

C & I short stroke kit installation instructions

This kit will not do an action job, change the trigger pull, or adjust the hammer spring. The 3rd generation kit will give you a shorter stroke by about 2 1/4" than stock. The 4th and 5th generation kits will give you a stroke of about 4 1/8" which is the shortest stroke allowed by SASS rules. Short stroke kits are Patented.

Disassemble the receiver. Loosen the lever and carrier spring screws, then remove cover plates, links, lever and lifting arm. Do not take out the bolt.

If you have a stock brass carrier you must modify it per the instructions on page 4. If you have a C&I aluminum carrier no modification is necessary. Install the carrier, new lifting arm and lever with the lever screw.



Manually push down on the lifting arm until it bottoms out on the receiver. Check to see that the carrier is approximately flush with the bottom of the receiver (see picture above). If your rifle is a large pistol caliber, it is better if the carrier (both brass and aluminum) is a little below the receiver.

If the carrier is high in the receiver, then the lifting arm needs adjusted by putting more arc in the arm. If the carrier hangs down below the receiver, then the lifting arm needs to be straightened out. Not all guns will need the next step but most will.



It is important to match the lever to the receiver. The goal is to have about .002-.005" of play between the lever and lifting arm when the lever is closed (see picture above left) or touching the lower tang (see picture below).

NOTE on 4th gen kits: DO NOT BEND LEVER. It will not bend, only break.

If the lever doesn't touch the lower tang, take a small amount of material off of the leading edge with a grinder between the pin and screw holes.

3rd and 5th gen kits ONLY: It may take several attempts at bending the lever to get a proper fit. Hold it in a vise and gently pull down (see picture above right). It doesn't take much to move it. Put the lever back in and make sure that the lever touches the lower tang (see picture below).



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Now install the new links in the gun, lube and/or oil as necessary. Put the covers back on using cover screws. Adjust carrier and lever springs as needed.



Cycle the lever and check the clearance between the bolt and carrier. Correct timing is achieved when the carrier just misses the bolt as shown in the pictures above. If the carrier hits the bottom of the bolt, you need to remove a small amount of material from the pad of the lifting arm (see picture below). A file, sander or grinder may be used to SLOWLY take away the SMALL amount of material to adjust the timing.

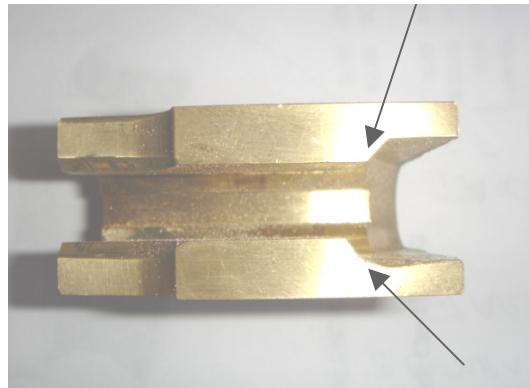


Please note: If you have our instructional DVD on how to take your 66/73 apart, you will notice that the links used at that time were different than your kit as we made a change on the right rear link. If your rifle was made after 2008, your bolt will come apart differently than our DVD also.

Be sure your ammo length is at least 1.45" or the gun may jam or not feed properly.

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Original Brass Carrier modification



If you are installing our short stoke kit and you have an original brass carrier, you will need to modify it. Use a dremel tool (or equivalent) to take a small amount of material off the areas that the arrows point to in the picture. Both sides should look like the one on the bottom (cut out and rounded). If you have an aluminum carrier from another company, it generally will NOT work with our short stroke kits.

If you have any questions, problems, or comments, please email "Jim Bowie" at jimbowie4775@gmail.com.

Warning: A competent gunsmith only should install this kit. This product is sold as is and without any warranty. No liability is expressed or implied for damage or injury which may result from the improper installation or use of this product.

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