



Just Right Carbines

Bolt Replacement Instructions



The J R Carbine

Proudly Made in the USA!

!! WARNING: Read these instructions CAREFULLY BEFORE you begin working on this firearm.

These directions are intended for individuals who possess at least intermediate mechanical skills. If you have any concerns for your mechanical abilities please call Just Right Carbines (877-778-8452) for assistance. Otherwise, Just Right Carbines recommends using a qualified gunsmith for all repairs, bolt replacements and/or caliber conversions.

1. Tools you will need:

- Buttstock buffer tube wrench
- 9/64-inch hex (Allen) wrench
- Gun vise, padded vise or other proper work surface
 - Note: Just Right Carbines recommends you use a gun vise or other padded vise to disassemble your JR Carbine to convert calibers or for other maintenance. However, if you are particularly mechanically inclined you can perform most work on your JR Carbine without a vise if you use a properly padded work surface.

2. Unload your JR Carbine before attempting any disassembly.

- Switch the safety lever from FIRE to SAFE.
- Pull the bolt handle rearward and lock it into the bolt catch.
- Press the magazine catch button and remove the magazine.
- Visually inspect the chamber and ensure it is empty.

3. Disassembly:

- Clamp the carbine firmly in your gun vise or padded vise. Ensure it is fully immobilized and in a stable position. Pad the vise as necessary to avoid marring the carbine's finish
[Note: Throughout the disassembly and reassembly process you may need to reposition and reclamp it one or more times to facilitate the process.]
- Remove the Buttstock.
 - Ensure the bolt is unlocked and is fully forward.
 - Using the buttstock portion of the combination wrench (the smaller of the two spanner wrench sections), loosen the buttstock castle nut counter-clockwise when viewed from the rear looking forward.
 - Unscrew the castle nut as far as possible.
 - Loosen the receiver plate and slide it rearward until it is against the buttstock castle nut.
 - Unscrew the entire buttstock assembly from the receiver by turning it counter-clockwise when viewed from the rear looking forward.
[Note: Be careful to keep the buffer, buffer spring, nylon disk, and rubber bumper from falling out of the buttstock when you remove it from the receiver. Set the buttstock assembly aside.]
- Remove the bolt:
 - Pull the bolt handle all the way to the rear.
 - Using a 9/64-inch hex wrench, loosen and unscrew the bolt handle mounting screw.
 - Remove the bolt handle through the circular port at the rear end of the bolt handle slot in the receiver. Set aside for reassembly.
 - Pull the bolt assembly rearward out of the receiver. Set aside for return to Just Right Carbines.

4. Reassembly with new bolt

- Install the new bolt:
 - Face the side of the receiver you want the bolt handle on upward.

- Ensure the hammer is still cocked from when you removed the old bolt. If it is not, carefully reach into the side of the receiver with a small diameter punch or screwdriver and manually push the hammer to the rear until it cocks.
- With the bolt and bolt extension locked together and aligned, insert the bolt into the receiver with the flat rail facing downward toward the trigger assembly.
- The bolt may meet some resistance when it contacts the cocked hammer. Gently tap the rear of the bolt assembly forward past the resistance.
- Align the bolt assembly's bolt handle mounting hole with the circular port at the rear end of the bolt handle slot in the receiver.
- Insert the bolt handle (with the bolt handle mounting screw in place) through the circular port and into the mounting hole.
- Make sure the bolt handle is perpendicular to the bolt assembly. Start the bolt handle mounting screw by hand and screw it all the way in until it is fully seated and just begins to get snug. **DO NOT FORCE!**
- **[Note: If the bolt handle mounting screw does not start easily, recheck to ensure the base of the bolt handle is firmly against the bolt assembly and perpendicular. Once the bolt handle is properly positioned the mounting screw should start easily.]**
- Before fully tightening the bolt handle mounting screw you should cycle the bolt back and forth to ensure there is no binding. If there is any binding, or if the bolt does not cycle freely (aside from slight pressure from the cocked hammer), recheck the bolt handle to ensure it is mounted properly, as described above.
- Once the bolt handle and bolt assembly operate freely within the receiver, finish tightening the mounting bolt hand tight.
- Reinstall the buttstock:
 - Ensure the bolt is unlocked and is fully forward.
 - Before you reinstall the buttstock assembly make sure all of its parts are properly installed within it and it is complete.
 - **[Note: If your bolt change kit came with a buffer different than the one in your carbine, install the new buffer in the buttstock assembly before reinstalling the buttstock assembly in your carbine.]**
 - Screw the entire buttstock assembly into the receiver by turning it clockwise when viewed from the rear looking forward. Keep turning until it will not go any further.
 - The buttstock must be properly aligned with the receiver so that when you slide the receiver plate forward it fits into the detent in the end of the receiver. If it is not, unscrew it less than one full turn – just enough to properly align the two and permit proper fitting of the receiver plate into the receiver.
 - With the buttstock properly aligned to the receiver and the receiver plate properly fitted and flush with the end of the receiver, tighten the buttstock castle nut clockwise – finger tight only – when viewed from the rear looking forward.
 - Using the buttstock portion of the combination wrench (the smaller of the two spanner wrench sections), tighten the buttstock castle nut hand tight.

5. Function Check

- Examine your reassembled carbine visually to ensure that all parts appear to be in their proper position.
- Cycle the bolt manually to ensure proper movement. Dry-fire your carbine to test function of the safety and fire controls.

- If you encounter any difficulties when performing this caliber conversion, or if you are unsure of the results of your carbine conversion, call Just Right Carbines (877-778-8452) for assistance or take your carbine to a qualified gunsmith for examination and evaluation.

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