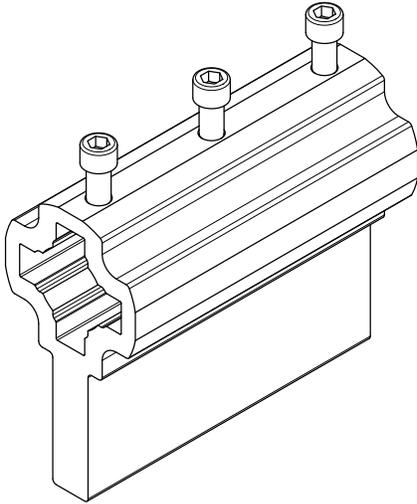


GEISSELE[®]

AUTOMATICS

We Manufacture Confidence[®]



REACTION BLOCK

DESIGNED TO BE USED
WITH MIL-SPEC BUFFER TUBES ONLY

User's Guide

READ THIS FIRST

Firearm safety is **YOUR** responsibility. You must memorize and put into practice the 4 Rules of Firearm Safety:

1. **ASSUME EVERY WEAPON IS LOADED.**
2. **KEEP YOUR FINGER OFF THE TRIGGER UNTIL YOU ARE READY TO SHOOT.**
3. **DO NOT LET THE MUZZLE POINT AT ANYTHING YOU ARE NOT WILLING TO DESTROY.**
4. **KNOW YOUR TARGET AND WHAT IS BEYOND.**

The Geissele Reaction Block is designed to aid in the assembly of lower receivers. Once the armorer has installed the buffer tube, the buffer tube can then be slid into the Reaction Block at the 3, 6, 9, and 12 o'clock positions. This allows the armorer to rotate the lower in 90 degree increments in the block simply by loosening the provided nylon screws, removing the lower, and sliding it back in at the desired orientation.

The Reaction Block provides an ultra-stable platform for performing an array of lower receiver operations, as well as making the installation of the buffer retainer nut quick and easy. All while keeping both hands of the armorer free to work, saving both time and frustration.

USAGE INSTRUCTIONS FOR COMPLETE RIFLES

1. Be certain the firearm is unloaded and the muzzle is pointed in a safe direction before starting this process. Remove the magazine and visually inspect the chamber to verify no rounds are in the weapon
2. Clamp the Reaction Block into a sturdy bench vise (FIGURE 1).

