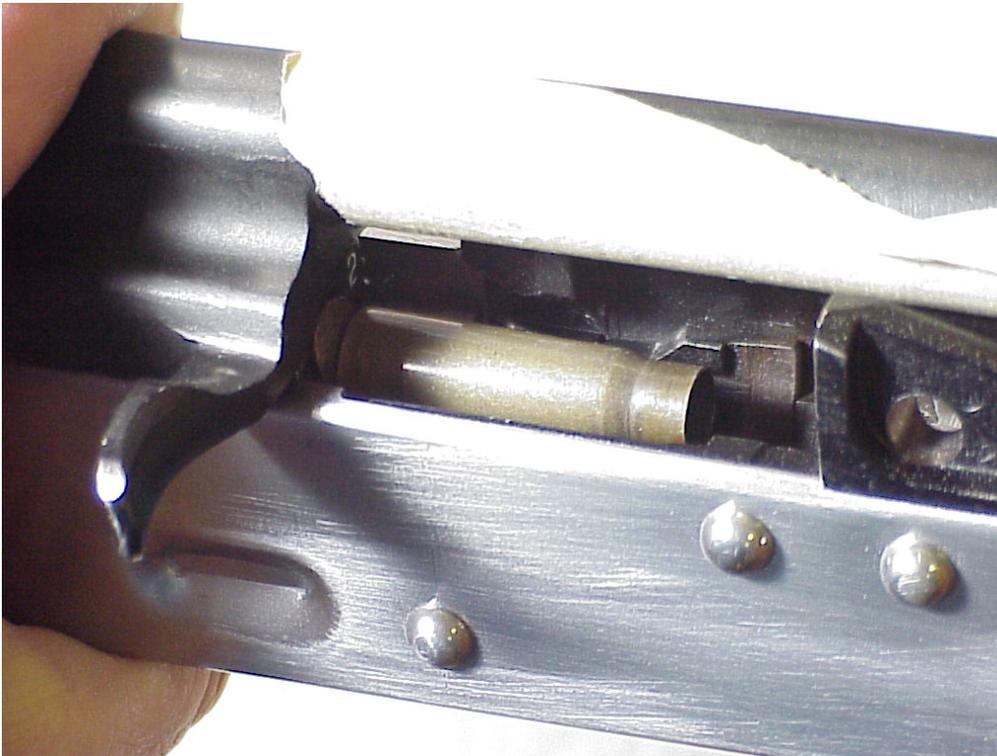


# Lower Rail Installation

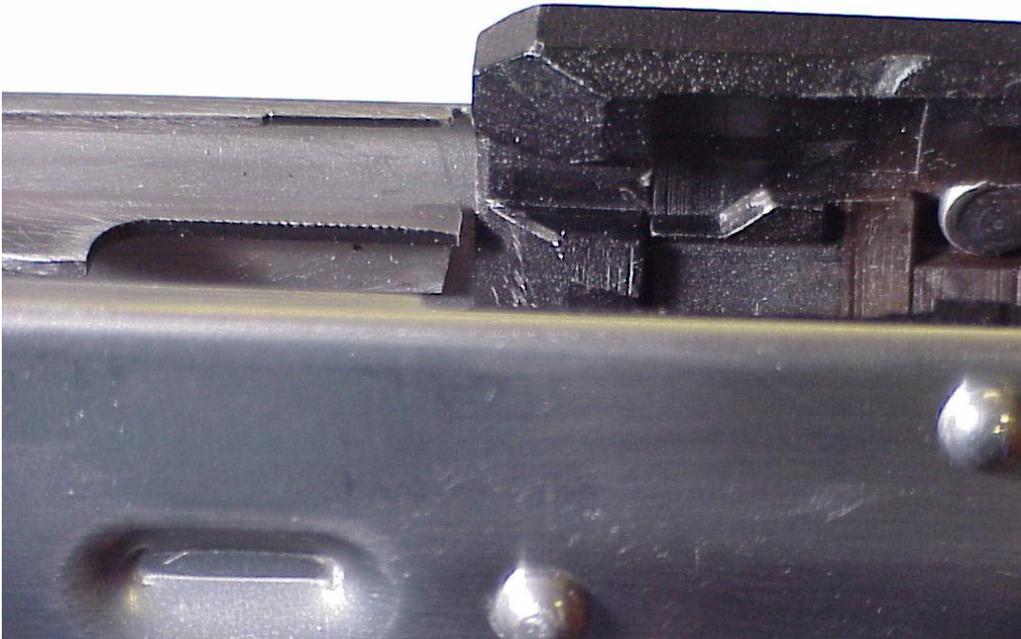
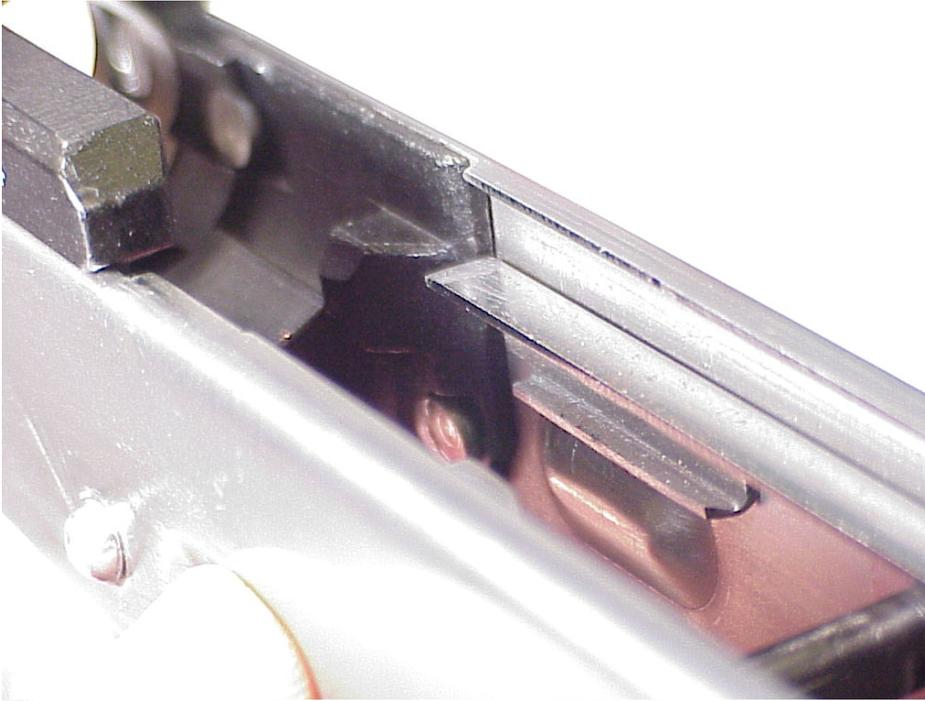
## Part 2

Continued from Lower Rail Installation Part 1

18. As a final check before spot welding the rails in position, I check for proper ejection of an empty casing. With the rails and center support temporarily installed and the case being held by the extractor, pull the bolt carrier back briskly. The empty casing should eject up and out to the right.



