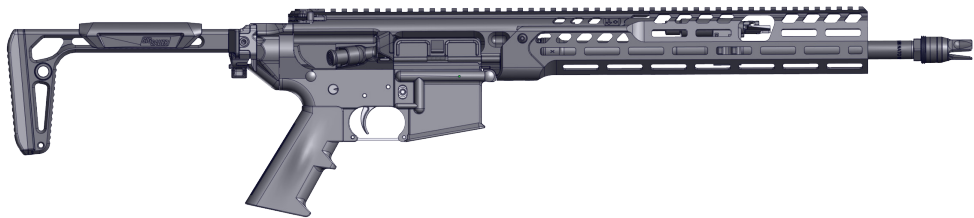


# **SIGSAUER®**



## ***MCX STOCK ADAPTER KIT***

### ***INSTALLATION INSTRUCTIONS***



READ THE INSTRUCTIONS AND WARNINGS IN THIS MANUAL CAREFULLY BEFORE INSTALLING THIS KIT. DO NOT DISCARD THIS MANUAL.



# WARNINGS

## 1.0 SAFETY WARNINGS

Read this entire manual and the manual for the host firearm thoroughly and carefully prior to installing SIG SAUER MCX Stock Adapter kits.

This manual contains important information necessary to safely install the SIG SAUER MCX Stock Adapter Kit onto an AR-15 /M4 type lower receiver assembly. Installation of this kit will eliminate the receiver extension, configuring the lower to accept a SIG SAUER MCX or SIG SAUER MCX-LT upper receiver group and MCX stock assembly.

The warnings in this operator's manual are important. By understanding the dangers inherent in the use of any firearm and by taking the precautions described in this manual, you can experience a higher level of safety in the use of your MCX Stock Adapter kit. Failure to heed any of these warnings may result in serious injury or death to you or others as well as severe damage to the MCX Stock Adapter kit, host firearm or other property.

As a valued SIG SAUER customer, we encourage you to visit [www.sigsauer.com](http://www.sigsauer.com). There, you will find links to product information and updates, merchandise promotions, and educational videos that will be of interest to you as an owner of SIG SAUER products.

The SIG SAUER MCX Stock Adapter Kit is designed to function reliably with proper care and knowledgeable use. You must understand the safe operation and use of your SIG SAUER MCX Stock Adapter Kit. Carefully read and follow these directions. Do not use the MCX Stock Adapter kit unless you fully understand these instructions and the safe operation of your host firearm.

Do not attempt to install the MCX Stock Adapter kit onto a firearm that has not been both visually and physically cleared of all ammunition.



# WARNINGS

**SIG SAUER**

## BASIC RULES OF SAFE FIREARMS HANDLING

1. ALWAYS treat every firearm as if it were loaded.
2. ALWAYS be sure the barrel is clear of any obstruction.
3. ALWAYS be sure of your backstop, what lies beyond, and the safety of bystanders before you shoot.
4. ALWAYS use clean, dry, original factory-made ammunition of the proper type and caliber for your firearm.
5. ALWAYS wear ear protection and safety glasses when shooting.
6. ALWAYS carry your firearm so that you can control the direction of the muzzle if you fall or stumble.
7. NEVER shoot at a flat surface or water.
8. DO NOT leave a loaded firearm unattended. Firearms and ammunition should be stored separately, locked if possible, beyond the reach of children, careless adults, or unauthorized users.
9. NEVER allow your firearm to be used by anyone who has not read and understood this operators manual.
10. DO NOT point any firearm, loaded or unloaded, at any undesired or unsafe target.
11. NEVER discharge your firearm near an animal unless the animal is trained to accept the noise. An animal's startled reaction could injure it or cause an accident.
12. NEVER drink alcoholic beverages or use drugs before or during shooting, as your vision and judgment could be seriously impaired, making your firearm handling unsafe.



# WARNINGS

## ALTERATIONS

This SIG SAUER MCX Stock Adapter Kit was designed to function properly in its original condition. Unauthorized alterations can make it unsafe. Do not alter any part or add or substitute any parts of this MCX Stock Adapter kit. The addition of any parts or accessories beyond the user level of maintenance described in this manual are not authorized.