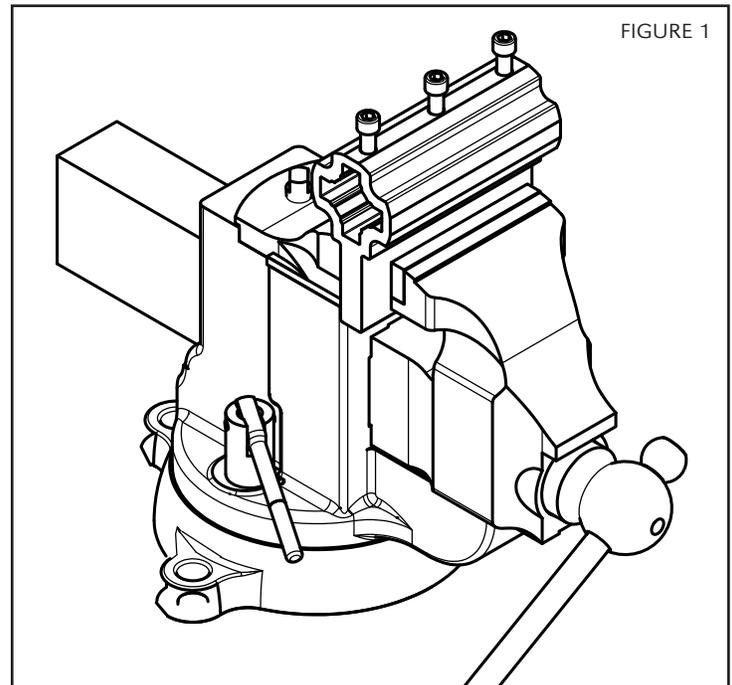


FIGURE 1

3. Separate the upper and lower receiver by removing both the front and rear takedown pins. The reaction block was only designed to aid in working on the lower receiver. *For an excellent upper receiver fixture please consider the Geissele Reaction Rod.*
4. Remove the buttstock from the carbine buffer tube. For removal instructions please consult the buttstock manufacturer.
5. Slide the buffer tube into the Reaction Block with the stock tab located in either the 3, 6, 9, or 12 o'clock positions. This location is determined by the task being completed. *Here are some examples:*
 - a. **The 3 O'clock Position:** Installation of the magazine catch and/or trigger guard (FIGURE 2a).
 - b. **The 6 O'clock Position:** Removal and installation of the trigger (FIGURE 2b).
 - c. **The 9 O'clock Position:** Removing and installing takedown pins and magazine release (FIGURE 2c).
 - d. **The 12 O'clock Position:** Installation of the grip or safety assembly (Figure 2d).

To obtain the strongest hold on your lower receiver, the buffer tube should be slid in to the block far enough that all 3 of the nylon screws tighten against the tube (FIGURE 3).

REMINDER: *The Reaction Block only fits Mil-Spec diameter buffer tubes.*

- If the receiver is positioned correctly the three retaining screws on top of the block may be screwed down by hand. These screws were not intended to be tightened with a tool or wrench; doing so could cause damage to the buffer tube or shear the screw.

USING THE REACTION BLOCK FOR A NEW BUILD

- The Reaction Block is the perfect tool for constructing a lower receiver from scratch. It acts as a 'third-hand' during some of the awkward assembly procedures.
- Before the Reaction Block can be used the buffer tube needs to be installed. To install, insert the buffer retainer pin and spring and thread the tube in until it holds the retainer pin down.
- Next, attach the receiver end plate and castle nut. The castle nut can be tightened once the buffer tube has been inserted into the Reaction Block.
- Follow Steps 5 and 6 from the previous section.

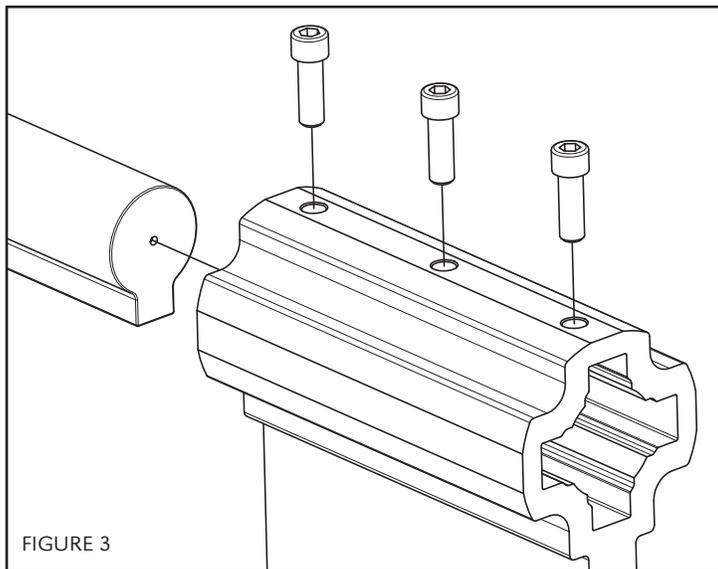


FIGURE 3

NOTES: Sliding the buffer tube in and out of the Reaction Block will eventually polish the outside of the tube; similar to what a plastic stock will do over time. To help prevent this be careful when sliding the buffer tube into the inside of the Reaction Block. A light coat of oil on the Reaction Block and buffer will also help.

If one of the plastic retaining screws is lost or misplaced do not replace with a metal screw. A metal screw will damage the buffer tube.

