

EVO4 – Assembly instruction

1 PREFACE

The EVO-4 damping system may only be removed and installed by persons who can demonstrate sufficient expertise. This includes gunsmiths, for example. Accordingly, these instructions are only intended for these persons.

Read these instructions completely before starting any of the steps listed.

2 SAFETY INSTRUCTIONS

The legal regulations are to be followed at all times. In addition, sporting regulations and the rules of the shooting range must always be observed.

The operating instructions must be read completely. If anything is unclear, contact a qualified person before use.

The purchased product is to be used exclusively for the intended use specified in the operating instructions.

The following safety instructions must always be observed when handling weapons, weapon parts and accessories! Failure to do so may result in personal injury and / or damage to property, in the worst case death or serious injury will occur:

- ⚠ A gun must always be handled as if it were loaded.
- ⚠ When working on a gun, it must always be checked for safety before starting and unloaded if necessary. Not only the weapon itself must be unloaded, but also the magazine if it is present.
- ⚠ A weapon must be loaded immediately before use and unloaded immediately after use.
- ⚠ The trigger of a firearm may only be pulled during firing.
- ⚠ Never point a gun at people, even if it is unloaded.
- ⚠ Before each use of a firearm, check that the barrel is clear. Clear means free of solid, as well as fluid objects. Also, never fire from barrels containing flammable or oxidizing gases. This does not apply to the composition of the ambient air.
- ⚠ Shoot a weapon only if sufficient bullet trapping is ensured. On shooting ranges, you may only shoot with ammunition that does not exceed the maximum permissible kinetic energy for the shooting range. For hunters, the only possible bullet trap is the grown ground, but its suitability must be checked in each individual case.
- ⚠ Always secure your weapon. Only if you want to fire a shot, unlock the weapon. Always remember that a safety can also fail. Therefore, never rely on a safety.
- ⚠ Use only high-quality, tested ammunition. This is the only way to develop the performance potential of high-quality weapons. Ammunition must always be checked for cleanliness before use. Otherwise, permanent damage to the weapon may occur.
- ⚠ Always use hearing protection when firing ammunition. This also applies to the use of ammunition with subsonic loads. If you use the gun professionally, observe the relevant occupational health and safety regulations. Also make sure that persons in your immediate vicinity have taken appropriate precautions.
- ⚠ Always use protective goggles when shooting and for all persons in your vicinity. Your eyes could be permanently damaged or even destroyed by flying projectile fragments, for example.
- ⚠ Always wear suitable clothing and safety equipment when handling firearms and accessories. Remember that hot casings, for example, can cause burns.
- ⚠ Before using a firearm, always inform all persons in your vicinity about potential risks when using firearms and their accessories.
- ⚠ If defects occur in a product, or if abnormalities become known, contact us or a specialist workshop authorized by us immediately.

- ⚠** Firearms may only be transported in an unloaded condition. The magazine must also be unloaded. The relevant legal requirements, as well as the accident prevention regulations, must be strictly observed.
- ⚠** The product may only be disassembled to the extent described in these operating instructions.
- ⚠** If you do not have sufficient expertise for assembly work, contact the nearest gunsmith, but do not under any circumstances carry out the work yourself.

The storage of weapons, weapon parts and accessories must be carried out in accordance with the legal regulations.

Access to and handling of our products must not be permitted to unauthorized, underage or mentally unpredictable persons.

These operating instructions must be handed over to the purchaser in the event of resale and are deemed to be part of the product.

