

QUATTRO-15

OWNER'S MANUAL



In order to avoid unnecessary misfeeds and maintain the reliability of the magazine, we recommend a H2 buffer over lighter or hydraulic buffers.

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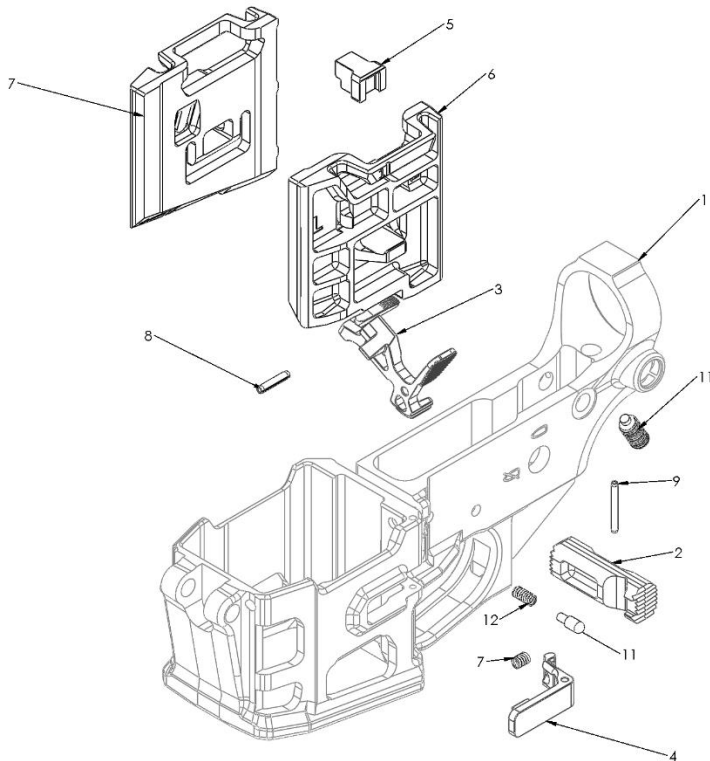


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QUATTRO Lower Instructions

Quattro Lower Receiver (QTR0004) BOM

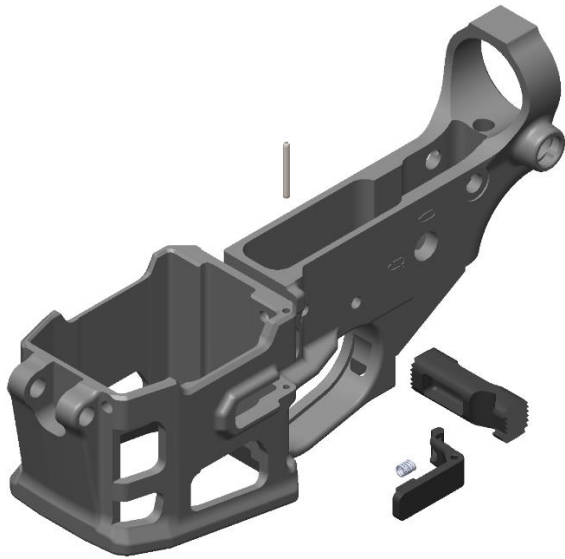


ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	QTR0004	RECEIVER, QTR	1
2	QTR0001	MAGAZINE BUTTON, QUATTRO-15	1
3	QTR0002	BOLT CATCH, QUATTRO-15	1
4	QTR0003	MAG CATCH, QUATTRO-15	1
5	QTR0007	MAG CATCH INSERT, QUATTRO-15	1
6	QTR0005	MAG WELL SIDE INSERT, QUATTRO-15 LEFT	1
7	QTR0006	MAG WELL SIDE INSERT, QUATTRO-15 RIGHT	1
8	HDW0107	MAGAZINE CATCH SPRING	1
9	HDW0106	SPRING PIN_3/32DIAx0.5	1
10	HDW0105	SPRING PIN_5/64x.75	1
11	HDW0197	NYLON TIP SET SCREW_1/4-28x0.5	1
12	HDW0198	PLUNGER, BOLT CATCH	1
13	HDW0199	SPRING, BOLT CATCH	1

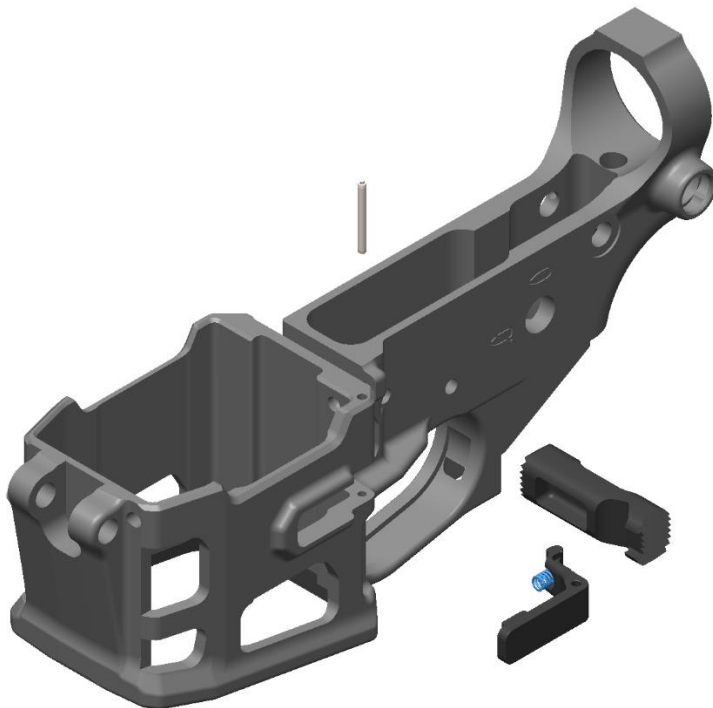


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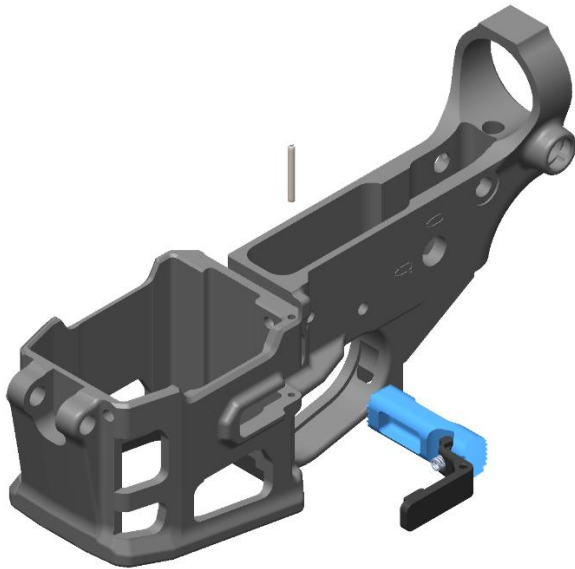
Magazine Catch Assembly (QTR0001, QTR0003, QTR0007, HDW0106)



