

Installation instructions for CZ Bren 805 Bolt release

▲ WARNING: BEFORE STARTING, MAKE SURE THE WEAPON IS UNLOADED, THE CHAMBER IS EMPTY AND THE SAFETY IS ENGAGED.

Below is a step-by-step pictorial of the installation process.
Always practice safety measure including safety glasses when working with tools.

Tools required for this installation are:
Drill, Hammer, Pick tool, Utility knife, Caliper or a measuring tape/ruler,
Punch tool, 1/8" drill bit, 1/4" drill bit.

After rifle safety check, separate the Bren 805's lower receiver from the upper receiver by removing the front takedown pin.



1. Separated lower receiver. Grip fin is for CA compliance only



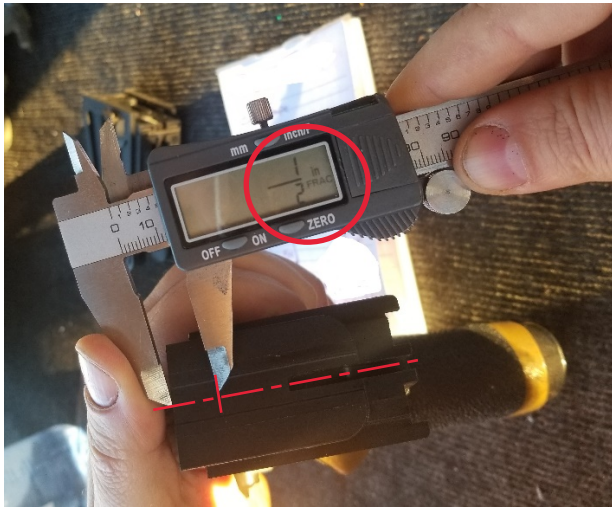
2. Using a punch tool, remove the roll pin out.



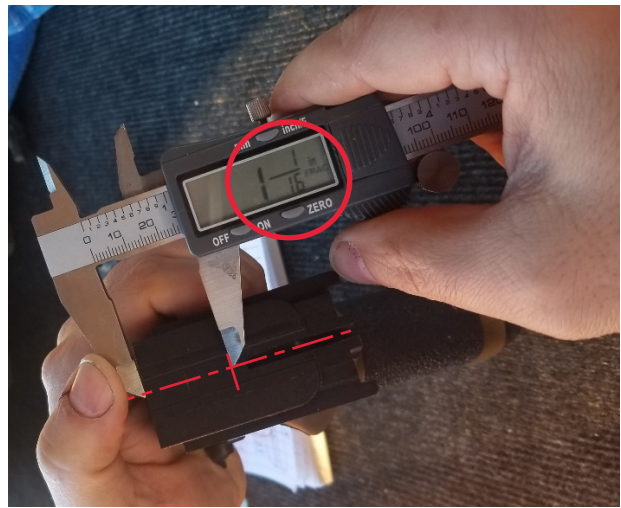
3. Slide the mag-well half of the receiver off and set aside.



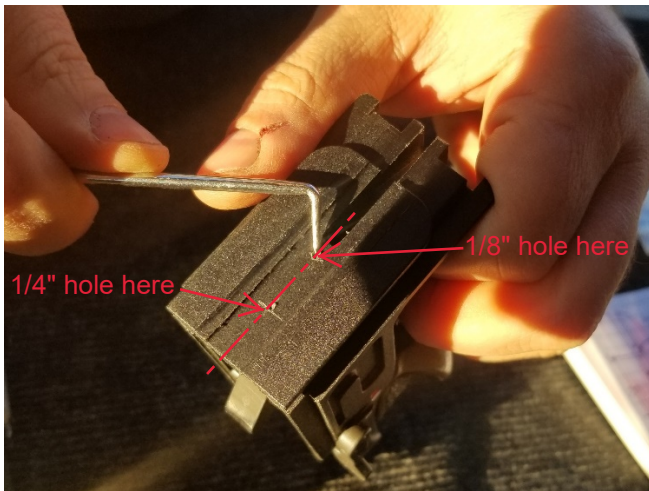
4. Drilling will be on this face of the lower receiver.



5. Mark the center of the upper 1/4" diameter hole, 1/2" down from the receiver top and centered left to right.



6. Mark the center of the lower 1/8" diameter hole, 1-1/16" down from the receiver top and centered left to right to align with existing channel.



