



**VECTOR BARREL  
REPLACEMENT INSTRUCTIONS  
[CENTERFIRE]**

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# DISCLAIMER AND SAFETY WARNING

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## **ALWAYS WEAR PROPER EYE PROTECTION WHEN SERVICING A FIREARM!**

It is highly recommended that you first read through these instructions in its entirety to familiarize yourself with the process before beginning any work.

Wear correctly rated eye protection at all times. Wear hearing protection if you will be exposed to noise exceeding 85 dB(A). Remove all ammunition from the firearm and the work area to eliminate the chance of a negligent discharge.

The KRISS Vector platform was not designed with the ability to remove and replace the barrel assembly outside of the production facility. The following instructions have been adapted from the original manufacturing process to be more accessible to individual professional gunsmiths who may have the requisite skills but not the access to the same tooling and machinery found in a manufacturing setting.

Improper or incorrect disassembly, installation, and/or reassembly may result in reduced performance, damage to property, and/or severe personal injury.

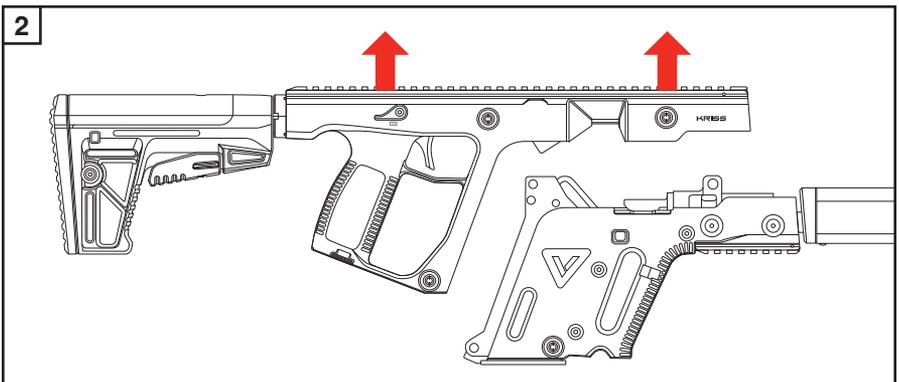
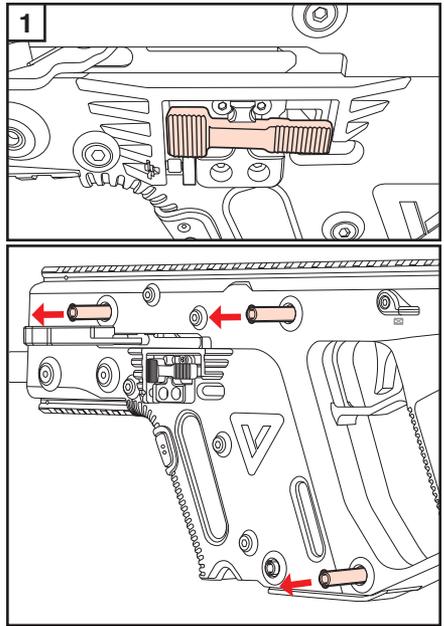
These parts and instructions are provided with no warranty, expressed nor implied.

# TOOLS NEEDED

- 2mm Allen Wrench
- 2.5mm Allen Wrench
- 3mm Allen Wrench
- 5mm Punch
- 3.5mm Punch
- 2.8mm HSS Drill Bit
- 4.0mm HSS Drill Bit
- #2 Easy Out & Tap Handle
- Bench Vise
- Heat Gun/Torch
- Ball Peen Hammer
- Needle Nose Pliers
- High Heat resistant Epoxy
- Loctite 263
- Armorer's Block / Pistol Block

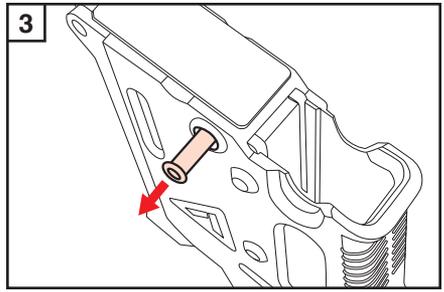
## GENERAL DISASSEMBLY

1. Ensure the bolt is forward and remove the 3 push pins in the upper.
2. Separate the upper and the receiver by grasping the upper and pulling upward while holding the receiver.



