

Extended Magwell Gen.2 (PN 04.101) for

- o **AR-15 9x19 Conversions with a .223 Rem Lower (mil.-spec.) and Colt Magazines**

Thank you for choosing a high-quality **TECTAL** product!

The *extended magwell* has been 100% engineered and “Made in Austria”. It offers the following benefits:

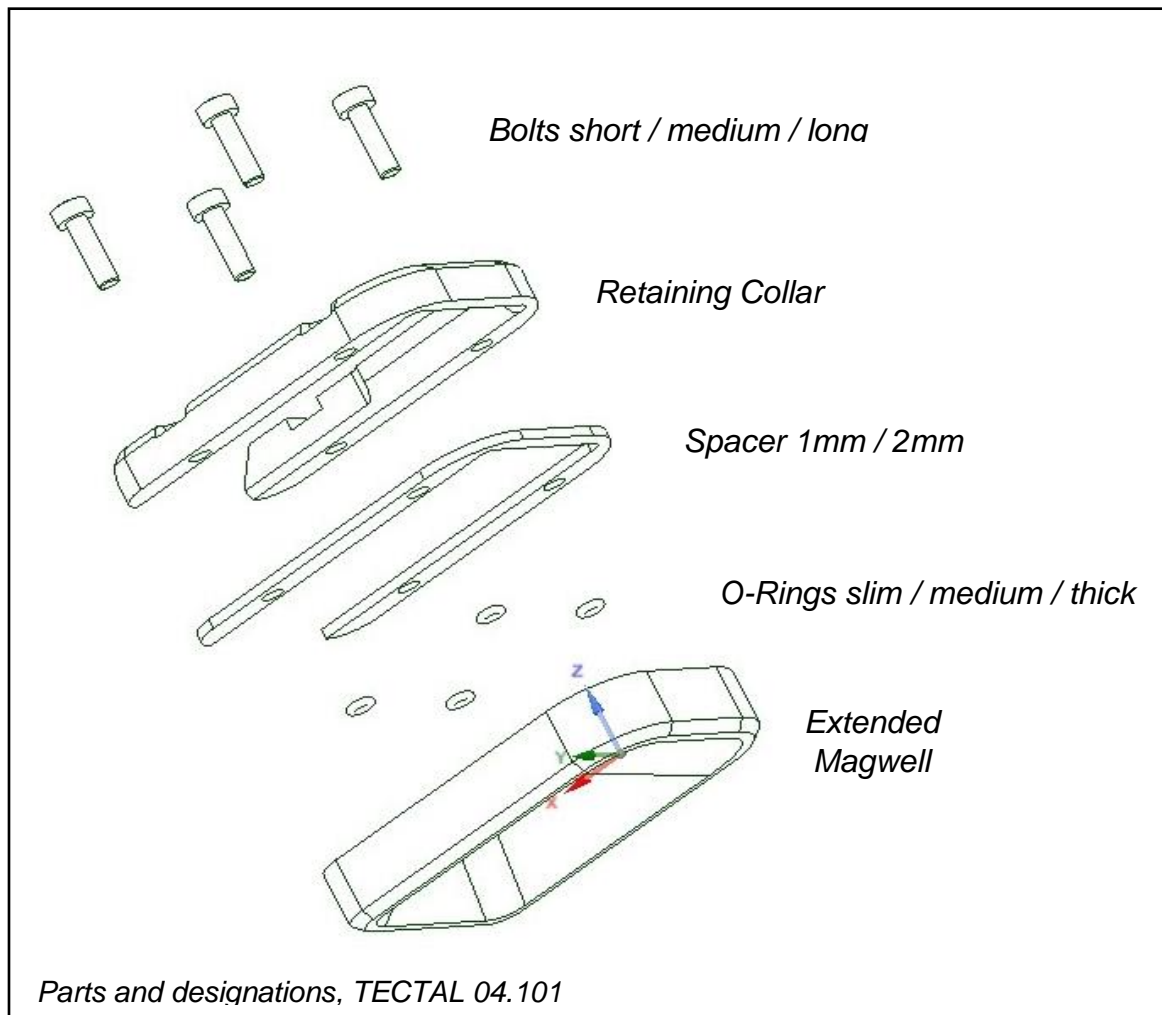
- ✓ Gen.2 – improved design
- ✓ Faster Reloads
- ✓ Modular adjustability to suit a wide range of AR-15 .223 Rem lower receivers (= lower)*
- ✓ High quality materials used throughout the construction (high strength Aluminium, stainless hardware, etc.)