## REPLACEMENT PARTS

Do not attempt to disassemble your firearm beyond the point explained in this manual. Disassembly beyond the instructions in this manual is restricted to a certified armorer or gunsmith. Failure to comply with these restrictions could void your warranty.

Warnings and instructions about the use of some SIG SAUER replacement parts, assemblies, and accessories may be described in literature accompanying the specific products. Read and carefully follow those instructions. Such warnings and instructions are provided to assure the safe functioning of the firearm. Failure to heed them may result in improper functioning, damage to the firearm, and serious injury or death to you or others.

Visit [www.sigsauer.com](http://www.sigsauer.com) to find links to product information and updates, merchandise promotions, and educational videos that will be of interest to you as an owner of SIG SAUER products.





# WARNINGS

**SIG SAUER**

## LIABILITY

This product is classified as a MCX Stock Adapter kit and is sold by SIG SAUER with the specific understanding that we shall not be responsible in any manner whatsoever for malfunctioning of the MCX Stock Adapter kit, host firearm, physical injury, or property damage resulting in whole or in part from:

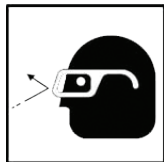
- Criminal or negligent discharge
- Improper, careless, or abusive handling
- Unauthorized modifications or parts replacement
- Defective, improper, hand-loaded, or reloaded ammunition
- Corrosion
- Neglect
- Other influences beyond our direct and immediate control

This limitation applies regardless of whether liability is asserted on the basis of contract, negligence, or strict liability (including any failure to warn). Under no circumstance shall SIG SAUER, Inc. be liable for incidental or consequential damages, such as loss of use of property, commercial loss, and loss of earnings or profits.



# WARNINGS

## 1.1 PERSONAL PROTECTION EQUIPMENT



During installation of this kit you will encounter spring loaded parts. Always wear safety glasses that meet the requirements of American National Standards Institute (ANSI) z87.1..



**WARNING: CANCER AND REPRODUCTIVE HARM—[www.P65warnings.ca.gov](http://www.P65warnings.ca.gov)**



Discharging firearms in poorly ventilated areas, cleaning firearms, or handling ammunition may result in exposure to lead and other substances known to the State of California to cause birth defects, reproductive harm, and other serious physical injuries. Maintain adequate ventilation at all times. Wash hands thoroughly after exposure. Shooting or cleaning firearms may expose you to lead.

## Contents

1.0 Safety Warnings . . . . .	2
1.1 Personal Protection Equipment . . . . .	6
2.0 General Information . . . . .	8
2.1 Product Description . . . . .	8
3.0 Disassembly . . . . .	9
3.1 Upper Receiver Removal. . . . .	9
3.2 Receiver Extension Removal. . . . .	11
4.0 Assembly . . . . .	18
4.1 Bumper Housing Installation . . . . .	18
4.2 Rail Attachment Installation . . . . .	19
4.3 Stock Installation . . . . .	21
4.4 Upper Receiver Installation. . . . .	23

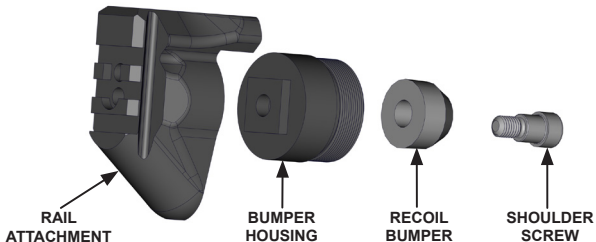


## 2.0 GENERAL INFORMATION

### 2.1 PRODUCT DESCRIPTION

This MCX Stock Adapter Kit gives you the ability to configure an AR-15 lower to accept a SIG SAUER MCX or MCX-LT upper receiver group and stock assembly. This kit is designed to accept SIG SAUER MCX and MCX-LT stocks which are sold separately. The installation of aftermarket stocks may not function properly and could impair operation of the firearm.

