

Pmac Assembly Instructions

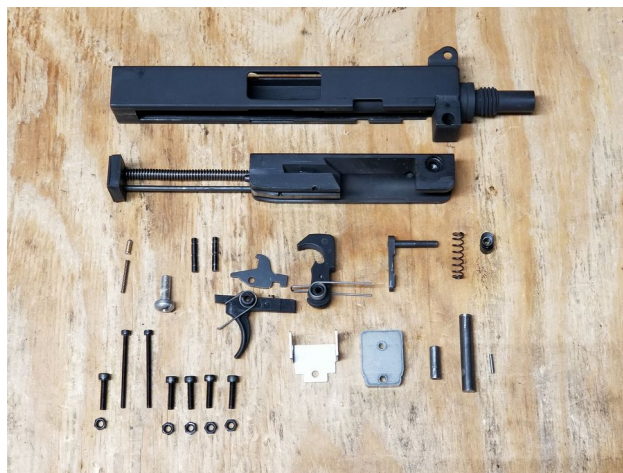


Required Tools

- Drill and Drill Bits
- Allen Keys
- Hack Saw (for DIY)
- Vise or Press (for DIY)
- File
- Punch Set

Required Parts

- Mac 9mm Upper/Bolt (side or top)
- AR-15 Fire Control Group, Safety Detent/Spring, Mag Catch and Grip Screw
- PMac Reinforcements/
Hardware Kit*



*Hardware kit includes- M3x45mm screws(x2), M4x16mm(x4), M4x18mm(x1), M4 nuts(x5), Steel Rods(5/16x1 15/16", 1/4x7/8" and 2x12mm)



Drill out safety hole with 3/8" bit, check safety selector fit. Check fit of mag catch and trigger pins. Trigger pins should be snug, tapping in with a mallet may be required. Mag catch and safety should move freely.



Install mag catch into mag catch adapter. Be sure to seat the catch fully into the adapter. Check fit in receiver after assembly. If catch assembly moves freely, install mag catch button/spring.



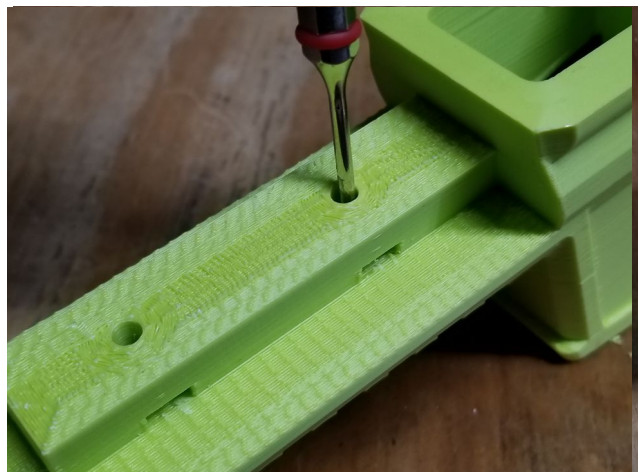
Make sure the catch is secure and functions properly before next step.



Install trigger assembly and safety selector. (follow standard AR-15 FCG assembly procedure) Check function, but do not allow hammer to strike the receiver at this point. Leave the hammer in the upright position for the next step.

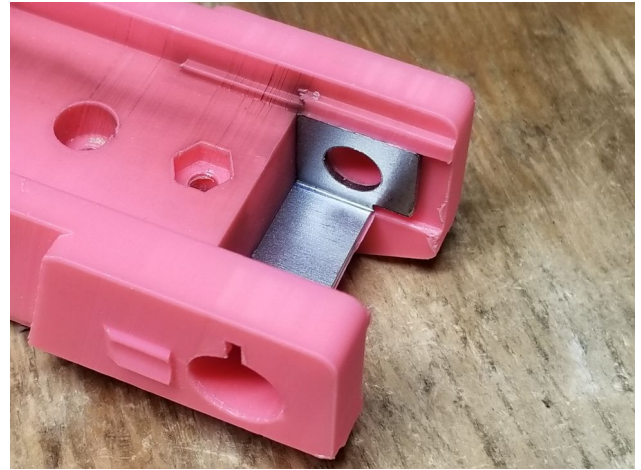
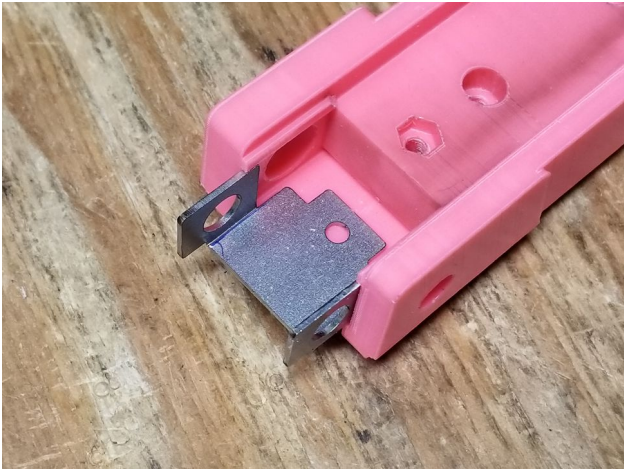


Create threads for grip screw prior to grip install. Bolt or tap can be used to make threads. Once threads are made, install grip, safety detent and detent spring. Check safety function with hammer down.

