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TECHNICAL NOTE 75: INSTALLATION OF ARMALITE'S® AR-50™ / AR-50A1™ SIGHT RAIL KITS (P/Ns AR500361, 50809330KIT. AND AR500365)

“NOTE: Please read these instructions thoroughly to determine if you are comfortable with the installation tasks. If you would like our Service Department to install this kit into your firearm, please contact our sales department at sales@armalite.com. Kit installation by our Service Department typically require less than one hour of labor.”

1. KIT CONTENTS

The ARMALITE® AR-50™ Sight Rail Kits include the following components:

- 5/32” ALLEN WRENCH (P/N AR50122)
- AR50 SIGHT RAIL SCREW (4 included) (P/N AR50116)
- PERMATEX THREADLOCKER, BLUE (P/N 19960)

And ONE of the following sight rails:

- AR-50 15 MOA SIGHT RAIL (P/N AR500360 with Kit P/N AR500361).
- AR-50 30 MOA SIGHT RAIL (P/N 50809330 with Kit P/N 50809330KIT).
- AR-50 50 MOA SIGHT RAIL (P/N AR500364 with KIT P/N AR500365).

Make certain that your kit contains all of these components.

2. APPLICABILITY OF THE AR-50™ SIGHT RAIL

ArmaLite's® AR-50™ Sight Rails are designed to be precisely, yet easily, fitted to the receiver on any AR-50™ or AR-50A1™ Rifle. The sight rail features a top surface bearing a MIL STD 1913 Picatinny Rail and a bottom surface with a recoil lug and two bearing pads.

Three sight rails are available: one with 15, one with 30, and one with 50 minutes of slope built into the sight rail. Using most standard scopes, the 15 MOA sight rail will be appropriate for shooting up to 1000 yards, the 30 MOA sight rail between 500 and 1500 yards, and the 50 minute sight rail between 1,000 and 2,000 yards. However, your particular rifle/scope combination may dictate a different choice of Sight Rail.

The AR-50™ sight rail uses unusually large anchor screws. In addition, the ingenious design of the sight rail keeps recoil loads from stressing the screws and possibly shearing them off. The recoil lug of the sight rail, engaging the recoil slot of the receiver, take all recoil loads, and the screws are only used to hold the sight rail against the receiver. The ArmaLite® sight rail is designed to assure a flat rail interface for the scope rings or mount.

3. INSTALLING A SIGHT RAIL ON AN AR-50™ SERIES RIFLE

a. SAFETY FIRST!!!!!! PLACE THE SAFETY IN THE SAFE POSITION. OPEN THE BOLT AND INSPECT THE CHAMBER TO MAKE SURE THAT THE RIFLE IS UNLOADED.

b. Degrease the four screw holes in the top of the receiver and the four screws using acetone, alcohol, or any other cleaner that does not leave an oily residue.

c. Set the “T” rails of the base into the “T” slots in the top of the receiver.

d. Apply blue serviceable locking liquid to the four screws.

e. Install all four screws loosely and then tighten evenly until the gap under the mount just barely starts to close. Back off if the top of the rail distorts. Allow 24 hours for the locking liquid to set.