

## Care and Assembly of the Sleeve and Breechblock

**Only the short section of the sleeve and o-ring come out of the gun.** I made the forward section a press fit into the bored area of the barrel and it is sealed and not removable without machining.

The chamber and sleeve need to be cleaned between weekend matches, but should be just fine for about a hundred rounds over a weekend of shooting. Soap and water are fine to clean this. When the gun is stored, just use light oil and place the sleeve without an o-ring in the gun so you don't lose it.

### Breechblock Cleaning:

Remove the block from the gun, take out the nipple and clean out screw. Hot soapy water and toothbrush, compressed air to blow out the fire path, install nipple and screw with never seize. There is nothing else to disassemble, as the pressure plate is mechanically staked in place and cannot be removed without machine work.

### Assembly for Shooting:

Spray the breechblock with Pam Canola Oil and lightly wipe off excess. Put the o-ring on the sleeve and coat with grease. Press the sleeve into the breech and, using index finger pressure on the bottom edge of the sleeve, slide the block in the frame while pushing forward on the bottom of the block while sliding it up. This should go together with some force by your hand. If not the o-ring might be pinched. **DO NOT USE A METAL HAMMER.** A dowel or small soft hammer can be an aid, with limited force, but this is fitted to be hand assembled.

After you install the lever pin, cycle the block to make sure it has a smooth glide motion. Some additional Pam can help this.

During a match I would run a damp patch between relays, and if the block feels a little stiff, a small spray of Pam on the open breech, then wipe the chamber.

As the breech face polishes itself you will find that it will need less oil.

You will need to pay attention to the face of the breechblock. I suggest that every third outing you lightly lap the face. To do this, use a piece of 600 grit wet/dry paper and a flat metal surface. Place the breechblock face down and with a figure 8 motion scuff the surface. This is done in about 10 seconds of scuff time.

Here are the part numbers:

O-ring – 2418T123  
Grease – 1392K31

Both are available from [mcmaster.com](http://mcmaster.com), and are very inexpensive.

Any questions please call.

Charlie Hahn, 410-208-4736