



# BEV™ BLOCK



**WARNING**

BEFORE STARTING! MAKE SURE THE WEAPON IS UNLOADED, THE CHAMBER IS EMPTY & THE SAFETY IS ENGAGED.



READ ALL INSTRUCTIONS BEFORE PROCEEDING TO AVOID LOSING ANY SMALL COMPONENTS.

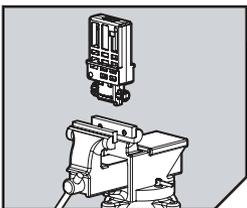


## INSTALLATION INSTRUCTIONS

**STOP**

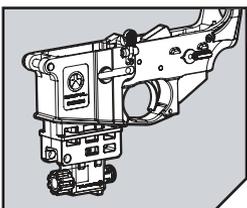
IMPROPER INSTALLATION AND/OR IMPROPER USE OF THIS PRODUCT MAY CAUSE WEAPON MALFUNCTION. WEAPON MALFUNCTION MAY CAUSE SERIOUS INJURY, INCLUDING GRIEVOUS BODILY HARM AND/OR DEATH.

FOR LOWER RECEIVER



### Step 1

Orient the *BEV Block* so that the upper receiver block is between the vise jaws, ensuring the *upper receiver retaining pin* is removed. Clamp the *BEV Block* in the vise at the wide, flat portion above the barrel extension engagement lugs and below the vise jaw locating rib.

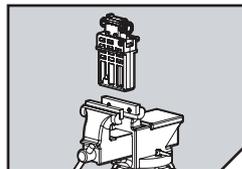
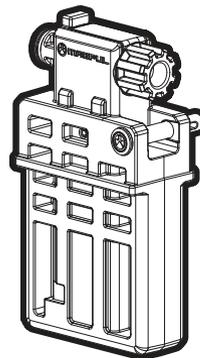


### Step 2

Once the *BEV Block* is secured in the vise, slide the lower receiver magazine well over the *BEV Block* until the magazine catch locks into the magazine catch notch on the *BEV Block* (engagement lugs facing forward), or until the lower receiver bottoms out on the vise jaw locating rib if you have not yet installed the magazine catch.

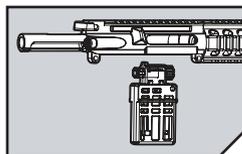
NOTE: The magazine catch must be depressed to remove the lower receiver from the *BEV Block*.

FOR UPPER RECEIVER



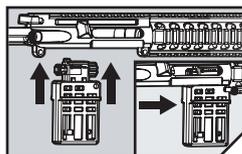
### Step 1

Orient the *BEV Block* so that the lower receiver block is between the vise jaws. Clamp the vise below the vise jaw locating rib.



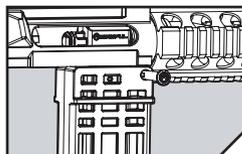
### Step 2

With the bolt carrier and charging handle removed, insert the field stripped upper receiver onto the *BEV Block* from the top, behind the chamber and roughly in-line with the ejection port. The upper receiver should rest on the middle retaining rib.



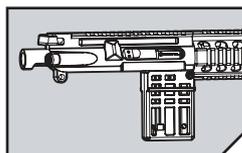
### Step 3

Push the upper receiver rearward onto the barrel extension engagement lugs until they interlock with the barrel extension. The front takedown pin lug and upper receiver retaining pin hole should be aligned.



### Step 4

Insert the upper receiver retaining pin through the *BEV Block* and the upper receiver.



### Step 5

Insert the bolt carrier with the bolt removed and push it onto the bolt carrier support post, ensuring that the front of the carrier slides over the rubber o-ring.