

**SAG AK MK2 FREEFLOAT CHASSIS
FOR KALASHNIKOV RIFLES
INSTALLATION MANUAL**



Prague

2018

www.sureshot-armament.com

Thank you for purchasing SAG AK MK2 FREEFLOAT CHASSIS.

We are proud of our product and hope you will like the way your AK feels and shoots after upgrading it with our kit.

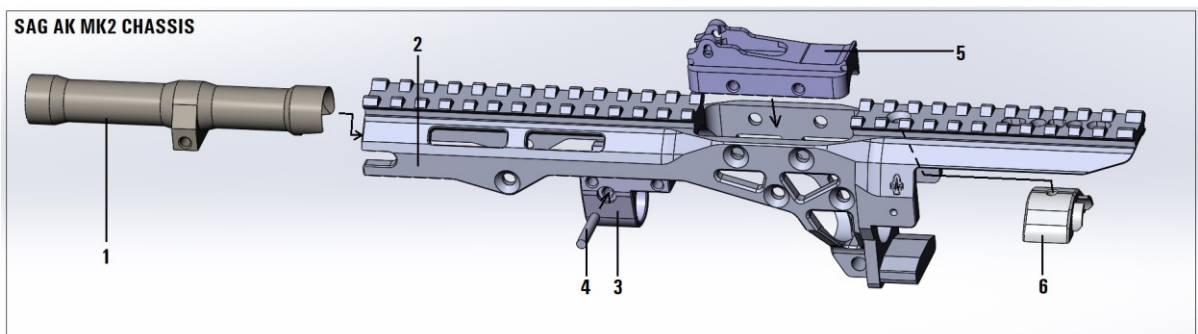
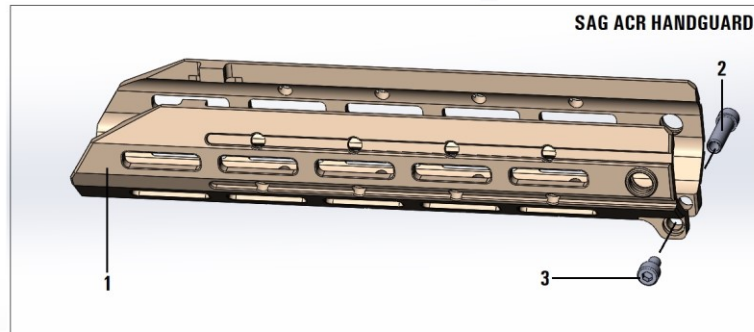
Before beginnings of installation MAKE SURE YOUR WEAPON IS UNLOADED and there is NO AMMO lying around. YOU ARE THE RESPONSIBLE PERSON FOR YOUR OWN SAFETY.

FOR INSTALLATION YOU WILL NEED

1. A CENTRE PUNCH \ SET OF DRIFTS
2. A HAMMER
3. A SET OF FILES \ DREMEL TOOL
4. WELL EQUIPPED WORKING SPACE WITH A VISE
5. (preferably) THE HUDRAULIC PRESS

If you are not sure you can make installation yourself please call your gunsmith.

IN THE PACKAGE



Common set consists of 2 boxes

Box #1 – SAG ACR HANDGUARD

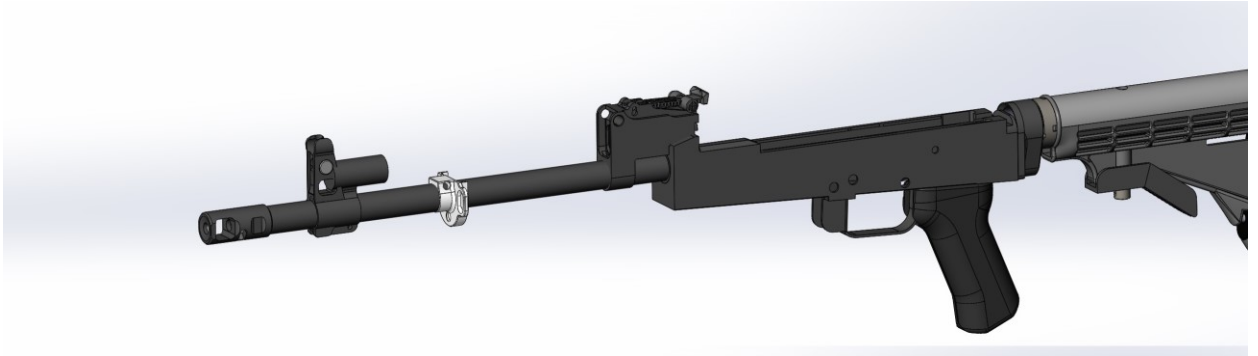
1. Bushmaster ACR One piece milled Handguard with M-LOK interface
2. Handguard pin
3. Fixing screw M5 DIN912

