

# Majestic Arms Ltd.

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## The Speed Strip Kit for All Ruger .22 Auto Pistols

Custom by



We are sure you will enjoy using your pistol in its new configuration. All steps have been taken to produce high quality components, which meet or exceed factory specifications to insure years of trouble free service.

U.S. Patent #5,666,755

*We recommend the conversion be done by a competent gunsmith.*

Kit Includes: 1 - New 2 piece stainless steel bolt stop pin  
1 - New hammer & 1 - 5/32 Allen key

Tools Needed: 1 - 3/32 Steel punch  
1 - Screwdriver (flathead)  
1 - 2-4 oz. hammer  
1 - Plastic or rawhide mallet  
1 - Brass or aluminum punch (1/4")  
1 - 1/4" Round pillar file

### Instructions for Installation

***Please read all directions before beginning. We are here to help you Monday through Friday, 10 AM - 6PM ET.***

**Before you start...Safety First!** With the pistol pointed in a safe direction, check to make sure the pistol is *NOT* loaded and the chamber is empty. Remove the magazine, then draw back the bolt and visually inspect that the chamber is *EMPTY*.

Step 1 Dry fire the pistol, then using a small screwdriver pry the mainspring housing out. (Like opening a pocketknife blade). Swing the mainspring housing outward and upward. Then pull downward removing the mainspring housing assembly as a unit. (See Fig. 1 & 1A)

Fig. 1



Fig.1A



Note: Due to a variance in manufacturing, with some pistols it may be necessary to tap the bolt stop pin, visible through the top rear of the receiver, with a brass or aluminum punch.

Step 2 Remove the bolt assembly and lay it aside.

Step 3 Remove the upper receiver. Holding the lower frame, tap the rear of the upper receiver with a plastic mallet until the upper receiver disengages from the pistol grip frame.

Step 4

Installing the "New Hammer". Remove both grip panels. Using a 3/32 or 1/8 punch, push the hammer pin, from right to left, partially but *NOT* all the way out of the frame, until the hammer is free to be lifted out of the frame. (See Fig. 2,2A)



Fig. 2

Hammer Pivot  
Pin Hole



Fig. 2A - Hammer in Frame

When the hammer is free, lift out and lay the frame assembly aside.

Step 5

The hammer pivot bushing and mainspring strut must be installed in the "New Hammer". With your fingers, remove the bushing in the old hammer. Next, using a 3/32 punch, drive out the mainspring strut retaining pin. Reinstall these parts in the "New Hammer". The mainspring strut retaining pin goes in from *left to right*. The hammer bushing goes in from *right to left*. (See Fig. 3 & 3A).

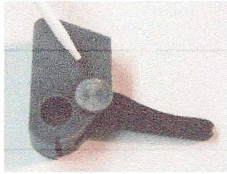


Fig.3

**Hammer-Left Side, Hammer Strut ↑**

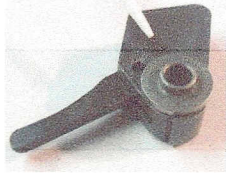


Fig.3A

**Hammer - Right Side**

Now that the parts are installed in the "New Hammer", replace the hammer assembly in the frame. Holding the grip frame in one hand, place the hammer bushing into the cut out in the trigger draw bar, then push the hammer and draw bar into the frame. Align the hammer with the pinhole by looking through the hole on the right side of the grip frame. When the hole in the hammer aligns with the hole in the frame you will be able to push the pivot pin back into place from the *left* side of the grip frame. When fully seated the hammer pivot pin will be flush with the *right* side of the grip frame. Replace the grip panels. All work on the lower frame is now complete.

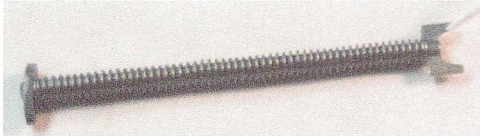
Step 6

Reinstall the upper receiver onto the pistol grip frame by placing the upper receiver onto the grip frame and pushing to the rear. On most pistols, it will be necessary to strike the muzzle with a plastic mallet to fully seat it onto the grip frame.

Step 7

Quite often the rear end of the recoil spring guide will have rough edges and burrs in the concave area. (See Fig. 4)

Fig. 4



**Recoil Spring Guide Rod**

← File Here

Lightly file the very end of the recoil spring guide using a 1/4" round file just enough to remove any rough edges found.

Step 8

Replace the bolt assembly into the upper receiver.