Supplied Parts:

- 1 pc. each *TECTAL Extended Magwell and Retaining Collar*
- 2 pc. *Spacer 1mm, 2mm*
- 2 pc. *Spacer 2mm*
- 4 pcs. each *Bolts short, medium, long*
- 4 pcs. each *O-rings slim, medium, thick*

* *mil.-spec. Lower, tested with lowers from Oberland, Schmeisser, DPMS, CMMG (Mk.4), Bushmaster XM15-E2*



INSTALLATION - PREPARATION

1. **Before maintaining or working on any firearm always ensure that it is unloaded and safe!**

While pointing the firearm in a safe direction remove any magazine from the firearm and ascertain it is unloaded by locking the slide to the rear and visually inspecting the chamber before working on or cleaning it! If loaded follow the proper procedures to unload the firearm safely!



Firearms Safety is your responsibility!

2. It is recommended to separate the lower and upper receiver for the installation process. The installation is on the lower only.
3. The 9mm magazine adapter must be inserted **before** the installation of the *extended magwell*!

INSTALLATION

Required tools:

- 2,5mm Allen key - preferably torque wrench with 2,5mm bit
1. Fit the *extended magwell* to the original magwell (→ loose fit; retention by *retaining collar*).
 2. Fit the *retaining collar* by sliding it on from the front and lowering it towards the *extended magwell*.
 3. Check if / how the *retaining collar* contacts the *extended magwell*:

a. No gap between *extended magwell* and *retaining collar*

A *spacer* is not required.

The *retaining collar* can be bolted to the *extended magwell* using the *short bolts* (M4x12). The maximum recommended tightening torque is 2,6Nm.

If the completed *extended magwell* shows **play** on the lower 4 pcs. of the most appropriately sized ***o-rings*** shall be added to eliminate resp. minimize any play:

- Undo the bolts connecting the *retaining collar* to the *extended magwell*
- Position 4 equally sized *o-rings* in the 4 indentations on the top side of the *extended magwell* (see pic. below)
- Bolt the *retaining collar* to the *extended magwell* with the *o-rings* in place



b. Gap between *extended magwell* and *retaining collar*

The use of the provided *spacers* is required!

1. Depending on the gap the 1mm, the 2mm *spacer(s)* or a combination may be used.

The *slimmest spacer* or combination of *spacers* which allow for installation without a gap is / are retained for further installation!



2. The *retaining collar* can be bolted to the *extended magwell* using the preselected *spacer(s)*.
 - 1mm or 2mm *spacer* → *medium bolts* (M4x14)
 - 3+mm combined *spacers* → *long bolts* (M4x16)

Maximum recommended tightening torque is 2,6Nm in any case.

If the completed installation of the *extended magwell* shows **play** on the lower, 4 pcs. of the most appropriately sized **o-rings** shall be added to eliminate resp. minimize any play:

- Undo the bolts connecting the *retaining collar* to the *extended magwell*
- Position 4 equally sized *o-rings* in the 4 indentations on the top side of the *extended magwell* (see pic. p.3)
- Bolt the *retaining collar* to the *extended magwell* with the *o-rings* and the pre-selected *spacer(s)* in place

Once the installation is complete the *bolts* may be secured with Loctite 243 (blue) or a comparable, non-permanent, medium thread locker to ensure bolt retention while maintaining convenient removability. **Maintain the max. tightening torque as per the above!**

Use of thread locker:

- Observe the manufacturer instructions for the correct use of the thread locker!
- Use the thread locker sparingly (~ 2 thread turns - do not cover the whole threaded length of the screws!) to ensure that the external retaining screw and the grub screw can be unthreaded again for maintenance!

NOTES ON INSTALLATION, MAINTENANCE AND COATING

INSTALLATION



Never try to close a gap between the *retaining collar* and the *extended magwell* using force by overtightening the *bolts* or other means. This will lead to deformations and irreparable damage to the components. Use the provided spacers and o-rings for adjustment!



The maximum recommended tightening torque for all bolts is 2,6Nm (see p. 3/4).

MAINTENANCE

During maintenance it is sufficient to wipe the *extended magwell* clean.

Due to the coating it is neither necessary nor recommended to use aggressive solvents or abrasive tools for cleaning!

COATING

The coating is applied electrochemically.

Where the Aluminium parts are suspended during processing they may show minute, bare spots where contact has taken place. These have no impact on the durability and resilience of the coating.

The coating is also subject to wear especially in exposed areas (edges, etc.). Process related spots and installation or usage related wear are not considered a defect.

In case of any questions please contact us at
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