**SIG SAUER MCX STOCK ADAPTER KIT:** Consists of a Rail Attachment, Bumper Housing, Recoil Bumper, and Shoulder Screw.







## WARNING

**PRIOR TO PERFORMING ANY MAINTENANCE ON THE FIREARM, READ AND UNDERSTAND THE OPERATOR'S MANUAL! ENSURE THAT THE FIREARM IS UNLOADED, CLEARED, AND THE MAGAZINE IS REMOVED! FAILURE TO UNLOAD AND CLEAR THE FIREARM MAY RESULT IN INJURY OR DEATH TO THE USER OR BYSTANDERS. SAFETY GLASSES SHOULD BE WORN WHENEVER DISASSEMBLING, CLEANING, INSPECTING, OR ASSEMBLING A FIREARM.**

### 3.0 DISASSEMBLY

Rifle should be held in a vise using a magwell block during the installation of this kit.

#### 3.1 UPPER RECEIVER REMOVAL

1. Remove upper assembly group in accordance with the instructions provided with your particular firearm.



### 3.2 RECEIVER EXTENSION REMOVAL

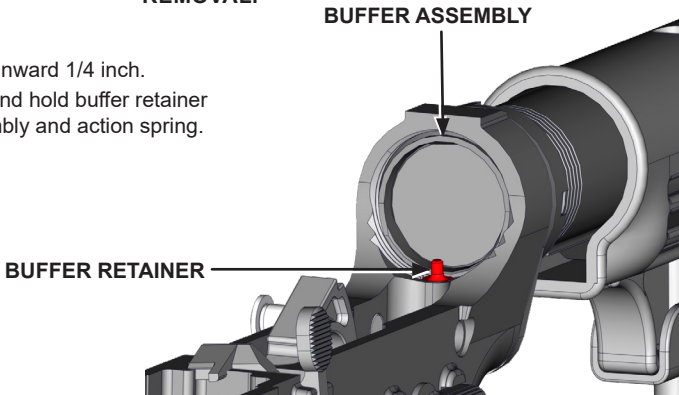


**WARNING PARTS UNDER SPRING TENSION**



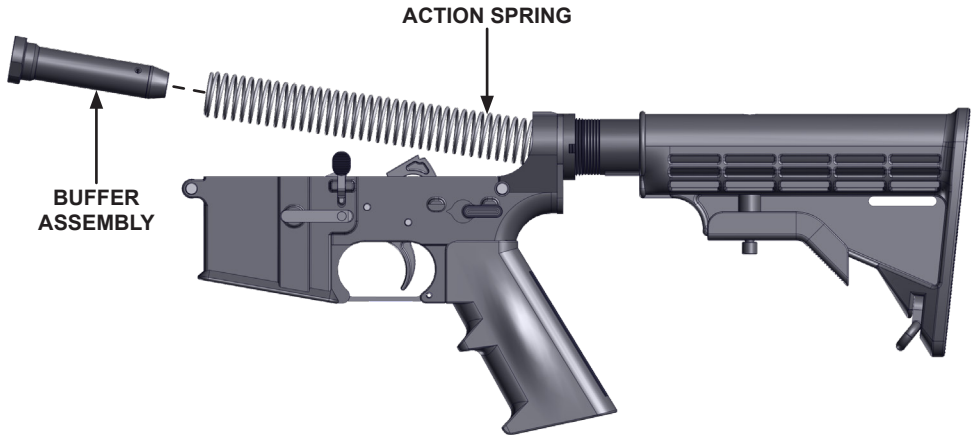
**RECOIL BUFFER RETAINER AND RECOIL BUFFER ARE UNDER SPRING PRESSURE. WEAR SAFETY GLASSES AND CONTROL THE BUFFER RETAINER AND BUFFER DURING REMOVAL.**

1. Press buffer assembly inward 1/4 inch.
2. Use a punch to press and hold buffer retainer to release buffer assembly and action spring.