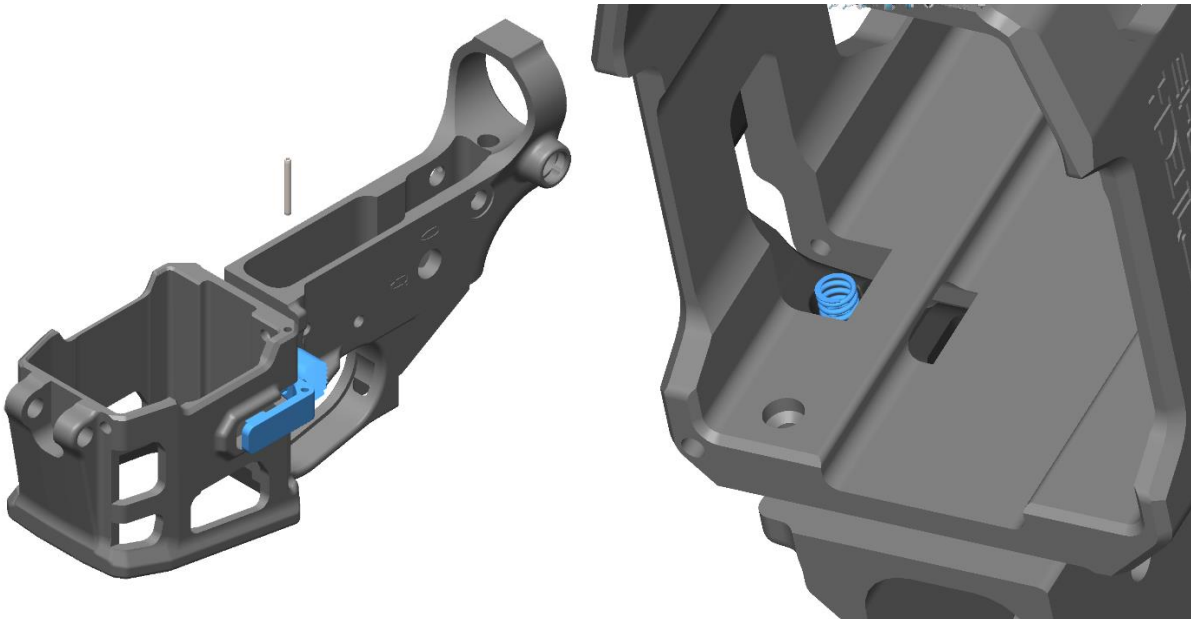
1. Insert QTR0006 into cutout on QTR0003.



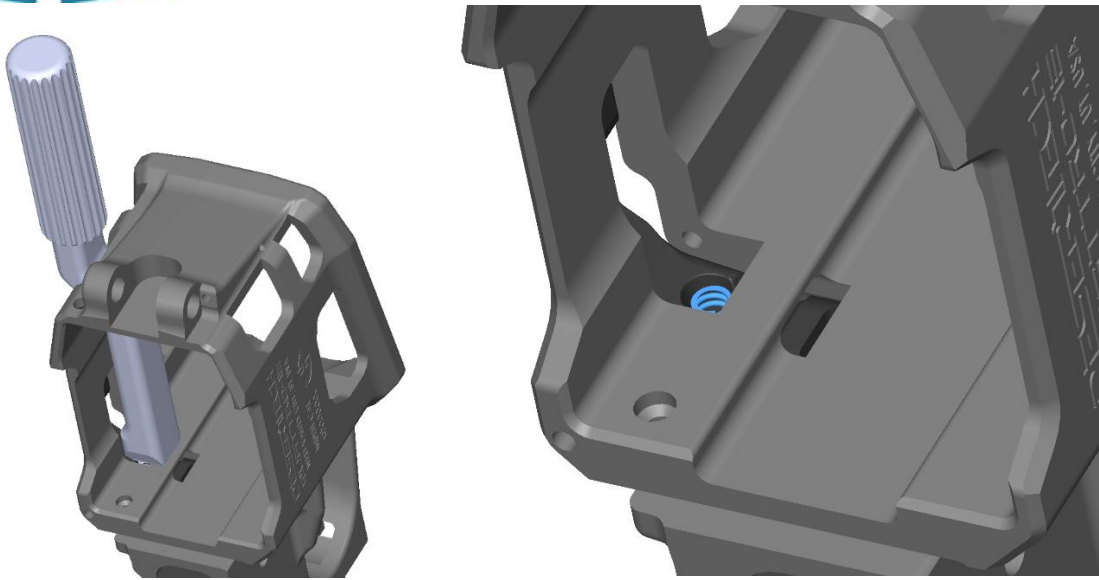
2. Insert QTR0003 into groove of QTR0001.