## BOLT ASSEMBLY

3. Remove the remaining push pin from the receiver and pull the slider and bolt assembly out by the base plate.



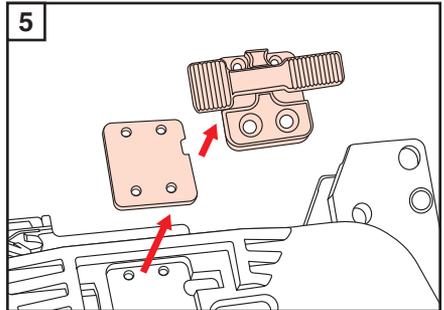
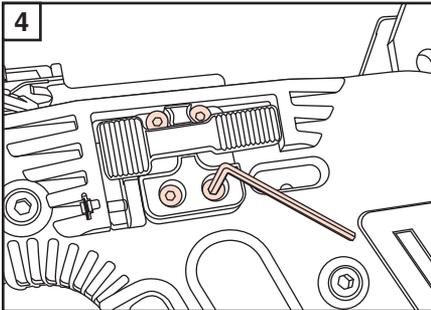
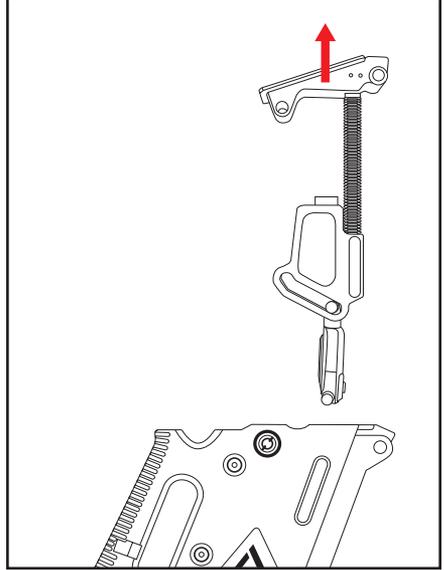
## BOLT LOCK ASSEMBLY

4. Remove the four mounting screws from the bolt lock block. This may require either a 2.0mm or 2.5mm Allen wrench depending on revision.

**Note:** Loctite 263 (red) is used from the factory. Careful application of heat may be needed, while taking care not to over-heat the surrounding polymer housing.

5. Older models incorporate a spacer under the bolt lock block.

**Note:** If your firearm has this spacer, it is imperative that it be installed during re-assembly.

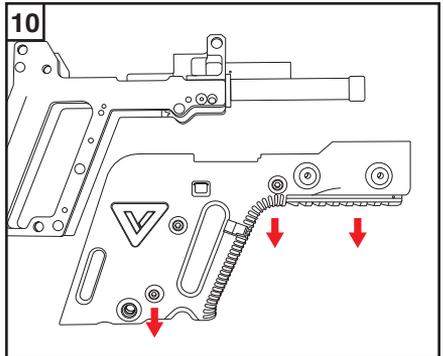
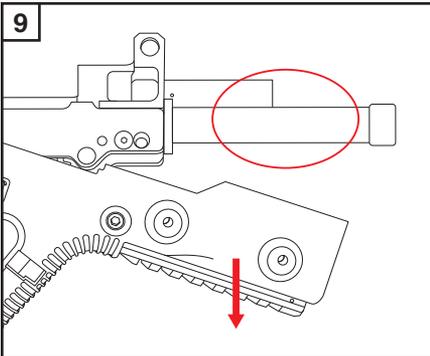
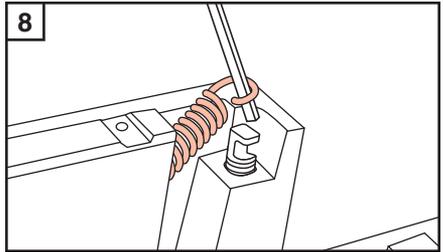
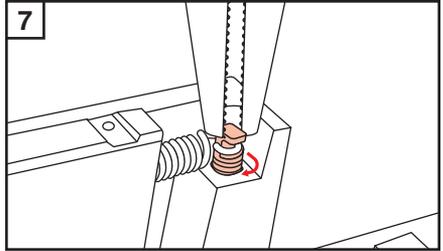
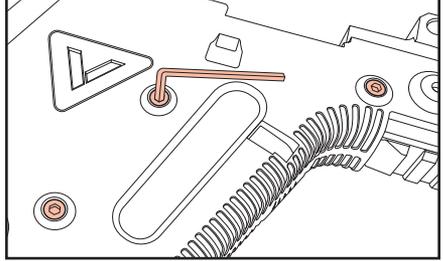
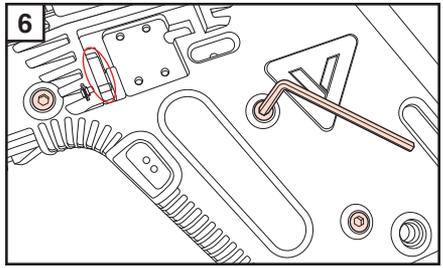


## LOWER HOUSING ASSEMBLY

6. To remove the Lower Housing (Injection molded polymer), use a 3.0mm Allen wrench to remove the (6) mounting screws on the right and left side of the housing.

**Note: Screws are installed with Loctite 263 (red) threadlocker.**

7. Using a small pair of needle nose pliers, turn the Charging Handle return spring anchor 90° to the right.
8. Un-hook the Charging Handle return spring.
9. Grasp the barrel. Slide the lower housing downward, starting with the forward end.
10. Once the housing begins to separate from the receiver, continue until completely removed.

