



**CAUTION: REMOVE THE MAGAZINE AND VISUALLY CHECK THE CHAMBER TO ENSURE THAT YOUR FIREARM IS UNLOADED.**

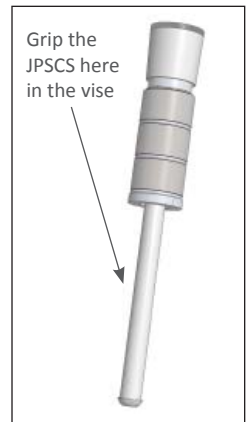
COMPARATIVE JPSCS SPRING RATES		
	JPSCS-15	JPSCS-10
HEAVIER ↓	JPSCS-15-80 White - Uncolored	JPSCS-10-100 Red - Uncolored
	JPSCS-15-85 Black - Uncolored	JPSCS-10-105 Red - Blue
	JPSCS-15-90 Green - Uncolored	JPSCS-10-110 Red - Yellow
	JPSCS-15-95 Yellow - Uncolored	
	JPSCS-15-100 Uncolored	

The JPSCS Alternate Operating Springs provide replacement springs for the JP Silent Captured Spring with different spring rates to facilitate more precise tuning and refinement of your rifle's cycling. As a general rule for selecting an alternate spring, install a heavier spring if you feel the buffer head fully compress and bottom out while firing the weapon with the existing spring in your JPSCS. If the bolt carrier will not lock back reliably on the last round fired even when completely gassed (in the case of an adjustable gas block), select a lighter spring. The ends of the springs have been color-coded for

ease of identification. To ensure your intended result, refer to the table at left in verifying both your current and replacement spring. The highlighted springs represent the default option we use and are a good starting point.

## INSTALLATION INSTRUCTIONS

1. Compress the buffer spring by hand and insert a hex key or other suitable tool into the hole in the guide rod to retain the mass. For your ease, you may wish to secure the JPSCS in a vise for this step.
2. Depending on the production run of your SCS unit, you may need to break down the thread locker if you cannot remove the screws easily. If the thread locker is too strong, apply heat with a propane torch or powerful heat gun to the guide rod while using a hex wrench to apply turning pressure to the screw. The screws of the JPSCS2 units are standard 10-32 screws that take a 1/8 hex key.



3. Remove the hex key from the guide rod while retaining the compressed mass with your hand. The spring pressure is approximately 15 lbs., so point these components away from your face as a precaution in case they fly apart.
4. Slowly relax the spring and remove both the spring and buffer mass from the guide rod.
5. Insert the new spring onto the guide rod and compress it completely with the mass slider until it reaches the bumper. Reinsert a hex key into the hole through the guide rod to retain the mass as before.
6. Install the guide rod screw and tighten it securely to retain the mass slider. The screws of the JPSCS2 units are standard 10-32 screws that take a 1/8 hex key. Remove the hex key from the guide rod.
7. Install the JPSCS into your rifle as described in the installation instructions. With your rifle reassembled with the SCS, test fire a few rounds to assess the function with the current spring.
8. When you are satisfied with your spring selection, clean the guide rod threads and screw with solvent and dry completely. Install the guide rod screw with thread locker and tighten the screw to 40-60 in-lbs. Some newer SCS kits come with screws pre-loaded with thread locker. The pre-loaded thread locker is only reusable two or three times. If you need to apply thread locker, we recommend a semi-permanent product such as Loctite® 243.

During regular rifle maintenance, check the tightness of the hex head screws at the ends of the JPSCS. The rear screw should be installed with a permanent thread locker such as Loctite® 263. The front flange screw is better secured with a semi-permanent thread locker like Loctite® 243.

**THANKS FOR YOUR BUSINESS!**