



WARNING



Never attempt to disassemble or reassemble a firearm unless you are absolutely certain that it is empty and unloaded. Visually inspect the chamber, the magazine and firing mechanism to be absolutely certain that no ammunition remains in the firearm. Disassembly and reassembly should follow the manufacturer's instructions. If such instructions are not immediately available, contact the manufacturer to see if they are available. If they are not available at all, then you should consult other reference sources such as reference books or persons with sufficient knowledge. If such alternative sources are not available and you have a need to disassemble or reassemble the firearm, you should proceed basing your procedures on common sense and experience with similarly constructed firearms.

With regard to the use of these tools, the advice of Brownells Incorporated is general. If there is any question as to a specific application it would be best to seek out specific advice from other sources and not solely rely on the general advice and warnings given.

HOW TO USE

- 1) Install carrier key with two Bolt Carrier Key Screws to carrier using 9/64" Allen wrench or equivalent bit, torque to 35-40 inch pounds. *Colt recommends the use of Permatex No. 3 Aviation Form a Gasket in a thin coat across the bottom of the carrier key to insure a complete seal.*
- 2) Insert assembled carrier and key into fixture with the carrier key end inserted into the open end of the fixture until it butts against the closed end of the fixture or the socket head cap screws securing the carrier key are centered between the cone tipped socket screws. Hand-tighten the cap screw in front of the carrier key to remove any movement of the carrier assembly in the fixture.
- 3) Using a 5/32" Allen wrench tighten EACH Allen head cap screw 1/4 to 1/2 turn at a time until you have securely staked the cap screws of the carrier key.
- 4) If you have raised an excessive burr that will interfere with the operation of the carrier in the upper receiver, carefully remove the burr using a fine file or stone.

Reassemble the firearm according to the manufacturer's instructions. Check for proper functioning using **ACTION PROVING DUMMIES**. Make sure **ALL SAFETY MECHANISMS** are fully functional as designed and approved by the manufacturer. If these tests prove satisfactory, test-fire the firearm with live ammunition in a **SAFE** and **APPROPRIATE** manner. **IMPORTANT!** Start the live ammunition tests by first loading an **ACTION PROVING DUMMY**, then a live round, into the magazine. Only after several tests have been conducted in this manner should additional rounds be placed in the magazine and fired.

BROWNELLS[®]

AR-15

CARRIER KEY STAKING TOOL

#080-000-638



READ & FOLLOW THESE
INSTRUCTIONS

BROWNELLS[®]

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