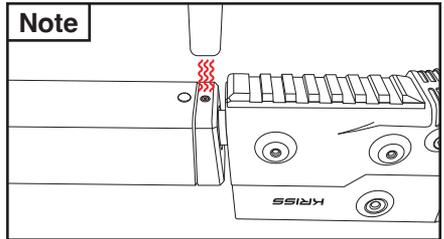
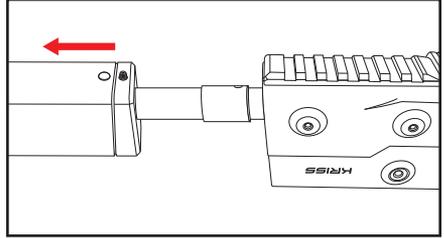
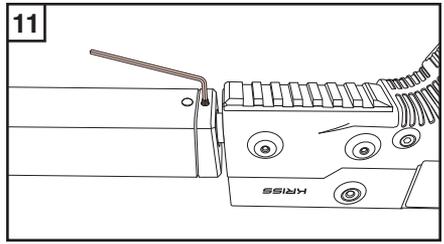


## CRB BARREL SHROUD REMOVAL

11. Using a 2.0mm Allen wrench, back out the set screw enough from the collar so the Barrel Shroud can be removed.

**Note:** Set screw is installed with Loctite 263 (red) threadlocker.

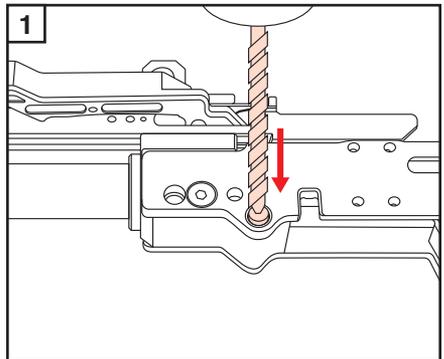
**Avoid stripping the set screw. Carefully apply heat if necessary to weaken the threadlocker, taking care not to overheat the lower housing if it is still installed.**



## RECEIVER DISASSEMBLY

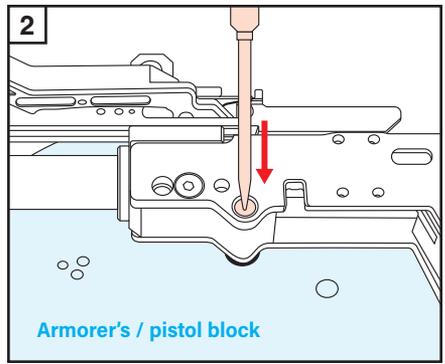
### DRILLING THE TRUNNION RIVET

1. Using a 4.0 mm HSS drill bit, drill the head of the rivet out from the Left-Hand side of the receiver.



## REMOVING THE TRUNNION RIVET

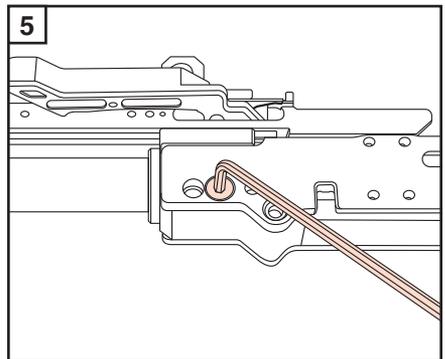
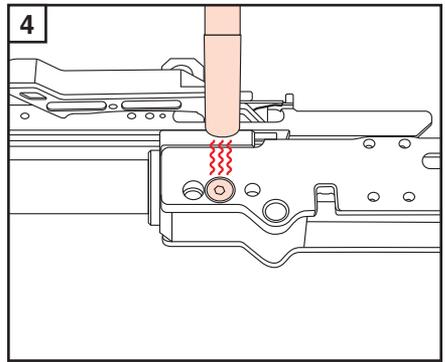
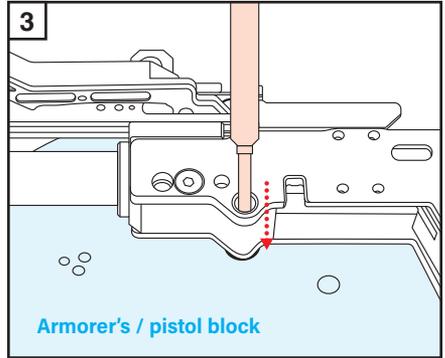
2. Once the rivet is drilled, rest the receiver on top of an armorer's block with a through hole large enough to accommodate the trunnion rivet. Use a 3.5mm punch to drive the rivet out of the receiver.
3. Continue until the rivet has been completely removed.



## REMOVE RECEIVER SCREWS: OPTION A

4. Using a torch or heat gun, heat the screw/trunnion to weaken the Loctite 263 (red) threadlocker.
5. There are two Short Receiver Screws, one on each side of the receiver. Using a 2.5mm Allen wrench remove both short receiver screws

