

SIGM400® UPPER ASSEMBLY INSTRUCTIONS

⚠ WARNING - SAFETY

Your SIGM400 upper assembly comes with all the necessary components and instructions to assemble the upper onto a properly assembled and functional AR15 type lower receiver. Failure to follow these instructions and install the supplied components can result in the improper function of your rifle.

Your SIGM400 Upper Assembly comes with a SIGM400 Owner's Manual and this instructional guide. These documents are designed to assist you in the proper installation of this upper assembly. Read these instructions and the supplied SIGM400 Owner's Manual until you fully understand the procedures required to install this upper assembly on your AR type lower. 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.

The SIGM400 Upper Assembly ships with a carbine length buffer and action spring. This is to be used in a carbine length receiver extension for a telescoping buttstock and **NOT** a rifle length receiver extension.

EYE PROTECTION

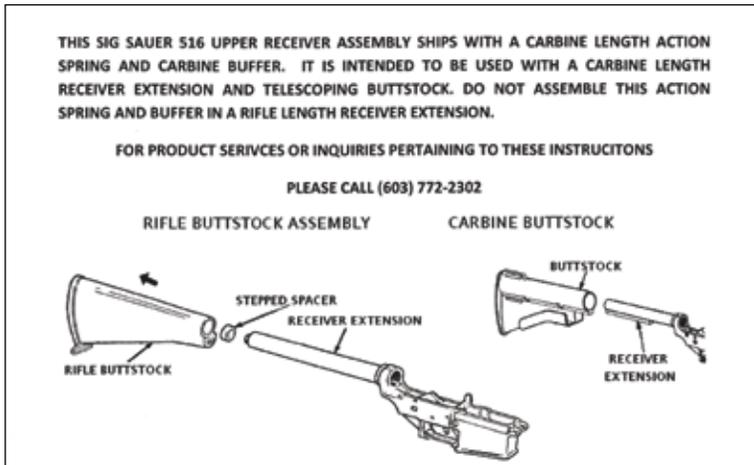
Some parts used in this procedure are under spring tension. Proper safety glasses should be worn while performing this installation.

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 AR type rifle:

1. Depress the magazine catch and remove the magazine if present.
2. Retract the charging handle and lock the bolt carrier 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.



Upper Assembly Installation Instructions

Your SIGM400 Upper Assembly comes with two additional components that require installation.

Action Spring

Recoil Buffer

The two enclosed pivot pins are for replacement on a SIGM400 lower **ONLY**.

Separate the Upper from the Lower Receiver (On your current rifle if still assembled)

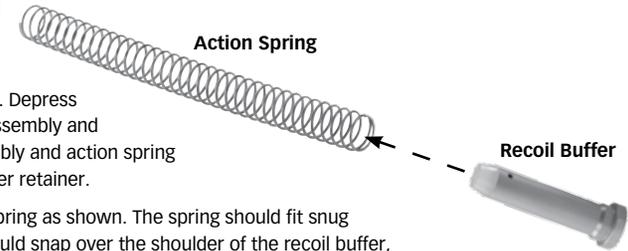
Push the Takedown pin (Rear Pin) from left to right until it reaches detent. Then push the Pivot Pin (Front Pin) in the same manner. Separate the upper receiver from the lower receiver.

Buffer and Action Spring Assembly/Installation

Removal of buffer and action spring from your current lower

Make sure the hammer is in the cocked position and the fire control selector is on "SAFE".

Press buffer assembly in about 1/4 inch. Depress buffer retainer and release the buffer assembly and action spring. Remove the buffer assembly and action spring from the receiver while depressing buffer retainer.



Insert the recoil buffer into the action spring as shown. The spring should fit snug over the body of the recoil buffer. It should snap over the shoulder of the recoil buffer, just under the large end. Grasp the head of the recoil buffer with one hand between the thumb and forefinger and, while pushing the action spring forward onto the buffer body use a clockwise twisting motion to snap it over the enlarged shoulder of the buffer.

