Firing Pin Tip Changing Instructions

Instructions can also be found on rumble at:
https://rumble.com/v7gurfs-451572328.html?mref=4nl7mu&mc=c9zu2

To change the tip on your firing pin, follow the steps below:

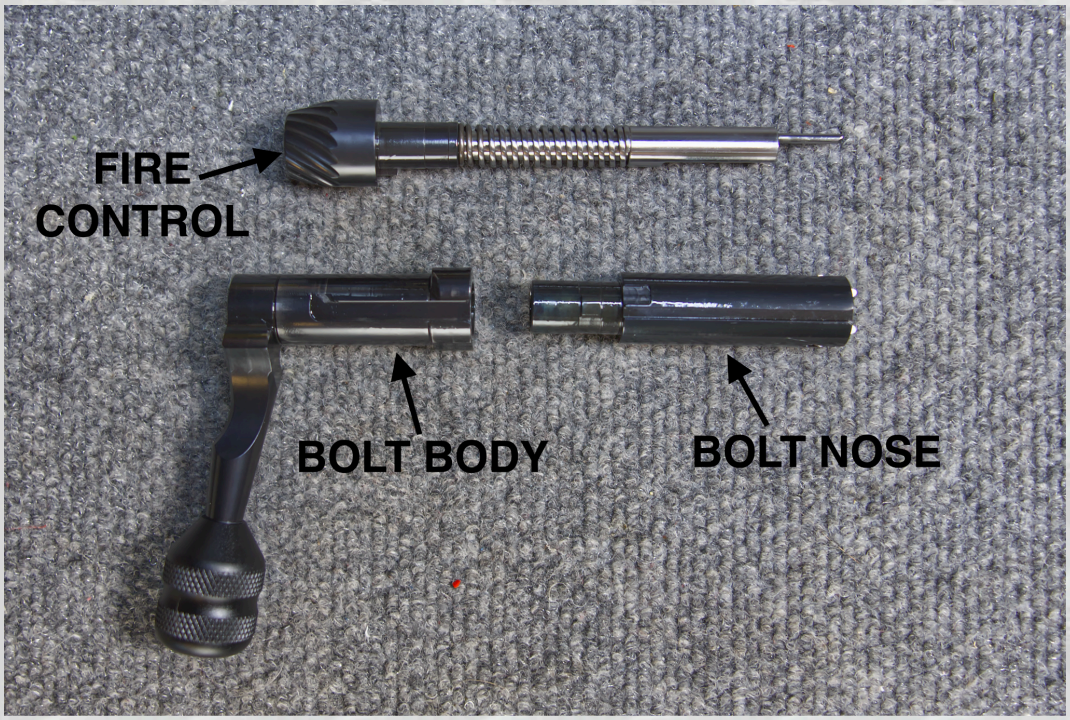
-Field strip the bolt.

1. Place the supplied Bolt Disassembly Tool over the shroud of the bolt.
2. Grip the bolt body and handle in one hand, and the Bolt Disassembly Tool in the other hand. DO NOT GRIP THE BOLT NOSE. IT MUST BE ALLOWED TO ROTATE FREELY IN THE NEXT STEP TO PREVENT DAMAGE.



3. Turn the Bolt Disassembly Tool Clockwise until you hear a pop releasing the fire control unit.
4. Pull the fire control unit from the rear of the bolt.

5. The bolt nose is held into the body by bayonet style lugs on the bolt nose. Rotate the bolt nose in the body while gently pulling the two apart. When it properly aligns, the nose will release and come apart from the body.