**Note: If the head of the screw strips out use option B**



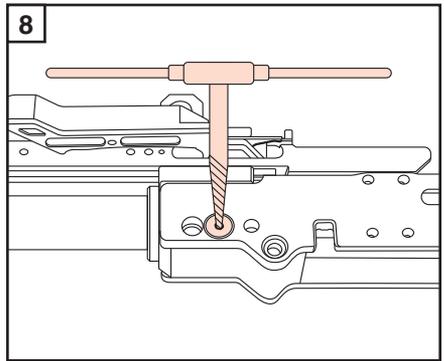
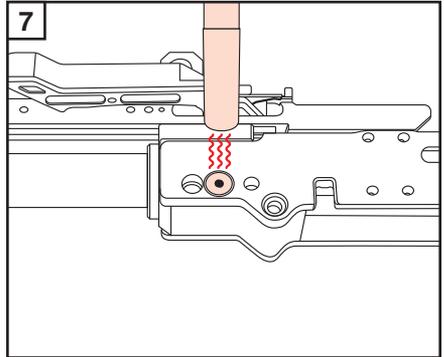
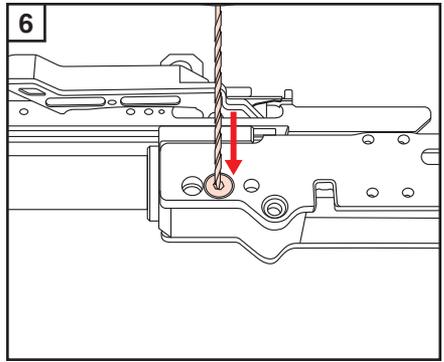
## REMOVE RECEIVER SCREWS: OPTION B

- Using a 2.8mm drill bit, drill the short receiver screw enough to get a #2 easy out into the head of the screw.

**Caution: Do not drill too deep, or damage to the trunnion screws may occur.**

- Using a torch or heat gun, heat the screw/trunnion to weaken the Loctite 263 (red) threadlocker.

- Drive a #2 easy out into the screw head. Use a tap handle to turn the easy out while applying significant downward pressure to keep the easy out engaged in the screw head.



# BARREL REMOVAL

## CLAMP THE RECEIVER

1. Using a bench vise clamp the bottom of the receiver firmly without crushing the receiver.

## SPREAD THE RECEIVER

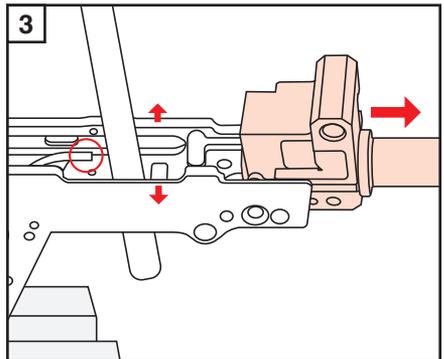
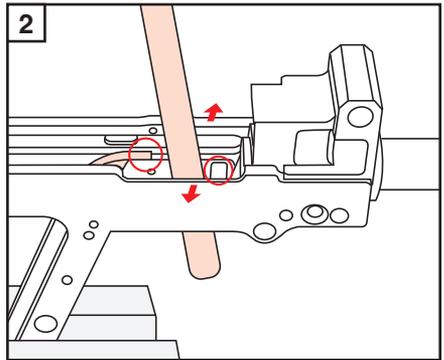
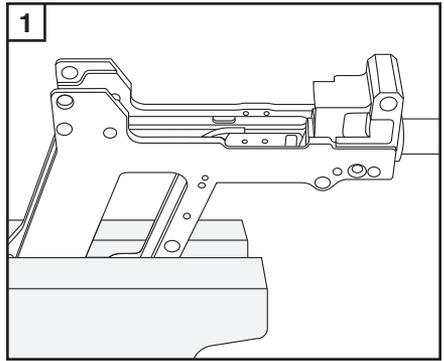
2. Use a tool to gently and simultaneously pry apart both receiver plates. Apply just enough force to be able to remove the barrel.

**Caution:** Make sure the prying tool does not contact the ejector or the bolt lock trigger cut out (indicated).

## REMOVE BARREL

3. Pull on the barrel up and forward, away from the receiver plates, while gently prying the receiver plates apart. Wiggling the barrel may also help during this process.

**Caution:** Avoid contacting the ejector. This will lead to damage.



# BARREL INSTALL

## CLEAN T-TRACKS

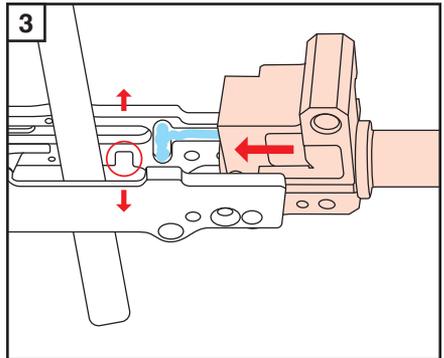
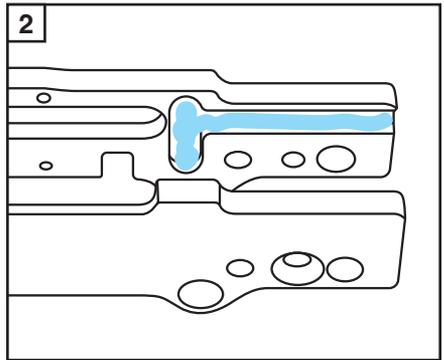
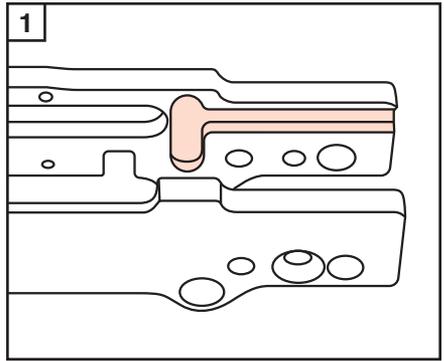
1. Before installing the new barrel, it is necessary to clean both "T-tracks". Scrape away all leftover epoxy from the original barrel installation, then degrease the T-tracks.
2. After a thorough cleaning, when you are ready to install the replacement barrel, apply a high heat epoxy to the T-tracks. This helps eliminate any extra movement in the barrel once hardened.