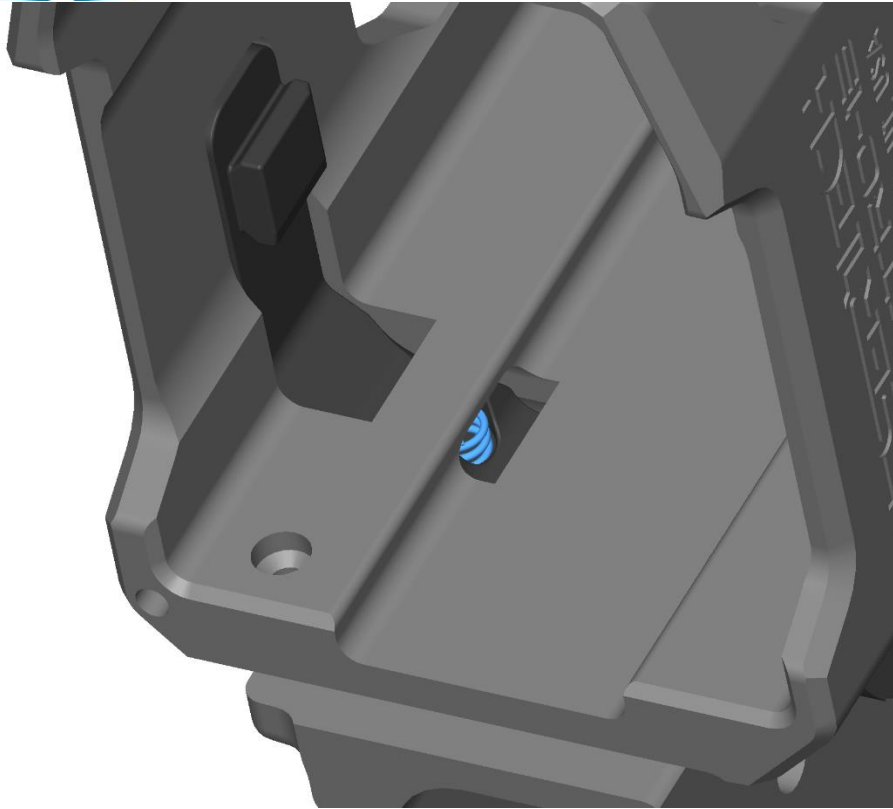
3. Insert QTR0001 partially into magazine button cut of QTR0004 until the spring QTR0006 meets the edge of the cut.



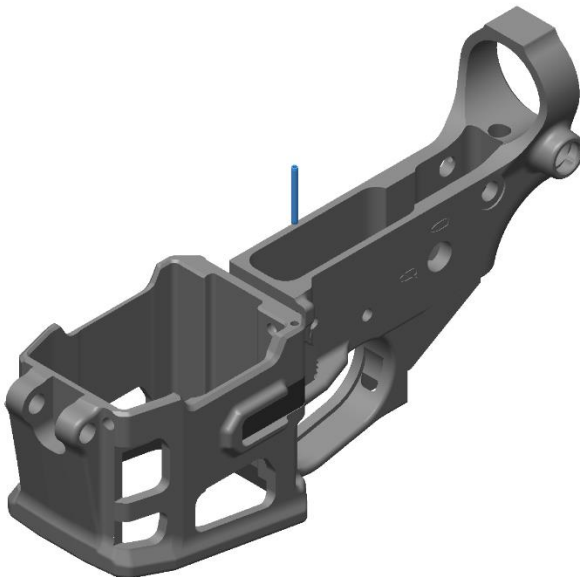
4. Compress the spring QTR0006 using a tool or a punch.



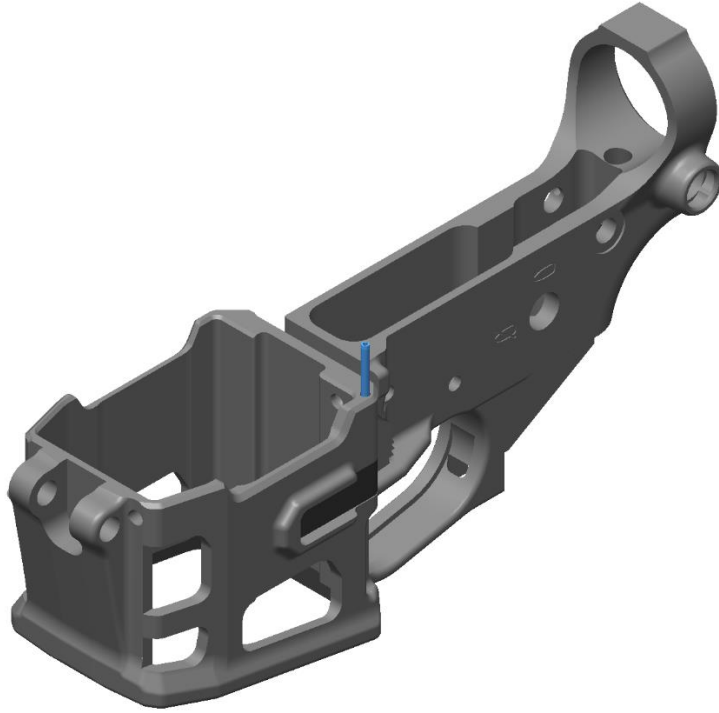
5. Push the button the rest of the way and verify the spring is oriented correctly.