3 DIASCLAIMER AND WARRANTY

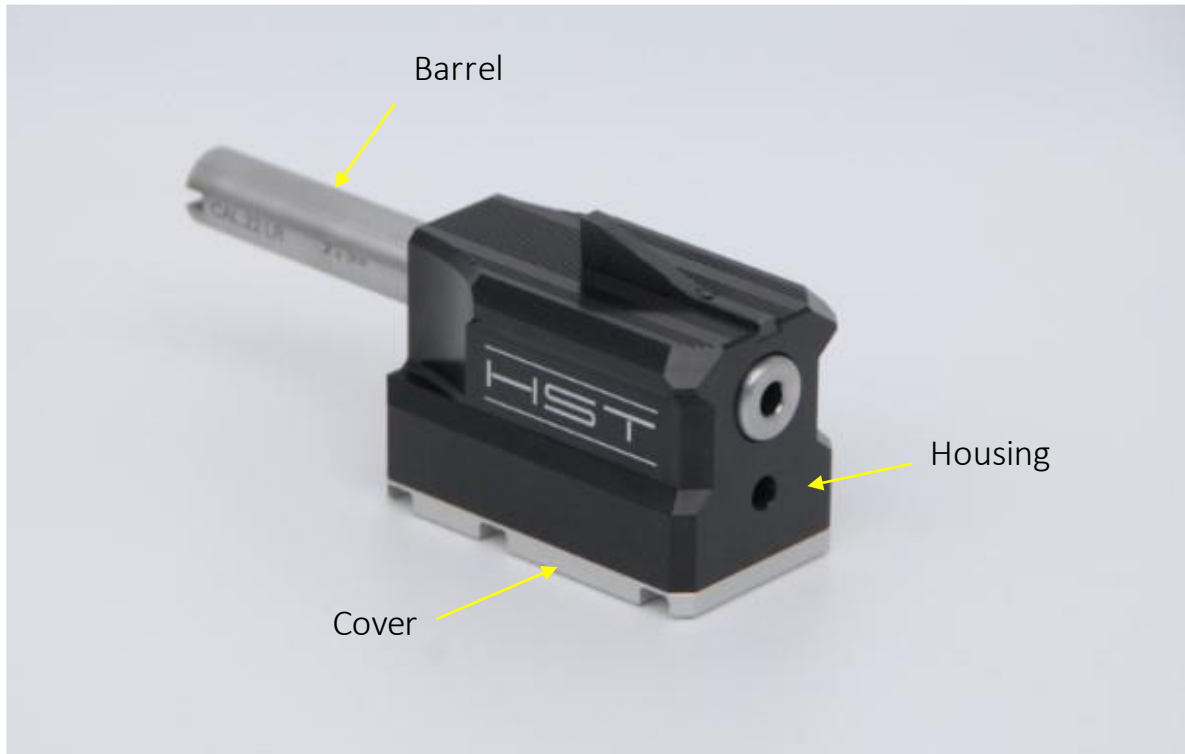
The product must be maintained and operated in accordance with the operating instructions. It is therefore essential that the corresponding operating instructions are also sold with the product itself in the case of resales. This responsibility is always assumed by the seller. Liability is assumed only for the intended use of the product. We are not liable, for incidental or consequential damages such as property damage, loss of business, income or profit. We are not liable in any way for any failure of the product, bodily injury or property damage that occurs in whole or in part:

- (1) due to improper or careless handling,
- (2) due to any modification of the weapon,
- (3) as a result of insufficient, as well as incorrect and inadequate care and cleaning,
- (4) due to insufficient frequent visual inspection as described in this manual,
- (5) due to the use of self-loaded, incorrect, unsuitable, defective and reused ammunition, as well as ammunition that does not comply with the CIP regulations for the corresponding caliber,
- (6) for accessories provided by the customer,
- (7) as a result of other influences beyond our direct or immediate control,
- (8) as a result of negligent or criminal use,
- (9) to firing performance of the firearm if accessories have not been properly installed.

The warranty service will be performed exclusively by a specialist workshop authorized by us or by ourselves. For this purpose, the customer must hand over the weapon to us or to the authorized workshop designated by us.

4 NAMING

The naming of the important individual parts is shown in the following illustrations.