## INSTALL BARREL

3. While the epoxy is wet, install the replacement barrel. Gently pry the receiver plates apart and slide in the barrel until it snaps into place.

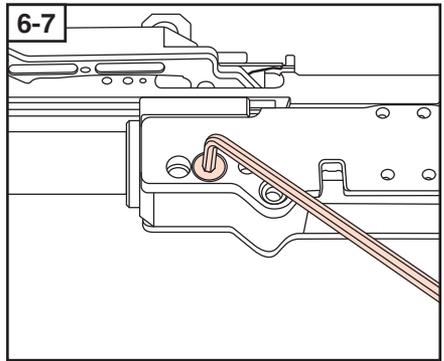
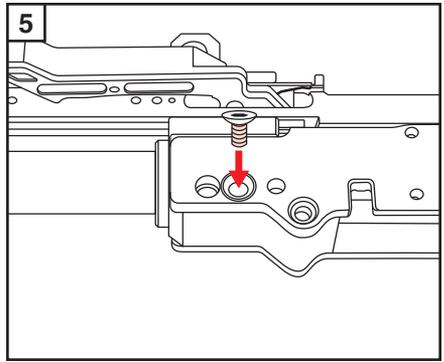
**Note:** Do not apply pressure to the bolt lock trigger cutout (indicated) or the ejector.

4. Remove and clean away excess epoxy that may squeeze out, especially around the chamber.



## INSTALL SHORT RECEIVER SCREWS

5. Apply Loctite 263 (red) to the short receiver screw.
6. Use a 2.5mm Allen key to reinstall the screw.
7. Torque to 3 Nm.



# REPLACING THE RIVET

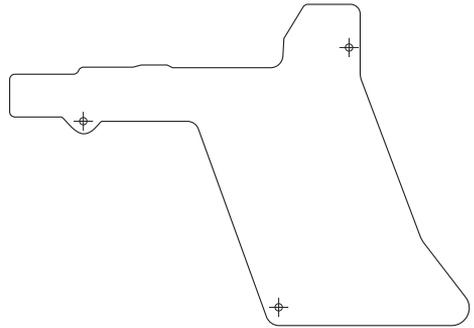
## SUPPORT FIXTURE

KRISS USA recommends building a small support fixture and clamping the receiver to the table so Hand Peening of the Trunnion Rivet can be accomplished.

The support fixture is a simple steel or aluminum plate (minimum thickness 1/4 inch) that has three screw heads positioned as locators for the receiver rivets.

A rivet template is available to help you create this fixture.

**Note: when using the PDF to print your template, make sure you have the printer set to actual size.**

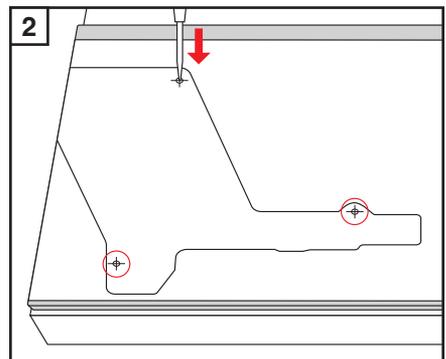
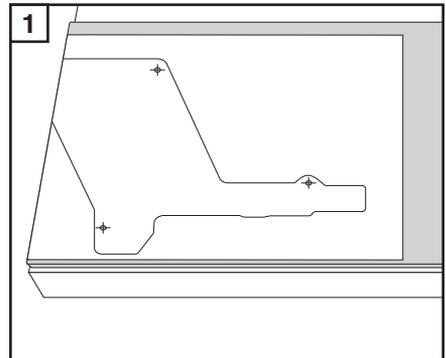


**Rivet template can be located at the end of the document.**

**Caution: Set the template to print at 100% or Actual size.**

## MARKING THE THREE HOLES TO BE DRILLED

1. Place the template on the fixture plate. Recommended placement should be near the corner as seen in the picture.
2. At each of the three positions, use a center punch and make a mark for drilling.



3. Using a 4mm drill bit, drill a hole at each position. If your plate measures thicker than 1/4 inch, drill each hole to at least 12mm (0.47 inches) in depth.