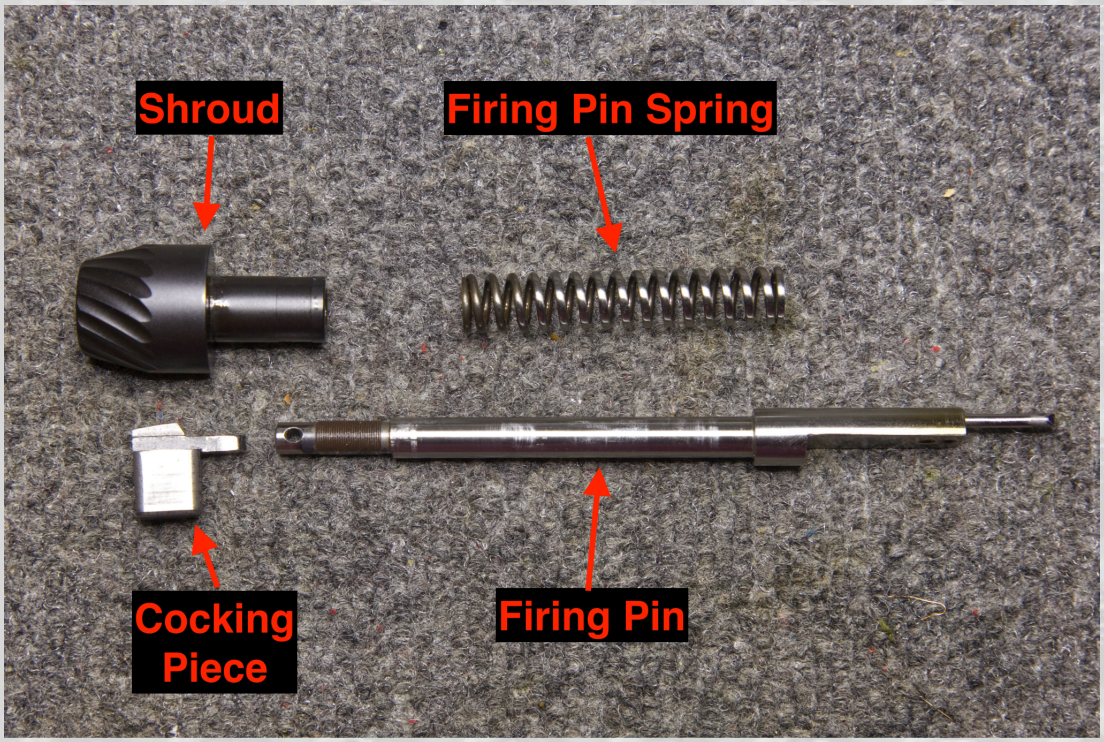


Once your bolt is field stripped, follow the steps below to remove your firing pin.

1. Using a good quality .050” Allen wrench (DO NOT USE A CHEAP ALLEN WRENCH FROM A BUDGET HARDWARE STRORE), loosen the two set screws in the cocking piece 3-4 turns. DO NOT USE EXCESSIVE FORCE. If the screws do not come loose easily, apply heat to the screws for a few seconds using a lighter, heat gun, or hair dryer. Use caution after to avoid burns as the parts will be hot.

2. Screw the firing pin until it stops while counting how many turns were needed. Remember the amount of turns for reassembly.

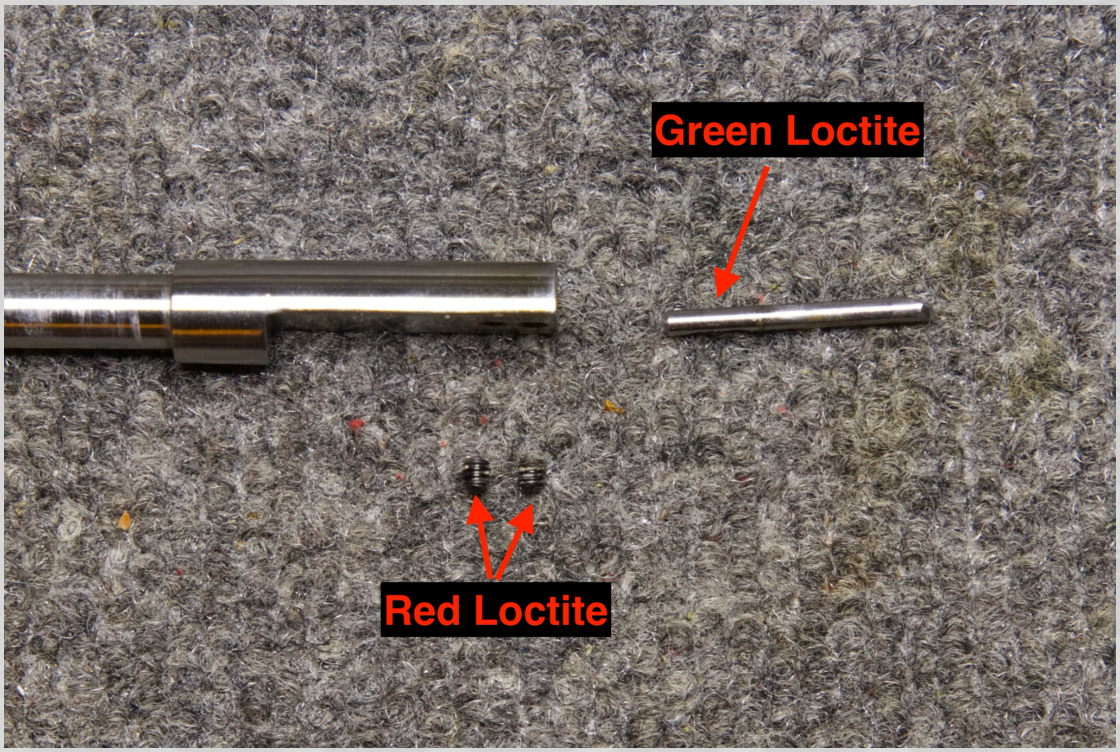
3. Unscrew the firing pin completely until the unit comes apart into 4 pieces: the firing pin, firing pin spring, shroud, and cocking piece.