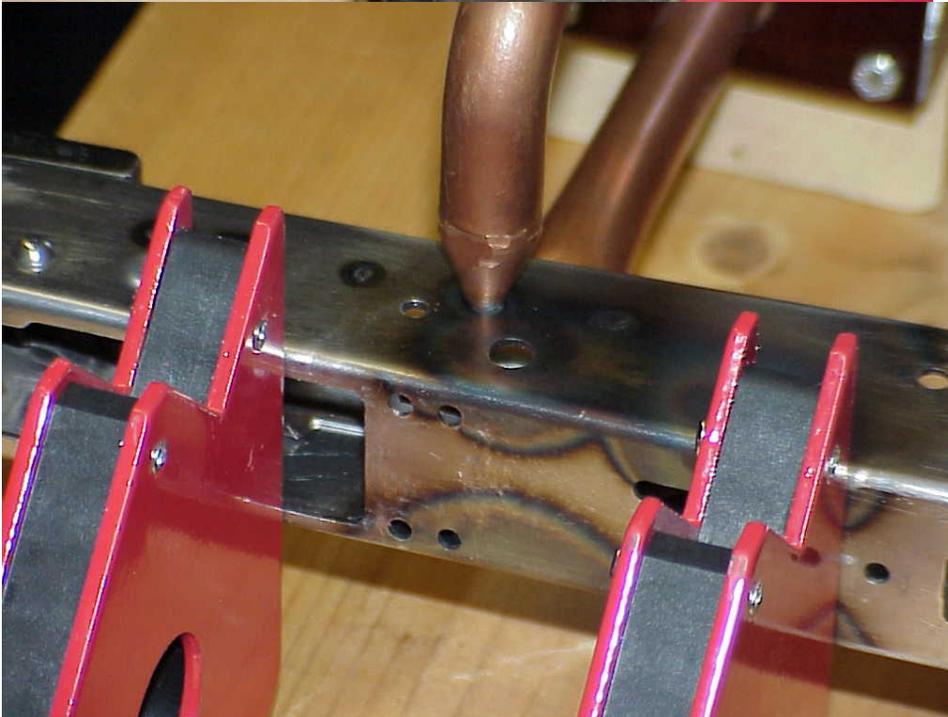
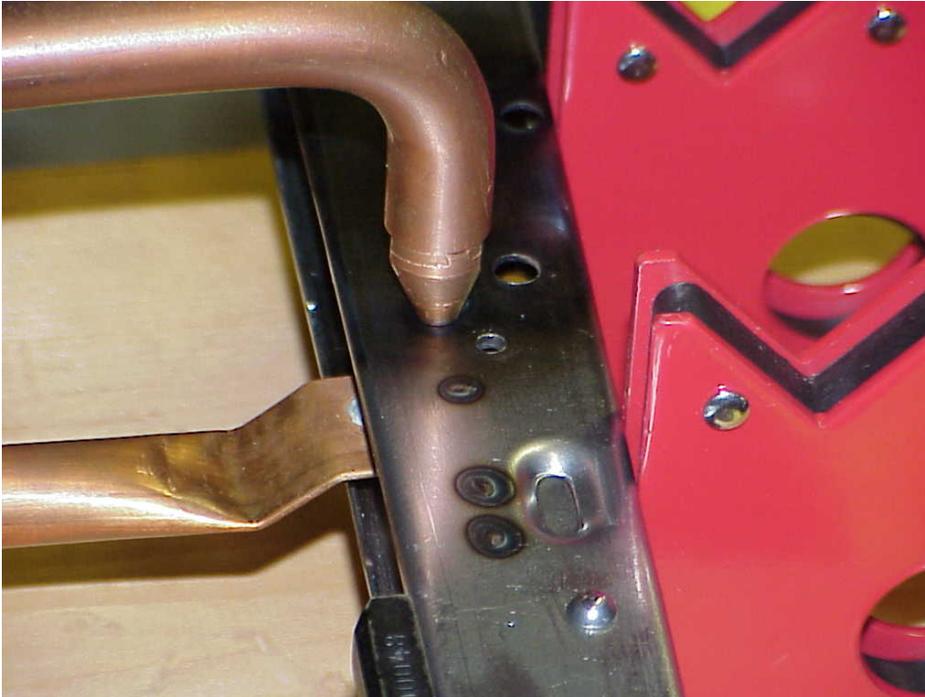
19. Ensure the rails are properly located, that they are in correct alignment with the front trunnion bolt guides. Insert the bolt carrier with bolt and carefully move the carrier forward till the bolt rotates in the front trunnion. Then slowly pull the carrier to the rear and remove. The carrier should glide smoothly the entire distance. This step is just insurance that the rails are in correct alignment. Be sure to make this check, as welding the rails out of alignment will cause an undue amount of trouble. Basically, once welded in place, they're welded in place.



<<<IMPORTANT>>>

As a minimum, heat treat the ejector, the hammer/trigger holes (4). In addition, if so desired, heat treat the LH small selector hole and the top of the lower rails. **THIS MUST BE ACCOMPLISHED PRIOR TO SPOT WELDING THE RAILS IN PLACE.**

20. Position the spot welder so that the receiver and rail to be welded are level and that the welding tips are in proper position. When ready, I hit the switch for about three (3) seconds, wait till the weld has cooled then disengage the welder tong and move on to the next weld. The red items in the pictures are magnetic welding squares that hold the work in almost any position for welding setup.



21. I usually put 4 welds (evenly spaced) on the LH rail (ejector) and five (5) welds on the RH rail (4 welds in a row with 1 weld low and above the hammer axis pin hole).



After all spot welds are completed, insert bolt carrier with bolt and move the carrier forward till the bolt rotates in the front trunnion. This operation should be as smooth as when accomplished in step # 19. This completes the lower rail installation.