



# JP ENTERPRISES

## JPSCS ALTERNATE OPERATING SPRINGS

**Product:**  
JPSCS-PACK15  
JPSCS-PACK10

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**CAUTION: REMOVE THE MAGAZINE AND VISUALLY CHECK THE CHAMBER TO ENSURE THAT YOUR FIREARM IS UNLOADED.**

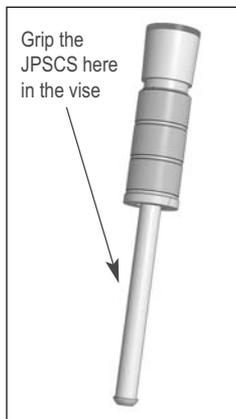
The JPSCS Alternate Operating Springs provide replacement springs for the JP Silent Captured Spring with different spring rates to facilitate more precise tuning and refinement of your rifle's cycling. As a general rule for selecting an alternate spring, install a heavier spring if you feel the buffer head fully compress and bottom out while firing the weapon with the existing spring in your JPSCS. If the bolt carrier will not lock back reliably on the last round fired even when completely gassed (in the case of an adjustable gas block), select a lighter spring. The ends of the springs have been color-coded for ease of identification. To ensure your intended result, refer to the table at left in verifying both your current and replacement spring.

	<b>JPSCS-15</b>	<b>JPSCS-10*</b>
<b>HEAVIER</b> ↓	JPSCS-15-80 White - Uncolored	JPSCS-10-100 Red - Uncolored
	JPSCS-15-85 Black - Uncolored	JPSCS-10-105 Red - Blue
	JPSCS-15-90 Green - Uncolored	JPSCS-10-110 Red - Yellow
	JPSCS-15-95 Yellow - Uncolored	
	JPSCS-15-100 Uncolored	

\* The initial run of JPSCS-10 units were assembled with uncolored springs. If you have a JPSCS-10 with no color coding on its springs, the spring is a JPSCS-10-100.

## INSTALLATION INSTRUCTIONS

1. Compress the buffer spring by hand and grip the guide rod in a soft padded vise where shown. Take care to grip the unit securely with the spring under tension in this way or it may take flight. On later runs of JPSCS units, you can also retain the mass slider by inserting an appropriately sized pin or tool into the hole located near the center of the guide rod.
2. To break down the thread locker securing the guide rod screw, apply heat with a propane torch or powerful heat gun to the guide rod while using a hex wrench to apply turning pressure to the screw. Once the screw breaks loose, remove the heat source and the screw.



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3. Carefully remove the JPSCS from the vise holding the buffer and guide rod firmly to prevent them from accidentally ejecting. The spring pressure is approximately 15 lbs., so point these components away from your face as a precaution in case they do fly apart.
4. Slowly relax the spring and remove both the spring and buffer mass from the guide rod.
5. Clean the guide rod in lacquer thinner, acetone, brake cleaner or equivalent. Allow the part to air dry or blow the threads out with compressed air to remove solvent.
6. Clean the guide rod screw with solvent and dry. Apply Loctite® 263 or equivalent thread locker to the threads.
7. Install the new spring followed by the buffer mass.
8. Compress the new spring onto the guide rod with the buffer mass and install the screw finger tight.
9. Re-secure the unit by the guide rod in the padded vise as you did in step 1. Tighten the screw to about 3-5 foot-pounds and allow the thread locker to cure before use.

During regular rifle maintenance, check the tightness of the hex head screws at the ends of the JPSCS. If they are loose, remove them, clean the threads and reapply Loctite® 263 before reinstalling.

**THANKS FOR YOUR BUSINESS!**