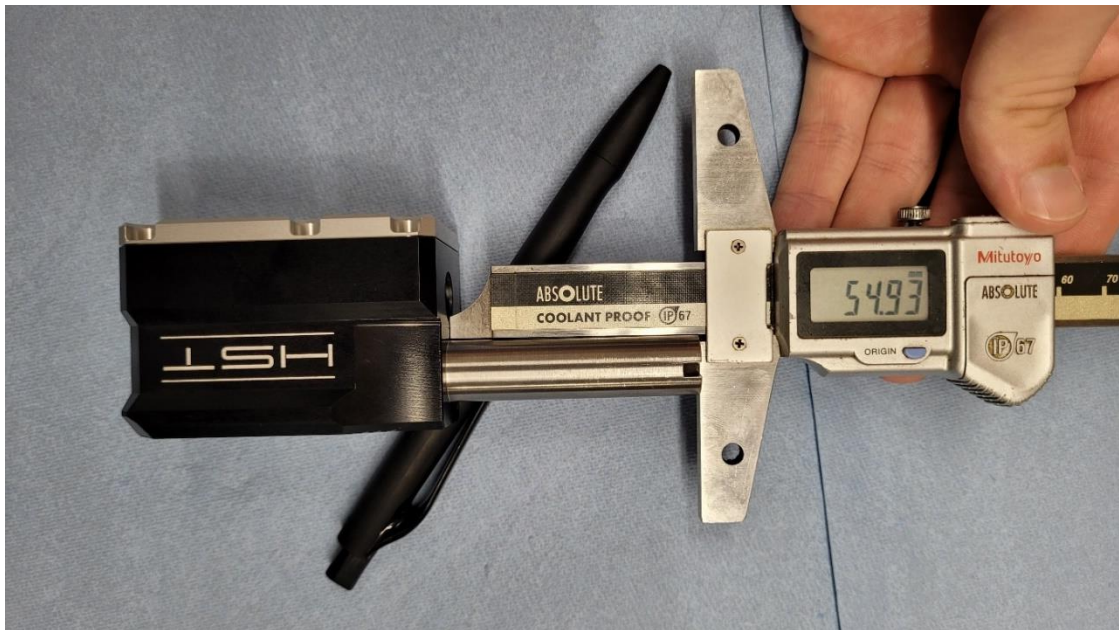
5 REMOVAL AND INSTALLATION OF BARRELS

The listed steps in the following chapters must always be carried out in sequence! Otherwise, the gun and/or the EVO-4 may be damaged or malfunction.

Especially when pressing, make sure that there is no dirt between contact surfaces, otherwise this can cause scratches on the EVO-4.