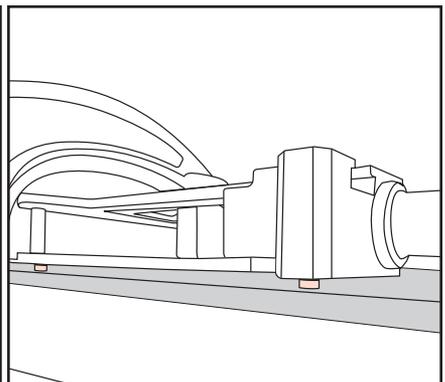
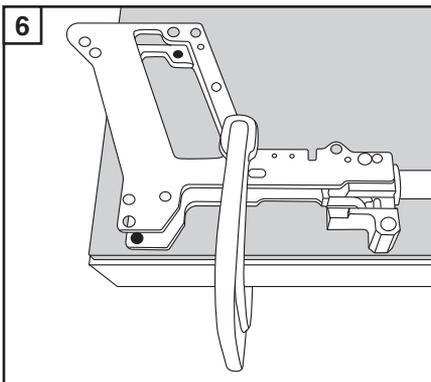
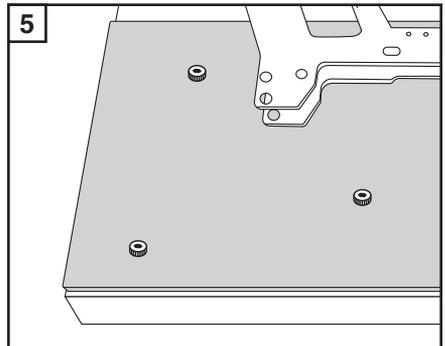
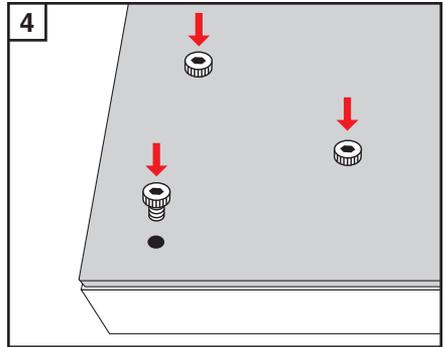
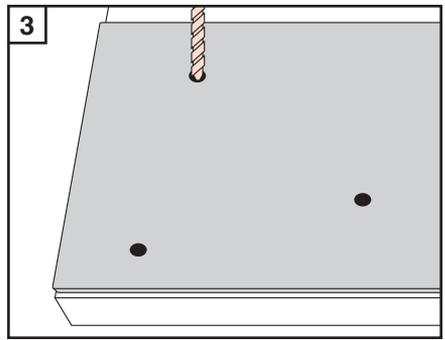
4. Use three of the old receiver housing mounting screws. Place one screw into each hole. The screw head should fit flush with the fixture plate. If the head does not sit flush, shorten the threaded end of the screw until the screw head sits flush.

5. Once the three screws are inserted, the receiver can be placed on top of the screws.

**Note: Make sure the rivet is sitting on top of the screw before clamping the receiver and fixture to the table.**

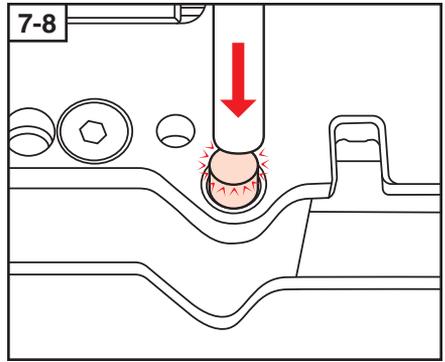
6. Position the C-Clamp as seen in the diagram; placement should be over the ejector mount area of the receiver.

**Note: Do not over torque the clamp, only enough pressure is needed to prevent the receiver and fixture from moving on the table.**



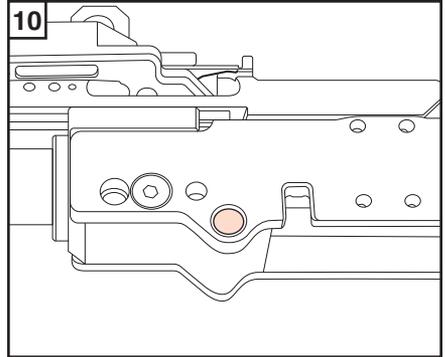
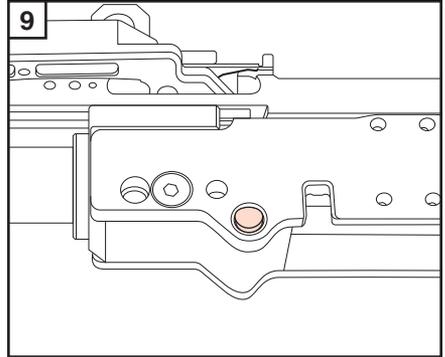
## INSTALL TRUNNION RIVET BY HAND PEENING

7. Use a 5mm punch and large hammer to form (peen) the rivet into the receiver counter bore
8. Start by hitting the outer edge of the rivet with the punch using about half the width of your punch to form the outer edges of the rivet.



Work your way around the rivet in a circular pattern moving towards the center. Continue doing this until you have fully seated the rivet into the receiver counter sink pocket.