7. Using a pick tool, dimple the receiver at the hole Center points as drill bit guide.



8. Using the 1/8" drill bit, drill the receiver's lower hole. Hole must be no deeper than 1/4".



9. Using the 1/8" drill bit, drill the lower receiver sideways inside the channel, through the end wall, until the bit comes out inside the firing group cavity.



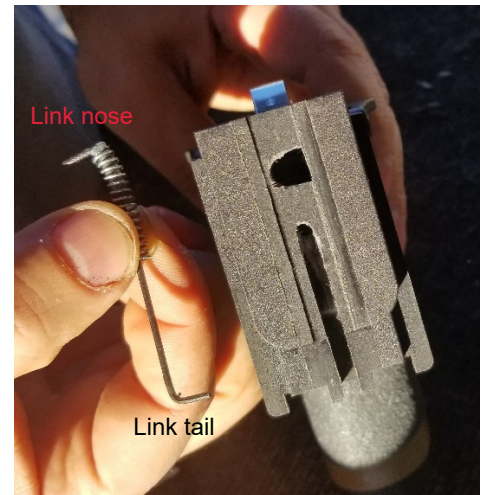
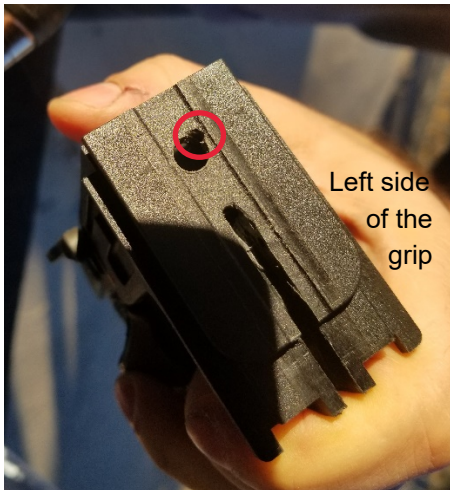
10. Using a utility knife, cut the receiver slowly along the existing channel side walls to extend the channel to the new 1/8" diameter hole.



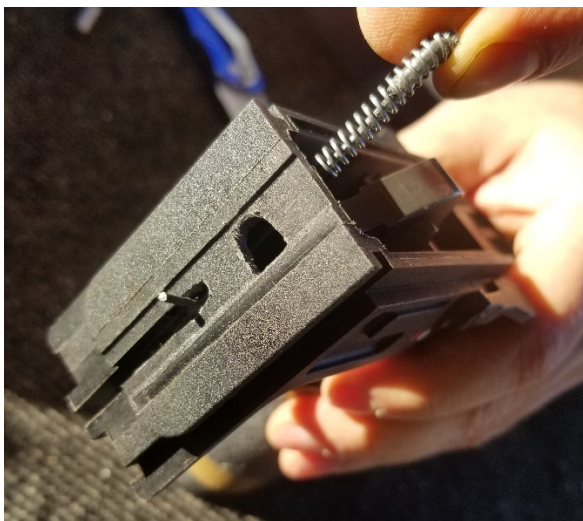
10. 1/8" hole daylight through firing group cavity.



11. Using the 1/4" drill bit, drill the receiver's upper hole. Apply light pressure while drilling to avoid the drill bit slamming into the hammer.



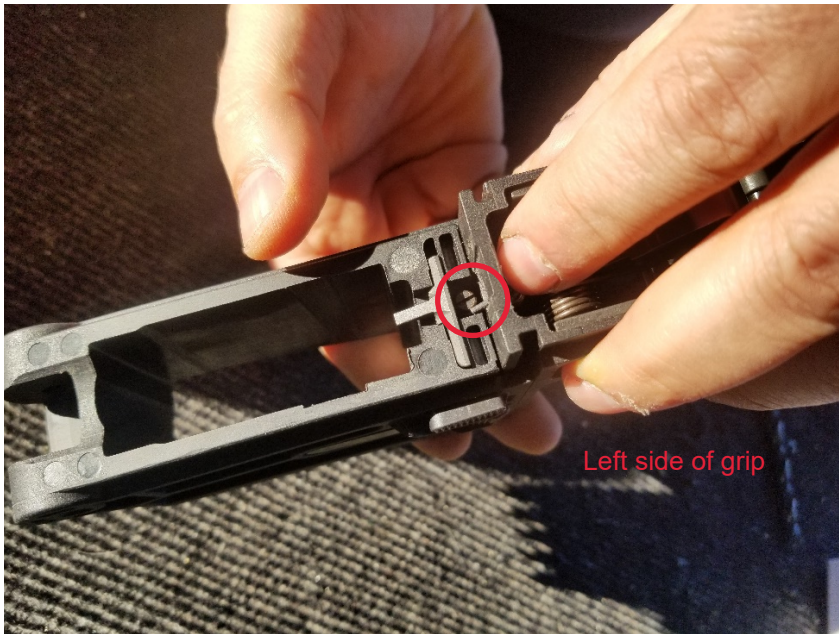
12. Using the 1/8" drill bit, drill 2 additional holes to the RIGHT side of the 1/4" hole and square the hole in a reversed "D" shape as shown. This step can also be done with the utility knife. Next step is to insert the link.