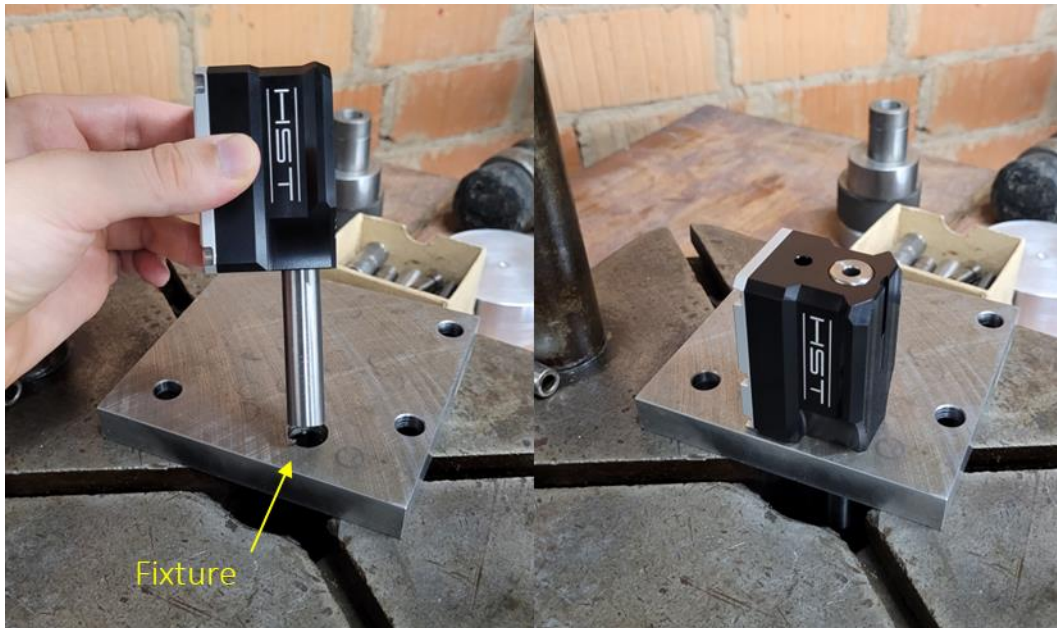
5.1 REMOVAL

1. Measure on the removed damping system how far the installed barrel protrudes (see following figure).

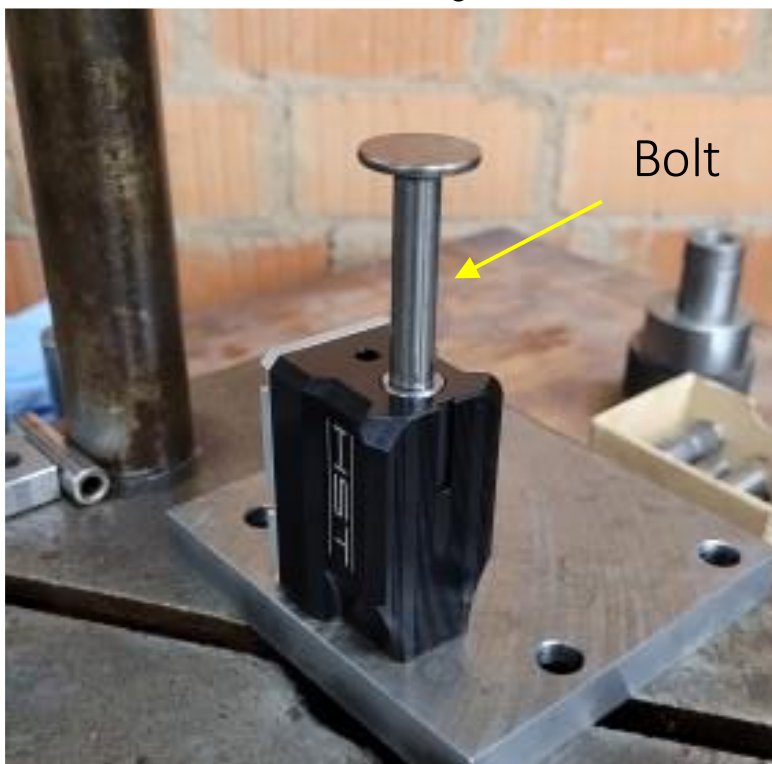


Make a note of this measurement. It will be used in Chapter 5.2 („Installation“).

2. Mount the cover on the housing! **This must be installed, otherwise the housing will be destroyed.**
3. Place the EVO-4 in an appropriate fixture. It is important that the barrel does not rest anywhere during subsequent pressing out.



4. Check whether the cover is mounted! If not, perform step 2.
5. Press the barrel out of the EVO-4 using a suitable bolt.