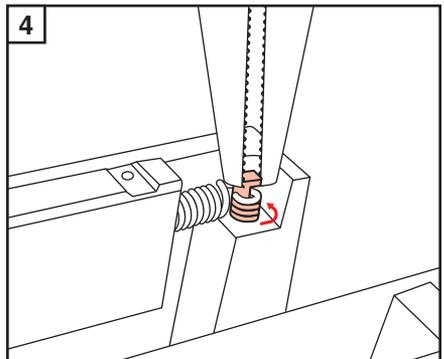
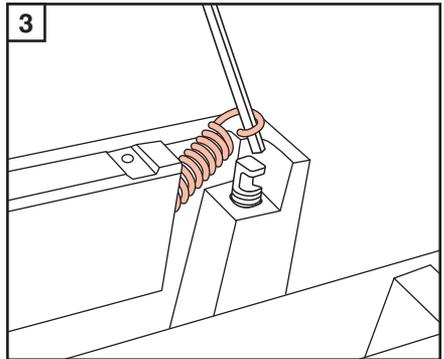
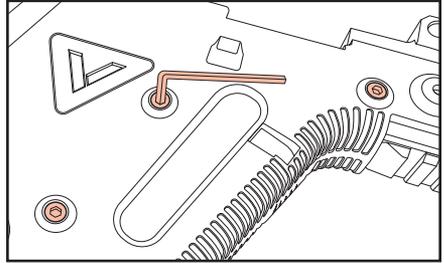
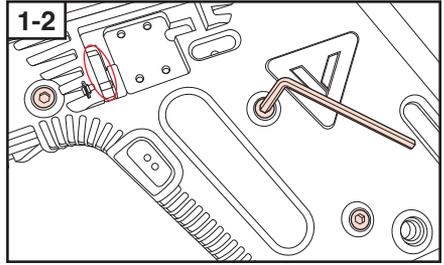
9. The rivet should start to flare out at the top as you are forming it.
10. The rivet should not have any movement once its formed into the counter bore. Both sides should sit flush or below flush with the receiver.



# REASSEMBLY / INSPECTION

## RECEIVER

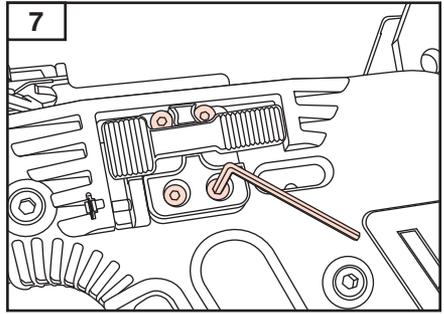
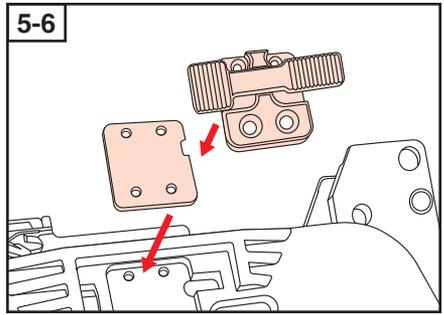
1. When sliding the receiver housing onto the receiver, ensure the bolt lock trigger is oriented correctly. Ensure all the mounting screw holes are aligned properly with the receiver plate locations.
2. Apply a drop of Loctite 263 "Red" to each of the (6) mounting screws and torque each screw to 2 Nm.
3. Re-hook the return spring for the charging slider. A hook tool or a paperclip may be needed to pull the spring far enough out to reinstall.
4. Rotate the charging handle spring post 90 degrees so the opening faces forward.



## BOLT LOCK BLOCK

5. If originally present, place the bolt lock block spacer into the cutout in the housing. The notch must align with the receiver plate.
6. Place the bolt lock block into position. Apply one drop of Loctite 263 (red) threadlocker to each screw and install, starting with the bottom of the block and moving clockwise.
7. Torque each screw to 2 Nm with a 2.5mm Allen wrench.

Once the Upper Assembly and Receiver have been assembled and the firearm is complete, a safety function check should be performed.



