



ACCURACY SPEAKS, INC.

3960 N. USERY PASS RD. • MESA, AZ 85207 • (480)373-9499

INSTALLATION INSTRUCTIONS

ARMY M-261 KITS

1. Drive out the roll pin that retains the chamber adapter to the bolt bar.
2. Hold the bolt slightly to the rear and install the assembly into the upper receiver. Guide the bolt bar into it's slot in the barrel.
3. Install and tighten the retaining screw.
4. Lightly lubricate and go shootin'.

HELPFUL HINTS

1. Remove and cut the charging handle latch spring. Also, reshape the latch to more easily enter it's cut in the receiver. The bolt spring in the kits does not always have enough energy to close the charging handle. This gives the impression that the round will not chamber, when in fact the charging handle is at fault.
2. Remove the firing pin and reshape the nose into a chisel point with a .030 flatt on the tip. Be sure to keep the flat perpendicular to the pin slot in the firing pin. Cut 2 coils from the firing pin spring.
3. The wire clip opposite from the extractor, will need to be adjusted (bent), to provide minimal tension against the case rim. Most guns will function well without this extractor clip.
4. Keep the chamber, the extractors and magazines clean.
5. This is a match chamber, the extractors will not usually remove an unfired round from the chamber.
6. Cheap ammo doesn't work.
7. Every barrel or upper receiver assembly is function fired with a minimum of 50 rounds of Win. T-22. If it dosen't work, it is repaired and retested. This doesn't mean that you will never have a problem, it does mean that it worked for me. Let's work together if you have a problem.

8. If you ever rupture a case, STOP SHOOTING, THERE IS A BULLET STUCK IN THE BARREL !! If you reload and fire with removing the bullet, you will bulge the barrel and ruin it.

ZEROING SERVICE RIFLE UPPERS

1. You will notice a set screw on the bottom of the front sight base, this is designed to allow you to adjust the wind zero, when sighting in the rifle.
2. Apply 10 clicks of elevation and center the rear sight for windage. Shoot at 50 yds. From prone position, make all elevation and wind adjustments to the front sight. Remember the front sight is moved toward the bullet hole, not the target.
3. When zeroed, tighten the set screw and apply LOC-TITE #290 to the sight base/barrel joint. When set the LOC-TITE will provide a very strong joint.