Step 9

Installing the "New Bolt Stop Pin". Using a 3/32 punch, drive the pin that the bolt stop pin pivots on almost, but not all the way out, just enough to allow the original bolt stop pin to be removed. Next, replace the old bolt stop pin with the "New" 2-piece bolt stop pin. Be sure to seat the pivot pin flush on both sides. Reinstall the mainspring housing assembly. It may be necessary to tap the mainspring housing assembly up into place with a plastic mallet. Once installed, the conversion is now complete. (See Fig. 5)

Fig. 5



Step 10

**TEST FUNCTION:**

With an *EMPTY* pistol, draw the bolt to the rear and cock the hammer. Then dry fire to make sure the hammer is cocking and releasing properly. Repeat this step. Cock the pistol again and dry fire again. After dry firing, hold the trigger to the rear and cock the pistol again, then release the trigger and dry fire again to insure the disconnecter is properly working.

Now, test the *Safety* by engaging it and pulling the trigger. The pistol should *NOT* fire.

If for any reason the pistol does not function, *Do Not* attempt to fire it. Contact *Majestic Arms LTD.* immediately for further instructions.

**You are now ready to "Speed Strip"**

- #1 Check to make sure the pistol is unloaded by removing the magazine and visually inspecting the chamber. After making certain the pistol is unloaded, cock the pistol and engage the safety. *Do Not* dry fire the pistol. Insert the allen key into the "Speed Strip" bolt stop pin at the top rear of the pistol, turn counter clockwise until the pin disengages.
- #2 Pull the pin up and out of the receiver.
- #3 Pull the bolt to the rear and out of the receiver. You have now field stripped your gun and are ready for cleaning. This method of disassembly *Does Not* enable you to separate the upper receiver from the grip frame. If you wish, you may still disassemble the pistol the original way.

Thank you for deciding to purchase the "Speed Strip Kit". Installation enables you to rapidly disassemble your pistol for routine cleaning and maintenance without difficulty of the original design system. You may still disassemble your pistol the original way if you choose.

**SAFETY AND SECURITY FIRST**

The "Speed Strip Kit" can also be used to effectively childproof your pistol. We recommend that the bolt assembly be removed and the bolt stop pin be replaced during storage. This will prevent the bolt assembly from being installed in the pistol. In this manner, the pistol can not be used by unauthorized persons.

Thank you. We hope you enjoy using your pistol in its new configuration.

Dino Longueira, Inventor

## Additional Instructions for MK III Series (Not Needed if Installing 3.2 Conversion Kit in a MK III)

If you are installing the "Speed Strip Kit" in a Ruger MK III, these additional instructions will be useful in understanding the additional parts which constitute the magazine disconnect safety.

This feature is found only on pistols of the MK III series.

Figures 1 & 2 show the proper relationship of the disconnect lever and spring in relation to the hammer and drawbar.

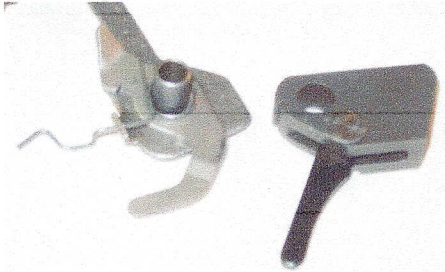


Fig. 1

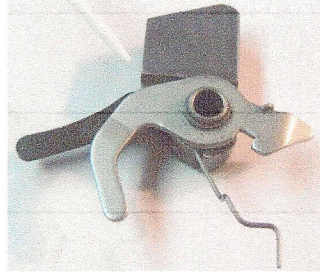


Fig. 2

Figure 3 shows the proper relationship of the hammer, disconnect lever, spring, sear, and safety when installed in the frame.

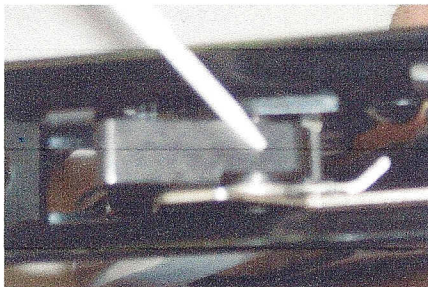


Fig. 3

**NOTE:** After installing the parts it will be necessary to insert a magazine in order to release the disconnect safety and check function.

### **NOTE II:**

When installing a 3.2 Conversion Kit, refer to Step 5 - Fig. 3 & 3A. Use the Hammer and Bushing supplied with the 3.2 Kit. (Use with MK I, MK II, & MK III) **The Magazine Disconnect, Linkage, and Spring (Illustrated on this page) Will Be Discarded.** The magazine disconnect will then be **SAFELY** omitted.