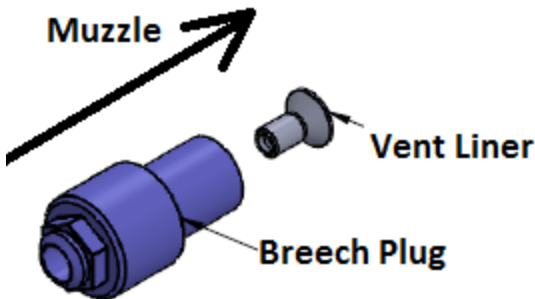


INSTALLATION and USE of Converted bolt and Badger Ridge Hunter 209 Conversion Kit (these instructions assume the bolt nose conversion has been completed by Badger Ridge or a competent gunsmith)

- 1: Ensure the rifle is on "Safe", deprimed, and unloaded prior to working on it.
- 2: Per the Remington Owner's Manual (a copy is available at [www.BadgerRidgeInd.com](http://www.BadgerRidgeInd.com)) remove the old breech plug and discard. **The modified bolt will not work with the original breech plug.**
- 3: Clean the rifle and ensure the breech of the rifle is clean and free of debris.



4: Place a very small amount of anti-seize grease on vent liner's threads and thread into Badger Ridge breech plug. Snug with 7/64 hex wrench and finger pressure. Ensure no anti-seize is on breech plug face nor in the flash chamber or channel of the vent liner.

5: Place the Badger Ridge Hunter Breech plug in to the action with the vent liner towards the muzzle and slide forward towards breech. Apply a small amount of anti-seize to first few threads of the breech plug being careful not to get any on the breech face nor in the primer pocket nor flash channel.

- 6: Move the Badger Ridge Hunter Breech plug into the breech and start the threads into the breech threads with finger pressure only.
7. Once started and threaded in completely with gentle finger pressure, torque Badger Ridge breech plug into breech per the Remington Owner's Manual with the standard breech plug wrench. (A 7/16 socket on an extension will typically work as well)
8. Place bolt into action, and affix bolt screw per Remington Owner's Manual directions. A small amount of antiseize in the bolt's guide notch will aid in working the bolt. Before using the rifle, make sure the bolt closes smoothly. If it engages the breech plug and does not close smoothly, the breech plug is most likely not safely and fully seated into the breech!!! It must be rectified before using the rifle or feeding primers!

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

**WARNING: Failure to properly clean and assemble, recognize or correct a deficiency in any component of the rifle can cause death, injury or property damage. Under take these procedures at your own risk.**

*Note: 209 shotshell primer dimensions vary slightly between manufacturers. Therefore your breech plug's flash chamber is a bit undersized for some primers. It may be necessary to ream the plug with a letter 'C' drill bit using only finger pressure in order to allow your chosen brand of 209 primers to feed and swage into it properly. Typically no more than 1/8" depth with the "C" drill bit is required.*

**Breech plug maintenance.** After firing 209 primers, burnt priming compound will coat the flash chamber and the flash hole of the Vent Liner. To clean, remove the breech plug and ream the flash chamber gently with a just undersize drill bit (7/32). Use torch tip cleaners to clean the vent liner. Scrub and remove all fouling with the appropriate solvents, and place anti seize on all breech plug/vent liner threads before using the breech plug.

DO NOT STORE YOUR RIFLE WITH THE BREECH PLUG INSTALLED, CHARGED, UNCLEARED, NOR UNPROTECTED BY GUN OIL OR BORE BUTTER. Even the high quality 416 stainless your Badger Ridge Hunter 209 conversion kit is made out of will corrode if not properly cared for. Remember Blackhorn 209 cleans up with standard gun cleaning products (Hoppe's #9 and gun oil), while all other black powder substitutes typically require organic cleaning solvents (Windex, soap, water) and organic oils/pastes (Bore butter).