

# SIG SAUER 522 RECOIL SPRING KIT UPGRADE

## SAFETY WARNING

Your SIG522 RECOIL SPRING KIT UPGRADE comes with all the necessary components and instructions to properly install this kit in your SIG SAUER 522 rifle. Failure to follow these instructions and properly install the supplied components can result in the improper function of your rifle.

Read these instructions and refer to your SIG SAUER 522 Owner's Manual until you fully understand the procedures required to install these parts. If you have any doubts about your ability to complete the installation process you should seek guidance from a qualified gunsmith or contact SIG SAUER Inc.

## EYE PROTECTION

Some parts used in this procedure are under spring tension. Proper safety glasses should be worn while performing this installation.

## AMMUNITION

Keep all live ammunition out of the work area. Unload and clear your rifle prior to bringing it into the work area and beginning this installation.

**To unload and clear your SIG SAUER 522 rifle: (Refer to owner's manual section 5.0 on page 33).**

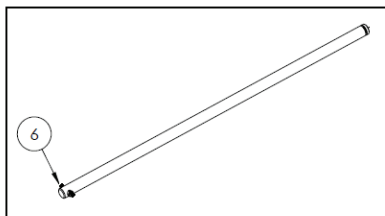
1. Depress the magazine catch and remove the magazine if present.
2. Retract the charging handle and lock the bolt to the rear.
3. Rotate the fire control selector to "SAFE"
4. Visually and physically inspect the chamber to ensure it is clear of ammunition.
5. Release the bolt to its forward position.

## Removing the bolt from the SIG522 rifle

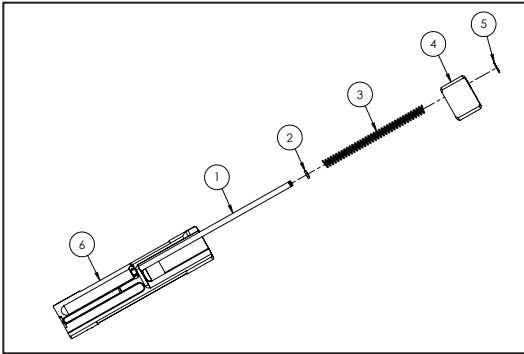
1. Press the rear takedown pin from left to right until it stops at detent (It is captive and will not remove from the receiver).
2. Pivot the receiver's apart.
3. Retract the charging handle to its rearward most position exposing the buffer.
4. Pull the charging handle outward and remove the bolt.
5. Remove the retaining ring from your current bolt and remove the recoil guide rod and components.

## Assemble the Recoil Spring Upgrade Kit

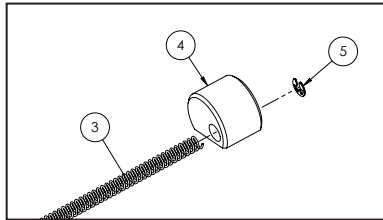
1. Using a hammer and a 1/16" roll pin punch drive the roll pin (#6) into the hole in the recoil guide rod (#1) until it is centered in the guide rod.



2. Secure the bolt in a padded vise with the firing pin hole facing downward.
3. Slide the guide rod up through the hole in the bolt.
4. Slide the recoil spring washer (#2) over the guide rod.



5. Slide the recoil spring (#3) over the guide rod (#1).
6. Grasp the recoil guide rod and spring assembly and insert it into the deeper hole of the buffer (#4).



7. Push it through until the end of the recoil guide rod is exposed (you should see the groove for the external retaining ring (#5) once you push the rod through the buffer #4).
8. Snap the external retaining ring onto the recoil guide rod ensuring it is completely into the groove of the guide rod.
9. Apply a light coat of lubricant to the recoil spring at this time.

### Installing the Upgrade Kit into the Rifle

1. Slide the bolt assembly back into the upper receiver.
2. Align the charging handle slot of the bolt with the slot in the upper receiver.
3. Slide the handle back into the bolt ensuring it is completely into the bolt.
4. Slide the bolt forward and guide the buffer into the rear of the upper receiver.
5. To close the receivers, apply slight pressure to the buffer and close the receivers together.

**NOTE: When you press the buffer slightly forward the external retaining ring should NOT be making contact against the buffer.**

6. Press the takedown pin from right to left until it stops.
7. Check bolt travel for smooth movement.

**FOR PRODUCT SERVICE OR QUESTIONS PERTAINING TO THESE INSTRUCTIONS PLEASE CALL SIG SAUER (603) 772-2302**