6. Reorient the lower and insert pin HDW0106 into the corresponding mag catch hole.



7. It is helpful to use a guide pin or punch to align the holes.



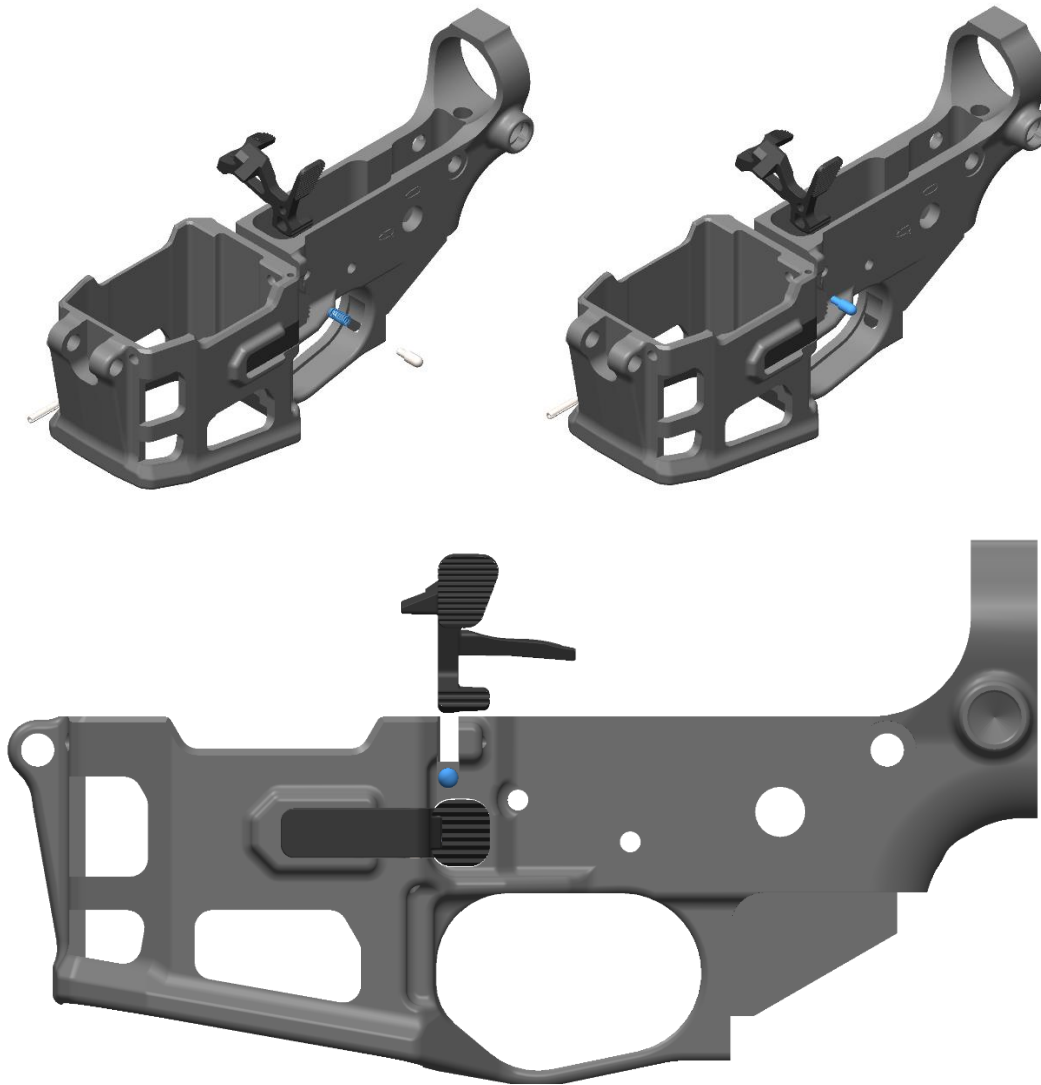
8. Drive the pin .500" down below top surface with a 3/32" dia driver. (a 5/64" dia driver is required to remove the pin)



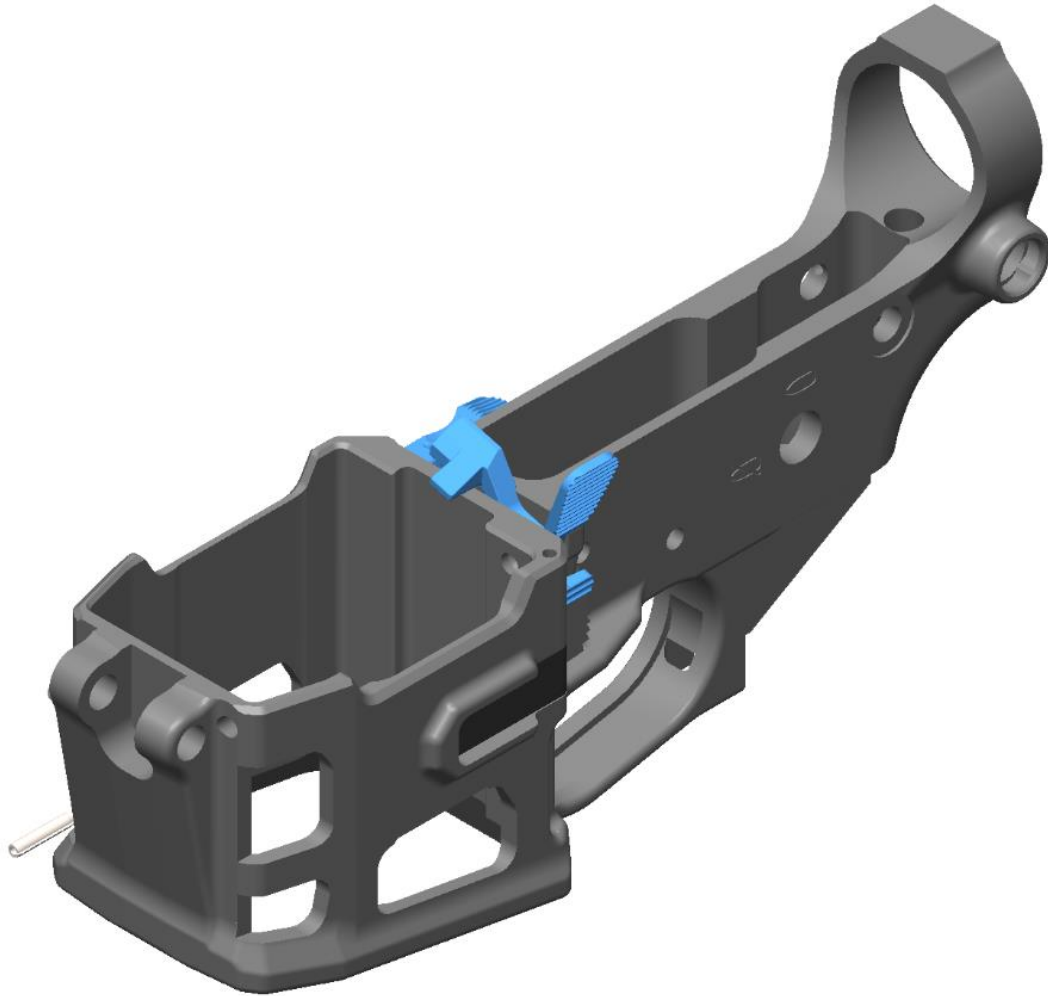
9. Verify that the magazine catch is functioning properly. Actuate the button from both sides. The button should require between 3-5 lbs and return to the engaged position each time. If necessary, repeatedly actuate the button until it returns properly.