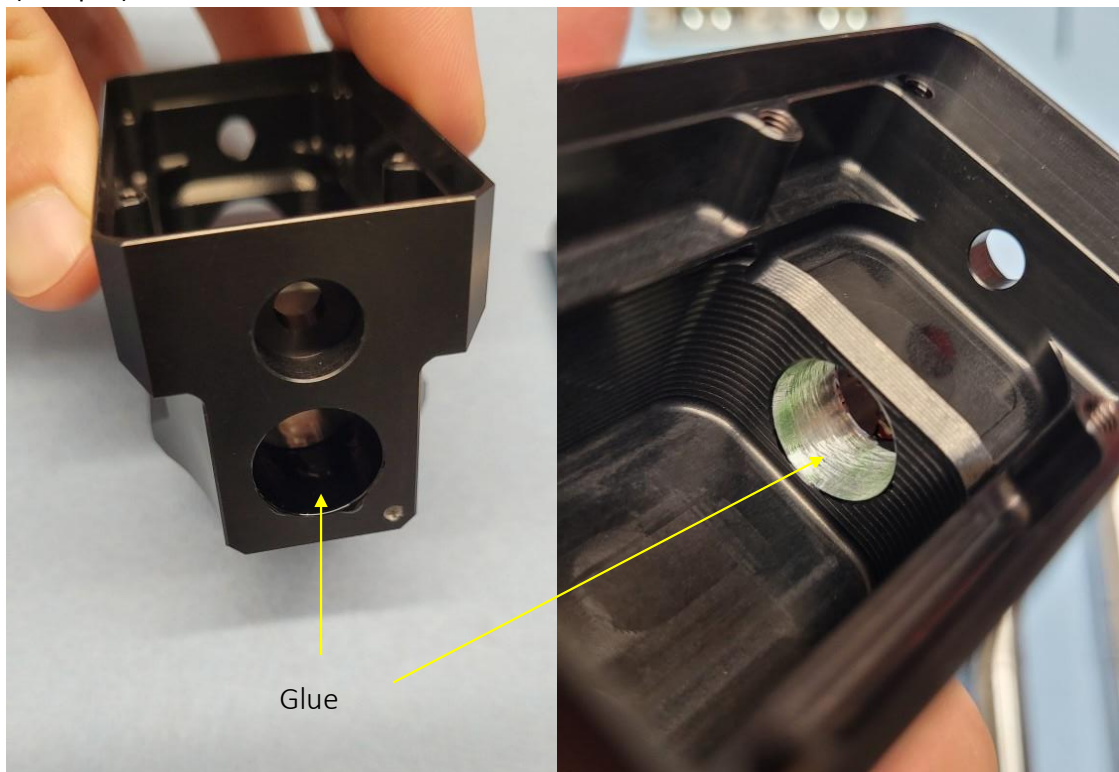


5.2 INSTALLATION

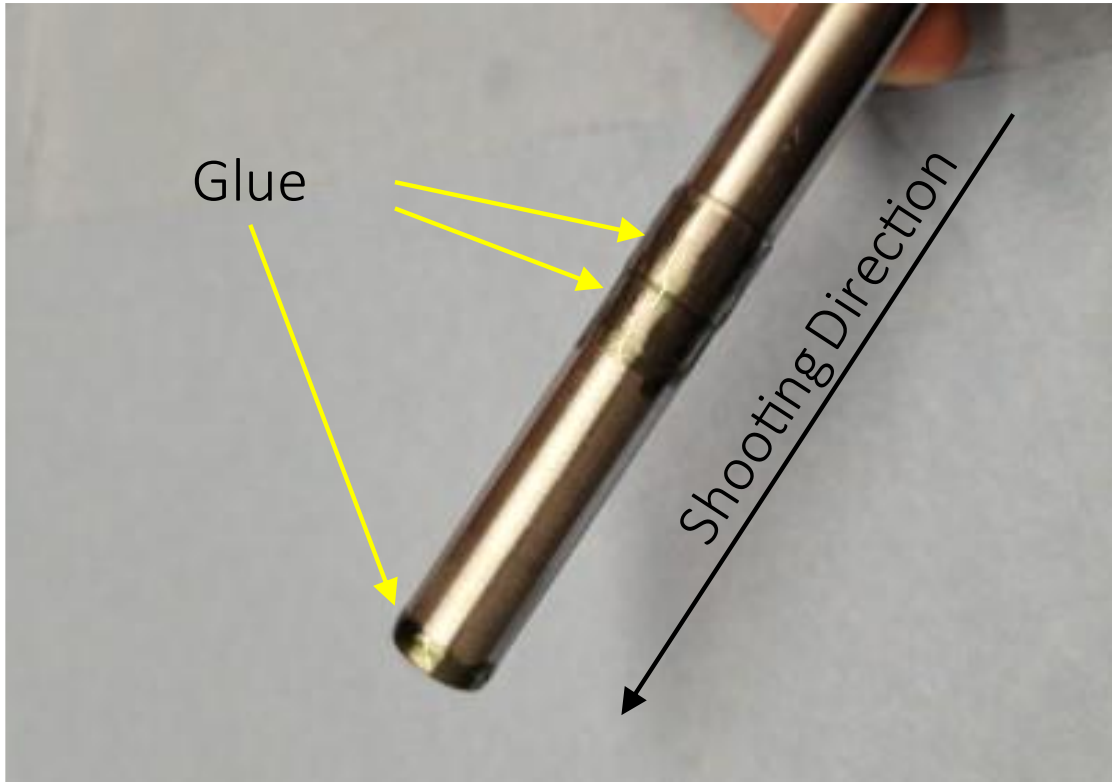
1. Remove all adhesive residues from the barrel you want to install.
2. Degrease the barrel at the subsequent gluing surfaces (see box in the following figure).



