



ACCURACY SPEAKS, INC.

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

INSTALLATION INSTRUCTIONS ATCHISSON/CEINER KITS

1. Pry the chamber adapter gently out of the action bars.
2. Hold the assembly together, and carefully install into the receiver. Hold the bolt slightly to the rear, this will allow you to align the action bars with their slots in the barrel.
3. 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. It is a common problem for the Atchisson bolt to drag on the magazine lips, giving the impression that the round will not chamber. This condition is aggravated by resting the magazine on your hand during standing. This is caused by variations in height of the magazine in different lowers. It will test fire fine on my lower and refuse to work on yours. When this happens, *lightly* file the lips of the magazine where they show contact or bend the lips down *slightly* to clear. In the worst cases you may have to grind additional clearance on the bottom of the bolt. This is a problem we are working to solve, but inconsistencies in magazines and the kit themselves make it difficult to design a permanent solution.
3. Keep the chamber, the extractors and magazines clean.
4. This is a match chamber, the extractors will not usually remove an unfired round from the chamber.
5. Cheap ammo doesn't work.
6. 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.

7. 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.
8. If you are going to install magazine adapters on your magazines, you will need to drill a 3/16" (.187) hole in the bottom of the magazine. It should be centered side to side and 3/16" to 1/4" from the front of the magazine to the center of the hole. Insert the screw and tighten. Adjust the set screws to lightly contact the lower receiver, this will allow you to use the magazine for support in the standing position.

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.