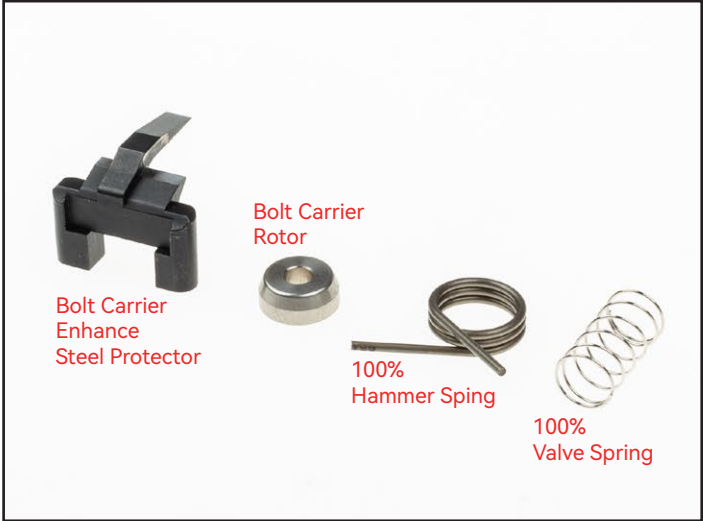


AR/A5 槍機或整槍穩定性提升組件（GM0614）及相關需修磨位置說明

AR/A5 BOLT/FULL-RIFLE STABILITY ENHANCEMENT COMPONENTS USAGE GUIDE



- GM0614 零件組
- GM0614 Parts Kit



- 本次升級的零件是滾輪和加強塊
- The upgraded parts this time are the roller and reinforcement block

更換滾輪

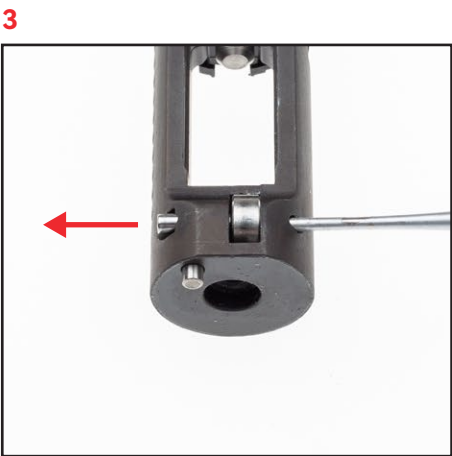
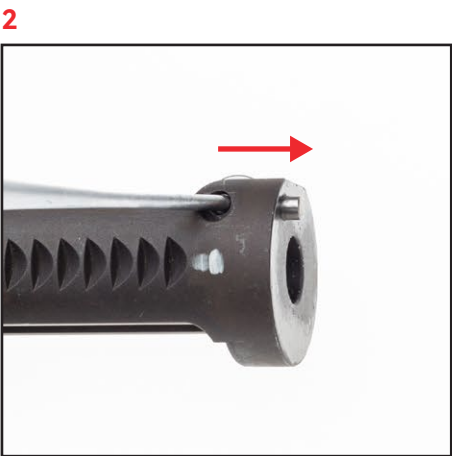
ROLLER



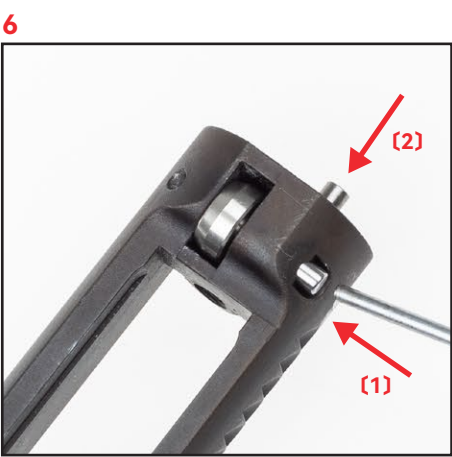
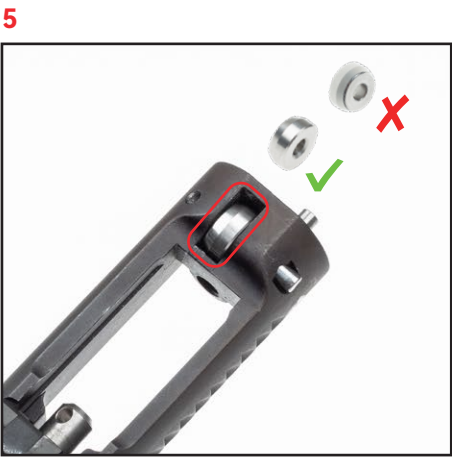
- 將原來直角滾輪升級成C角滾輪
- Upgrade the original right angle roller to a C-Chamfered roller
- 按型號選擇3mm或4mm的C角滾輪
- Select 3mm or 4mm C-Chamfered roller by model



