



Tuning your new ADIGS - Adjustable Drop In Gas System

Please read all of the instructions before proceeding.

This procedure requires the rifle to be fired.

You will need to use a range or facility where it is safe and legal to test fire.

Firearms are inherently dangerous and should only be handled by competent qualified individuals. Always keep your muzzle pointed in a safe direction to avoid harm or injury to you or others.

The Sun Devil Adjustable Gas Key comes set wide open and will act as a standard gas key until it is adjusted. **ADJUSTMENT IS REQUIRED FOR BEST PERFORMANCE.**

1. Using the 5/32 hex wrench, turn in (clockwise) the self-locking gas adjusting screw one (1) turn.

This decreases the gas to the carrier.

2. Install BCG (Bolt & Carrier Group) into your rifle.

3. Load a magazine with one (1) cartridge.

4. At a place safe to test fire, load the rifle.

5. Pointing in a safe direction, fire the rifle.

6. Check to see if the bolt locks open.

If YES, remove BCG and repeat steps 1 through 6

If NO, remove BCG and continue.

7. Using the 5/32 hex wrench, turn out (counter clockwise) the gas adjusting screw one quarter (1/4) turn. This increases the gas to the carrier.

8. Load a magazine with one (1) cartridge.

9. At a place safe to test fire, load the rifle.

10. Pointing in a safe direction, fire the rifle.

11. Check to see if the bolt locks open.

If NO, remove BCG and repeat steps 7 through 11.

If YES, verify operation as follows:

12. Load a magazine with one (1) cartridge.

13. At a place safe to test fire, load the rifle.

14. Pointing in a safe direction, fire the rifle.

15. Check to see if the bolt locks open.

If NO, remove BCG start back at step 7.

If YES, remove BCG and continue.

16. Using the 5/32 hex wrench, turn out (counter clockwise) the gas adjusting screw one quarter (1/4) turn. This increases the gas to the carrier.

This should ensure reliable operation.

17. Place a small amount of BLUE Loctite (242) on the self-locking gas adjusting screw as a secondary means of locking.

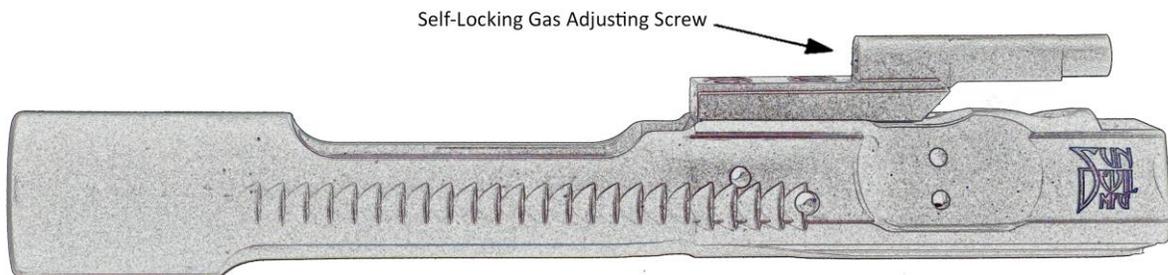
You are finished with the tuning procedure.



ADJUSTMENT PROCEDURE SUMMARY

1. Using the 5/32 hex wrench, turn in (clockwise) the self-locking gas adjusting screw one (1) turn and Install BCG (Bolt & Carrier Group) into your rifle.
2. At a place safe to test fire, load the rifle with one (1) cartridge in the magazine and test fire the rifle.
3. Remove BCG and repeat steps 1 & 2 until the rifle DOES NOT lock open.
4. Remove BCG and turn out (counter clockwise) the gas adjusting screw one quarter (1/4) turn.
5. Load the rifle with one (1) cartridge in the magazine and test fire the rifle .
6. Remove BCG and repeat steps 4 & 5 until the rifle DOES lock open.
7. Remove BCG and turn out (counter clockwise) the gas adjusting screw one quarter (1/4) turn. This should ensure reliable operation.
8. Apply a small amount of BLUE Loctite 242 to the Self-Locking Gas Adjustment Screw as a secondary means of locking.

Tuning procedure finished.



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