



MRTS Recoil Kit User Guide

SIG P2022



Technical Support

FAAC Incorporated offers 24/7 telephone as well as email-based technical support. Please contact MILO Service with any concerns or problems at:

Email: support@milorange.com
Phone: 1-800-344-1707

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Introduction

The purpose of the MRTS recoil kit is to quickly convert a live firearm into an effective training weapon that is both realistic and safe. No live ammunition can be loaded into, or fired from, the weapon when the recoil kit is installed.

When the weapon is fired with the recoil kit installed, an infrared (non-visible) laser is secured into the muzzle of the firearm, allowing interaction with the MILO simulator.

ALL FIREARMS SAFETY RULES AND GUIDELINES SHOULD BE FOLLOWED AT ALL TIMES!

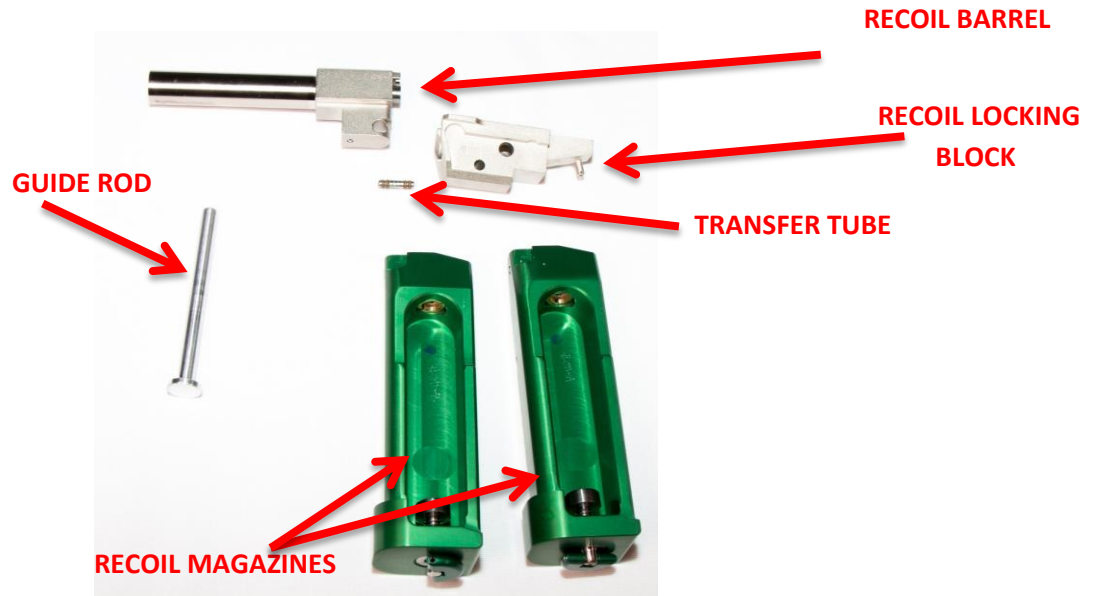


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Parts & Components of the Kit

There are several parts of the original weapon needed, in addition to the recoil kit components, in order for proper operation.



The following original weapon components are used:

- Frame and slide (and all sub components)

The following recoil kit components are provided as part of the recoil kit:

- Recoil Barrel: Takes the place of the weapon's live fire barrel.
- Recoil Magazine (2): Takes the place of the weapon's original magazine.
- Recoil Locking Block: Replaces the factory locking block
- Transfer Tube: Fits between the recoil barrel and locking block, allows CO2 to transfer from magazine to the chamber
- Guide Rod: Replaces the factory guide rod.
- Spare Parts & Tools:
 - Magazine top port gasket (2)
 - Magazine piercing nozzle gasket
 - Recoil Bolt Assembly Large replacement O-ring
 - Bolt Connector O-rings
 - Bolt Connector Installation Tool and Wrench
 - Bolt Oil & Teflon Grease

Recoil Kit Installation

- 1) Remove the original magazine from the weapon and ensure that then weapon is clear and safe.
- 2) Remove the slide from the frame per the manufacturers specifications.



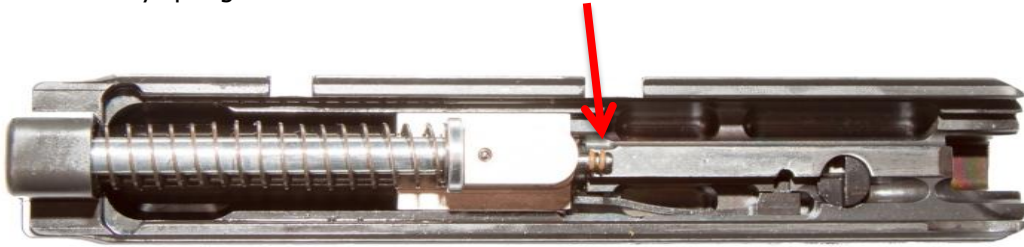
- 3) Once filed stripped, remove the locking insert axel, this is removed from right to left. Then remove the trigger pivot from left to right.



