

A sharp 1.6mm, 1.7mm, 1.9mm and 2.2mm drill bit are need to build this chopper.

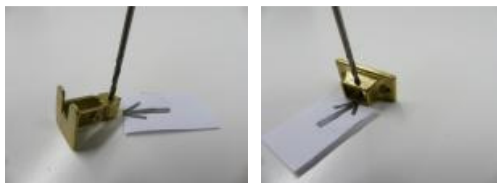
1.

With a file, Dremel or bench grinder, remove the excess brass from the casting process and polish to a nice finish.



2.

Drill a 1.9mm hole into the top rear of the buffer shank and the top and bottom holes in the buffer stock.



3.

Snip off the cleat, but make sure you include a little of the scrap brass. File or grind the end into a shallow point.



4.

Drop the cleat into the buffer stock through the hole that has NO counter sink. The cleat has a front face, this is the side with a small flat that butts up against the rim of the stock. File this flat until the cleat is a nice fit on top of the stock.



5.

While still on the sprue, drill a 1.7mm hole through the pivot of the chopper. Drill a 1.6mm hole through the buffer shank sides. Make sure the two holes line up very close to square.



6.

Snip off the pivot pin and cut off the waste brass from the chopper. File the chopper to a neat finish. Drop the chopper into position and push the pivot pin into place. Solder with a soldering iron, (70-80 watt) or 'peen' the pivot pin with a small hammer to fix into position. You could also use a blob of Epoxy glue. Make sure the chopper stays loose!!



7.

Drill two 2.2mm holes into the shank. Due to shrinkage, we have found you will need to keep these holes tight to the outside of the marked holes. Even then you may need to slot the holes outwards a few fractions to get the correct hole spacing. There is plenty of metal to do this, so there is no problem.



8.

Put the shank into the stock with the cleat in the correct position and making sure the stock has the counter sink at the bottom. Solder, (with a 70-80 watt iron) or 'peen' with a small hammer the bottom of the cleat to fix into position. You could also use a blob of Epoxy glue. Polish to a neat finish.



9.

Fit the spring into the back of the stock onto the tongue of the shank. Note if the buffer head is square to the stock, if not, rotate the spring until all is square to the eye. Paint and bolt onto your buffer beam. This coupling does

not come with bolts as it is assumed Accucraft bolts will be used.



PLEASE NOTE !

It has come to our attention, that Accucraft changed the hole spacing on their chopper couplings at some point in the past. Our choppers have a 20mm buffer bolt hole spacing. Our choppers can still be made to fit the old Accucraft spacing, but you will need to re-drill the buffer beam or our buffer stock. You may find a nut and bolt a better fitment for this older spacing, rather than trying to use the thread in the buffer beam!