

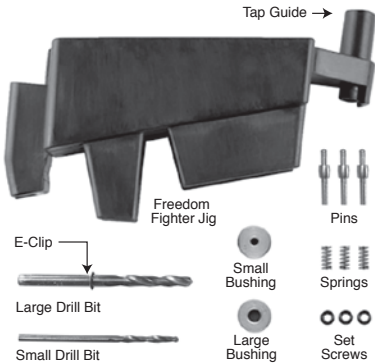


INSTALLATION INSTRUCTIONS:

Modification to your firearm is required. To ensure proper operation, a qualified gunsmith is recommended.

The Freedom Fighter Kit Part List

The Freedom Fighter package contains many small parts necessary for installation. Care must be taken to work on a clean, organized surface to reduce risk of losing parts.



The Hogue Freedom Fighter™ provides a fixed magazine solution. The installation requires modifying the receiver by drilling a hole into the firearm. Once modified, the magazine release can only be activated when the upper receiver is swung open putting the firearm in a “disassembled” configuration.

VIDEO INSTRUCTIONS

Scan this code with your mobile device to watch installation video.



or visit

Hogueinc.com/tacrifles/ar15/freedomfighter

Follow installation instructions carefully.

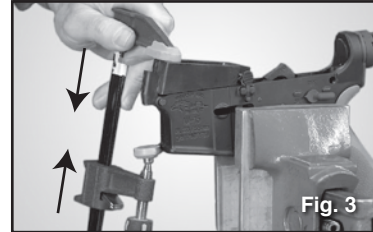
1. Assure the firearm is unloaded.
2. Remove upper receiver from lower receiver. Remove bullet button or existing magazine catch (Fig 1.)



3. With forward takedown pin fully inserted (closed position), cock the hammer and place Freedom Fighter jig into the top mag well of lower receiver (Fig 2.) Securing the receiver in a vise is not necessary but does make the drilling process easier.



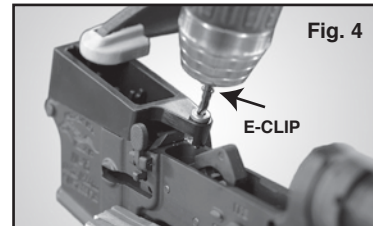
4. **IMPORTANT:** Using a clamp to secure the Freedom Fighter into the top mag well, clamp jig firmly down and visually verify it is in full contact with the upper surface of receiver (Fig. 3.)



5. Ensure the e-clip is installed into the groove in the supplied large drill bit.



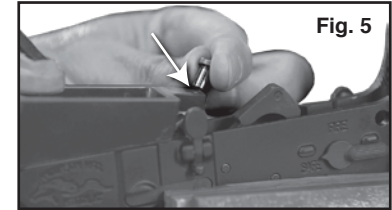
6. Use large bit to drill to full depth (Fig. 4.) Lubricate cutting with a suitable aluminum cutting fluid such as WD-40. Remove drill, clear chips away and repeat, re-lubricating often. Proceed a little at a time and stop when the e-clip bottoms out on the metal bushing. *Note: For all drilling operations, it is best to use high RPM and allow the bushing to guide the drill angle.*



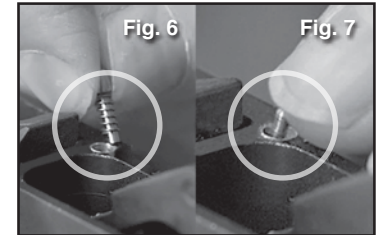
7. **IMPORTANT:** Clean all metal burrs and chips at every step during installation. If necessary, re-insert jig and chase hole with drill bits both small and large. Even the smallest of burrs could prevent the pin from plunging.

8. Replace large metal bushing with small size bushing (Fig. 5.) Change to small drill bit and drill again until you feel the bit break through. Remove clamp and jig.

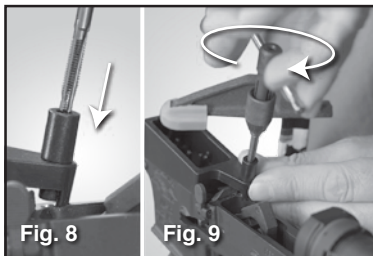
See Step #7.



9. Place spring and pin with domed end up into hole and check fit and function (Fig. 6.) Pin should easily plunge and return on its own (Fig 7.) Remove the spring and pin.



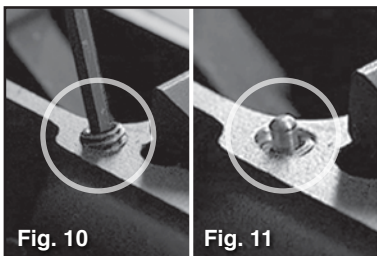
10. Install the tap guide bushing (plastic) into the jig (Fig. 8.) Reinsert the jig into the top mag well and carefully tap the hole approximately 4 revolutions (depending on your tap) using an 8-32 tap (Fig. 9.) Use cutting fluid or WD-40 as a lubricant. Proceed a little at a time checking depth by threading the set screw to test the fit. Tapping is complete when set screw stops flush with the top of the receiver surface. More is OK but not necessary. If set screw does not thread easily it may not be tapped deep enough.



See Step #7.

11. Insert the spring and pin then the set screw with a 5/64" allen wrench (Fig 10.) Check once again that the pin plunges and returns easily on its own before installing the mag catch button in the receiver (Fig 11.)

See Step #7.



12. Install a standard Mil-Spec mag catch, spring and button into the receiver. Thread the parts together until the mag catch works with the Freedom Fighter pin in the raised position but not in the depressed position. If the upper receiver does not close fully you have gone too far. Go back and adjust the mag catch button as necessary (Fig. 12.)



IMPORTANT!

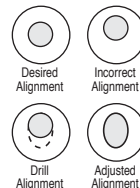
Check all functions of your firearm after Freedom Fighter is installed.
Test-fire your firearm.

Trouble Shooting

- **Spring and pin do not move freely**
The spring and pin must move freely up and down after inserted into drill hole. If the pin is catching and preventing unrestricted movement you must reinstall the jig and repeat the drilling steps to clear out burrs or ridges that are causing the problem.
- **Set screw does not screw deep enough**
If you are unable to thread the set screw flush with the top of the receiver surface, the hole will require further tapping to make the threads a bit deeper.
- **Upper and lower receiver will not close together after installation**
If the upper does not close completely, the mag catch may be threaded in too far. Back the mag catch out a turn or two.
- **The angle of the drill holes was created inconsistently not allowing the spring and pin to engage properly**
If the drill holes are not created concentric

with each other the pin may bind rather than move freely. Use the drill to **cautiously** shave material inside hole in an oval shape focusing where pin is catching.

Eyeball small & large holes



- **Large bit did not stop at E-clip and drilled all the way through**
Use your tap to thread the hole all the way to the bottom. Use one of the set screws with a thread locking compound and secure all the way at the bottom. Spring and pin will work effectively installed over locked set screw.
- **Questions regarding installation:**
Read the instruction sheet completely.
Watch the installation video at hogueinc.com/tacrifles/ar15/freedomfighter
Call customer service at 1-800-438-4747



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