Box #2 – SAG AK MK2 CHASSIS

1. Gas tube
2. Upper
3. Barrel Nut
4. Barrel Nut Pin
5. Rear sight base
6. Top cover insert
7. (not shown) M5x10 DIN 7991 screws

STEP 1

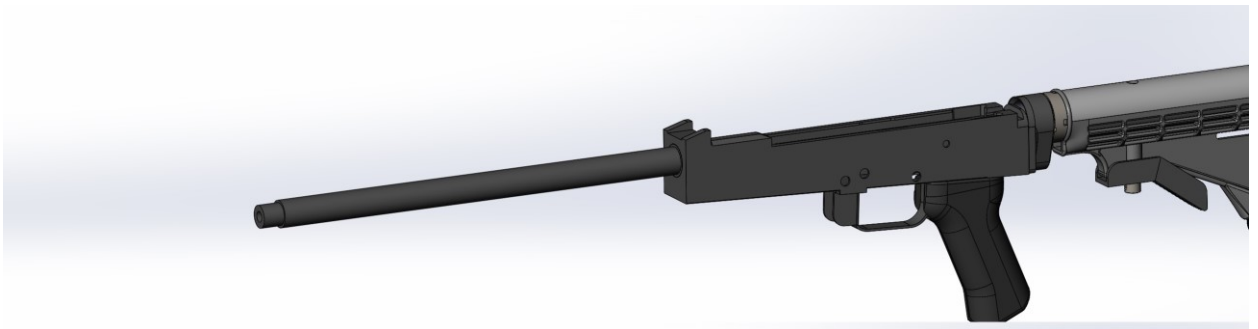
Make full partial disassembly of the rifle.



STEP 2

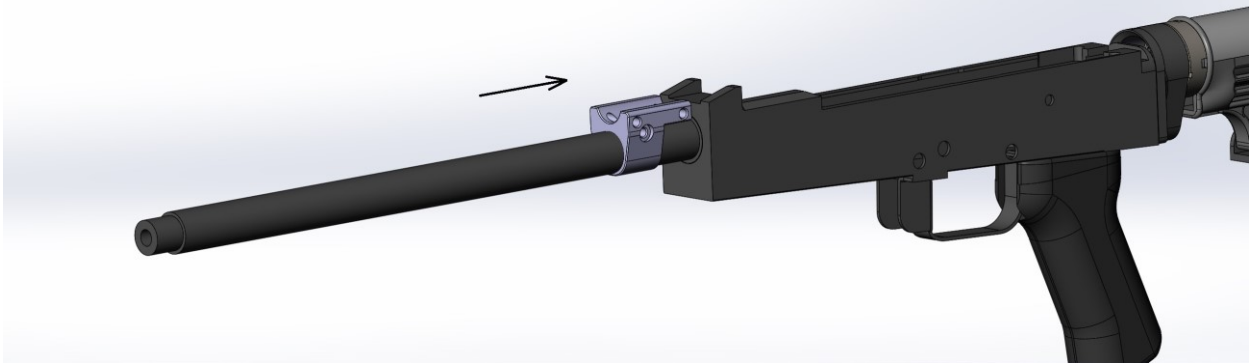
Remove everything from the barrel:

- Muzzle brake (could be mounted on barrel or on the front sight base)
- Front sight post (punch 2 pins sideways then remove the post)
- Gas block (punch 2 pins sideways then remove the gas block)
- Front base handguard bracket (slide it forward)
- Rear sight post (punch one pin sideways then remove sight post)



