



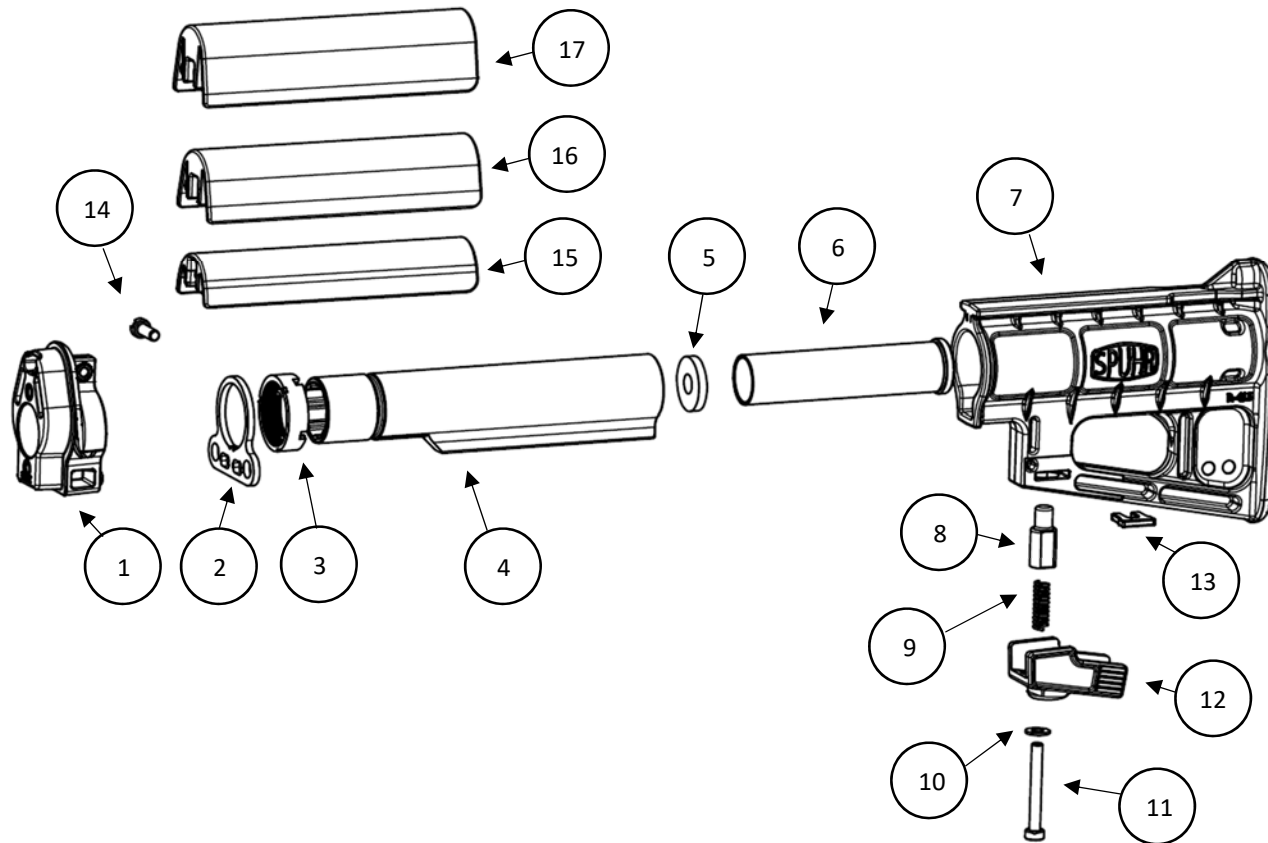
MANUAL R-410 G3 STOCK ASSEMBLY

Upon delivery the stock is assembled into one piece. Do not disassemble the stock beyond what is described below.

NOTE: Do not attempt these instructions without first ensuring that the rifle is unloaded and on safe!

1. Remove the stock assembly from the rifle. Remove the original stock from the back plate by removing the recoil pad and unscrewing and setting aside the *Buffer screw, self-locking* (HK part# 1013-041.17), *Spring washer* (HK part# A 8 DIN 127), and the two *Countersunk screw, self-locking with Toothed lock washers* (HK part# 1013-041.31 and V 5,3 DIN6798). Remove the buffer assembly from the back plate and set it aside.
2. Separate the *G3 Stock Assembly* by pulling down on the front of the *Buttstock Lever* (#12) while pulling the *Spuhr Buttstock* (#7) off the *Buffer Tube* (#4).
3. Fit the *G3 Stock Adapter* assembly (consisting of the *G3 Stock Adapter*, *Spuhr Buffer Tube*, *Rear Sling Plate*, and *Castle Nut* as a complete unit) to the Back plate. Reposition the buffer assembly into the back plate and secure it using the two *Countersunk screw, self-locking* and *Toothed lock washers* (HK part# 1013-041.31 and V 5,3 DIN6798) from step 1.
4. Secure the *G3 Stock Adapter Assembly* to the buffer assembly by sliding the *Buffer Tube Locking Washer* (#5) or the *Buffer Collet* (#6)¹ into the *Spuhr Buffer Tube* followed by the *Buffer screw, self-locking* (HK part# 1013-041.17) with *Spring washer* (HK part# A 8 DIN 127).
5. Reattach the *Spuhr Buttstock* to the *Spuhr Buffer Tube* in the opposite order of step 2 above.
6. Attach the *Cheek Piece* (#15) by sliding it onto the comb of the *Spuhr Buttstock* (#7) and then securing it to the *Stock Adapter* (#1) using the *M5x16 Cheek Piece Screw* (#14).
7. To adjust the length-of-pull push or pull down on the rear of the *Buttstock Lever* until the *Locking Plunger* is freed from the *Buffer Tube*. Release the lever when in desired position and give the *Buttstock* a slight pull to ensure the *Locking Plunger* is securely locked into the *Buffer Tube*.
8. To change *Cheek Piece*, unscrew the M5x16 screw on the right side of the *Cheek Piece* and then pull the *Cheek Piece* to the rear until it can be lifted off the comb of the *Buttstock*. To attach an optional replacement *Cheek Piece Riser* (#16 and #17) follow step 6 in the reverse order.

¹ Long/pneumatic buffers use the *R-421 Buffer Tube Locking Washer* whereas firearms with short buffers use the *R-425 Buffer Collet*.



ITEM	QTY	PART NO.	DESCRIPTION
1	1	R-411	G3 Stock Adapter
2	1	R-413	Rear Sling Plate
3	1	R-414	Castle Nut
4	1	R-412	Spuhr Buffer Tube
5	1	R-421	Buffer Tube Locking Washer (for long/pneumatic buffers)
6	1	R-425	Buffer Collet (for short buffers)
7	1	R-415	Spuhr Buttstock
8	1	R-419	Buttstock Locking Plunger
9	1	S-2106	Stainless Steel Spring 5x7x27
10	1	A-0180	5.5 mm SS Washer
11	1	S-1013	MC6S 12.9 M5x40 Screw Zi-Ni + Tuflok
12	1	R-418	Buttstock Lever
13	1	R-420	Buttstock Locking Washer
14	1	S-1014	M5x16 Cheek Piece Screw Zi-Ni + Tuflok
15	1	R-416	Cheek Piece
16	0	R-423	Cheek Piece Riser, 8 mm (optional)
17	0	R-422	Cheek Piece Riser, 12 mm (optional)