Bolt Catch Assembly (QTR0002, HDW0198, HDW0197, HDW0107)

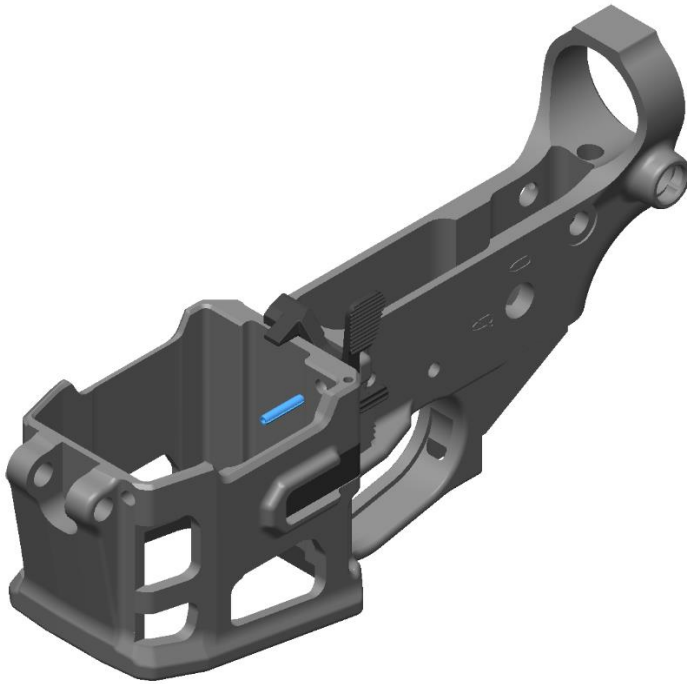
10. Reorient the lower and insert spring HDW0197 and plunger HDW0198 into the hole above the mag catch release button on the left side of the receiver.



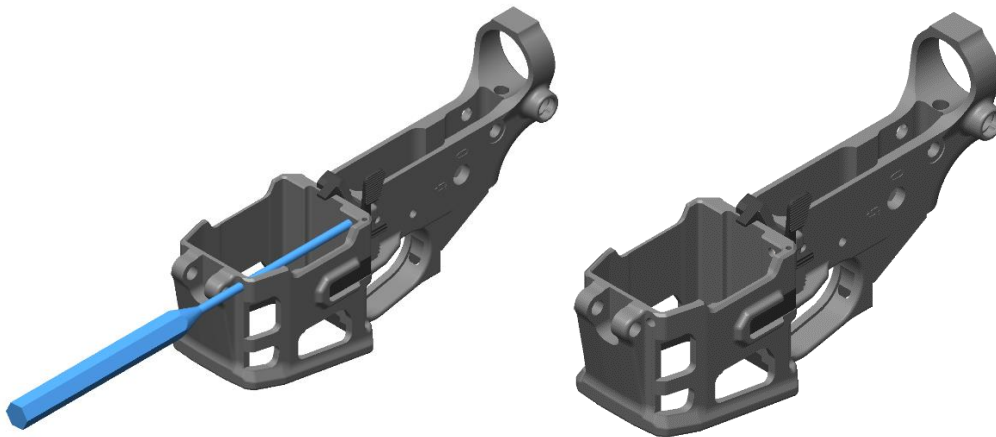
11. Starting with the left side of the receiver, hook the lower finger tab of the bolt catch QTR0002 into the lower receiver and rotate it in while compressing the plunger.



12. Insert pin HDW0199 into the corresponding hole in the lower receiver. It is helpful to use a guide pin or punch to align the holes.

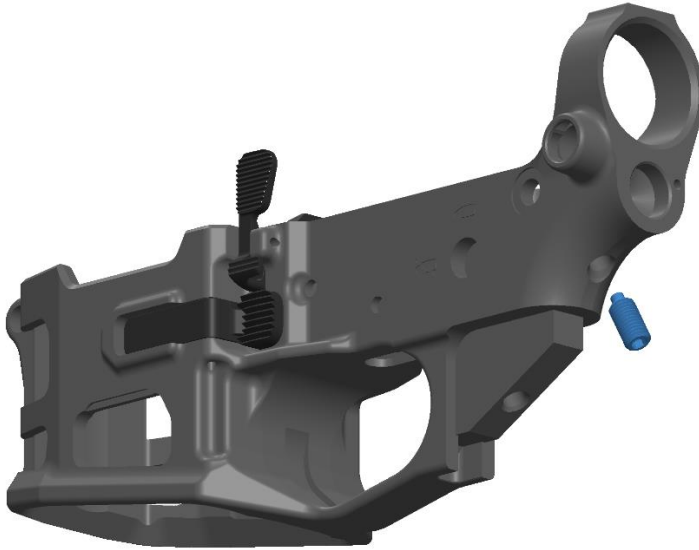


13. Drive the pin .100" down below top surface with a 5/32" dia 6" long driver from the front of the receiver. (a 3/32" dia driver is required to remove the pin)



Assembling Tensioner Screw

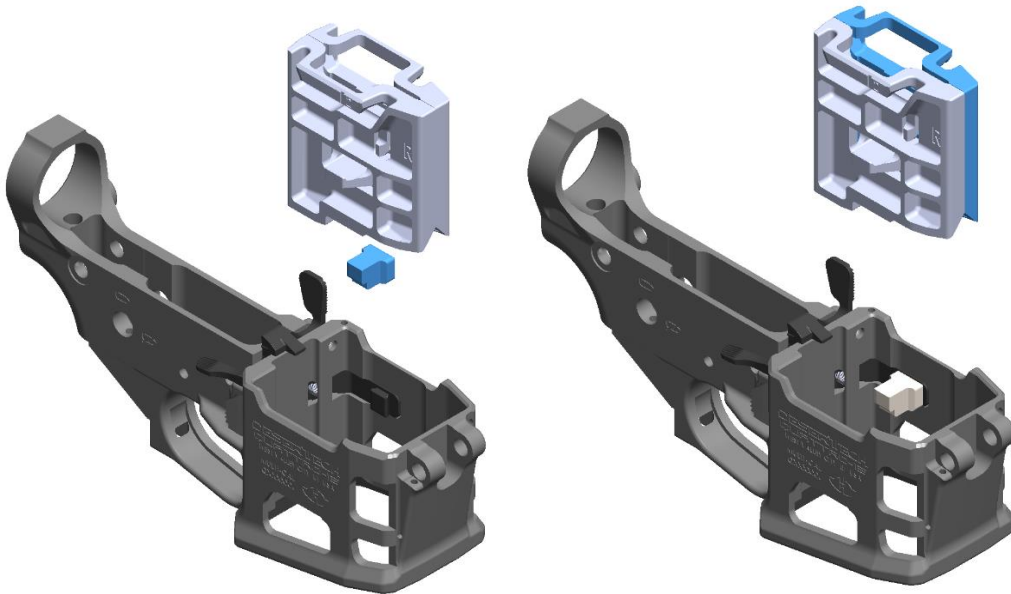
14. Screw the set screw HDW0197 into the back of the receiver leaving it slightly proud. Once the lower receiver is attached to the upper receiver it can be tension by tightening it until it contacts the take down pin then loosening it a 1/4 - 1/2 of a turn. Blue Loctite is recommended for final set.



