



October 8, 2009 Rev 6

## **TECHNICAL NOTE 76: INSTALLATION OF ARMALITE'S® AR-30™ SIGHT RAIL KIT (P/N 30910000KIT)**

“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-30™ Kit includes the following components:

- 5/32” ALLEN WRENCH (P/N AR50122)
- AR30 SIGHT RAIL SCREW (3 included) (P/N 30935005)
- AR30 SIGHT RAIL SCREW (1 included) (P/N 30920000)
- AR-30 10 MOA SIGHT RAIL (P/N 30910000)
- PERMATEX THREADLOCKER, BLUE (P/N 19960)

Make certain that your kit contains all of these components.

### **2. APPLICABILITY OF THE AR-30™ SIGHT RAIL**

ArmaLite's® AR-30™ Sight Rail is designed to be precisely, yet easily, fitted to the receiver on any AR-30™ 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.

The AR-30™ Sight Rail uses unusually large anchor screws. In addition, the ingenious design of the base keeps recoil loads from stressing the screws and possibly shearing them off. The recoil lug of the base, engaging the recoil slot of the receiver, take all recoil loads, and the screws are only used to hold the base against the receiver. The ArmaLite® base is designed to assure a flat rail interface for the scope rings or mount.

### **3. INSTALLING A SIGHT RAIL ON AN AR-30™ 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” rail of the base into the “T” slot in the top of the receiver.

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

e. **INSTALL THE SHORT SCREW IN THE FRONT HOLE IN THE RECEIVER.** Then install the other three screws in the other three holes. Tighten 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.

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*THE WIZ*