- 使用4mm內六角扳手逆時針拆卸零件槍機延長塊〔1〕，然後用工具推出兩條定位銷。
- Use a 4mm hex wrench to remove component Speed Bolt Extension 〔1〕 by turning counterclockwise, then drive out the two locating pins with a tool.



- 取出舊的直角滾輪，裝上C角滾輪，按照順序推入定位銷。
- Remove the old right angle roller, install the new C-chamfered roller, and drive in the locating pins in sequence.



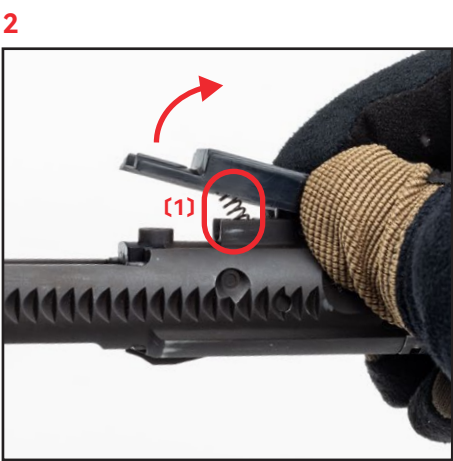
- 對準位置，順時針裝上槍機延長塊〔1〕，完成！
- Align the position, install the Speed Bolt Extension 〔1〕 clockwise, and complete the installation!



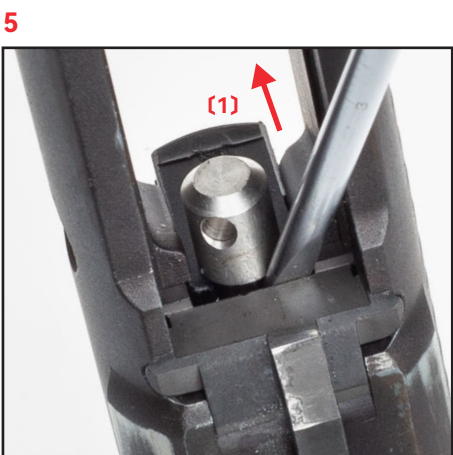
更換加強塊
REINFORCEMENT BLOCK



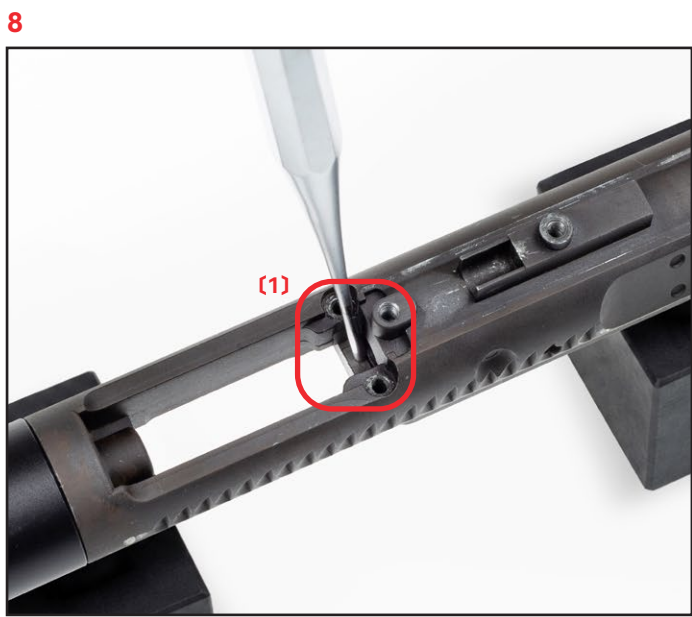
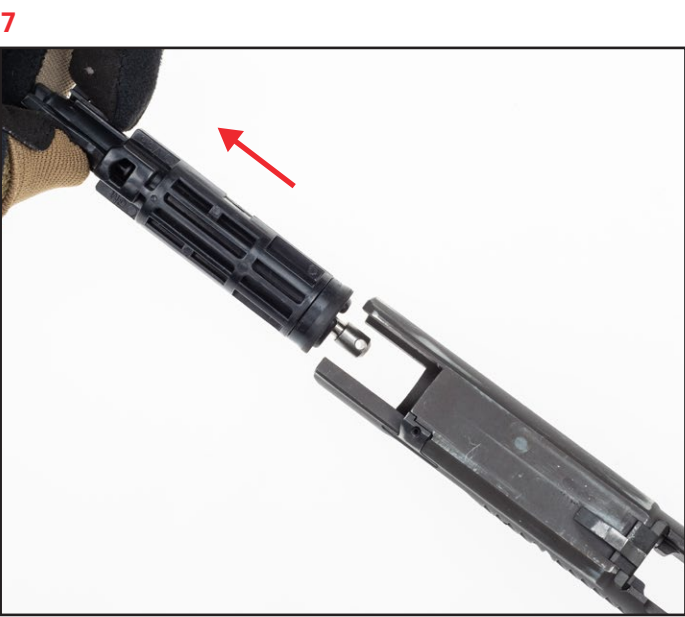
·新舊加強塊對比(備註：不鏽鋼版本不需要換加強塊)
·Comparison: Legacy Reinforcement Block vs. Upgraded Reinforcement Block
(Note: The stainless steel variant does not require replacement of the reinforcement block.)



