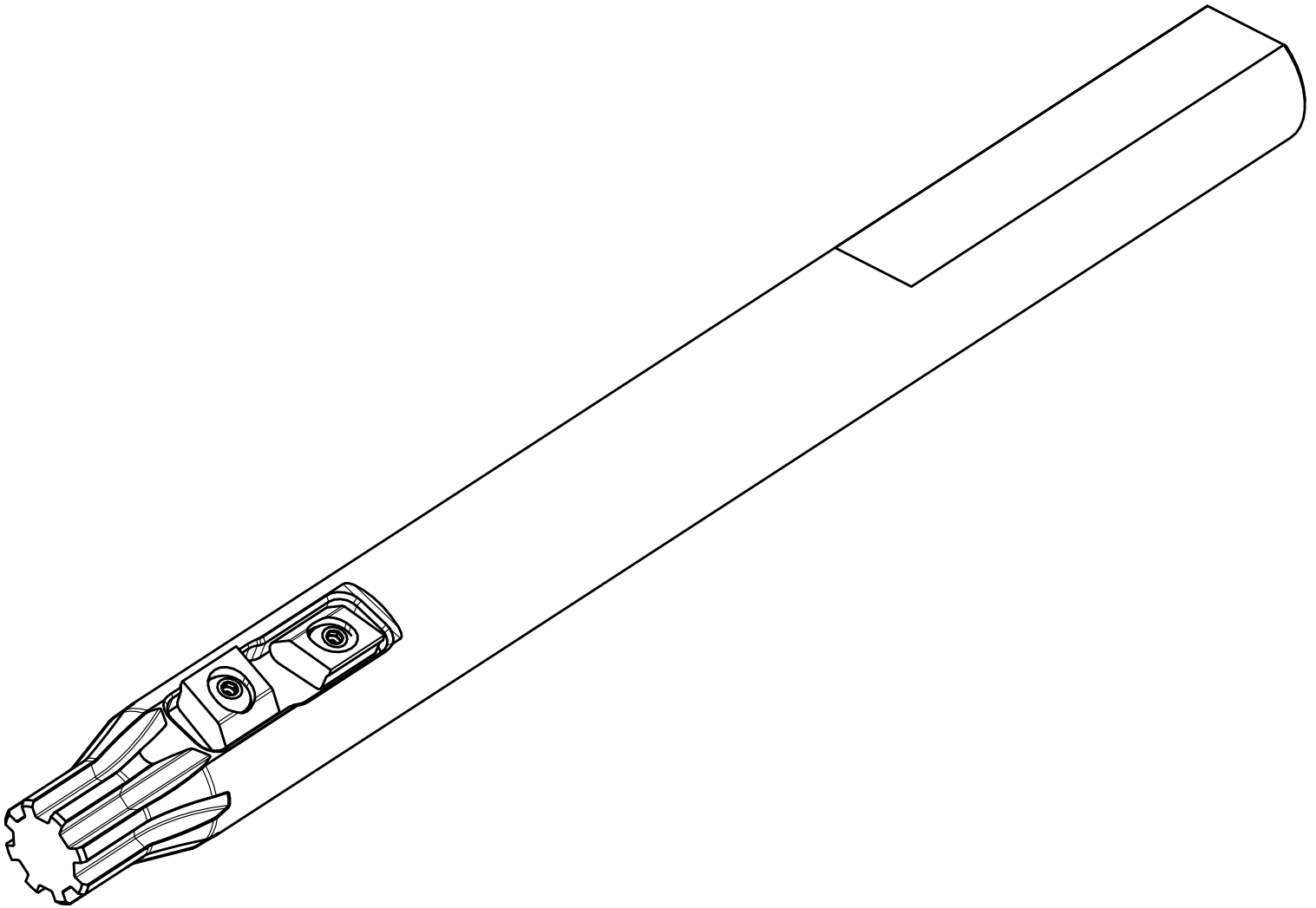


GEISSELE[®] ***AUTOMATICS***

SUPER REACTION ROD Operator's Manual



SUPER REACTION ROD

Operator's Manual

READ THIS FIRST:

