
FORSTER PRODUCTS

310 E. LANARK AVENUE, LANARK, ILLINOIS 61046 PHONE: 815-493-6360 FAX: 815-493-2371 www.forsterproducts.com

LONG BARREL RECEIVER EXTENSION FOR FORSTER'S UNIVERSAL SIGHT MOUNTING FIXTURE



This Extension allows you to accurately drill and tap on up to 26" barrels. Even front sights can be installed in one step.

- 1) Remove the original receiver Support Pad Shaft (UF1000-103) from the Forster Universal Sight Mounting Fixture. Install the Long Barrell Receiver Extension (EXT100-100) in the same opening, keeping the Extension at its lowest position. Lower the V-block shafts (UF1000-102) to their lowest positions. Tighten the Extension's side-locking screw (UF1000-036) with the 3/16" Allen wrench provided.
- 2) Place the barrel on the two V-blocks (UF1000-102) with the action over the Extension. Position the barrel so that it will just rest on the front V-block when the V-block is raised. Do not install the front C-clamp (UF1000-014) yet, as you do not want to interfere with the vertical adjustment. Make sure the Extension's support pad clamp (EXT100-101) is positioned inside the receiver. The rear C-clamp should now be snug, but not overtightened.
- 3) Raise the rear V-block to bring the action into contact with the drill bushings and tighten the side-locking screw to hold the V-block in position. Next, adjust the front V

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Block to secure the muzzle end of the barrel. Since most barrels are tapered, it will be necessary to raise the front V Block higher than the rear, as follows:

- a. Using a micrometer or calipers, measure the diameter of the barrel where it contacts the front and rear V Blocks.
- b. To calculate the exact difference in height, subtract the small diameter from the larger diameter, and multiply this value by 0.707.
- c. Loosen the adjustment screw, raise the front V Block to the height of the rear V Block plus the value you received in calculation 3.b., above, and then tighten the screw.

******A machinist's rule will satisfactorily measure the correct height. If extreme accuracy is needed, employ a feeler gauge between the top of the machined boss and the bottom of the V Block.*******

4) When raising the Extension, make sure that the recoil lug does not contact the base of the Extension. It is optimal to have the flat portion of the lower receiver square and flush with the Extension.

5) After horizontal adjustment of the barrel, make sure both C-clamps are in place and all screws are tightened. When drilling or tapping the front portion of the barrel, the front C-clamp must be removed.



(Picture shows Extension assembled on site fixture with barrel installed)

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