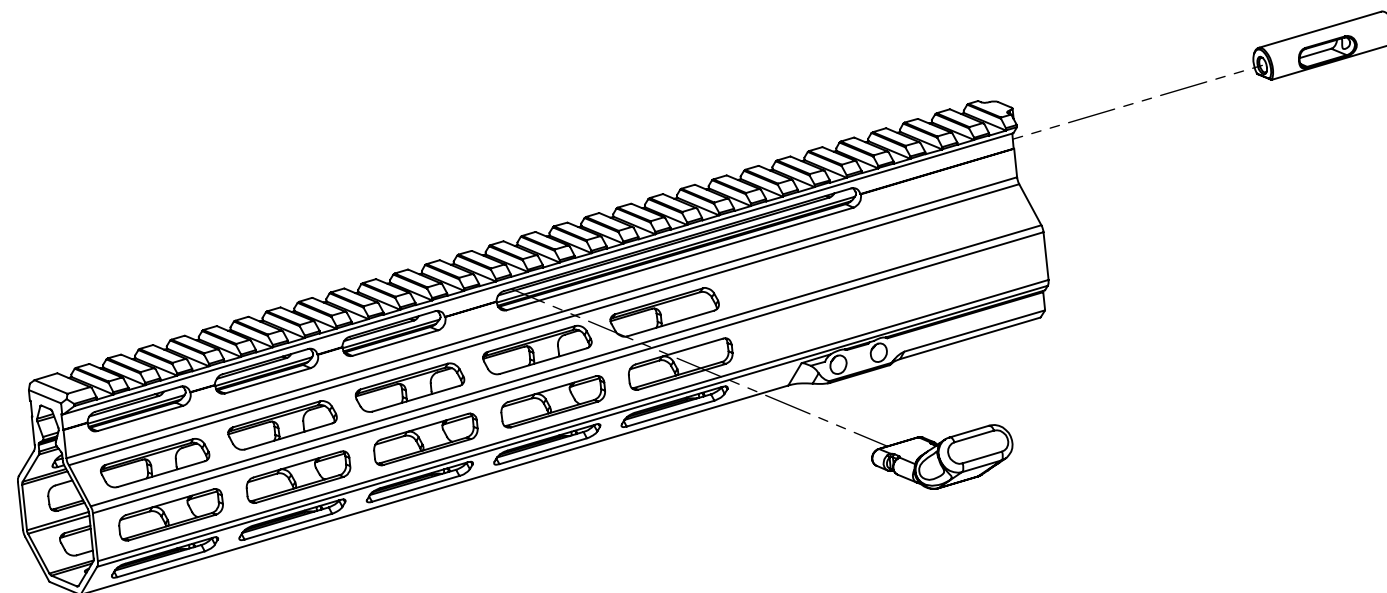
EXCESSIVE TORQUE CAN CAUSE THE THREADED PORTION OF THE CHARGING HANDLE ROD TO SHEAR AND RENDER THE HANDGUARD INOPERABLE

STEP 5: USE LONG 3/32" HEX KEY TO REMOVE TWO #10-32 SET SCREWS FROM THE FRONT OF THE CHARGING HANDLE TROLLEY



SET SCREWS ARE LOCATED HERE IN THE FRONT OF THE CHARGING HANDLE TROLLEY

STEP 6: PULL OUT THE CHARGING HANDLE AND SLIDE THE CHARGING HANDLE TROLLEY OUT OF THE HANDGUARD HEX CHANNEL



CHARGING HANDLES MUST HAVE TWO NOTCHES SO THE CHARGING HANDLE ROD CAN PROPERLY SEAT AGAINST CHARGING HANDLE.

USING A CHARGING HANDLE WITH ONLY ONE NOTCH WILL CAUSE THE CHARGING HANDLE ROD TO BE TOO LONG IN THE UPPER RECEIVER AND CAUSE MALFUNCTIONS.

ASSEMBLY NOTES:

- 1. REASSEMBLE IN REVERSE ORDER**
- 2. CLEAN ALL THREADS WITH ACETONE OR SIMILAR SOLVENT**
- 3. USE BLUE LOCTITE 243 OR SIMILAR THREAD LOCKER ON THREADS**
- 4. TIGHTEN ALL THREADS TO 15-20 IN/LBS**
- 5. LUBE THE EXTERIOR OF THE CHARGING HANDLE ROD & TROLLEY WITH GREASE BEFORE INSTALLING HANDGUARD ON UPPER RECEIVER ASSEMBLY**

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
 TOLERANCES:
 ANGULAR: ±1°
 TWO PLACE DECIMAL ±.01
 THREE PLACE DECIMAL ±.005
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TITLE: **REVISED GEN 2 CHARGING HANDLE DISASSEMBLY INSTRUCTIONS**

SIZE: **C** DWG. NO.: **2308013** REV: **A**

DO NOT SCALE DRAWING SCALE: 1:2 WEIGHT: SHEET 2 OF 2