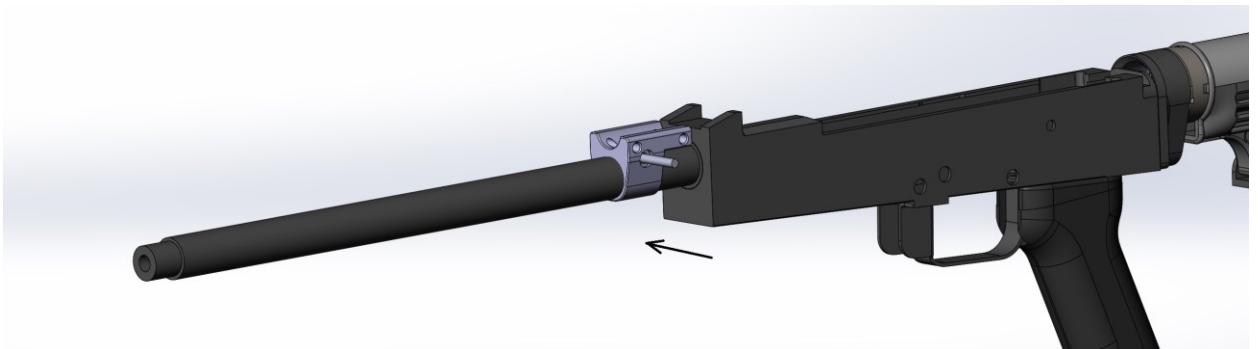
STEP 3

Pressfit the provided barrel nut on to the barrel till the side hole for fixing pin will not align with the cutout on the barrel left after you removed the rear sight post.



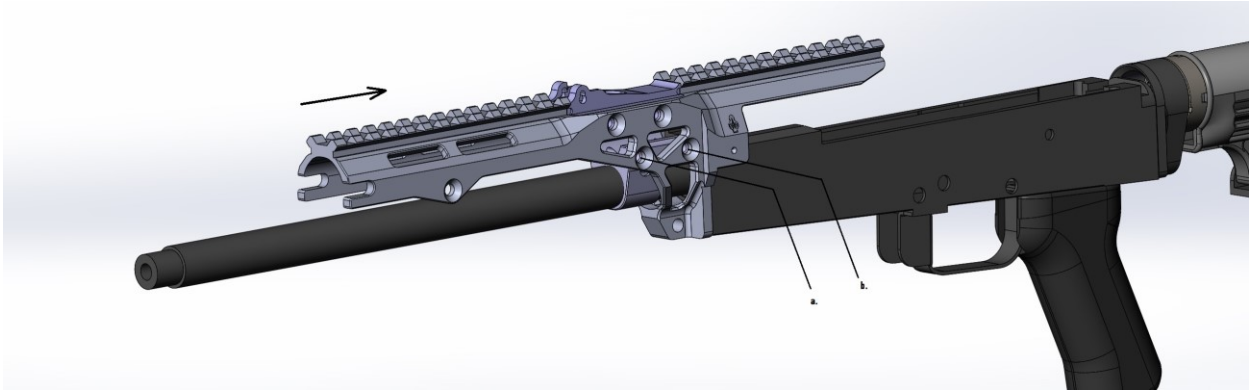
STEP 4

Pin the barrel nut with the barrel nut pin

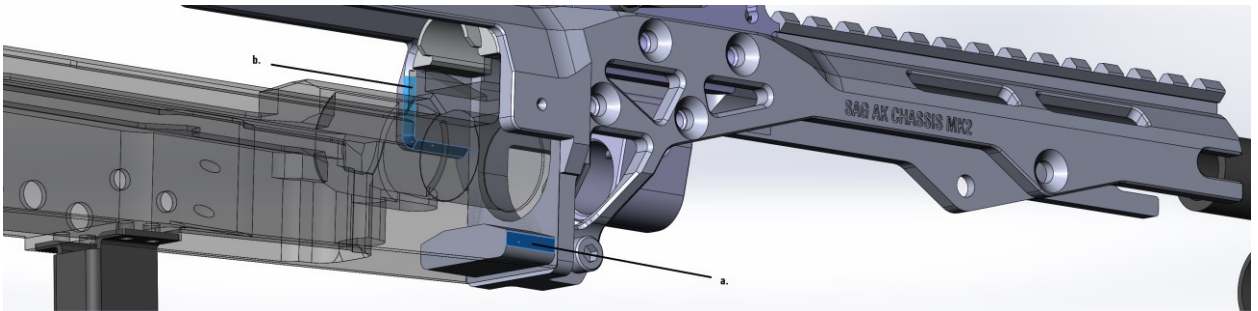


STEP 5

Slide assembled upper (with iron sight base and dustcover insert) on to the barrel nut. Fix it with 2 front screws (a.) and two rear screws (b.) to the Barrel nut. While fixing upper with crews do control that upper should be parallel to the bore or have slight incline forward)