To assemble the action spring and buffer into the receiver extension slip the action spring over the buffer retaining plunger and press the action spring the remainder of the way until the head of the buffer snaps over the buffer retainer.

Assemble the SIGM400 Upper to Your Lower

With the front pivot pin and the rear takedown pin held by the detent completely extending outward, mate the receivers together aligning the holes for the corresponding pins. Push the front pivot pin in from right to left until the detent snaps in to place. Repeat the procedure with the rear takedown pin.

⚠ WARNING - If the upper and lower receiver do not mate together and resistance or some other form of interference is present STOP. DO not attempt to force the receivers together or fire the rifle. Contact SIG SAUER or a qualified gunsmith.

Conduct a Function Check

1. Insert an empty magazine into magazine well until it locks.
2. Pull down to ensure it is locked in place by the magazine catch.
3. Pull charging handle fully back then push it forward into locked position. Bolt carrier should be held to the rear by the bolt catch.
4. Depress magazine catch and release magazine.
5. Push top of bolt catch to release bolt carrier. Carrier will travel forward into the locked position.
6. Set fire control on SAFE.
7. Press trigger to the rear and release it. Nothing should occur.
8. Set fire control selector on SEMI.
9. Press trigger to the rear and **DO NOT RELEASE IT**. You should hear a loud click as the hammer falls. **KEEP TRIGGER PRESSED TO THE REAR.**
10. Pull charging handle to the rear and release it while keeping trigger pulled. Hammer should not fall but be held by the disconnect.
11. Release the trigger. A click should be heard as the hammer is caught by the trigger sear.
12. Press the trigger and the hammer should fall.

⚠ WARNING - If the rifle does not react to the function check described above or you are not certain on how to perform this diagnostic procedure, please contact SIG SAUER or a qualified gunsmith.

SIGM400® UPPER ASSEMBLY SPECIFICATIONS

	Classic	Swat	Enhanced Carbine	300 Blk ECP	ECP
Caliber	5.56x45 NATO	5.56x45 NATO	5.56x45 NATO	.300 BLK	5.56x45 NATO
Op Sys	Direct Gas Impingement	Direct Gas Impingement	Direct Gas Impingement	Direct Gas Impingement	Direct Gas Impingement
Overall Length	24.9"	24.9"	24.9"	24.9"	24.9"
Barrel Contour	M4 Profile	M4 Profile	M4 Profile	M4 Profile	M4 Profile
Barrel Length	16"	16"	16"	16"	16"
Rifling	1:7 RH	1:7 RH	1:7 RH	1:6 RH	1:7 RH
Weight w/BCG	4.3 Lbs	4.5 Lbs	4.3 Lbs	4.2 Lbs	4.6 Lbs
Flash Suppressor	M16A2 Style	M16A2 Style	M16A2 Style	M16A2 Style	M16A2 Style
Handguard	M4 Type	Sig M1913 Quad Rail	Magpul MOE	Magpul MOE	Magpul MOE
Muzzle Thread	1/2x28 TPI	1/2x28 TPI	1/2x28 TPI	5/8x24 TPI	1/2x28 TPI
Front Sight	Forged 'F' Marked	Forged 'F' Marked	Forged 'F' Marked	Magpul Flip	Magpul Flip
Rear Sight	Alum Flip up	Alum Flip up	Magpul Flip	Magpul Flip	Magpul Flip

Features & Benefits

- Direct gas impingement system
- Nitride treated barrel
- Threaded Muzzle with flash suppressor
- Variety of hand guard options
- Chrome lined bot carrier with properly staked carrier key
- "T" marked upper receiver

**FOR PRODUCT SERVICE OR INQUIRIES PERTAINING TO THESE INSTRUCTIONS
PLEASE CALL (603) 610-3000 Ext. 3**

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INSTALLATION INSTRUCTIONS**

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