

# Just Right Carbines

## Caliber Conversion Instructions



## The J R Carbine

# Proudly Made in the USA!

**!! WARNING: Read these instructions CAREFULLY BEFORE you begin working on this firearm.**

These directions are intended for individuals who possess at least intermediate mechanical skills. If you have any concerns for your mechanical abilities Just Right Carbines recommends using a qualified gunsmith for all repairs and/or caliber conversions.

## 1. Tools you will need:



Figure 1

- Combination barrel/forend/buttstock wrench (Figure 1 – included with caliber conversion kit), OR:
  - AR-15 compatible barrel nut wrench,
  - Quad forend wrench, and
  - Buttstock buffer tube wrench
- 9/64-inch hex (Allen) wrench – included
- 1/8-inch hex (Allen) wrench – included
- 1/16-inch hex (Allen) wrench – included
- Gun vise, padded vise or other proper work surface
  - Note: Just Right Carbines recommends you use a gun vise or other padded vise to disassemble your JR Carbine to convert calibers or for other maintenance. However, if you are particularly mechanically inclined you can perform most work on your JR Carbine without a vise if you use a properly padded work surface.

## 2. Unload your JR Carbine before attempting any disassembly.

- Switch the safety lever from FIRE to SAFE.
- Pull the bolt handle rearward and lock it into the bolt catch.
- Press the magazine catch button and remove the magazine.
- Visually inspect the chamber and ensure it is empty.

### 3. Disassembly:

- Note: Be careful to set aside the caliber-specific items you are removing (barrel, bolt assembly, ejector plate – if applicable, and magazine well) from the carbine to ensure they are not mistakenly reinstalled during the caliber conversion process. You MUST NOT mix and match caliber specific parts. Otherwise, serious injury or death could result!
- Clamp the carbine firmly in your gun vise or padded vise. Ensure it is fully immobilized and in a stable position. Pad the vise as necessary to avoid marring the carbine's finish  
**[Note: Throughout the disassembly and reassembly process you may need to reposition and reclamp it one or more times to facilitate the process.]**
- Remove the Buttstock.
  - Ensure the bolt is unlocked and is fully forward.
  - Using the buttstock portion of the combination wrench (the smaller of the two spanner wrench sections), loosen the buttstock castle nut counter-clockwise when viewed from the rear looking forward.
  - Unscrew the castle nut as far as possible.
  - Loosen the receiver plate and slide it rearward until it is against the buttstock castle nut.
  - Unscrew the entire buttstock assembly from the receiver by turning it counter-clockwise when viewed from the rear looking forward.  
[Note: Be careful to keep the buffer, buffer spring, nylon disk, and rubber bumper from falling out of the buttstock when you remove it from the receiver. Set the buttstock assembly aside.]
- Remove the barrel.
  - Using the quad forend portion of the combination wrench (the larger of the two spanner wrench sections), loosen the quad forend locking ring counter-clockwise when viewed from the rear looking forward.
  - Unscrew and remove the quad forend. Set aside.
  - Using the barrel nut portion of the combination wrench (the portion with the three protruding lugs), loosen the barrel nut counter-clockwise when viewed from the front of the barrel rearward.
  - Unscrew and remove the barrel nut. Set aside.
  - Pull the barrel forward, away from and out of the receiver. You may need to rotate it back and forth slightly to facilitate removal.

- If there are any aluminum shim washers between the barrel flange and the receiver, keep them with the barrel for reinstallation with the barrel at a later time. Set the barrel aside.
- Remove the bolt:
  - Pull the bolt handle all the way to the rear.
  - Using a 9/64-inch hex wrench, loosen and unscrew the bolt handle mounting screw.
  - Remove the bolt handle through the circular port at the rear end of the bolt handle slot in the receiver. Set aside.
  - Pull the bolt assembly rearward out of the receiver. Set aside.
- Remove the ejector plate:
  - [Note: The 9mm and .40S&W models use the same ejector plate. If you are converting from a 9mm to a .40S&W - or vice versa - it is not necessary to change ejector plates. Remove the ejector plate ONLY if you are converting to or from a caliber OTHER THAN 9mm or .40S&W.]
  - Place the receiver with the ejector plate facing upward.
  - Using a 1/16-inch hex wrench, loosen and remove the forwardmost ejector plate mounting screw first. Then loosen and remove the rear mounting screw. Set both aside with the barrel and bolt assembly you just removed.
- Remove the magazine well:
  - Place the carbine with right side of the receiver facing upward.
  - Using a 1/8-inch hex wrench, loosen and remove all three of the take-down screws (two in the trigger assembly, one in the magazine well). Set aside.
  - Pull the trigger assembly and magazine well straight away from the receiver as a unit. Once free of the receiver, pull the magazine well and trigger assembly apart. Set the trigger assembly aside, and set the magazine well aside with the barrel, bolt assembly, and ejector plate you just removed.