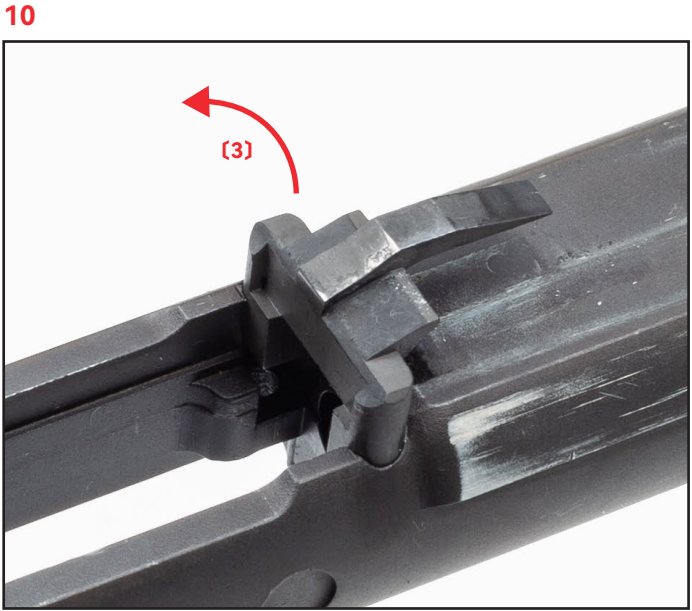
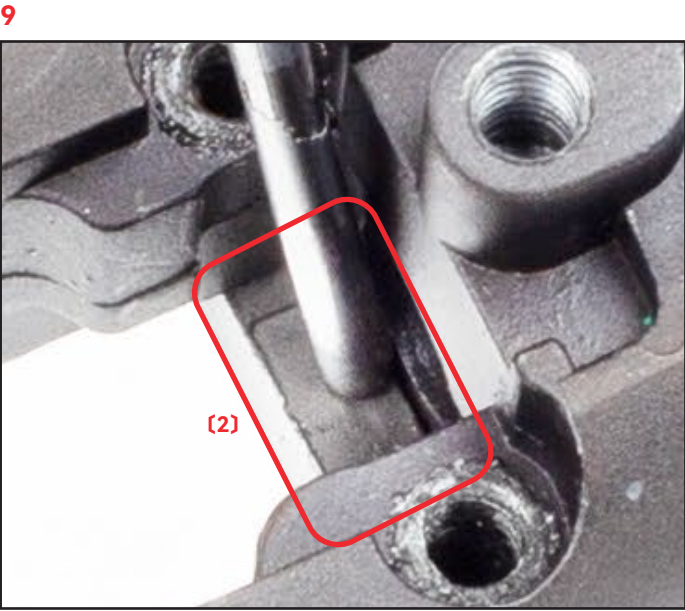
·使用十字螺絲刀拆卸推嘴復位桿頂部兩顆螺絲，拉起推嘴復位桿拆出彈簧(1)，拉出推嘴(2)並且拆卸推嘴復位桿(3)。
·Use a Phillips screwdriver to remove the two screws on the top of the Nozzle Reset. Lift the Nozzle Reset to extract spring (1), then pull out the Nozzle (2) and remove the Nozzle Reset (3).