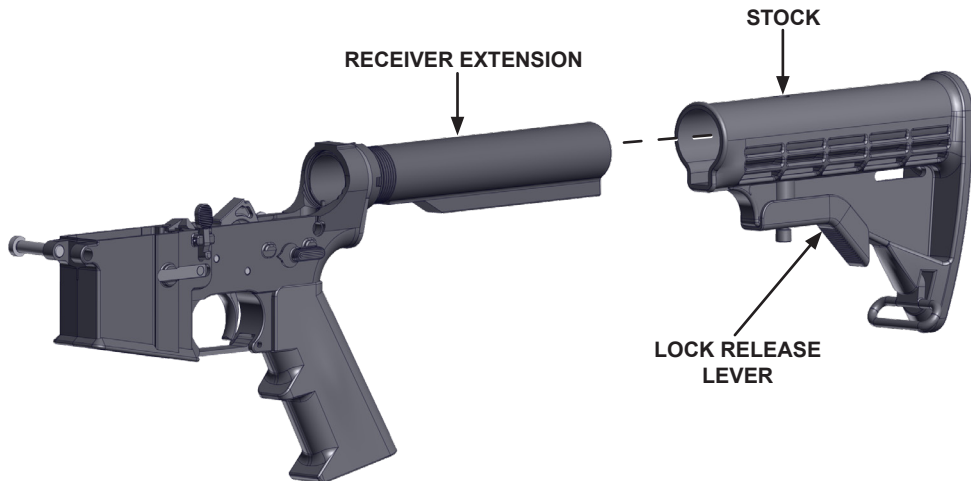




3. Carefully, remove buffer assembly and action spring from receiver extension while pressing buffer retainer.



4. Grasp lock release lever, pull downward, then slide stock to rear to separate stock assembly from lower receiver extension.

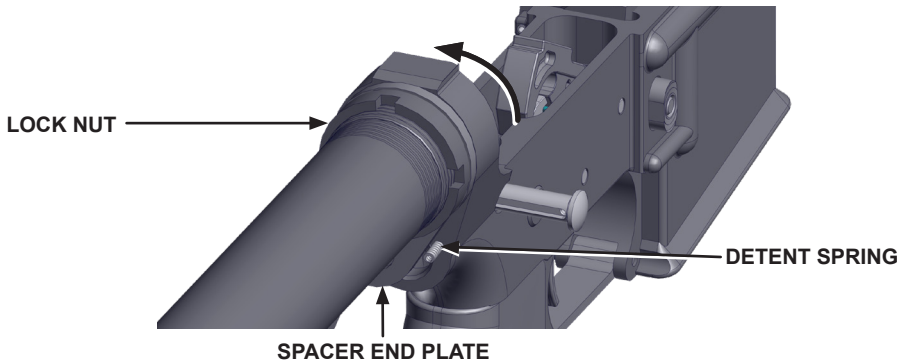




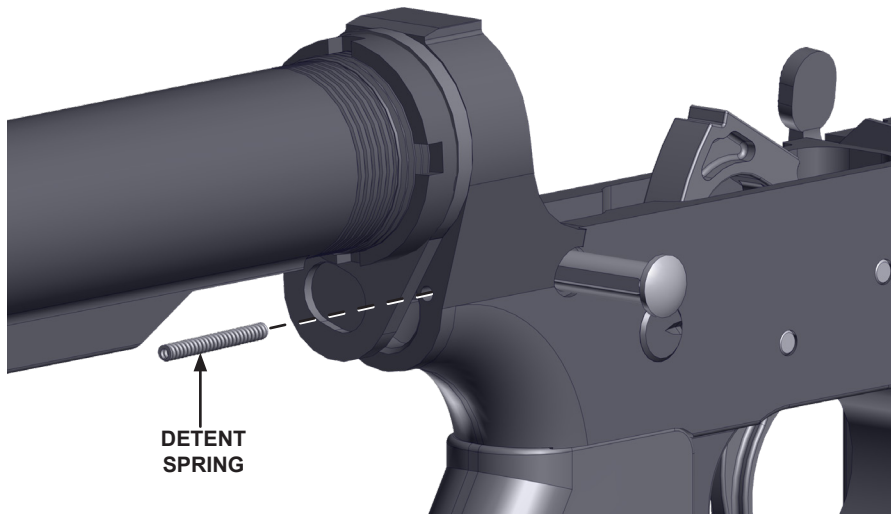
## CAUTION

THE SPACER PLATE APPLIES PRESSURE TO THE TAKE DOWN PIN DETENT SPRING. THE LIP OF THE LOWER RECEIVER EXTENSION ALSO HOLDS THE BUFFER RETAINER AND RETAINER SPRING IN THE LOWER RECEIVER.