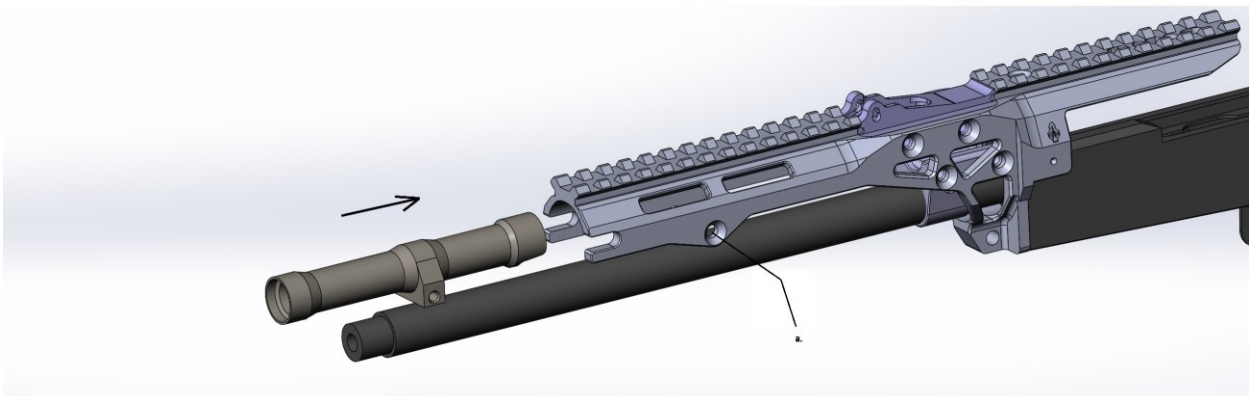


In case of Chinese AK or Vepr (RPK) rifles with wider front trunnion and trickier receiver walls you will need to file down areas on the “tooth” (a.) and “ears” (b.) to fit.



STEP 6

Slide gas tube from the front inside the upper and fix it to the upper with 2 screws (a.)



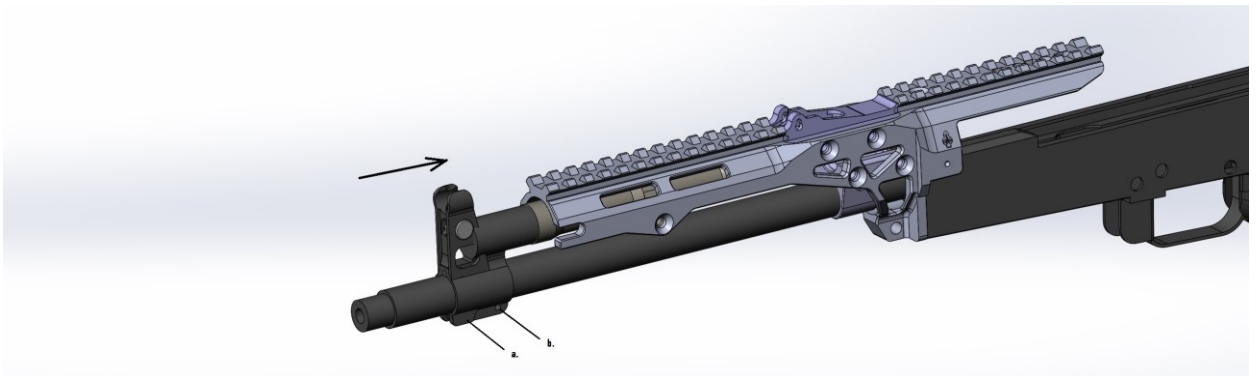
STEP 7

Make sure fixing is not stiff and allows gas tube rotate on the screw axis up and down to compensate barrel harmonics during the shots string.