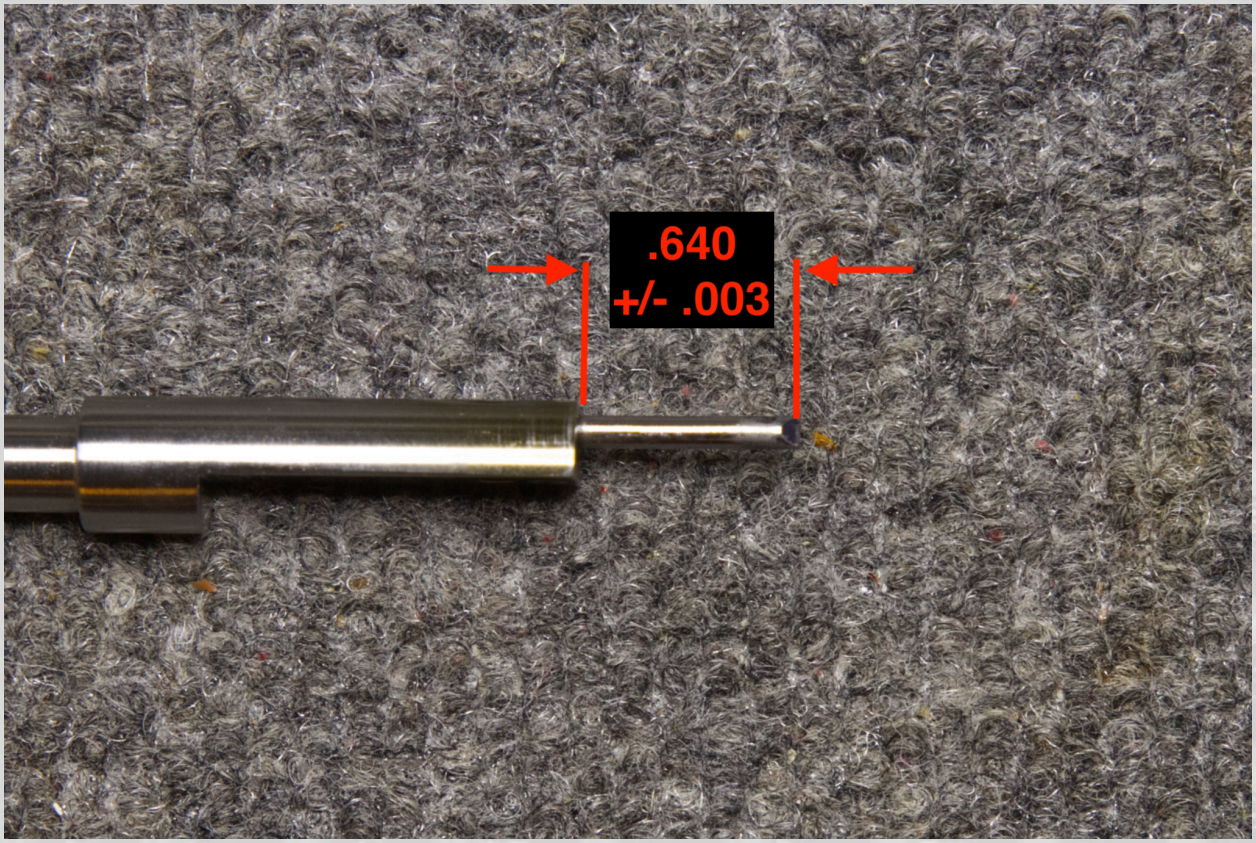
Once the firing pin is removed, follow the steps below to change the tip:

1. Apply heat to the screws and tip of the firing pin using a lighter, small butane torch, or heat gun.
2. Remove the set screws using a high quality, 0.050” allen wrench(DO NOT USE A CHEAP ALLEN WRENCH FROM A BUDGET HARDWARE STRORE).
3. Remove the tip by pulling straight out with pliers or vise grips. Use caution not to bend or break the tip.
4. Apply the included Loctite Retaining Compound 680 (green) to the new tip and insert into the hole, ensuring the slot for the set screws is point down.