5. Use an AR15/M4 Armorer Wrench or lock nut wrench to engage large open notches in lock nut, then loosen lock nut counterclockwise.
6. Carefully unscrew lock nut as you maintain control of spacer end plate.

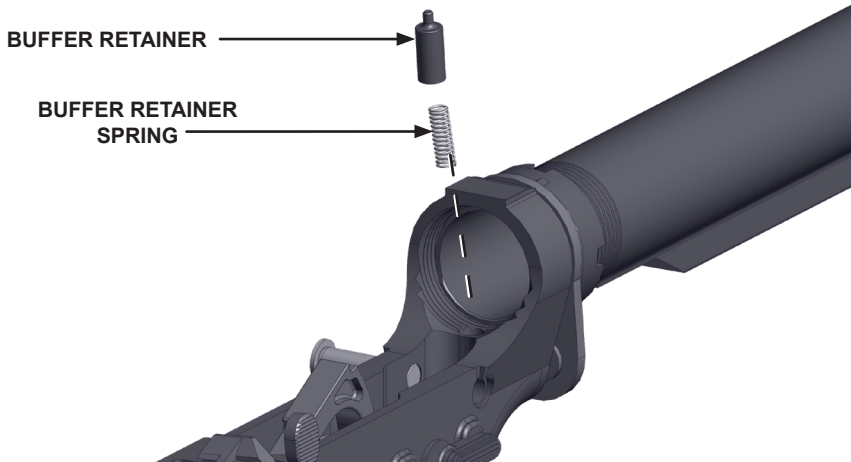


7. Once there is enough clearance, remove detent spring and set it aside for later use.





8. Unscrew lower receiver extension by hand until buffer retainer and spring can be removed.





9. Continue to remove receiver extension from lower receiver, then remove lock nut and spacer from receiver extension.

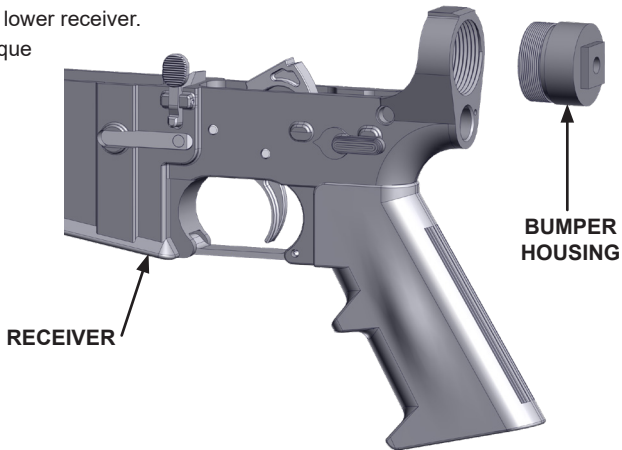




## 4.0 ASSEMBLY

### 4.1 BUMPER HOUSING INSTALLATION

1. Clean threads of receiver and bumper housing. Apply blue threadlocker #242 to bumper housing threads.
2. Thread bumper housing into lower receiver.
3. Use 3/4 inch wrench and torque bumper housing to 25 ft-lbf.



## 4.2 RAIL ATTACHMENT INSTALLATION

### CAUTION

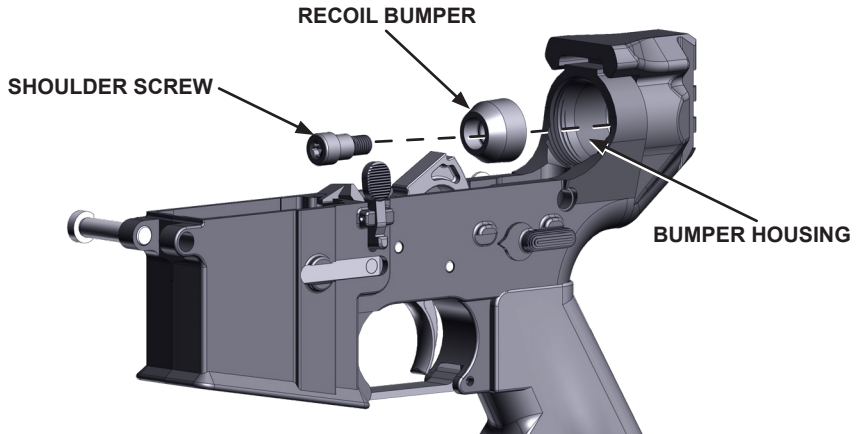
DETENT SPRING IS COMPRESSED BY RAIL ATTACHMENT DURING INSTALLATION. USE CAUTION AS NOT TO DAMAGE SPRING.

