

Arming The M228 Head for Reusable Smoke Signal Rev 1.4

M228 Head Modified Specifically by NFE Tactical

Items necessary



NFE Tactical Primer Press



Compound Linesman Pliers
(Leverage Pliers)



Thread Locker (Red)



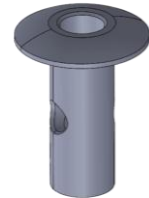
2-3mm Safety Fuse



Federal GM100M Small
Pistol Match Primers



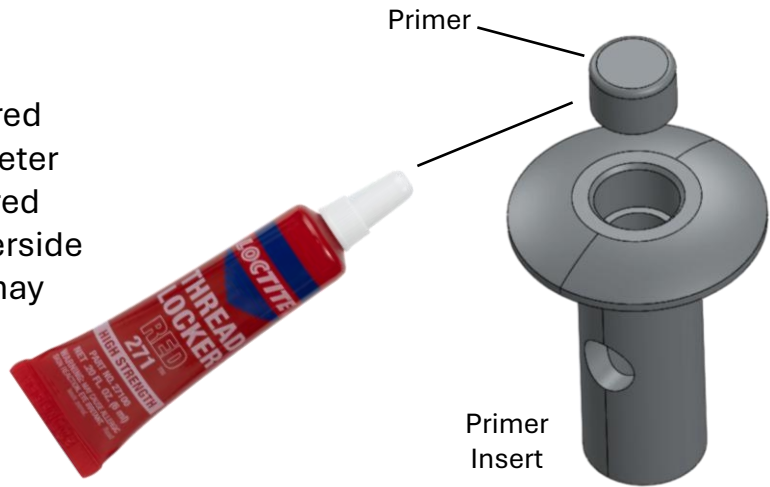
M228 Head Assembly



Primer Insert

1

Apply a small amount of red thread sealer to the diameter of the primer. Do not get red thread sealer on the underside of the primer or ignition may fail.



2

Using the NFE Tactical Primer Press, Place the primer insert into the die and place the primer on top of the hole of the primer insert. Using the red handle, press down until the primer is seated into the primer insert.



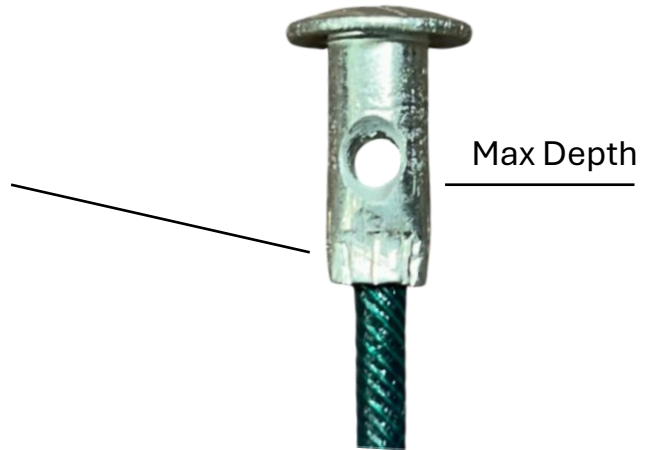
3

Cut a piece of fuse approximately 7 inches long. Using the pliers, crimp the bottom tip of the Primer Insert onto the fuse. Do not block the vent hole of the primer insert. The crimp should form a cone shape.

Glue can be supplemented for this step. Do not get glue on the exposed end of the fuse or ignition will fail.

4

Using the pull pin, hold back the striker and replace the pull pin keeping the striker locked down.

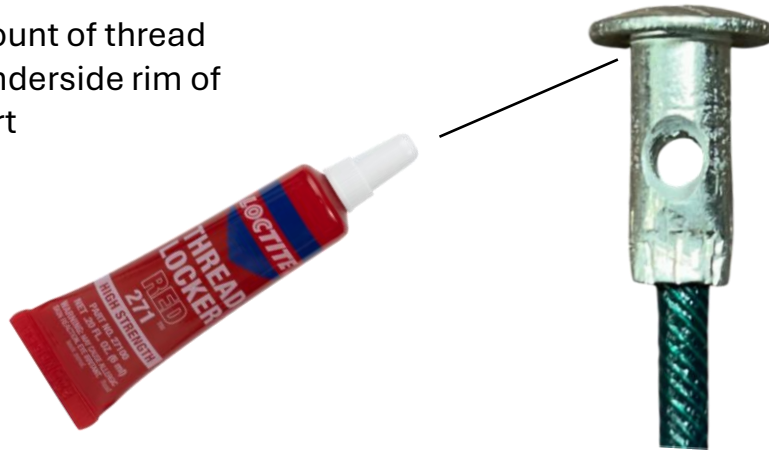


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5

Put a small amount of thread sealer on the underside rim of the primer insert



6

Place the Primer, Primer Insert & Fuse assembly into the head. Make sure the head of the Primer Insert is fully seated into the counterbore of the M228 Head. Failure to seat at the incorrect height will result in failure to ignite.



7

Hook the safety lever (Spoon) onto the M228 Head and swing down.



8

While holding the spoon downward, remove the pull pin holding back the striker and hold the spoon down all the way till the holes of the spoon line up with the holes of the head and place the pull pin back into the holes.



Do not let go of the safety lever (spoon) until it is locked in place by the pin. Failure to do so will result of striking the primer and igniting the head.



**The device is now armed
and ready to use**

Homemade smoke devices must be used the day of construction or it becomes a regulated explosive and you must abide by all requirements from the ATF. Using the M228 head for anything other than a smoke signal will be a Destructive Device and must be registered. Check with Federal and local laws.