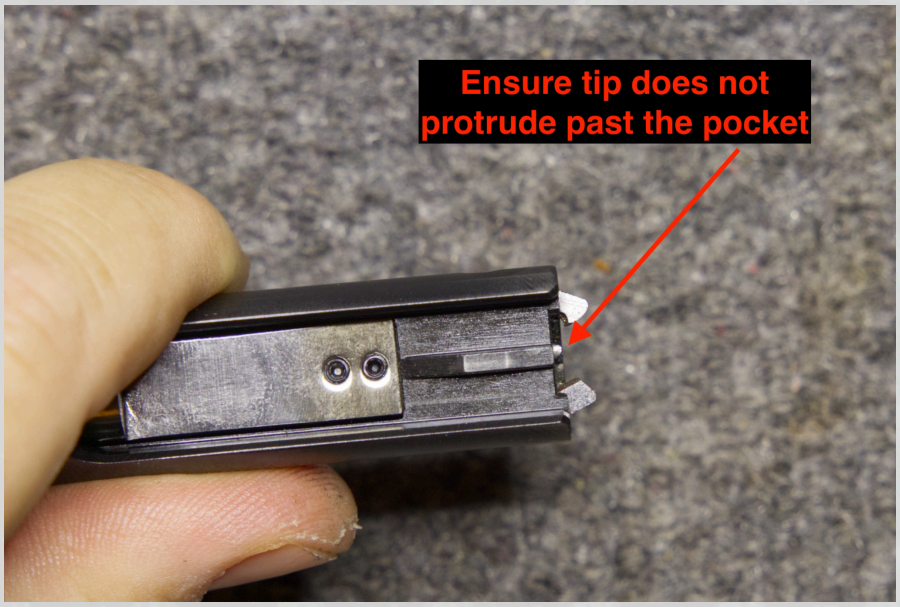
5. Apply the included Loctite thread locker 263 (red) to the set screws and reinstall. Torque finger tight.

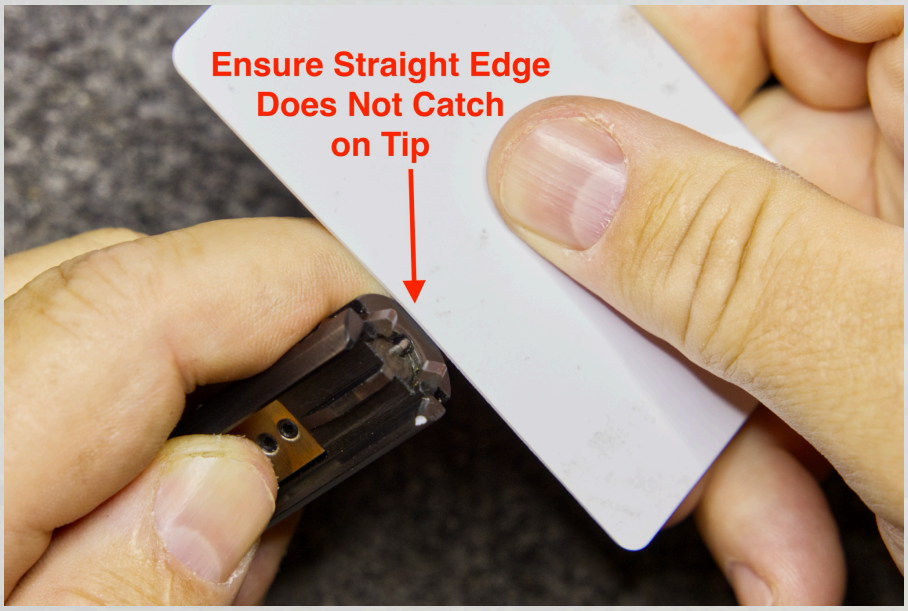


6. Measure the tip to ensure the proper protrusion. The tip should protrude 0.640” from the shoulder with a tolerance of +/- 0.003”.



7. Insert the firing pin into the bolt nose, and ensure the tip does not protrude past the pocket. Use a credit card or similar straight edge to run over the face of the bolt and ensure it does not catch on the tip.