1. Install detent spring into lower receiver.
2. Position rail attachment over bumper housing and push it up against receiver.



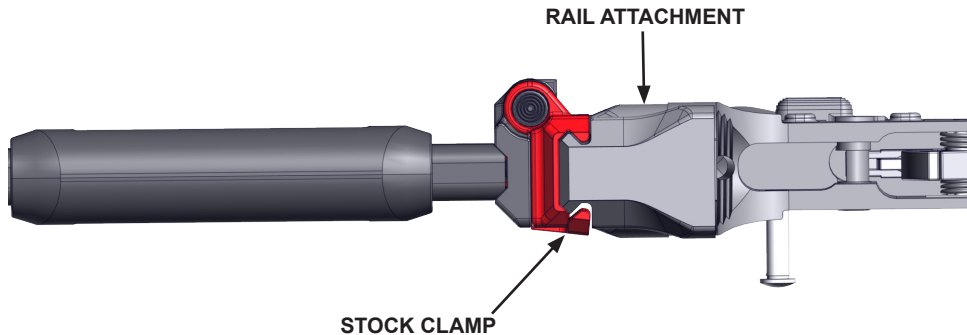


3. Clean threads of shoulder screw and apply blue threadlocker #242.
4. Insert shoulder screw through recoil bumper.
5. Install recoil bumper and screw into bumper housing with taper facing outward.
6. Using a T27 drive bit, torque shoulder screw to 70 in-lbf.



### 4.3 STOCK INSTALLATION

1. Install stock clamp to the MIL-STD 1913 rail on the rail attachment.



\*SIG SAUER MCX Minimalist Stock shown.



2. Using a T27 drive bit, tighten clamp screw until snug. Do not over tighten.



#### 4.4 MCX UPPER RECEIVER INSTALLATION

1. Attach MCX or MCX-LT upper receiver group to lower receiver. Push pivot pin in from right to left until it stops.





2. Close the upper and lower receivers then push in takedown pin from right to left until it stops.





**NOTES:**



## NOTES:

## **SIG SAUER® Limited Lifetime Warranty**

SIG SAUER warrants that the enclosed product was originally manufactured free of defects in material, workmanship, and mechanical function. For the lifetime of the original purchaser, SIG SAUER agrees to correct any defect in the product for the original purchaser by repair, adjustment, or replacement, at SIG SAUER's option, with the same or comparable quality components (or by replacing the product at SIG SAUER's option); provided, however, that the product is returned unloaded and freight prepaid to:

SIG SAUER  
18 Industrial Drive  
Exeter, NH 03833

This limited warranty is null and void if the product has been misused; damaged (by accident or otherwise); fired with hand-loaded, reloaded, or improper ammunition; fired with an obstruction in the barrel; damaged through failure to provide reasonable and necessary maintenance as described in the manual accompanying this product or the original firearm; or if unauthorized repair or any alteration, including of a cosmetic nature, has been performed on this product or the original firearm. This limited warranty does not apply to normal wear and tear of any parts. Subject to the foregoing, this limited warranty confers the right to have the covered firearm or its parts repaired, adjusted, or replaced exclusively upon the original purchaser, which right is not transferable to any other person. No implied warranties of any kind are made herein, and this warranty does not apply to any accessory items attached or appurtenant to the firearm. In no event shall SIG SAUER be liable for any incidental or consequential damages arising from or in connection with this limited warranty.

**SIG SAUER®**

[sigsauer.com](https://sigsauer.com)

**SIG SAUER, Inc.**  
**72 Pease Boulevard, Newington, NH 03801 USA**

All trademarks, service marks, trade names, trade dress, product names, and logos appearing in this manual are the property of their respective owners. No trademark or service mark appearing in this manual may be used without written consent of the mark's owner.