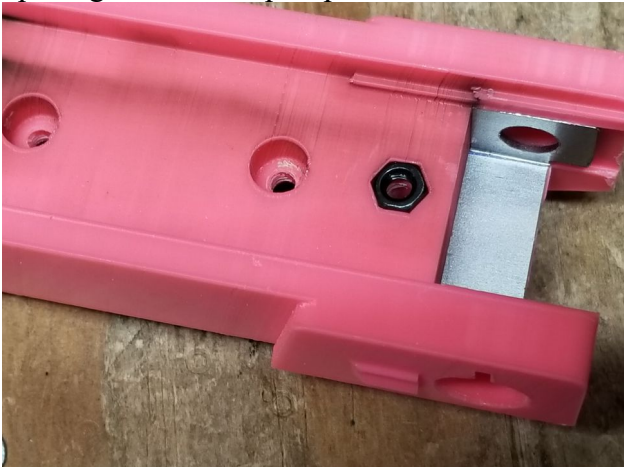


Check fit of front end. Clean up mating surfaces. Front should slide smoothly on and off dovetail of the receiver. Set front end aside.

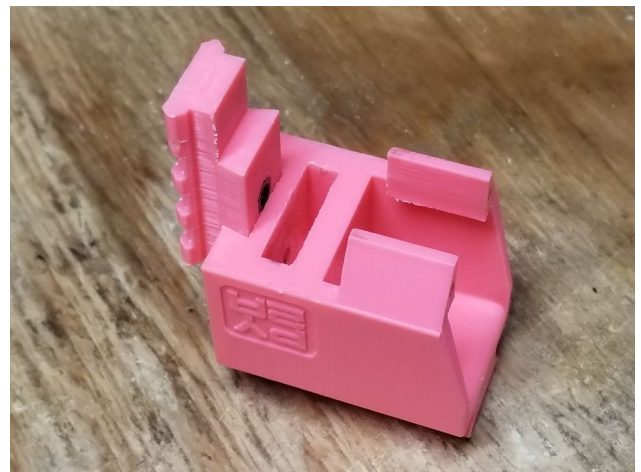
Install two M4 nuts into the slot in the dovetail. Align with a punch before installing front end.



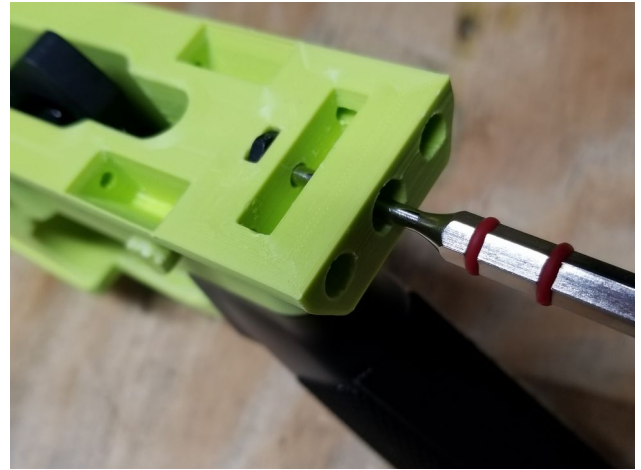
Install front reinforcement. Attachment tab of reinforcement should be flush with the bottom of the opening. It should tap or press in without much force.



Install M4 nut into recess and M4x16mm screw through trunion assembly. Make sure screw head is flush or past surface.



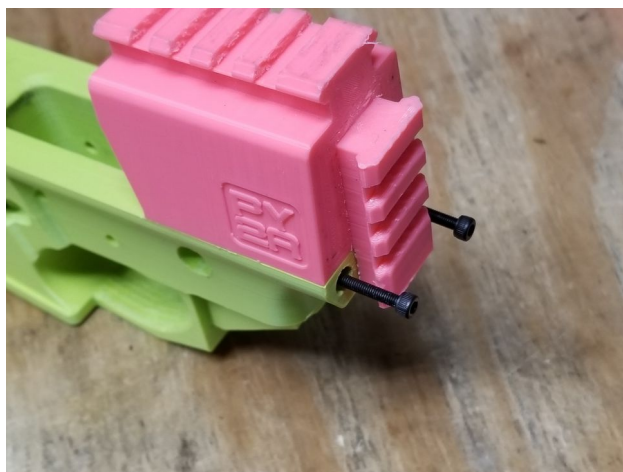
Install M4 nut in rail of your choice. Make sure surface is flush and install rail into hood slot, flat side down.



