

INSTALLING A PIONEER GUN WORKS ACTION SPRING SET



IMPORTANT NOTICE, PLEASE READ BELOW!!!!

*There are two specific details that **MUST** be acknowledged before and **DURING** installation of the Action Spring Kit assembly.

1: There is a **“High Ridge”** on the cam surface of the lever of most 1873, and 1866 STOCK model rifles. These high ridges have a sharp edge to them, and if not modified as instructed by our action spring installation video (**refer to the tech. info page on our website**) will cause premature damage to the tip of the spring arm! This high ridge **MUST** be attended to appropriately **BEFORE** installation of the action spring arm on the left side of the rifle! **Repeat, this is a MUST!!!**

2: When installing the spring arm on the right side of the rifle, after screwing the spring arm in place, **take a metal punch or similar tool, and with a small hammer, tap along the length of the spring arm.** This will insure that the full area of the tip of the spring arm is riding on the full surface area, of the cam surface of the lifter arm. Performing this procedure every time the spring arm is installed/re-installed, will assure there will be no premature wear to the surface of the cam on the lifter arm, OR the tip of the spring arm.



The Action Spring set consists of a left and right side spring assembly. Each spring assembly contains a mounting base, pivot arm, and tensioning rod.

1: After removing the side plates and toggle link assemblies, remove the stock lever and lifter arm springs and screws. Wedging a flat head screwdriver tip underneath the arm of the spring, and gently popping the tips from the cam surface areas of the lever and lifter arms, then unscrewing them, can more easily remove the stock springs.

2: Hold the Action Spring mounting base and pivot arm assembly in place and thread the mounting screw in about half way, as shown in the left photo. Next, insert the tensioning rod in place – over the pivot-arm and under the base, as shown in the photo. Finally, tighten the mounting screw until the Action Spring assembly sits firmly against the bottom of the rifle's receiver, as shown in the photo. Repeat this process to mount the other Action Spring assembly on the other side of the rifle.

3: The two photos enclosed show the Action Spring set properly installed on the lever and lifter arm of the rifle. There is no need to adjust the tension, as this has been designed into the Action Springs. Be sure to tighten the spring assemblies in place, **and make sure that the tips of the pivot arms are riding completely on the lever and lifter arm surfaces where they rest.** Also, apply a small amount of oil to the pivot arms where they are mounted to the base, and to the cam surfaces of the lever and lifter arm where the pivot arm tips ride. We recommend Machine Gunner's Lube for this, which we have available for purchase.