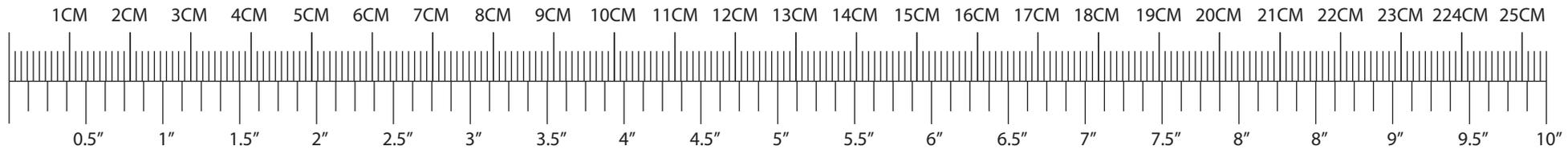
# FUNCTION CHECK

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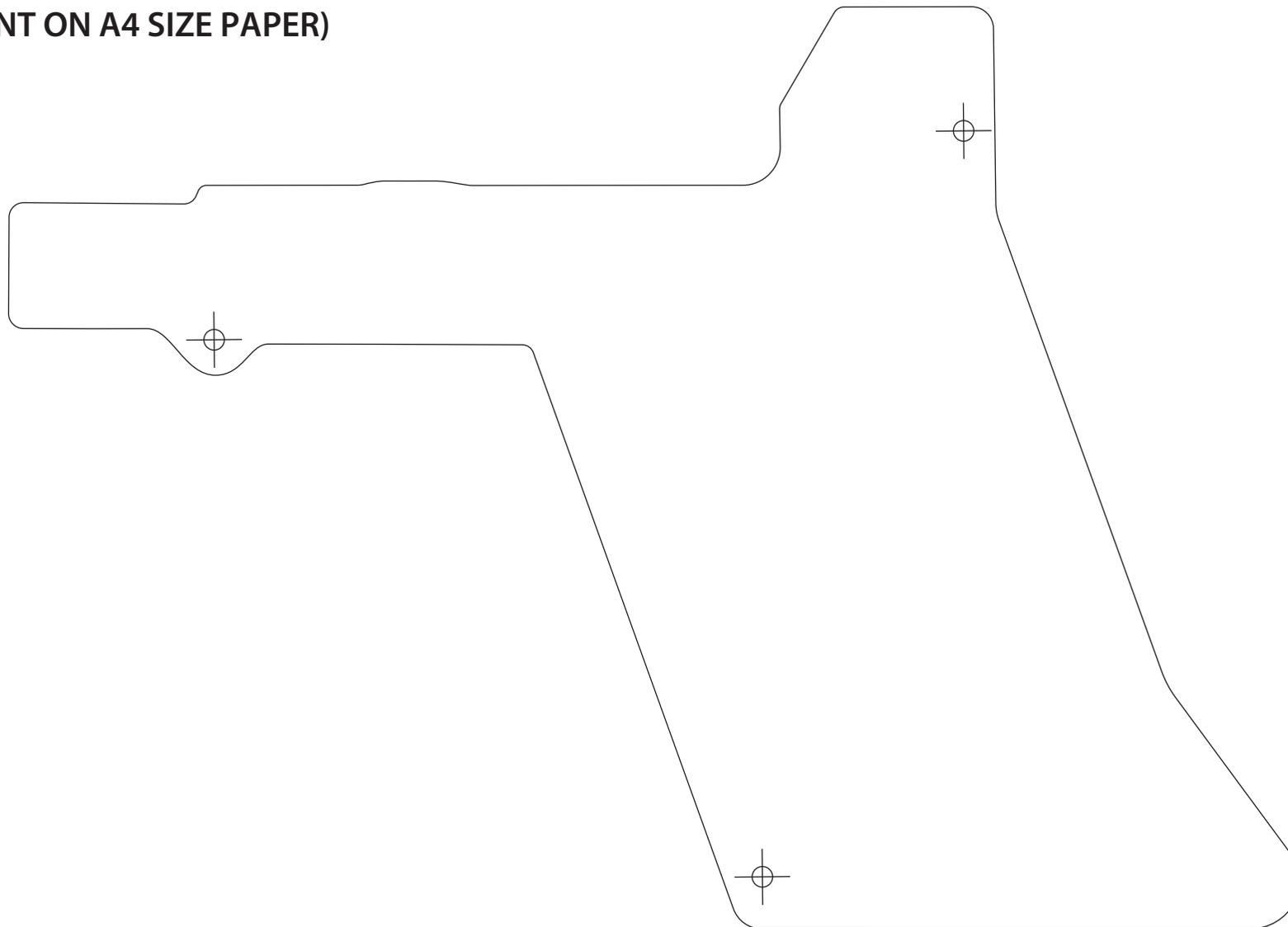
1. Always clear the firearm prior to handling by pointing in a safe direction and locking the bolt to the rear position. Ensure there is not a round in the chamber or a magazine inserted.
2. After clearing the firearm, release the bolt by depressing the bolt catch.
3. With the safety engaged, pull the trigger. The hammer should not fall.
4. Disengage Safety lever and set to the fire position.
5. Pull back on the charging handle and charge the system.
6. Pull the trigger to release the hammer. An audible sound of the hammer releasing and striking the firing pin should be heard.
7. In order to check the trigger reset, continue to hold down the trigger after the hammer has struck the firing pin.
8. While holding the trigger down, charge the gun again and after charging, slowly release the trigger. There should be an audible click when the trigger resets.
9. Repeat this process two to three times to confirm trigger reset.

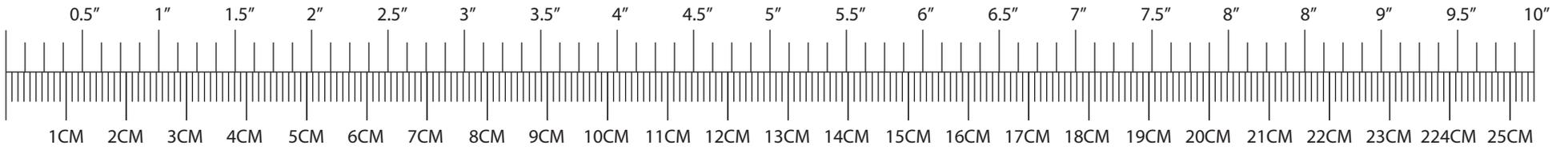


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**A** (PRINT ON A4 SIZE PAPER)





**B** (PRINT ON LETTER SIZE PAPER)

