



# Just Right Carbines

.45 ACP Buffer Upgrade & Buffer Tube  
Extension Kit Instructions

(Extends a standard buffer tube internal depth  
from 7 inches to 8-1/5 inches.)



**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 kit installations or repairs.

**Items included in this kit:**



\*\*\* Current as of 3-5-2014

**Important Note:** *If your buffer tube measures 8.5" internally, you do not need this kit. Installing it on an 8.5" buffer tube will result in non-warranty related damage to the bolt handle and potentially the receiver.*

**The customer will be responsible for any damage resulting from not following this warning.**



Magazine well (caliber may vary)

## 1. Tools you will need:



Figure 1

- Combination barrel/forend/buttstock wrench (Figure 1 – included with caliber conversion kit), OR an M4 Buttstock buffer tube wrench.
- 1/16-inch hex (Allen) wrench – included in kit
- 1/8-inch hex (Allen) wrench – included (NOT shown above)
- Gun vise, padded vise or other proper work surface
  - Note: Just Right Carbiners 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.
- Allow the bolt to close on the empty chamber.

## 3. Disassembly:

- 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 re-clamp 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.
  - Remove all of the buffer assembly components from the buffer tube. Set aside the buffer spring to re-use it.
  - Set aside all of the old buffer parts (buffer, small nylon disk, short bumper). Do not attempt to re-use any of these old parts. Doing so can damage your carbine and cause it to malfunction.
  
- 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.
  
- Test fit the buffer extension:
  - Measure the inside of your current buffer tube with all bumpers, discs and springs/buffers removed. If the internal depth measures 7", continue with the installation of the buffer tube extension. ***IF THE INTERNAL DEPTH MEASURES 8.5" AND SKIP THE INSTALL OF THE BUFFER TUBE EXTENSION.*** You have the correct size tube and this extension will not be necessary. If you have questions, please call us.
  - First, examine the set screw in the underside of the buffer extension. Make sure it is backed far enough out of the extension that it will not interfere with screwing the extension all the way onto the buffer.
  - Screw the extension onto the buffer tube threads *just until you meet some resistance.* There will still be about 1-3 threads showing on the buffer tube

at this point. **Do not tighten further** or you will compress the buffer tube and prevent the buffer from sliding freely within it.

- If the set screw is not aligned perfectly with the index slot in the bottom of the buffer tube threads (and it probably WON'T be), unscrew the extension just enough to bring the set screw into proper alignment (less than a full turn).
- Use the allen wrench to tighten the set screw very lightly - just enough to ensure it touches the index slot and will keep the buffer tube and extension in proper alignment while the Loctite sets.
- Loosen the set screw and unscrew the extension from the buffer tube.
- Install the extension onto the buffer tube:
  - IMPORTANT! To ensure proper adhesion, clean the threads on the buffer tube and inside the extension with acetone, alcohol, or other solvent - and make sure they are dry and free of any residue - before applying Loctite.
  - Snap the cap off the Loctite capsule.
  - Apply Loctite to the threads at the very end of the buffer tube opening.
  - Cover the threads all the way around the buffer tube for the first 1/2-inch of threading, starting at the end. Do not apply any Loctite beyond the first 1/2-inch.
  - Screw the adapter onto the buffer tube all the way just as you did during the test fit.
  - Unscrew enough to align the set screw with the index slot as before.
  - Tighten the set screw again as before, just until it touches the index slot, then back it out 1/2 turn. The extension will be a little loose but will remain in alignment. DO NOT OVERTIGHTEN, or you will deform the buffer tube and prevent the buffer from sliding freely within it. Set aside and allow the Loctite to fully cure - **at least 24 hours.**

### **Buffer Extension Properly Installed**



#### 4. Reassembly:

- 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.
  - 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.
- Reinstall the buttstock:
  - Ensure the bolt is unlocked and is fully forward.
  - Install the new rubber bumper in the buffer tube with the larger-diameter base to the rear/bottom of the tube.
  - Next, insert the nylon spacer in the buffer tube so that it sits on top of the rubber bumper.
  - Insert the buffer spring (which you previously set aside during disassembly) into the buffer tube, followed by the new heavy buffer.
  - 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. The handle **MUST** retract to between the lock down notch and the keyhole in the back of the receiver. ***IF YOUR HANDLE DOES NOT STOP BETWEEN THESE TWO LANDMARKS, DO NOT FIRE THE WEAPON!*** You have to adjust the shims in the buffer tube to get the handle to retract to between those two landmarks. Dry-fire your carbine to test function of the safety and fire controls.
- If you encounter any difficulties when performing this caliber conversion, or if you are unsure of the results of your buffer kit installation, Just Right Carbines strongly recommends that you take your carbine to a qualified gunsmith for examination and evaluation.
- *Note: If, after you install your new Buffer Extension Kit and test fire your JR Carbine, you experience any incidents in which the buffer locks to the rear and fails to return the bolt into battery, you will need to install your optional nylon shim disk in the base of the buffer tube, underneath the rubber bumper. Simply remove your buttstock, remove the buffer components, install the nylon shim in the base of the buffer tube, and reinstall the buffer components.*

**For additional assistance please see our instructional video on our website at [www.justrightcarbines.com](http://www.justrightcarbines.com), or call us M - F, 9:00 AM - 3:00 PM EST, at 585-396-1551**

### COMPONENTS

