

SHTM SAFETY HARBOR FHTM FIREARMSTM INC.

SHTFTM 50 UPPER CONVERSION

⚠ WARNING

Risk of serious injury or death.

Always point the firearm in a safe direction.

Verify that the firearm is not loaded before beginning disassembly or assembly.

⚠ WARNING

Risk of serious injury or death.

Do not disassemble the firearm any further than instructed.

Do not modify or alter any part of the firearm.

Wear the appropriate protective clothing while disassembling and assembling the firearm.

AR LOWER PARTS REPLACEMENT

⚠ Remove the magazine (if equipped) and verify that the firearm is not loaded and safety is on SAFE.

1. Separate your current AR lower from the upper.
2. Remove the buffer (A), buffer spring (B), detent (C) and detent spring (D). See figure 1.

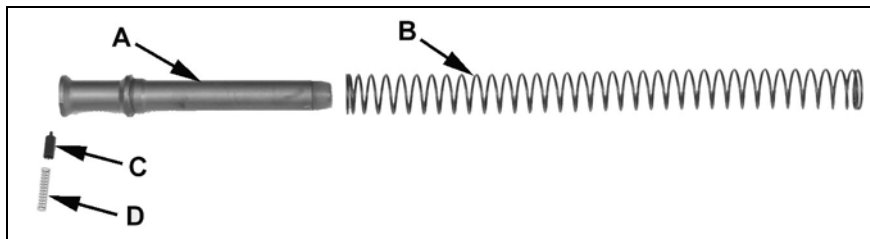


Figure 1

To remove (C) and (D), turn buffer tube counter clockwise 3-4 turns. This will allow the detent and spring to be removed. If you are using the stock buffer tube on your lower, retighten buffer tube to lower receiver. If a replacement stock will be used, completely remove the buffer tube and install new stock and buffer tube.

3. Remove roll pin (E), bolt hold open latch (F), detent (G) and spring (H) from left side of the receiver. See figure 2.

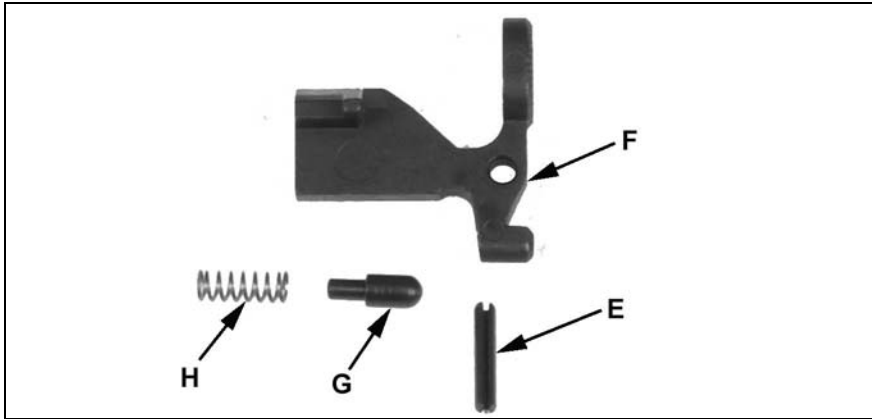


Figure 2

Before performing step 4, note the way spring is attached to the hammer.

4. Remove the stock AR hammer (I) and replace with the Safety Harbor hammer (J). Replace stock AR hammer pin with anti-walk pin and clip provided. If your AR spring (K) does not have enough striking power, use the Safety Harbor spring (L). See figure 3.

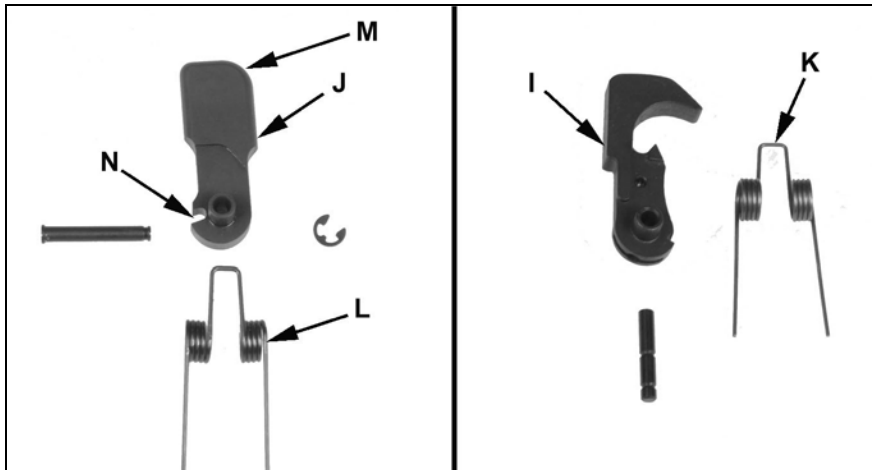


Figure 3

5. When installing the Safety Harbor supplied hammer, install with the large radius (M) facing forward and sear notch (N) toward trigger (O). See figure 4.