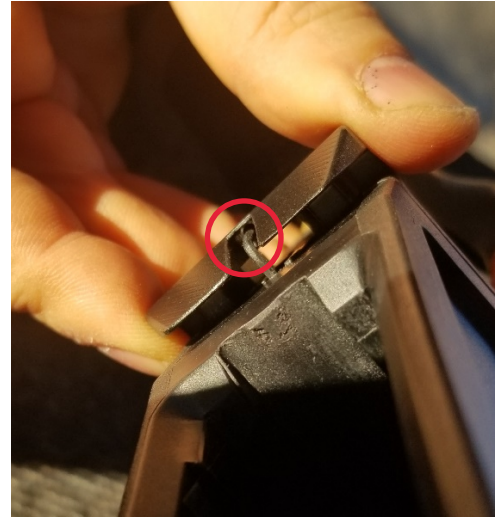
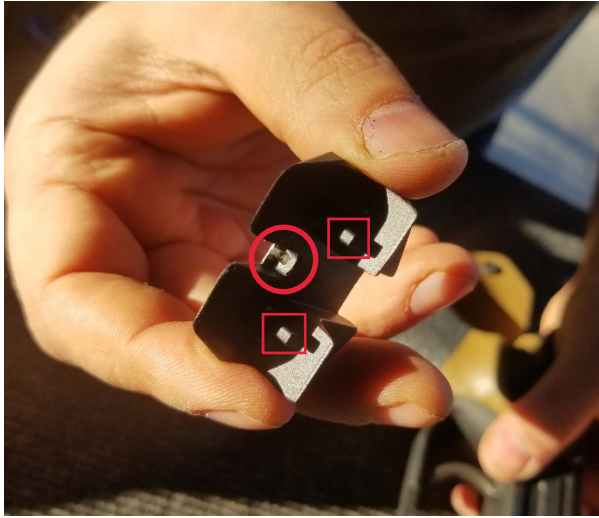
13. insert the link into the receiver by lowering it down the firing group cavity and out the 1/8" hole with the tail pointing outwards. Once the link nose is inside the firing group cavity, rotate the link 180 degrees where the nose is pointing outward and the tail will be pointing towards the trigger guard .



14. Press down the link from above while pulling the tail down and guide the nose through the upper hole. The link tail will be in axis with the receiver and the nose will be slightly offset to the left (when the lower is gripped).



15. Slide the mag-well half back on the receiver and make sure the nose slides to the left of the bolt hold spring screw. The link tail is now captured between the 2 lower receiver halves.



16. There is a small drilled hole towards the bottom of the Bolt release button facing the mag-well. Press down on the link near the hammer, where the tail will extend pass the bottom of the receiver. Slide the button on the tail and make sure the tail is completely inside the button. At this point, the button will be aligned to be seated in its final position and depress the link from above.

17. Hammer the lower receiver roll pin into place.

18. Check the button functionality by pressing downwards on either side (one side at a time) to make sure it pivots normally and visually inspect the top of the linkage near the hammer as it will move up and down with each button press. Press the stock bolt hold button to make sure the bolt hold rises fully without getting caught by the Bolt Release link nose.

19. Assemble the rifle by putting the lower and upper receivers together and secure with the front take down pin.

20. Test the Bolt Release by racking the rifle (without a mag) and pressing the bolt hold button, then release the bolt with the Bolt Release button. Do this several times on either side of the button. Repeat this process again by using an EMPTY magazine where the bolt will be held back by the magazine follower. Test the Bolt Release several times on each side.

Please contact me via email at shahen90065@yahoo.com with any questions and or concerns.



Thank you for your purchase and support.