

Thank you for your purchase! **More detailed installation instructions are available at our website: [www.BadgerRidgeInd.com](http://www.BadgerRidgeInd.com)**

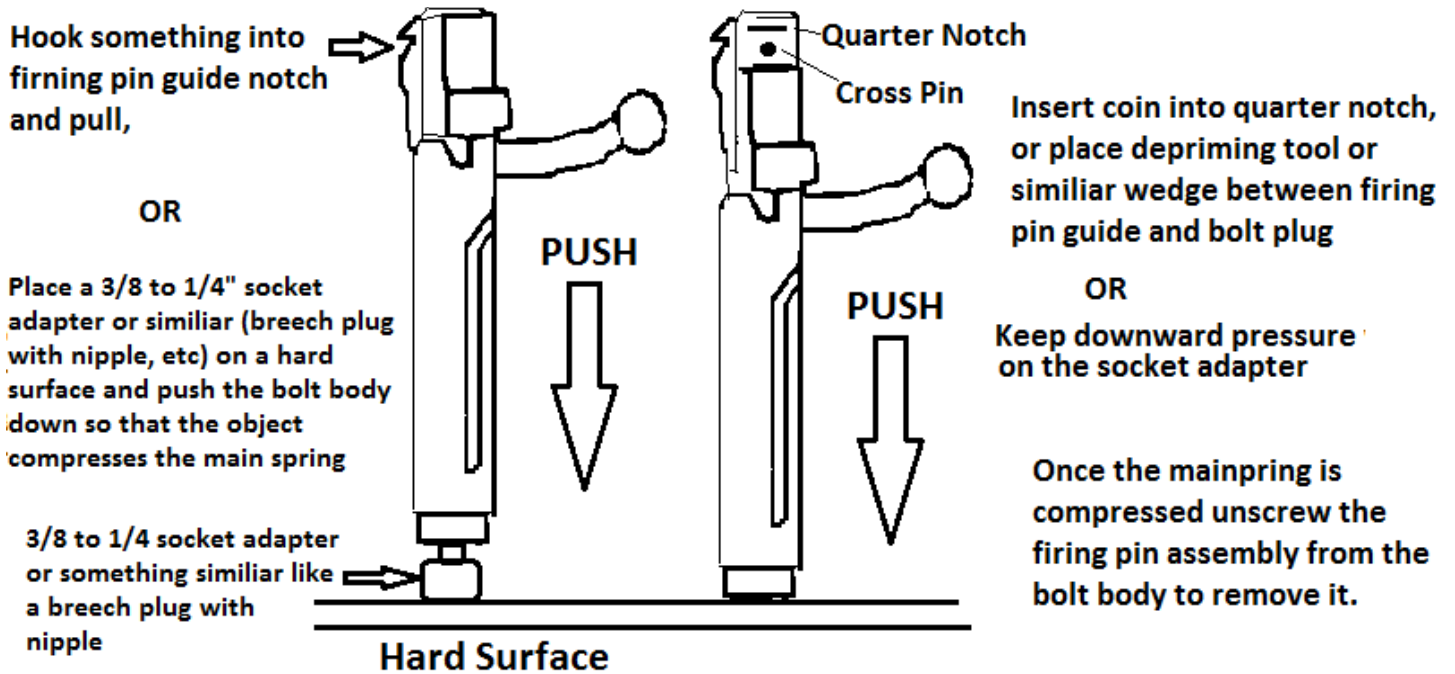


**WARNING:**

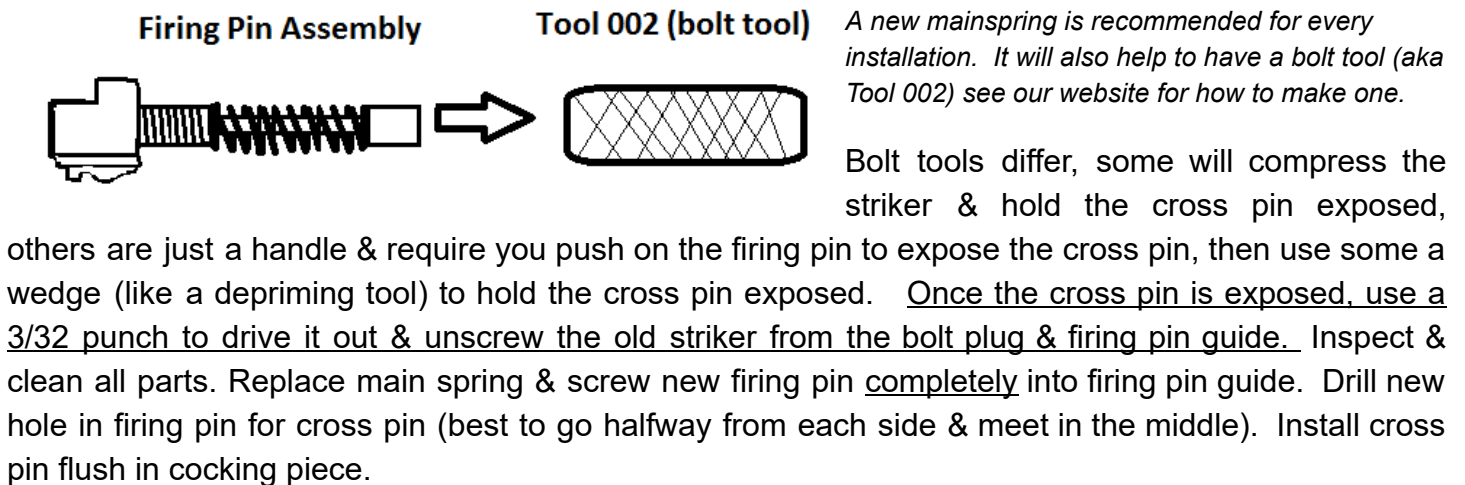
It is our recommendation that you pay Badger Ridge to install, or have a competent gunsmith install our 209 conversion kit. If you chose to do the work yourself, you do so at your own risk. Modifying & inspecting firearms requires the ability to recognize an unsafe component & determine proper effective repairs. Failure to do so may cause death, injury, or damage or loss of property.