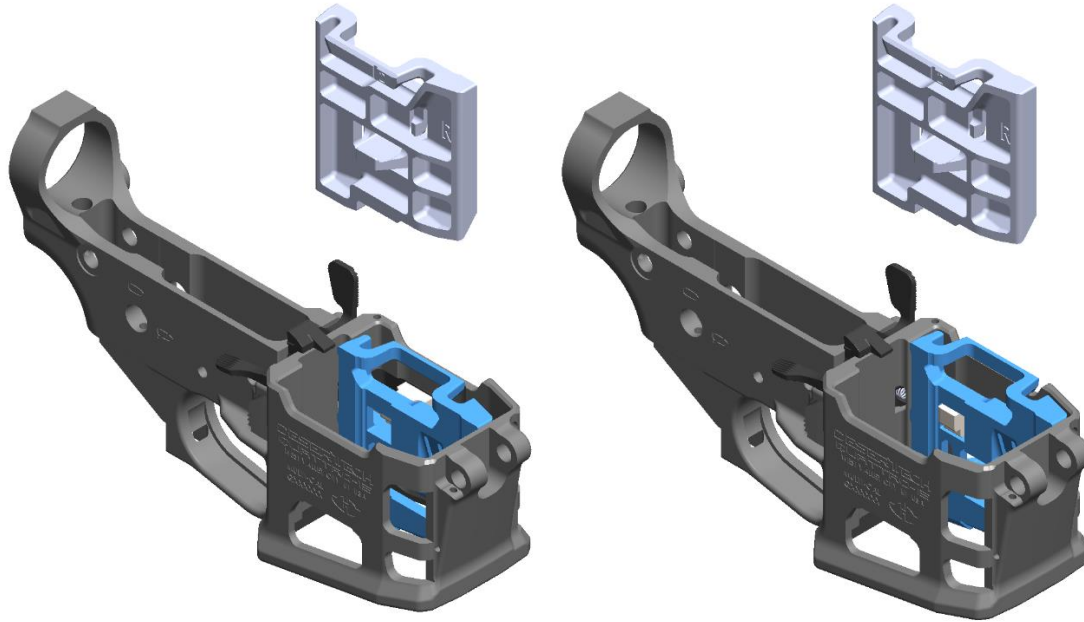
Magazine Insert Instructions

Magazine Well Inserts (QTR0005, QTR0006, QTR0007)

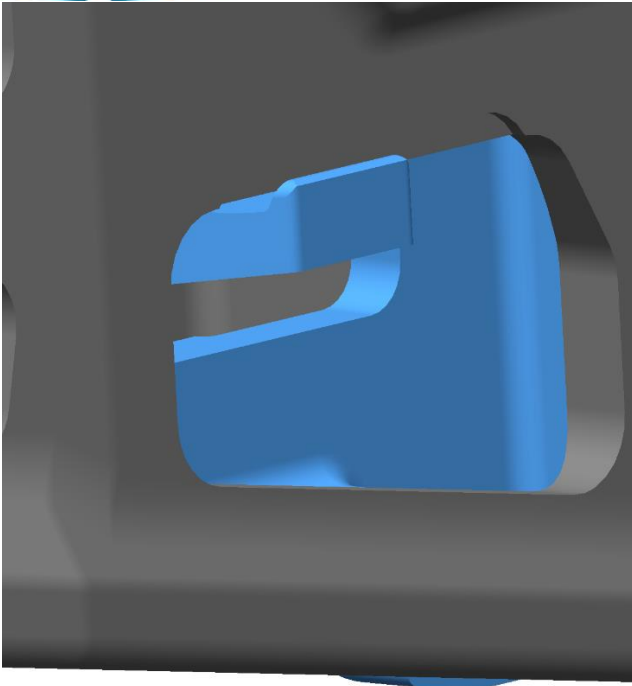
15. Insert the mag catch insert QTR0007 onto the existing mag catch from the top of the receiver by engaging the dove tails.



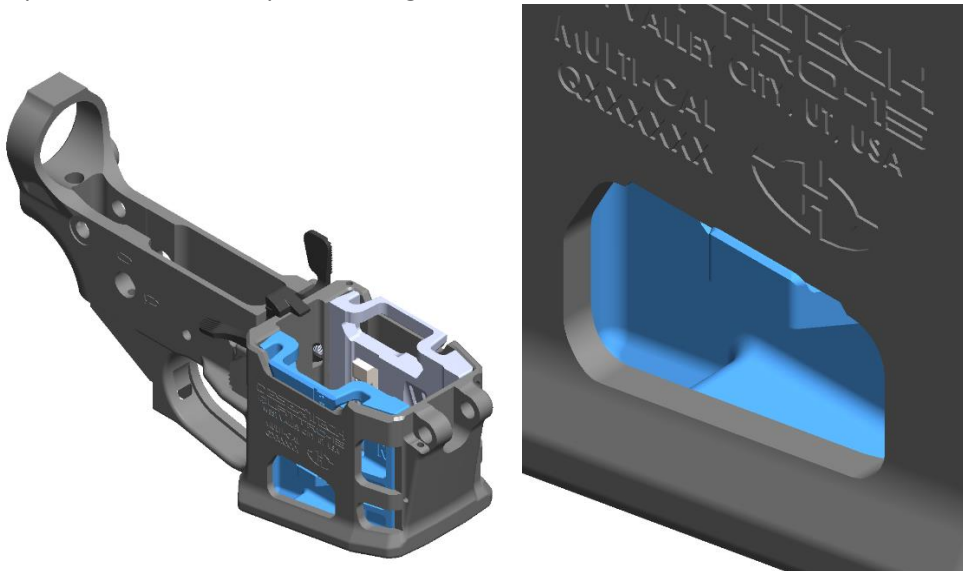
16. Insert the left insert QTR0005 into the mag well and push it to the side, over the mag catch.



