

SUN DEVIL MFG

ADIGS™ - Gas Key Retrofit Instructions

Note from the Lawyers:

Always make sure when handling a firearm that it is safe, unloaded and kept pointed in a direction not to cause or lead to harm or injury. Firearms are inherently dangerous and should only be handled by competent qualified individuals.

Supplied in this retrofit kit:

- (1) Sun Devil adjustable Gas Key
- (2) Socket Head Cap Screws 8-32x1/4
- (1) Red Loctite 262
- (1) Blue Loctite 242
- (1) Hex wrench - 5/64
- (1) Hex wrench - 9/64

Please read all of the instructions before proceeding.

1. Disassemble Bolt & Carrier Group.
2. Remove the two socket head cap screws (1) securing the gas key (2).
See Fig.1
Note: DO NOT REUSE THESE SCREWS. Discard these screws.
3. Remove the Gas Key (2).
4. Clean the carrier (3) where the Gas Key was removed.
Make sure any sealant or oil that may be left on the carrier is removed.
5. Clean the bottom of the new Sun Devil Gas Key
It needs to be free of oil.
6. Apply a thin layer of Red Loctite 262 to the bottom of the NEW Sun Devil Adjustable Gas Key around the gas port as shown in fig.2
7. Place the New Gas Key on the carrier.
8. Without delay, apply a small amount of red Loctite 262 to the threads of the two 8-32x1/4 socket head cap screws and immediately place in the New Gas Key and fasten to the carrier using the 9/64 hex wrench provided. The torque specification is 35 to 40 inch-pounds.
Note: Loctite can start setting immediately. Full cure requires 24 hours.
9. Reassemble Bolt & Carrier Group.
10. Apply Blue Loctite (242) to the self-locking gas adjustment screw after tuning your rifle.

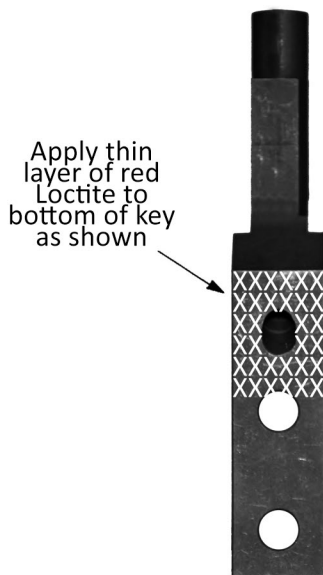
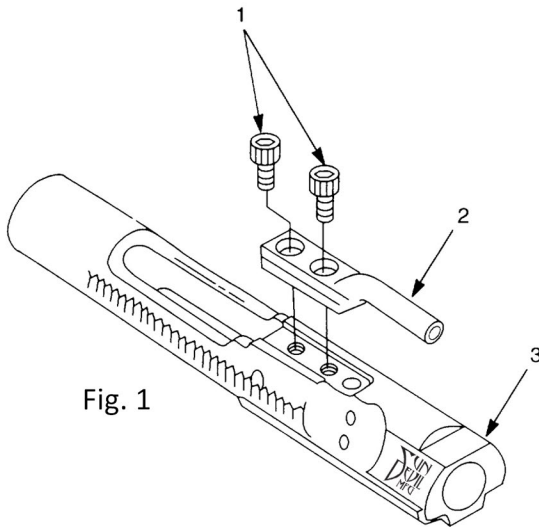


Fig. 2



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