·使用2mm內六角扳手拆卸加強塊的兩顆螺絲，用一字螺絲刀翹出定位塊(1)、(2)。
·Use a 2mm hex key to remove the two screws from the reinforcement block, then pry out the locating blocks (1) and (2) with a flathead screwdriver.



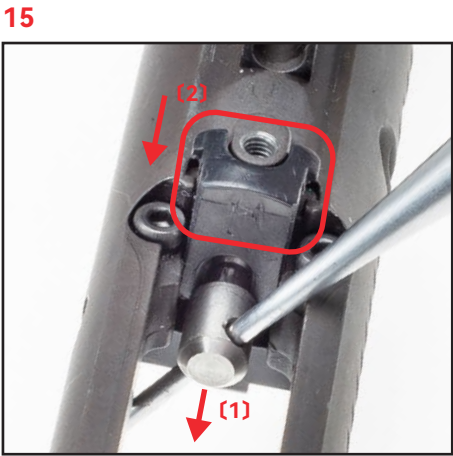
·抽出推嘴，用高度相同的物體承托槍機，輕輕將加強塊敲出(1)。
·Extract the nozzle, support the bolt carrier with a shim of equal height, then gently tap out the reinforcement block (1).



·敲擊位置特寫(2)。加強塊被敲凸出後，即可取出加強塊(3)。
·Close-up of striking location (2). Once the reinforcement block is tapped out, remove the reinforcement block (3).



·裝上新的加強塊，裝回螺絲（螺絲塗上螺絲膠），確保加強塊安裝到位。
·Install the new reinforcement block, reinstall the screws (applying threadlocker to the screws), and ensure the block is fully seated and aligned.



·裝回推嘴，用工具輔助拉住推嘴定位柱(1)，裝上定位塊(2)。推嘴固定好後，拉出推嘴，裝回推嘴復位桿。
·Reinstall the nozzle, use a tool to secure the nozzle locating post (1), then install the locating block (2). After securing the nozzle, extract it again and reinstall the nozzle reset lever.



·裝回推嘴復位桿的彈簧，如圖16-17所示一端在槽內(1)，一端卡住復位桿內(2)，再向下壓即可裝好。
·Reinstall the recoil spring for the nozzle reset lever. As shown in Figure 16-17, position one end within the guide slot (1) and latch the other end into the reset lever (2), then press downward to secure the assembly.

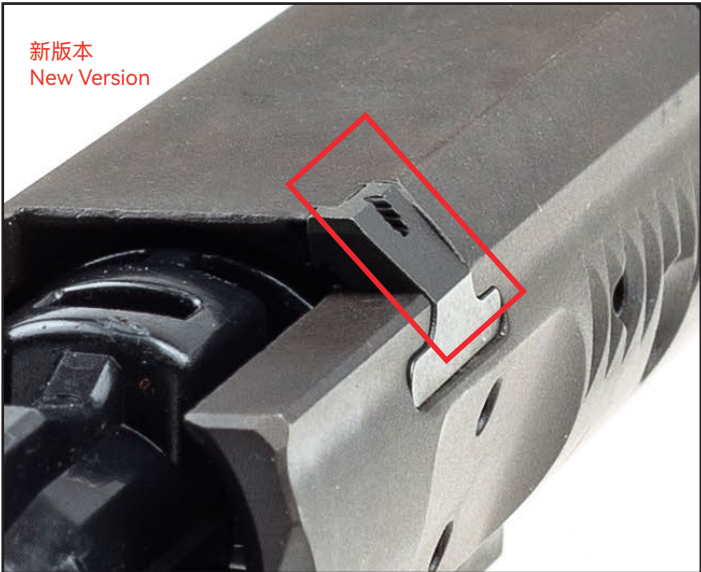


·裝回推嘴復位桿的螺絲（螺絲塗上螺絲膠），本次升級教程完成！
·Reinstall the screws on the nozzle reset lever (apply threadlocker to the screws). This concludes the upgrade tutorial!