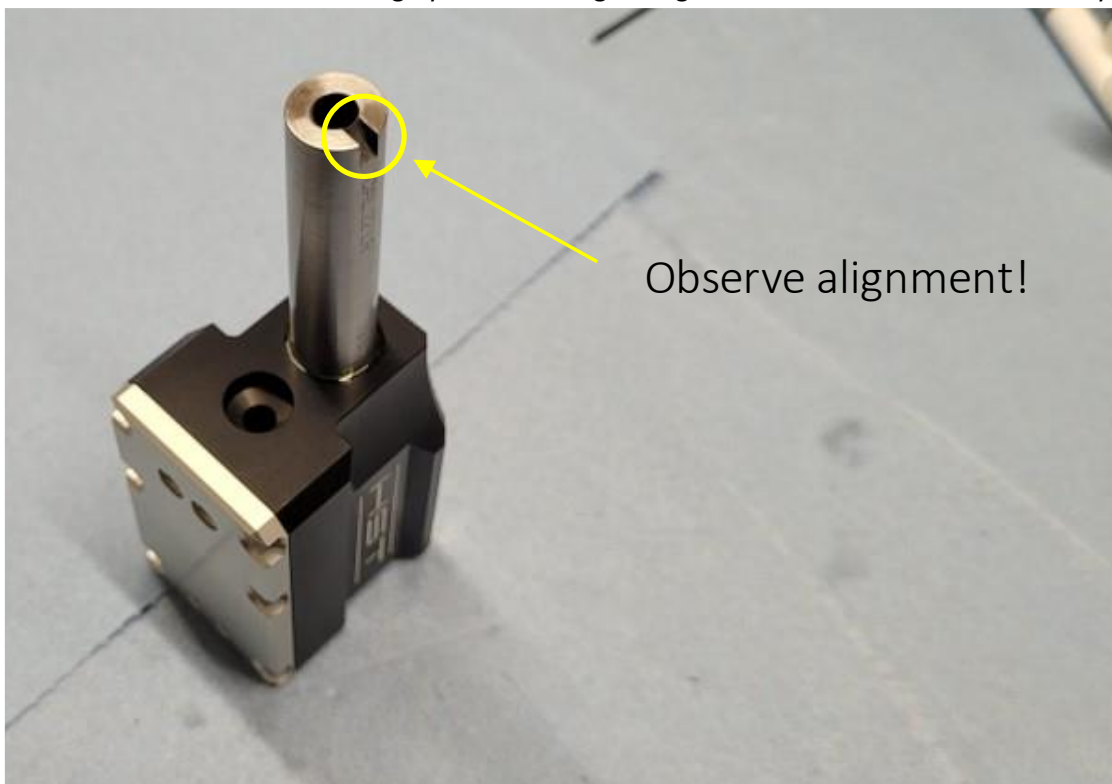
3. Degrease the housing on the inner surface of the bore into which the barrel will be pressed.
4. Put a slight amount of glue to the previously cleaned surfaces in the housing. Use Loctite 638 (or equal).



5. Put a slight amount of glue to the previously cleaned surfaces on the barrel. Use Loctite 638 (or equal).



6. Mount the cover on the housing! **This must be installed, otherwise the housing will be destroyed.**
7. Insert the barrel into the housing by hand and align the groove for the extractor horizontally.



To check the alignment, you can put the system on the receiver in this condition and check if the extractor has enough space in the groove. Before doing so, make sure that no excess adhesive comes into contact with the receiver or any other surface.

6. **Check whether the cover is mounted! If not, mount it.**
7. Place the EVO-4 in an appropriate fixture. It is important that the EVO-4 rests on the fixture with the housing and not with the barrel. **If this is not observed, the barrel will be damaged.**



8. Press in the barrel according to the measured offset. The press-in depth was determined in the chapter 5.1 („Removal“). **Be careful not to damage the barrel with tools! Hint: Build yourself a stop that limits the offsets (see following illustration).**



9. After pressing in, check the depth and alignment of the groove for the extractor. If necessary, press the barrel out again and install it again.

10. Remove any excess adhesive. Do not use any cleaners for this purpose, but simply wipe it off with a cloth.
11. Let the EVO-4 rest for at least 24 h at a temperature of at least 20 °C so that the adhesive cures.