17. Press firmly of the insert until the clip engages the outside of the reciever as shown.

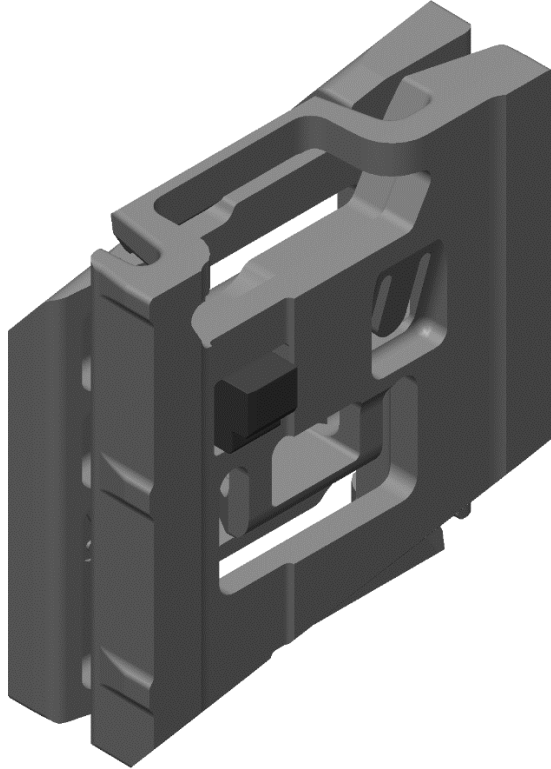


18. Repeat the last two steps for the right side.

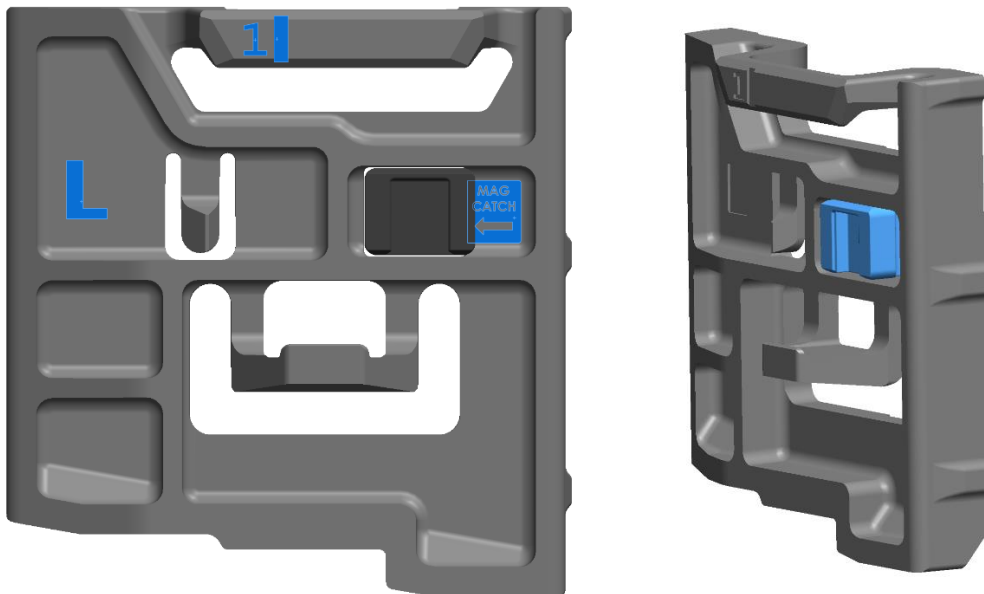


19. The inserts can be removed by releasing the clips engaged on the receiver and reversing these steps.

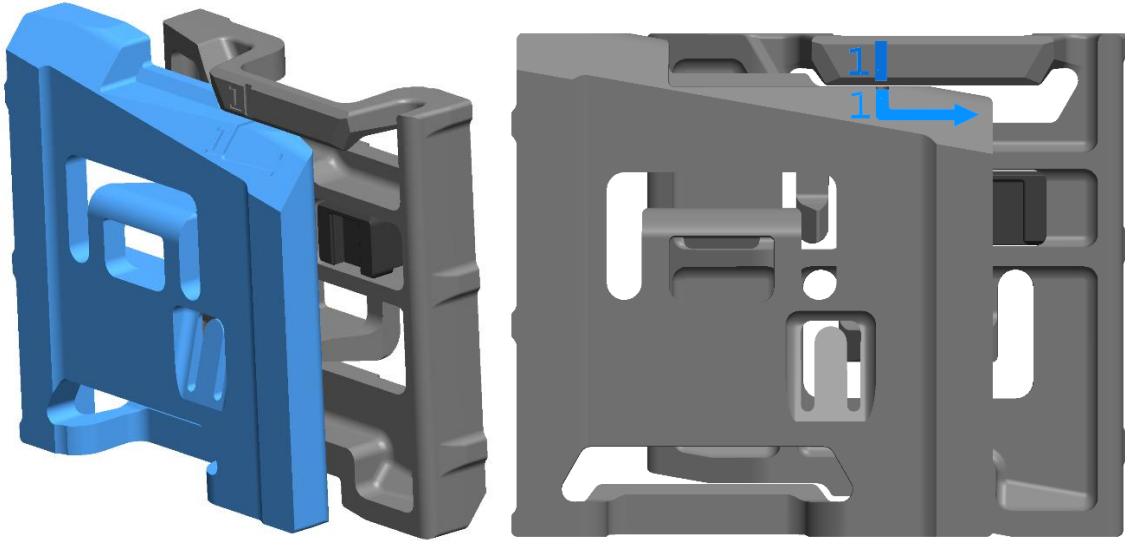
20. Once removed the mag well inserts assemble together for compact storage.