需修磨位置說明
AREAS REQUIRING GRINDING



- 修磨該位置的利邊，極大減小槍機框復進過程中對上機匣塗層和金屬的刮削機率，提高復進速度與穩定性。新批次已減少該位置金屬或已經通過CNC加工出圓角。
- Deburr the sharp edges at this location to significantly reduce scraping risks on the upper receiver coating and metal surfaces during bolt carrier reciprocation, enhancing cycling speed and stability. New production batches feature either reduced base material or precisely machined radii via CNC at this location.

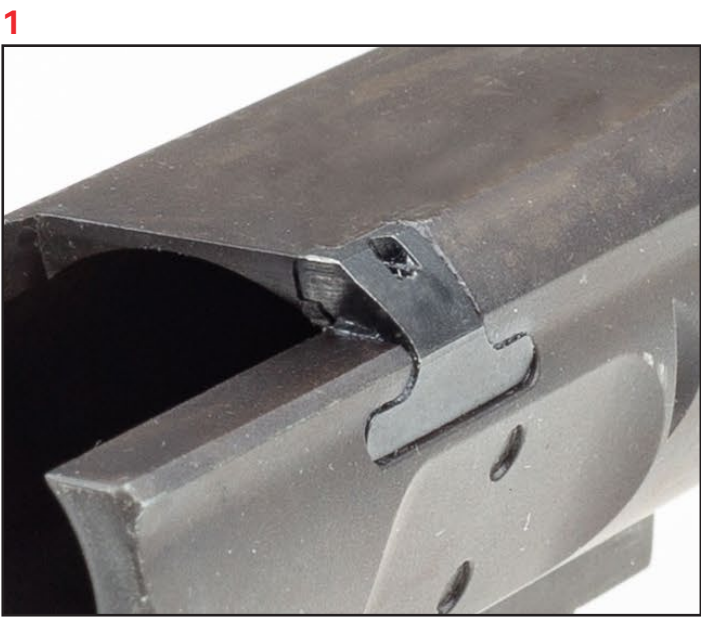


新版本
New Version

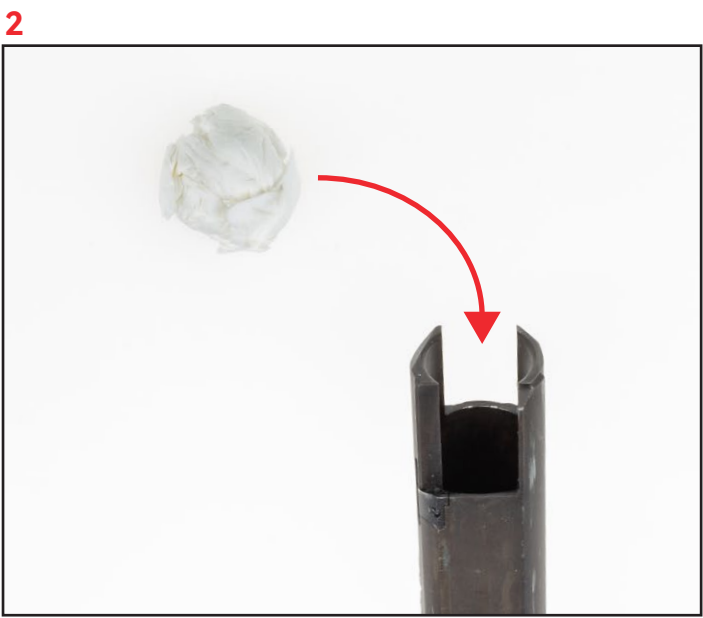


舊版本
Old Version

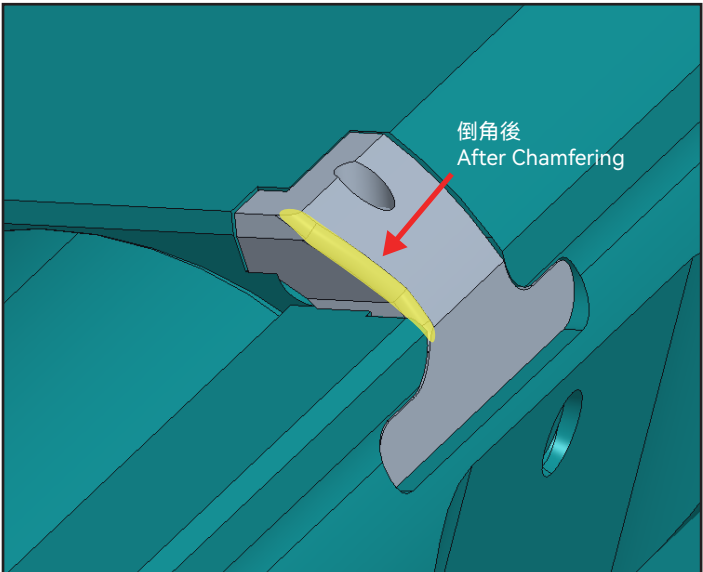
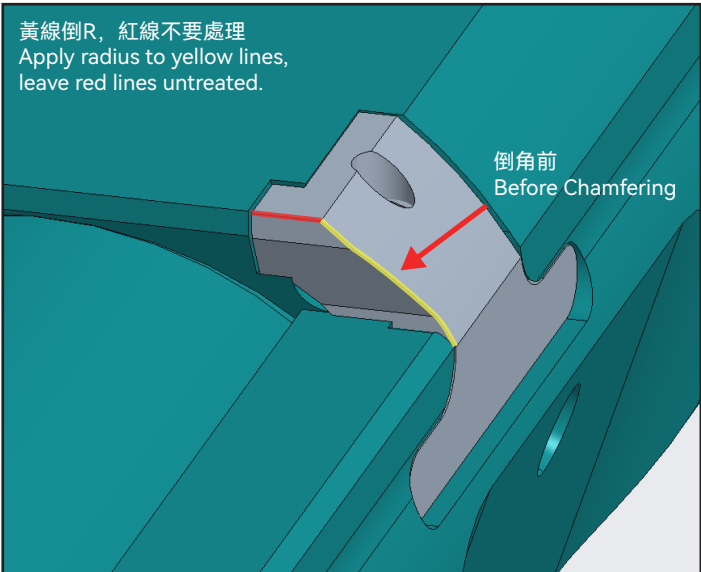