#### 4. Reassembly in new caliber

- Before you begin reassembly make sure you have set aside all of the caliber-specific parts you removed from your carbine.
- Install the new magazine well:
  - Mate the trigger assembly and magazine well by fitting the boss on the front of the trigger assembly into the corresponding hole in the magazine well's rear face. **[Note: If you are converting to a .45ACP or .45GAP caliber the boss on the front of the trigger housing may protrude into**

**the center of the magazine well and prevent proper magazine insertion. If so, you should take a file and reduce the overall length of the post until it no longer interferes with magazine. DO NOT REMOVE THE POST ENTIRELY, or you will be unable to reassemble your carbine.]**

- Rotate the two to align their upper sides with one another.
- Make sure the hammer is pulled back in the cocked position.
- Fit the trigger assembly and the magazine well to the receiver, together as one unit.
- Start the three take-down screws into their holes and screw them in all the way. Once all three are screwed into place, snug each of them hand tight with the 1/8-inch hex wrench.
- Install the new ejector plate (if included in conversion kit):
  - Place the receiver with the intended ejection port facing down.
  - Insert the ejector plate straight into the upward-facing ejection port (the side you do NOT want to eject from).
  - Start the two ejector plate mounting screws by hand and screw them in all the way. Once they are both screwed into place, snug each of them hand tight with the 1/16-inch hex wrench.
- Install the new bolt:
  - Face the side of the receiver you want the bolt handle on upward.
  - Ensure the hammer is still cocked. If it is not, carefully reach into the side of the receiver with a small diameter punch or screwdriver and manually push the hammer to the rear until it cocks.
  - With the bolt and bolt extension locked together and aligned, insert the bolt into the receiver with the flat rail facing downward toward the trigger assembly.
  - The bolt may meet some resistance when it contacts the cocked hammer. Gently tap the rear of the bolt assembly forward past the resistance.
  - Align the bolt assembly's bolt handle mounting hole with the circular port at the rear end of the bolt handle slot in the receiver.
  - Insert the bolt handle (with the bolt handle mounting screw in place) through the circular port and into the mounting hole.
  - Make sure the bolt handle is perpendicular to the bolt assembly. Start the bolt handle mounting screw by hand and screw it all the way in until it is fully seated and just begins to get snug. DO NOT FORCE!

**[Note: If the bolt handle mounting screw does not start easily, recheck to ensure the base of the bolt handle is firmly against the bolt assembly and perpendicular. Once the bolt handle is properly positioned the mounting screw should start easily.]**