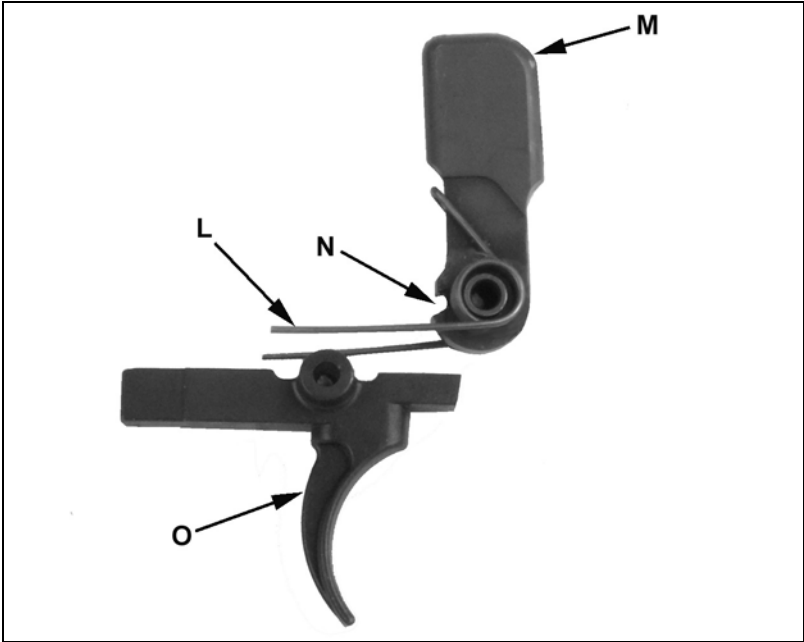


Figure 4

6. To remove disconnecter (Q), push trigger pin (P) at least half way out. This will allow the disconnecter (Q) and spring (R) to be removed from the trigger. After both parts are removed, push trigger pin back through the trigger to its original position. See figure 5 and 6

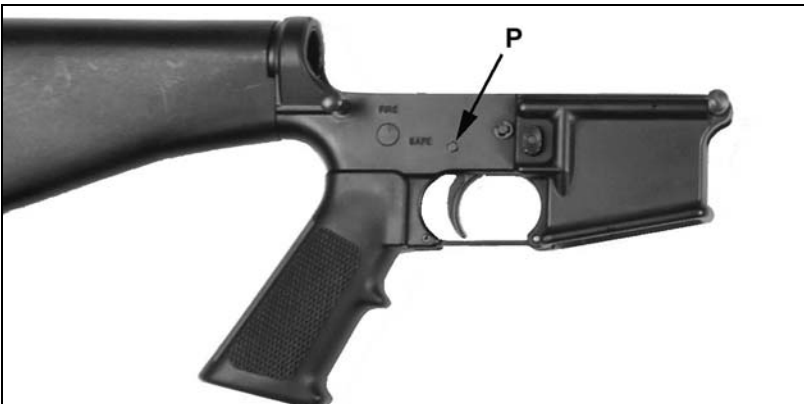


Figure 5

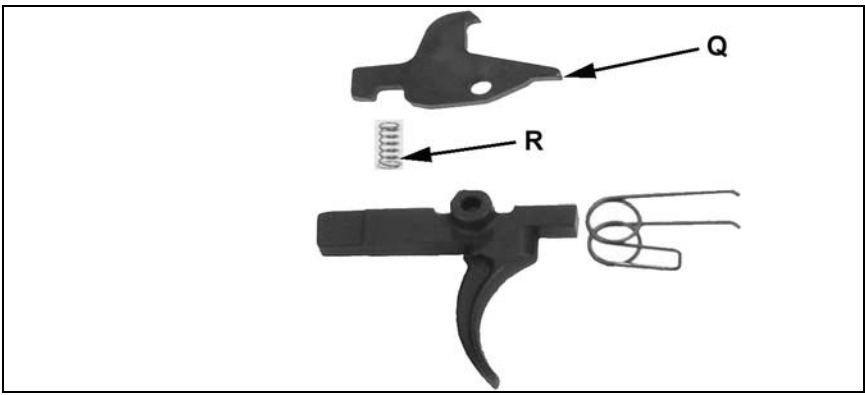


Figure 6

7. Attach the AR converted lower to the Safety Harbor upper. See figure 7.



Figure 7

DISASSEMBLE FOR CLEANING

⚠ Disassembling the firearm and the handling of ammunition and cleaning products may result in exposure to lead and other substances known to cause birth defects, reproductive harm, cancer, and other physical injury. Wash hands thoroughly after exposure. Read and follow the warnings and labels of all ammunition and cleaning products carefully.