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

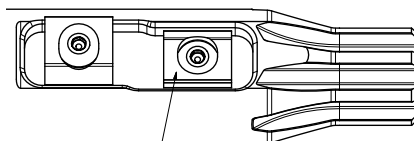
- 1. ASSUME EVERY WEAPON IS LOADED.**
- 2. KEEP YOUR FINGER OFF THE TRIGGER UNTIL YOU ARE READY TO SHOOT.**
- 3. DO NOT LET THE MUZZLE POINT AT ANYTHING YOU ARE NOT WILLING TO DESTROY.**
- 4. KNOW YOUR TARGET AND WHAT IS BEYOND.**

The Super Reaction Rod was designed with the advanced armorer in mind, an armorer who frequently works on AR15/M4 platforms with over torqued, seized or Loctited barrel nuts. The Super Reaction Rod works by pre-loading the barrel nut extension to the lugs of the Super Reaction Rod to eliminate any movement before adding torque to the barrel nut, while at the same time fixing the upper receiver into place. Having the barrel nut extension mated to the Super Reaction Rod lugs and fixing the upper receiver before torquing will remove any potential stress that could be placed on the index pin. This allows the armorer to place tremendous torque on the barrel nut. The Super Reaction Rod's pre-loading system can also be removed to allow it to work just like a standard Reaction Rod, which allows upper work to be performed in 360° both vertically, and horizontally.

USING YOUR SUPER REACTION ROD:

1. Secure the reaction rod in your bench vise, locating on the flats with the two brass wedge clamps slightly angled up as shown in Figure 1
 2. Please notice the orientation of the brass wedge clamps in the slot before removing them. (See Figure 2) **NOTE:** They only sit in the slot one way.
 3. Remove the two clamps and clamping screws using a 3/32" Allen key.
 4. Carefully slide the upper onto the Reaction Rod until the wedge cutout of the rod is in the ejection port of the upper receiver.
 5. Properly align the two brass wedge clamps into the cutout and start the clamp screws. (**DO NOT TIGHTEN**)
 6. The procedure for installing and removing the barrel nut is different and **MUST** be followed properly. (See Figure 3 for properly attached upper)
 - A. **INSTALLATION OF BARREL NUT:** Using the short arm of the Allen Key to turn the wrench, tighten the left/back brass wedge clamp first. This will properly preload the rotation of the upper. Then snugly tighten the right/front brass wedge clamp. (Front as in toward the muzzle)
 - B. **REMOVAL OF BARREL NUT:** Using the short arm of the Allen Key to turn the wrench, tighten the right/front brass wedge clamp first. This will properly preload the rotation of the upper. Then snugly tighten the left/back clamp.
- NOTE:** There are many different AR15 uppers and they all may not have the ejection port machined to Military dimensions. If the width of the ejection port is too wide, and can still rotate away from the tightened clamp, a .020" brass shim placed between the tightening clamp and the side wall of the ejection port can be used to eliminate the additional distance needed to properly pre-load the upper on the Super Reaction Rod.

Figure 1



Muzzle Clamp Side

Figure 2

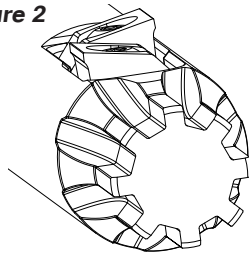
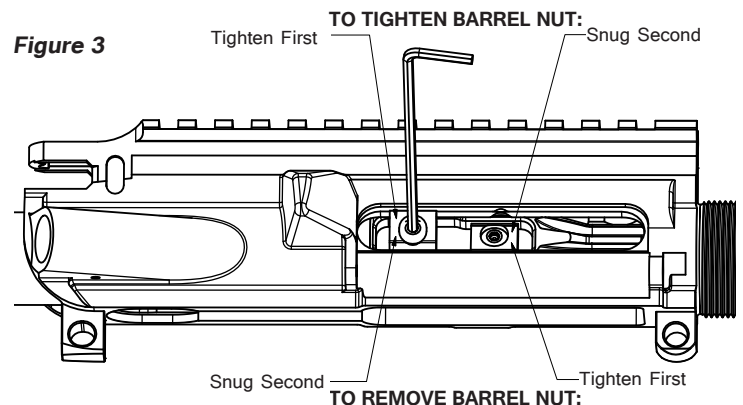


Figure 3



REMOVING THE UPPER FROM THE REACTION ROD:

1. Loosen and remove the two clamps and clamp screws.
2. Carefully slide the upper receiver off the Reaction Rod.
3. Insert the clamps properly into the cutout and snug the screws for storage.

Thank you for your purchase. Contact Geissele Automatics with any questions.

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