STEP 8

Reinstall original gas block and fix it to the place by two pins which you removed during STEP2. If you opt for aftermarket adjustable clamp-on gas block – fix it to the place in accordance with gas block installation instruction



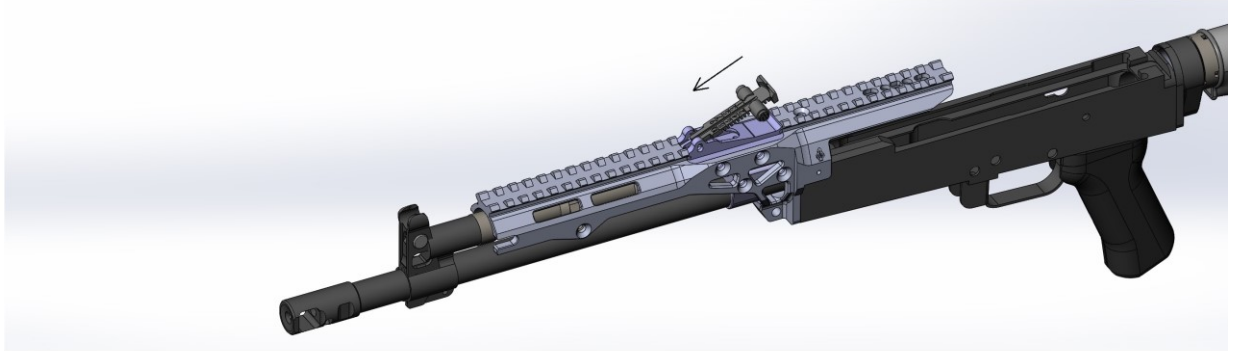
STEP 9

Reinstall front sight post (if it is a separate piece) and a muzzle brake. Do it in reverse to your operations on STEP2



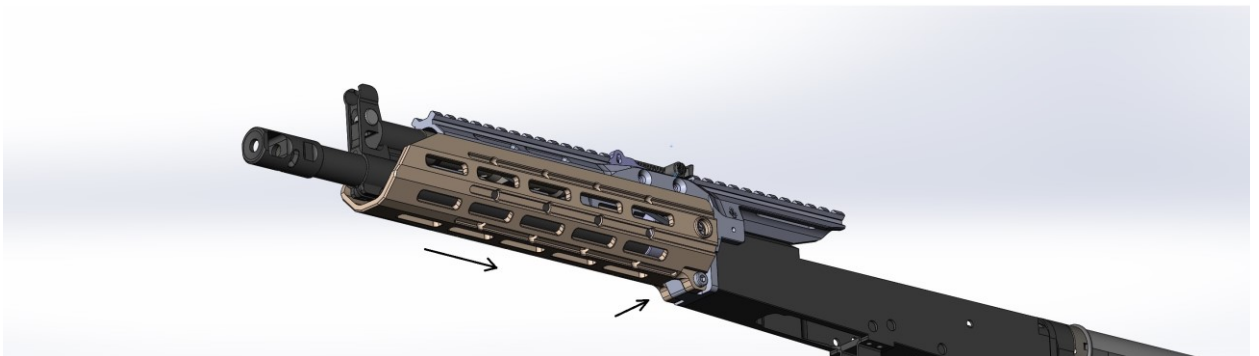
STEP 10

Remove the rear sight leaf and the rear sight leaf spring from original sight post and install it inside the rear sight base on the chassis. Watch appropriate Video instruction: <https://www.youtube.com/watch?v=RBu0YpfPHyc>



STEP 11

Slide the lower Bushmaster ACR compatible handguard to the upper and fix it with the lower handguard pin. You can use any metal ACR Bushmaster Handguard with Our SAG AK MK2 FREEFLOAT CHASSIS. In case of using ACR Bushmaster Polymer handguard you may need to file down the rear end of handguard to fit.



STEP 12

Insert BCG into place and install the recoil spring. Check the charging function.



STEP 13

Insert top cover. If it tight fit – unscrew the top cover insert from the upper and file it down to fit the front curve of your top cover.



THE INSTALLATION IS NOW COMPLETE

THANK YOU.

TEAM SURESHOT ARMAMENT