

## ASSEMBLING THE MAGAZINE CATCH COMPONENTS

1. Insert the magazine catch axle (24) into the frame (1) from either side, tapping it in partially using a hammer (the axle should not protrude inside the frame, see Figure 65).
2. Insert the magazine release button (21) into the frame (1) centering it (see Figure 66).
3. Position the magazine catch (22) inside the frame (oriented as shown on Figure 64 - catching ledge towards the top and pointing into the magwell) from the top using needle nose pliers and align it with the hole while inserting a pin punch in the hole opposite from the partially inserted magazine catch axle (24). Tap the axle slightly so it inserts into the hole of the magazine catch (the axle should not protrude into the slot in the center of the magazine catch (22) (see Figure 69).
4. Place the magazine catch spring (23) within the magazine catch (22) slot with its legs pointing upwards using needle nose pliers (see Figure 68) and retract the punch just enough to insert it in the spring opening then push the punch through the spring, to hold it in place (see Figure 69, one leg should be against the frame (1) and the other protruding through the magazine catch (22) slot into the magwell). The punch is used as a slave pin to temporarily hold one side of the magazine catch (22) and its spring (23).
5. Carefully tap the magazine catch axle (24) all the way into the frame (1) using the hammer while the punch is being expelled from the other side of the frame (1). Use the punch and a hammer to finalize its seating (see Figure 70).
6. Use a small flathead screwdriver (preferably with a notch) or a spring aligner tool to reach the magazine catch spring (23) from the top of the frame (1) and move its leg to position it behind the magazine catch (22) (see Figure 71). Note there is a notch cut in the magazine catch to allow the spring leg to be pushed behind the catch.



CHECK: Verify the magazine catch axle is positioned in the center of the frame, correct its position using a pin punch if necessary. Depress the magazine release button alternatively from one and the other side of the frame to check it is moving the magazine catch.

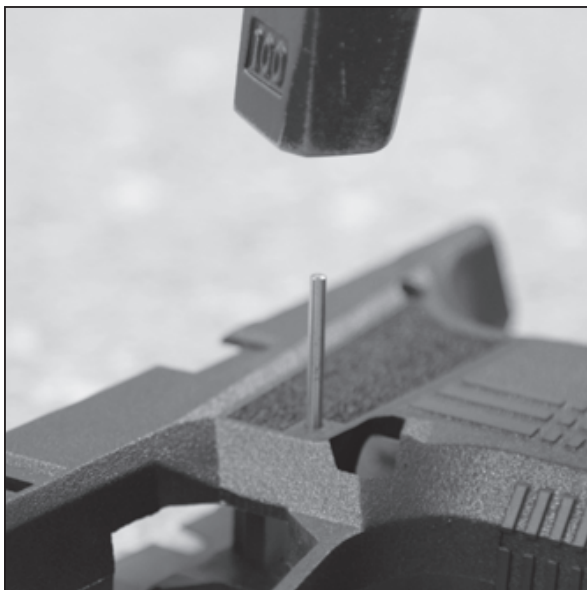


Figure 65 — Partially inserting the magazine catch axle into the frame

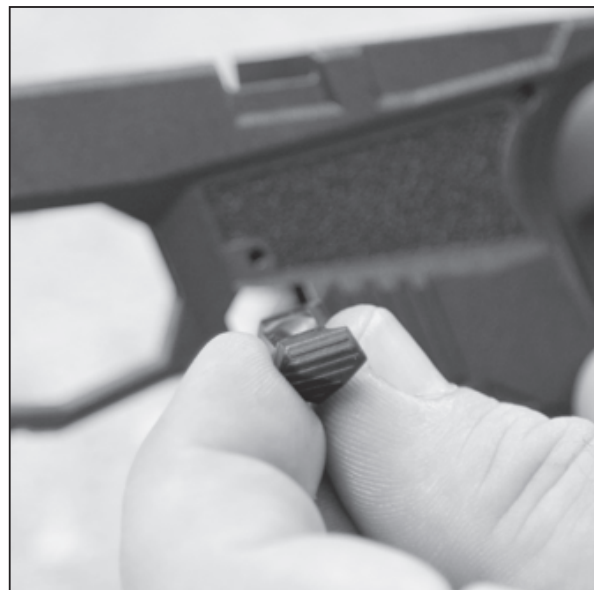


Figure 66 — Inserting and centering the magazine release button in the frame

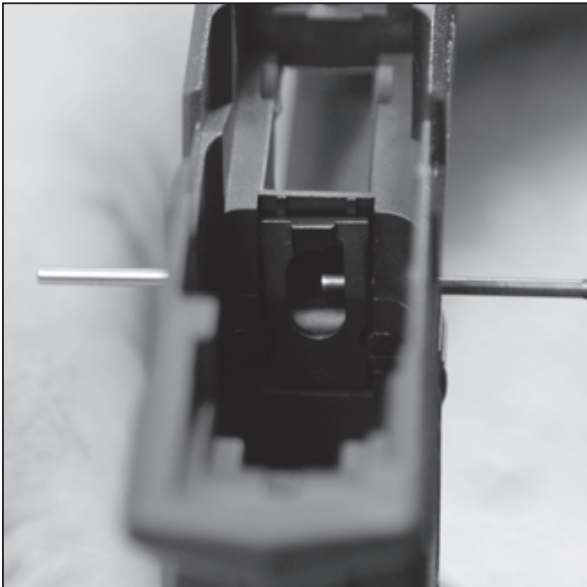


Figure 67 — Placement of the magazine catch in the magwell with the axle and the punch holding it in place from either side



Figure 68 — Placing the magazine catch spring inside the magazine catch slot



Figure 69 — Insert the punch through the spring to hold it in place

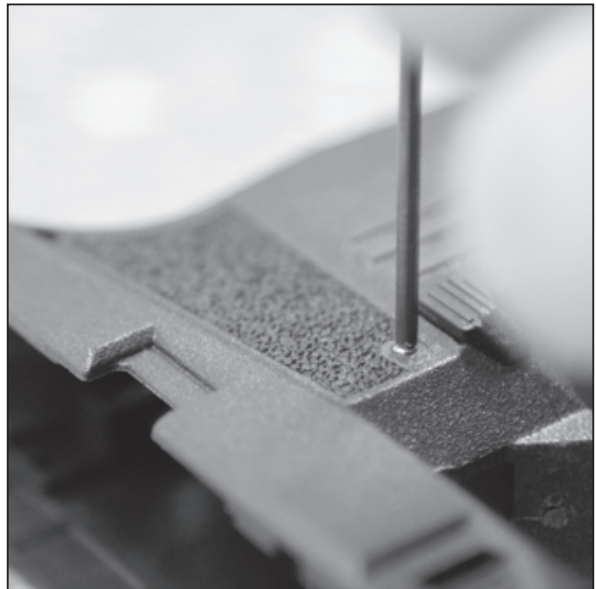


Figure 70 — Using the punch to seat the magazine catch axle centered in the frame



Figure 71 — Pushing the magazine catch spring into position through a notch in the magazine catch