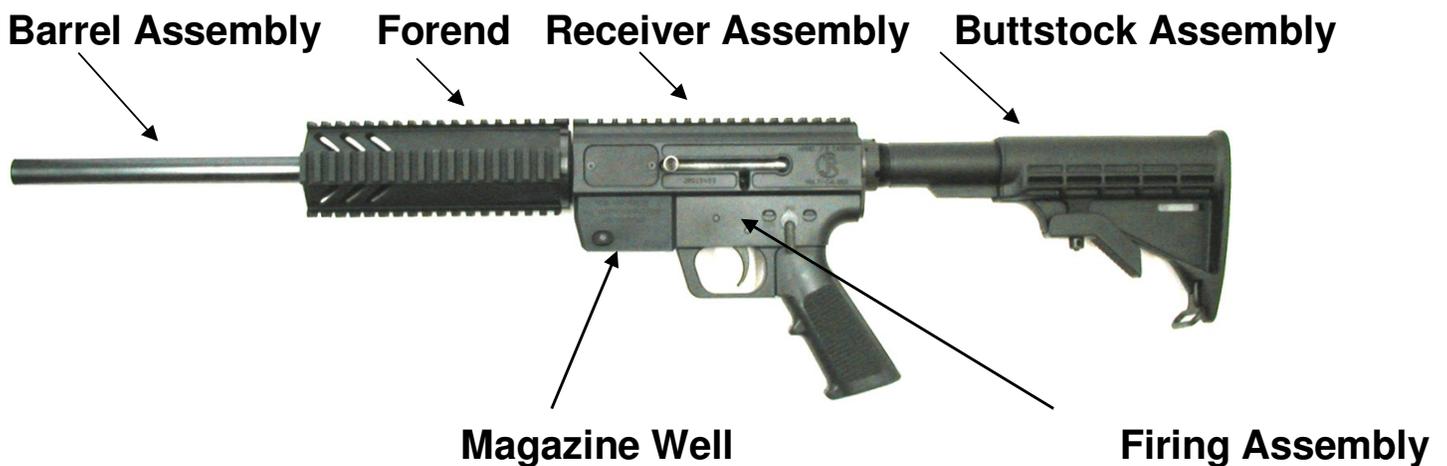
- Before fully tightening the bolt handle mounting screw you should cycle the bolt back and forth to ensure there is no binding. If there is any binding, or if the bolt does not cycle freely (aside from slight pressure from the cocked hammer), recheck the bolt handle to ensure it is mounted properly, as described above.
- Once the bolt handle and bolt assembly operate freely within the receiver, finish tightening the mounting bolt hand tight.
- Install the new barrel:
  - With the barrel alignment slot facing the bottom of the receiver, insert the chamber end of the barrel into the front of the receiver.
  - Place the barrel nut over the barrel and screw it onto the threads at the front of the receiver. Tighten hand tight with the barrel nut wrench.
  - Place the quad forend over the barrel with the threaded side toward the receiver.
  - Screw the forend onto the barrel nut until it will not go any further.
  - Unscrew the forend less than one full turn – just enough to align the picatinny rail extension to line up with the rail machined into the top of the receiver.
  - Hold the forend in place to maintain alignment with the receiver rail and tighten the forend locking ring finger tight.
  - Carefully tighten the quad forend locking ring hand tight with the quad forend wrench. Be careful to avoid marring the quad forend or receiver with the wrench, and to maintain alignment of the picatinny rails.
- Reinstall the buttstock:
  - Ensure the bolt is unlocked and is fully forward.
  - Before you reinstall the buttstock assembly make sure all of its parts are properly installed within it and it is complete.  
**[Note: If your caliber conversion kit came with a buffer different than the one in your carbine, install the new buffer in the buttstock assembly before reinstalling the buttstock assembly in your carbine.]**
  - Screw the entire buttstock assembly into the receiver by turning it clockwise when viewed from the rear looking forward. Keep turning until it will not go any further.

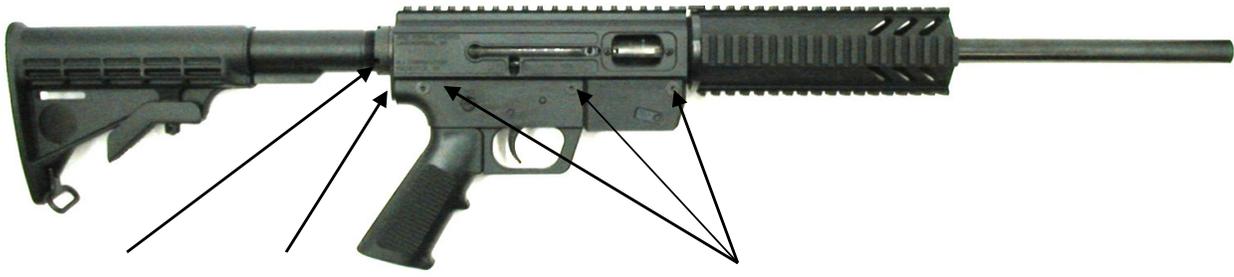
- The buttstock must be properly aligned with the receiver so that when you slide the receiver plate forward it fits into the detent in the end of the receiver. If it is not, unscrew it less than one full turn – just enough to properly align the two and permit proper fitting of the receiver plate into the receiver.
- With the buttstock properly aligned to the receiver and the receiver plate properly fitted and flush with the end of the receiver, tighten the buttstock castle nut clockwise – finger tight only – when viewed from the rear looking forward.
- Using the buttstock portion of the combination wrench (the smaller of the two spanner wrench sections), tighten the buttstock castle nut hand tight.

## 5. Function Check

- Examine your reassembled carbine visually to ensure that all parts appear to be in their proper position.
- Cycle the bolt manually to ensure proper movement. Dry-fire your carbine to test function of the safety and fire controls.
- Double check the markings on you barrel, magazine well, and bolt to ensure they are all marked with the new caliber.
- If you encounter any difficulties when performing this caliber conversion, or if you are unsure of the results of your carbine conversion, Just Right Carbines strongly recommends that you take your carbine to a qualified gunsmith for examination and evaluation.

## COMPONENTS





**Castle Nut and Receiver Plate**

**Take-down Screws**