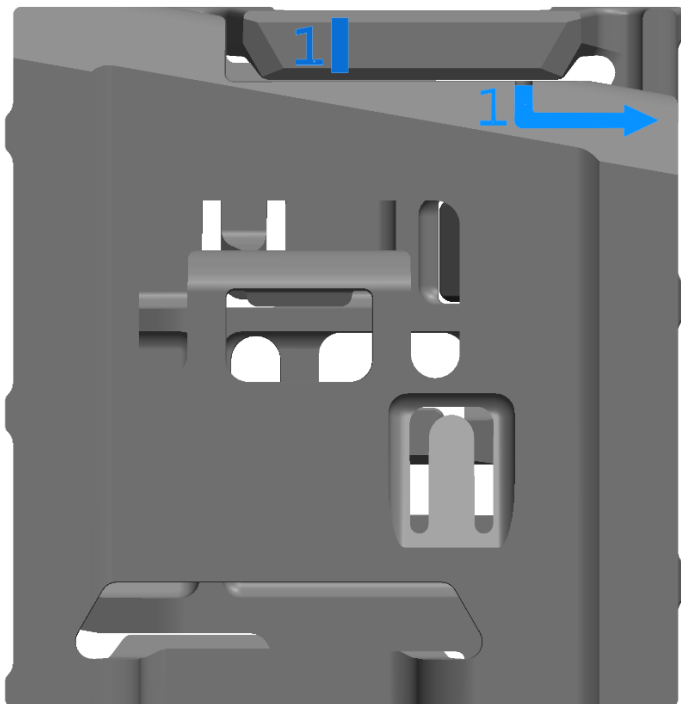
21. Place the Mag catch insert into the left well insert in the designated slot.



22. Turn one on the right insert upside down and line up the marking with the arrow.

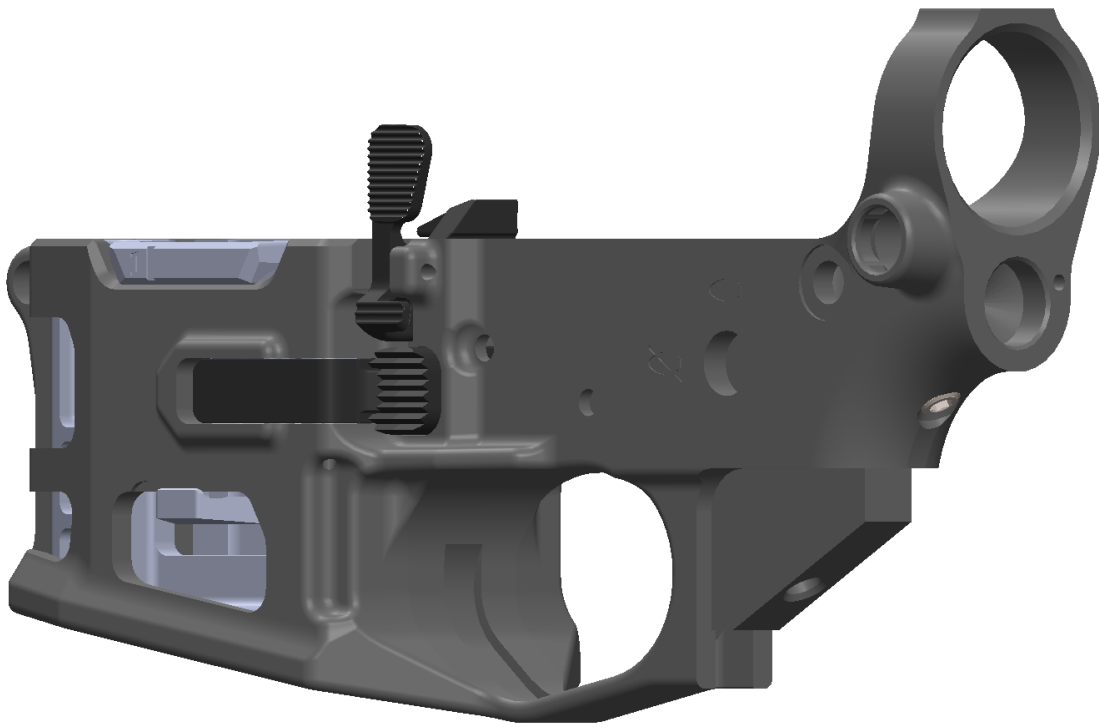


23. Slide the insert in the direction of the arrow until it stops.

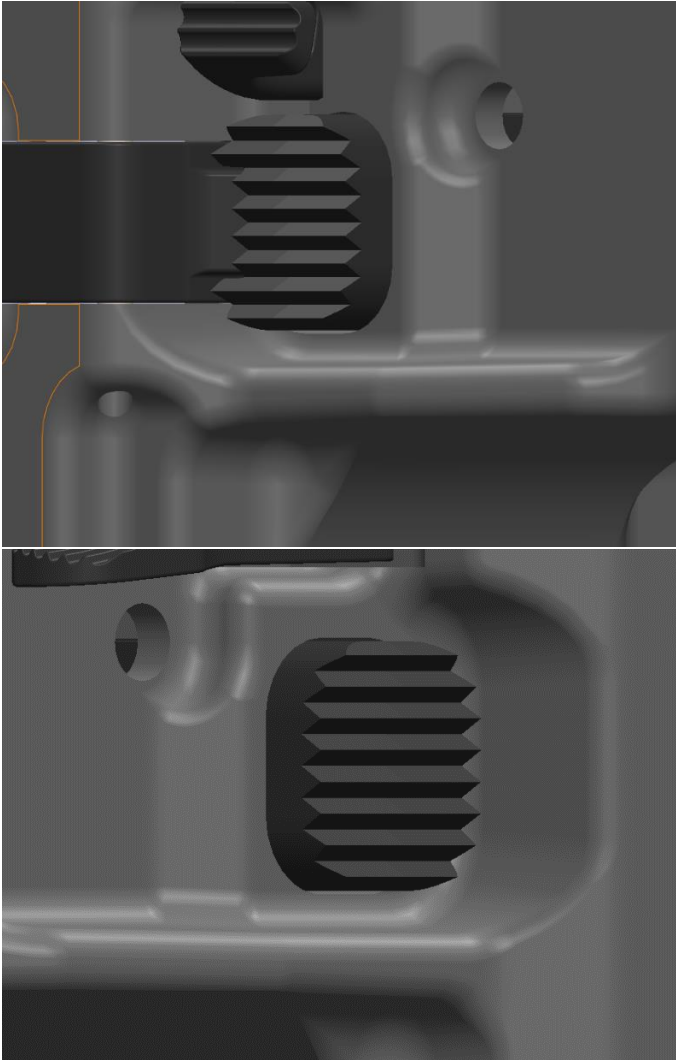


Ambidextrous Controls

(Images below to portray ambi controls)



Magazine Release (Left/Rigth)



Bolt Catch Engagment and Release (Left/Right)

