



JP ENTERPRISES

LARGE FRAME BOLT CARRIER

Product:
JPBC-4, JPBC-4A,
JPBC-5, JPBC-5A

Page: 1/2

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

This large-frame bolt carrier can be used in right-handed receivers of either the DPMS or Armalite pattern but requires use of JP or DPMS subcomponents including the firing pin, cam pin, firing pin retainer pin and bolt assembly. Use of non-compatible subcomponents may cause dangerous malfunctions such as slamfiring. For use in an Armalite-pattern receiver, we also recommend using a JP or DPMS barrel and extension. In either case, headspace should always be checked by a gunsmith prior to use.

To maximize performance advantage, the JPBC-4 low mass carrier should be used in conjunction with an adjustable gas system to allow tuning of the action velocity into the optimal range for your ammunition. This will significantly improve impulse feel and reliability.

CARRIER ASSEMBLY

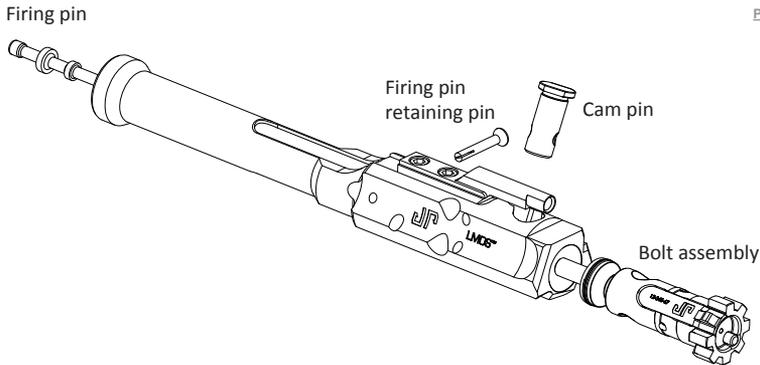
1. Install the bolt assembly into the front of the carrier with the extractor facing to the ejection port side until the cam pin hole in the bolt aligns with the rearmost section of the cam pin hole in the carrier. The extractor will be to the right at approximately 45° when looking at the carrier from the rear.
2. Insert the cam pin in the carrier and into the bolt assembly. Unlike a small frame carrier, the firing pin bore in the cam pin can be aligned with the firing pin bore in the bolt and carrier and does not need to be rotated after insertion.
3. Insert the firing pin from the rear of the carrier until it drops all the way into the center of the bolt. The firing pin should protrude from the face of the bolt when the bolt is in its rear most position.
4. Insert the firing pin retaining pin into the bore from the left side of the carrier until it protrudes from the right side of the carrier

At this point, the firing pin should move back and forth within the bolt so that it sits proud of the bolt face when pushed forward but is completely below the bolt face when pulled to the rear. The firing pin should move freely within the bolt and carrier with almost zero resistance. If the pin does not move freely, recheck your installation. If problem persists please contact JP before using this bolt carrier group in your rifle.

Visit us at www.jp Rifles.com

Rev. 06.15

P.O. Box 378, HUGO, MN 55038 • VOICE: 651-426-9196 • FAX: 651-426-2472



CARRIER INSTALLATION

1. Ensure that that bolt assembly is pushed to its forward most position. The cam pin should be centered on the top of the carrier, directly below the carrier gas key.
2. Make sure that the top charge handle is in position. Top charging handles must be inserted and slid partially forward prior to installing the carrier group. If you are using a JP side-charge upper (LRP-07 or PSC-12), the side-charge handle must be installed and pushed fully forward before the BCG is inserted.
3. Slide the bolt carrier group into the bore of the upper receiver until it locks into place in the barrel extension. The rear of the carrier should be flush or slightly below the rearmost surface of the upper receiver. Ensure that any charging handles are in their forwardmost position and locked in place
4. Reassemble the upper and lower receivers as normal.

Check for smooth function using the charging handle. Ensure that the bolt locks back when the bolt catch is depressed or an empty magazine is inserted and the charging handle is pulled. Use the bolt release to let the bolt forward without interference from the charging handle and ensure that it travels fully forward into battery.

THANKS FOR YOUR BUSINESS!