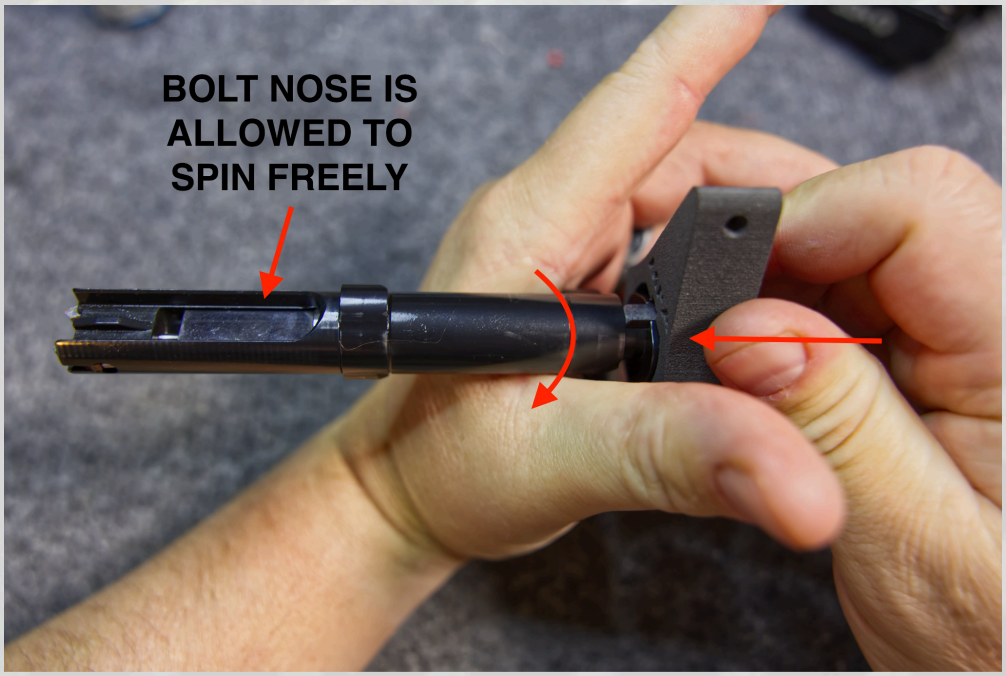
Bolt Reassembly

1. Using a rag, cotton swabs, and some degreaser or bore cleaner, clean all parts.
2. Apply a thin coat of gun oil to the sides and bottom of the cocking piece where it rides in the shroud.
3. Apply a thin coat of gun oil to the firing pin.
4. Insert the cocking piece into the shroud and firing pin into the spring.
5. Hold the cocking piece and shroud in one hand while holding the firing pin and spring in the other. Insert the firing pin into the shroud, press both hands together to compress the spring, and turn the firing pin while holding the pressure until the threads start to catch.
6. Screw the firing pin all the way in until it bottoms out.
7. Back the firing pin out the same number of turns you counted during disassembly. Ensure the bottom of the firing pin is clocked to line up with the bottom of the cocking piece.
8. Tighten the set screws to 4 in/lbs. or finger tight using a .050” Allen wrench.
9. Insert the bolt nose into the bolt body and rotate until the lugs are oriented in the correct position allowing the parts to slide completely together.

10. Insert the fire control unit into the back of the bolt. DO NOT APPLY ANY FORCE AT THIS TIME. The firing pin tip will need to line up with the hole in the bolt nose as the lug on the shroud aligns in the proper position with the bolt body. Visually line up the firing pin tip with the hole in the bolt nose while you rotate the nose and fire control together to line up the shroud and the bolt body. When the parts line up, the fire control will easily slide into the bolt until the cocking piece begins to contact the body.



11. Place your Bolt Disassembly Tool over the shroud with one hand. Grip the bolt body in the other hand. DO NOT GRIP THE NOSE. IT MUST BE ALLOWED TO ROTATE FREELY IN THE NEXT STEP TO PREVENT DAMAGE. Firmly press the tool in towards the bolt body, while holding the pressure, slowly rotate the Bolt Disassembly Tool counterclockwise until you hear a small pop. The bolt should now be assembled and in the cocked position.



12. Lubricate the outside of the bolt with a good quality gun oil. Insert the bolt into the receiver. Cycle the bolt a few times to distribute the lubrication through the action. Remove the bolt and wipe off any excess lubrication. The bolt should appear shiny and slightly wet with a thin coat of oil when lubricated properly.
13. Reinsert the bolt into the rifle.