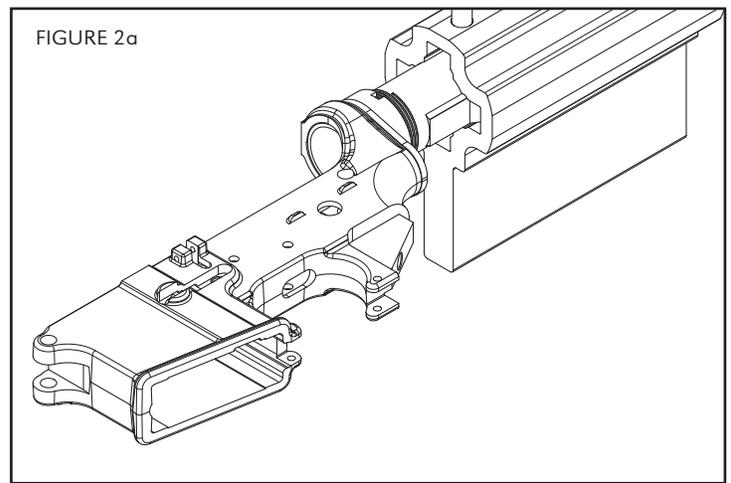


FIGURE 2a

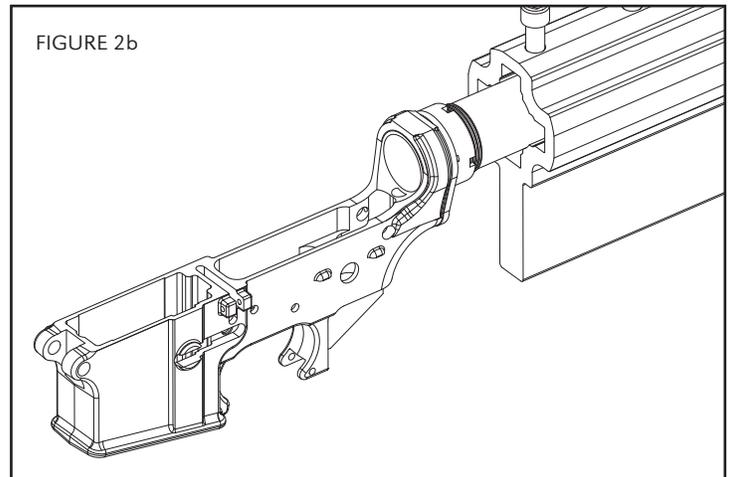


FIGURE 2b

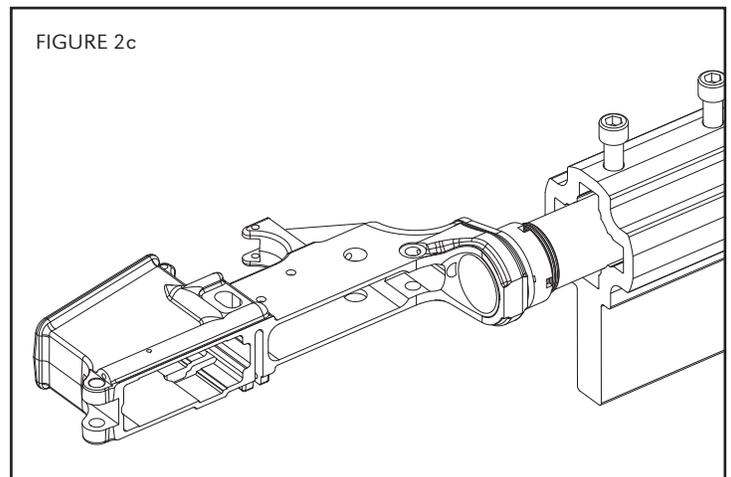


FIGURE 2c

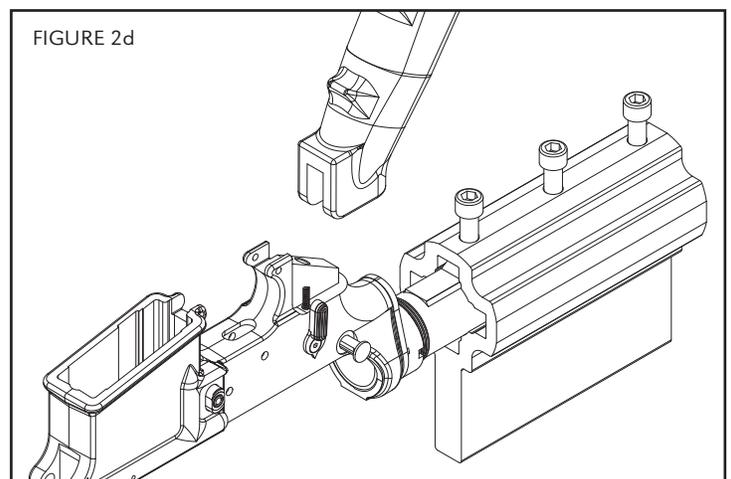


FIGURE 2d

Thank You For Your Purchase.
Contact Geissele Automatics with any questions.

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GEISSELE REACTION BLOCK INSTRUCTIONS VERSION 2 - 03/25/15