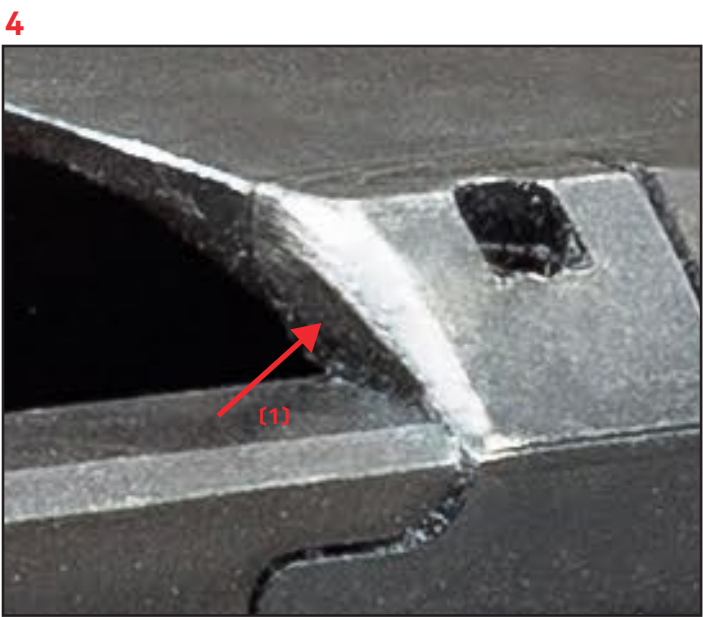
- 新舊版本對比，新版本或經過CNC修圓的版本不需要處理，只有邊角鋒利的舊版本才建議修磨。
- New versions or CNC-machined rounded versions require no treatment. Deburring is recommended only for sharp-edged legacy versions.



- 先按上述**加強塊教程1-7**拆除推嘴，然後用紙巾堵住氣缸口，以防碎屑掉落氣缸。
- First follow **reinforcement block instructions 1-7** to remove the nozzle, then use a tissue to plug the cylinder port to prevent debris from entering



- 使用銼刀對掛機加強片的鋒利邊緣打磨至**(1)**圓滑狀態。操作完成後，請清理殘留的金屬碎屑。
- File the sharp edges of the sear reinforcement plate to a smooth radius **(1)**. Clean residual metal debris after completion.



- 3D圖，倒角前後對比
- 3D Diagram: Chamfering Before and After Comparison