⚠ 1. Verify that the firearm is not loaded. See Unloading in this manual.

⚠ WARNING

Risk of serious injury or death.

Always point the firearm in a safe direction.

Verify that the firearm is not loaded before any disassembly or cleaning.

WARNING

Risk of serious injury or death.

Do not disassemble the firearm any further than instructed in this manual.

Do not modify or alter any part of the firearm.

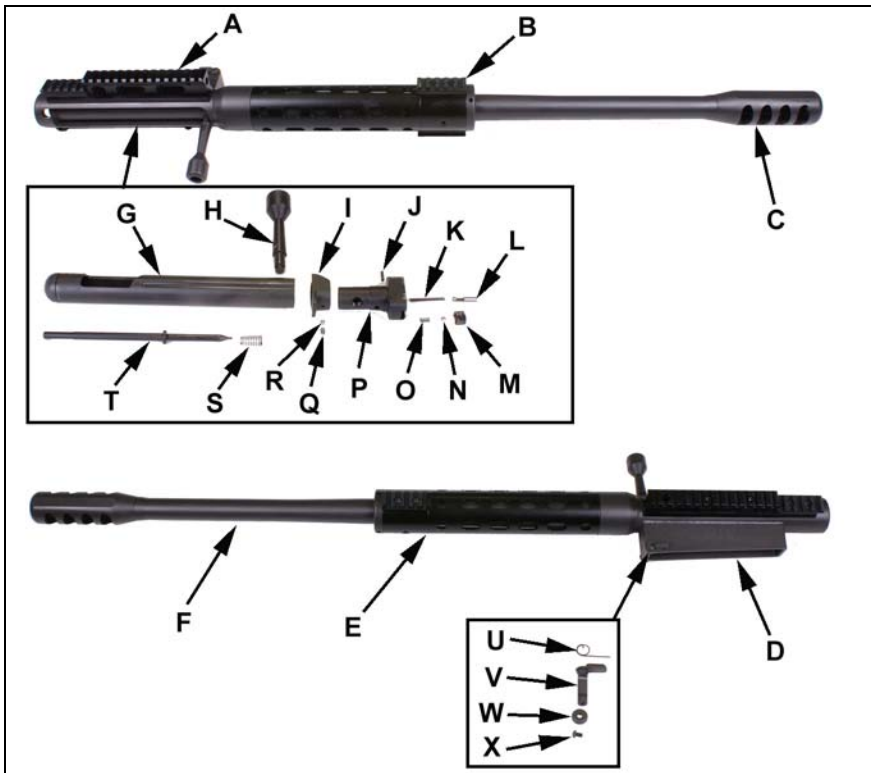
Wear the appropriate protective clothing while disassembling and assembling the firearm.

2. Using a $\frac{3}{8}$ wrench, turn bolt handle counter clockwise to remove.
3. Remove bolt head and firing pin through magazine well or ejection port.
4. Remove bolt body from the rear of the receiver.
5. Clean components with a quality gun cleaning solution. Lubricate components with a quality gun lubricant.
6. Inspect all parts for wear and damage. Carefully inspect the firing pin. Replace pin if worn, bent or if the tip is deformed.

ASSEMBLY

1. Insert bolt body into upper receiver.
2. Install firing pin and bolt into upper receiver.
3. Install bolt handle and tighten to 5-10 lb/ft of torque.

UPPER RECEIVER



- A – Scope Rail
- B – Iron Sight Mounting Rail
- C – Muzzle Brake
- D – Magazine Well
- E – Hand Guard
- F – Barrel
- G – Bolt Body
- H – Bolt Handle
- I – Bolt Head Follower
- J – Ejector Pin
- K – Ejector Spring
- L – Ejector

- M – Extractor
- N – Extractor Ball
- O – Extractor Spring
- P – Bolt Head
- Q – Bolt Head Follower Spring
- R – Bolt Head Follower Ball
- S – Firing Pin Spring
- T – Firing Pin
- U – Magazine Latch Spring
- V – Magazine Latch
- W – Mag. Latch Spring Retainer
- X – Magazine Latch Screw

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