



This specially designed punch removes the bolt catch pin from the lower receiver magazine housing with virtually no chance of damaging either part. Please note there is a projection, or vertical ridge, slightly forward of the bolt catch, over the magazine well. If the bolt catch pin is driven FORWARD, toward the muzzle end of the rifle, in an effort to remove the bolt catch, the bolt catch pin WILL strike this vertical ridge and scar the magazine housing and/or bend the bolt catch pin. The bolt catch pin MUST ALWAYS be removed by driving it to the REAR of the receiver. The Brownell AR-15/M16 Bolt Catch Pin Punch is designed to remove this pin and avoid damage to the magazine well housing.



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

Following the manufacturer's instructions, disassemble the rifle to the point that the lower receiver is detached from the upper receiver group.

Secure the lower receiver in a vise with padded jaws in such a way that you have unrestricted access to the bolt catch pin on the left side of the receiver. One note of caution: **BE VERY CAREFUL WHEN USING THE VISE THAT YOU DO NOT SQUEEZE OR COLLAPSE THE LOWER RECEIVER HOUSING!** Position the Brownell AR-15/M16 Bolt Catch Pin Punch on the forward, or muzzle, end of the bolt catch pin, parallel to the surface of the magazine well housing. The punch should be placed so the relieved, or flat area of the punch clears, or extends over, the magazine well housing projection. Use a suitable, small hammer to drive the bolt catch pin to the rear and out.

Please note the bolt catch pin is a roll pin. Ideally, a roll pin punch would be used when removing this pin. However, because of the construction of the magazine well housing and the amount of material that must be removed from the punch body for clearance, a modified, flat-faced punch must be used to make the bolt catch pin punch. Be very careful to avoid damaging the roll pin during removal. Reinstall the bolt catch pin using a $\frac{3}{32}$ " roll pin punch. Since the pin will be driven in from the butt end of the receiver, there is ample clearance for the roll pin punch. Use the bolt catch pin punch **ONLY** when removing the bolt catch pin. Do not use it for installing the pin.

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/M16 BOLT CATCH PIN PUNCH

#080-216-012



READ & FOLLOW THESE
INSTRUCTIONS

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