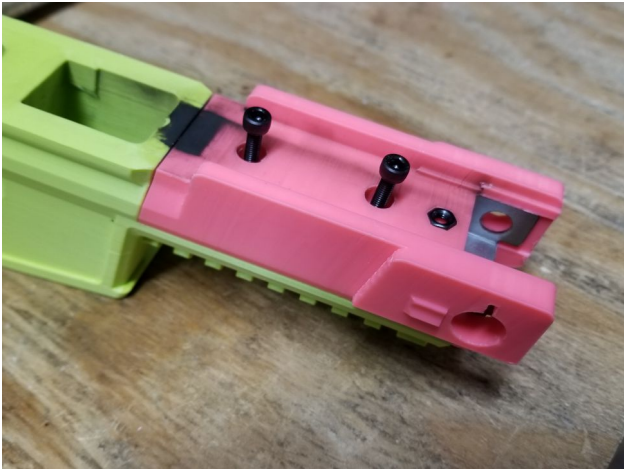
Install M4 nut into receiver, center with punch



Insert rear reinforcement until holes line up. Install M4x18mm screw until tight. Screw head should be flush or below surface.



Install hood so it is flush with no gaps between it and the receiver. A mallet can be used to lightly tap it into place. **Misalignment will cause malfunctions.** Once in place, install M3x45mm screws until flush with back of the receiver. Also install M4x16mm inside hood until flush.



Install M4x16mm screws through front end until flush. Front end must be level with the receiver.
Misalignment will cause malfunctions.



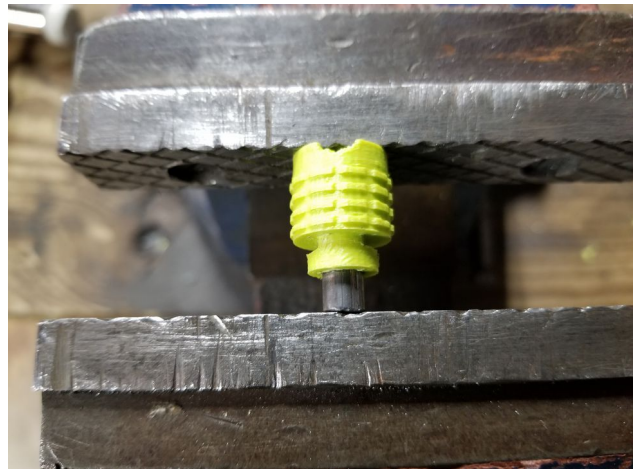
Cut 5/16" rod to 1 15/16" length. Clean up ends and chamfer.



Press front pin knob onto 5/16" pin until bottomed out. Drill hole with 5/64" bit and install 2x12mm pin.



Make sure 2mm pin clears opening in front end.



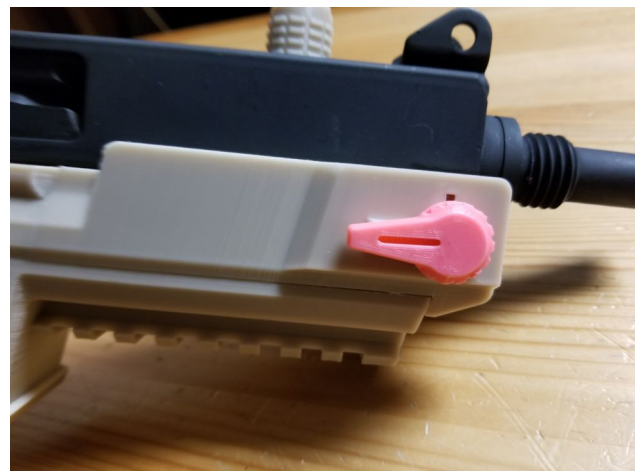
Cut 1/4" steel rod to 7/8", clean and chamfer ends. Press 1/4" rod into charging handle until bottomed out.



Check fit and make sure bolt moves freely. Check clearance on opposite side, handle can not protrude.



With the hammer up, slip the back end of the upper into the hood bringing the front end down into the proper position. Once in place, line up the holes before inserting the front pin. It may be necessary to push the upper back slightly.



Line up pin and pin slot, push front pin in. Turn counter clockwise 90 degrees to lock. It may be tight the first couple times, use a pliers to help turn the knob, if needed.



To disassemble, the hammer must be decocked. To do so, pull the charging handle back to the front of the ejection port and pull the trigger with the safety off.