**ALWAYS PLACE THE SAFETY ON & UNLOAD/DE-PRIME FIREARMS BEFORE WORKING ON THEM**

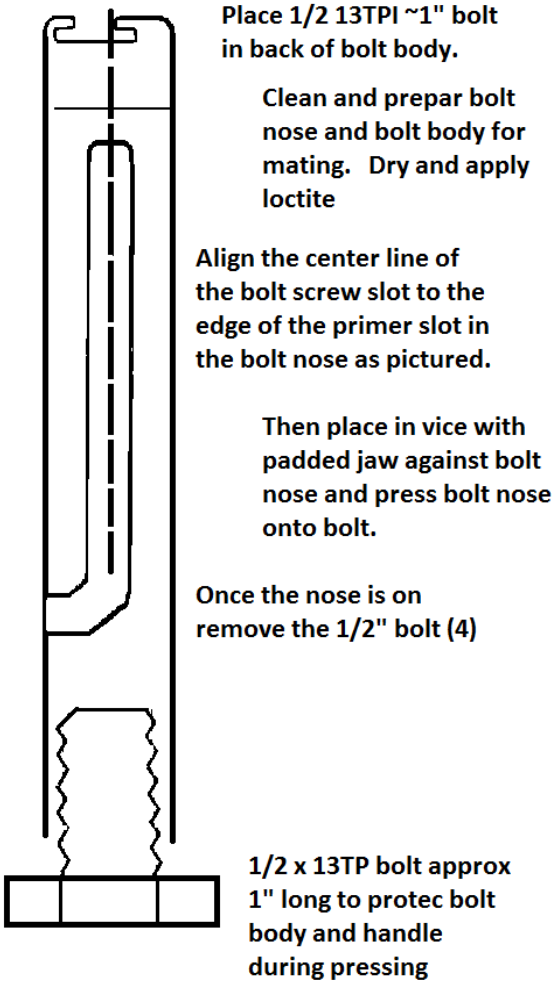
**Step 1: Unload & make safe, then disassemble the OEM Bolt**



**Step 2. Disassemble the firing pin assembly, clean, inspect, & then install the new firing pin**



**WARNING: Failure to properly clean & assemble, recognize or correct a deficiency in any component of the rifle can kill, maim, injure, or damage property. Undertake these procedures at your own risk.**



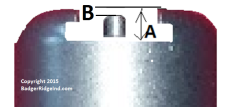
### **Step 3: Clean, prep bolt body, & install bolt nose**

Bolts are commonly neglected & frequently very corroded inside. Thoroughly clean & inspect the bolt body for damage. *It's common to have to replace an entire bolt body if it has been subjected to corrosive elements & neglected, Badger Ridge sells brand new bolt bodies.*

Affix the nose to the body, be sure the primer slot is aligned as depicted! **AGAIN, MAKE SURE THE BOLT NOSE PRIMER SLOT IS ALIGNED AS DEPICTED!!!** Some use thread locker on the nose too.

### **Step 4: File firing pin down to .060 - .050 protrusion**

The firing pin is purposely too long & must be filed down & shaped to properly discharge a 209 primer without rupturing it. Screw the firing pin assembly fully into the bolt body, align the cocking piece to the discharged position & remove the quarter. File the firing pin flush to the top of the bolt nose, remove the firing pin & shape & debur it. Then place back in the bolt & determine protrusion. Then repeat removing, shaping, re-installing & measuring until protrusion is as close to .060" (without going over), but no less than .050" with a flat deburred profile (do not round the face of the firing pin).  $A \text{ minus } B = \text{Protrusion}$



**WARNING: Failure to properly shorten & shape the firing pin can cause slam fires, primer rupturing, failure to fire, hang fires, ballooned primers & other ignition dangers!**

### **Step 5: Lube & Assemble Bolt - Install Bolt & Breech plug**

Once the firing pin protrusion is set, lubricate (dry teflon lube is recommended) & assemble the firing pin to the bolt body (cocked). Discard OEM breech plug. Ensure the breech of the rifle is clean & free of debris. Place a small amount of anti-seize grease on vent liner's threads & thread into Badger Ridge breech plug. Snug with hex wrench & finger pressure. Ensure no anti-seize is on breech plug face nor in the flash chamber or channel. Place breech plug into the action & slide forward towards breech. Apply a small amount of anti-seize to first few threads being careful not to get any on the breech face nor in the primer pocket nor flash channel. Snuggly torque Badger Ridge breech plug into breech per OEM specifications. Place bolt into action, & affix with bolt screw per OEM directions. A small amount of anti seize in the bolt guide notch will aid in working the bolt. Tune breech plug to your chosen 209 primers with a Letter "C" drill bit as needed. Less tuning is better than over-tuning: over-tuning can cause leaks or ballooning primers. Remember: primers go in the slot on the nose of the bolt, and the bolt feeds them into the breech plug.

Beware: Anti-seize in the flash channel or breech face can cause hang or misfires.