

STAINLESS STEEL FEEDLIP INSTALLATION INSTRUCTIONS

M-11/9 ZYTEL MAGAZINE

This procedure requires average skills. Read instructions completely before proceeding. In general the procedure is to clean and abrade the magazine, apply epoxy to one side and affix one feedlip, clamp, clean excess epoxy and let dry for 4 hours before proceeding with the other feedlip. Be patient, take your time and you will end up with a high quality, reliable, trouble-free magazine.

NOTE: It is very important to use the J-B WELD epoxy specified below. This epoxy meets the strength and temperature range required. Using a different adhesive may result in failure of the inserts to adhere to the magazine during operation.

Tools and materials:

J-B WELD two part epoxy, part no. 8265-S

Isopropyl Alcohol

Stiff Toothbrush

Paper Towel

80 grit emery paper

220 grit wet/dry sand paper

Craft Sticks/Popsicle Stick for mixing

Flat toothpicks

1" C-clamp

Mixing container

Procedure:

- 1) Disassemble magazine. Remove baseplate, spring and follower.
- 2) Thoroughly clean feedlip area with alcohol and toothbrush.
- 3) Wipe area with a paper towel and insure magazine is dry.
- 4) Abrade magazine feedlips with 80 grit emery paper in areas shown in Figure 1. Wrapping emery paper around craft stick for use as a file may help abrade inside magazine.
- 5) Thoroughly clean feedlip area with alcohol and toothbrush to remove sanding dust and debris.
- 6) Abrade both metal feedlips with 80 grit emery paper in area to be epoxied.
- 7) Clean metal feedlips with alcohol and dry.
- 8) Mix two part epoxy. Dispense equal parts of epoxy in a mixing container. Only dispense enough required for one feed lip. Only a dab is required. Using a craft stick, mix thoroughly! Take your time mixing, the epoxy takes a while to start to set.
- 9) Liberally apply epoxy to one side of the magazine feedlips abraded in step 4.
- 10) Position one feedlip and clamp with a 1" c-clamp as shown in figure 2. Insure the top of the feedlip is pressed flush with the top of the magazine while tightening. Use enough pressure on the c-clamp to firmly hold the feedlip, but make sure you do not crush or deform the magazine. Epoxy should seep out from the edges.
- 11) Using a toothpick, carefully remove excess epoxy.
- 12) Let cure for 4 hours minimum.
- 13) Remove c-clamp.
- 14) Repeat steps 8 through 13 for the other side.
- 15) Using 80 grit emery paper, carefully remove any remaining epoxy protrusions, internally and externally.
- 16) Using 220 grit wet/dry sanding paper, wet sand metal feedlips and surrounding epoxy to magazine junction.
- 17) Clean with alcohol and toothbrush and dry.
- 18) Reassemble magazine.

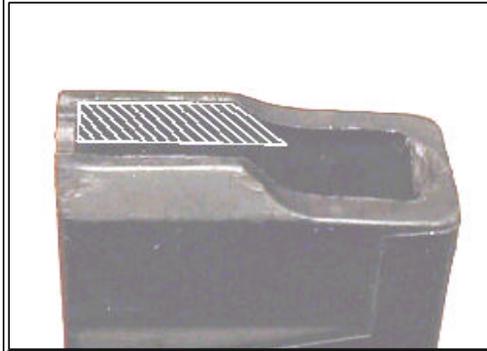


FIGURE 1



FIGURE 2

Manufacturer and/or Seller assume no liability for this product or its use. Keep out of reach of children. Kit contains small parts that pose a choking hazard. No warranty is implied or stated. Installer assumes all liabilities for any damages to firearm, property or persons. This is not a factory installed component.