- 4) Pull the factory locking block out of the frame, and replace with the supplied locking block. When inserting the new locking block ensure that you fit the rails of the locking block into the channel of the frame.



- 5) Remove the factory guide rod, spring, and barrel. Replace with the recoil barrel, supplied guide rod and factory spring. Ensure that the transfer tube is inserted into the recoil barrel.



- 6) Reinsert the locking insert axel, push from left to right. Then install the trigger pivot from right to left.

- 7) Reattach the fully assembled slide to the frame.



- 8) Next install the laser and batteries, you must ensure that the battery spring is installed into the adapter first, next install two size 377 batteries into the laser, ensuring the positive side is facing out. Screw the laser into the adapter until the black O-ring is no longer visible.



- 9) To install the CO2 cartridge to the magazine, place the smaller diameter portion of the cartridge into the magazine first and align it with the piercing nozzle at the top of the magazine. Then, firmly tighten the thumb screw at the bottom of the magazine to secure the CO2 cartridge in place and pierce it for use.
- 10) If charging of the action is required for this weapon, do so. Test fire the recoil weapon.



Recoil Kit Removal

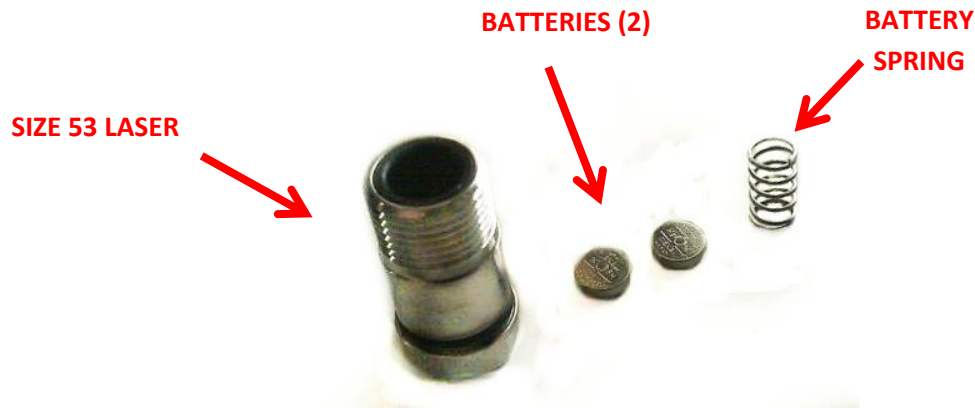
To remove the recoil kit, take out the magazine and fire the weapon once to ensure the recoil bolt is not charged. Note that some recoil kits may require you to release the magazine and manually pull on the magazine to release it.

- 1) Remove the slide from the frame.
- 2) Remove the guide rod, spring, and recoil barrel.
- 3) Remove the recoil locking block.

Laser Information

An infrared (IR) laser insert module is provided with each recoil kit. The IR laser emits a pulse of light each time the weapon is fired. The pulse is not visible to the human eye. The laser pulse is detected by the MILO simulator and is used to indicate the shot location.

Recoil Rifles use standard SIZE 53 recoil lasers.



Laser Batteries

To power the laser, 2x #377 batteries are used. A set of batteries should last 3 weeks, depending on use. The batteries should be installed with the negative (-) side facing into the laser.



CLASS 3R LASER PRODUCT
INVISIBLE LASER RADIATION
AVOID DIRECT EYE EXPOSURE

Maintenance

Every 5000 shots, or as needed, you should perform the following maintenance on the recoil kit:

Lubrication of weapon

If your weapon normally requires lubrication on slide rails or elsewhere, be sure to apply it.

Lubrication of recoil barrel and Magazine port

Place a small drop of the supplied clear machine oil into the top of the magazine every few magazine changes to help reduce the amount seal needed.



changes

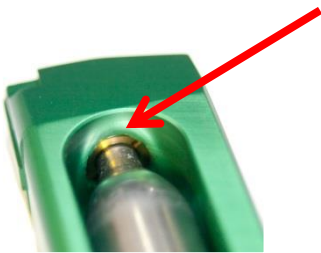
Lubricate the rest of the firearm, per the manufacturers' recommendations.

Troubleshooting



Air leak on top port of magazine when not in weapon

An air leak from the top port of a magazine that is not installed in a recoil weapon is an indication that the magazine itself has a worn gasket. Follow the repair guide for magazine gasket replacement. If the magazine continues to leak afterwards, contact MILO Range Customer Service.



Air leak at top of CO2 cartridge in magazine when not in weapon

An air leak from the top of the CO2 cartridge is an indication that the gasket around the piercing nozzle of the magazine is worn or missing. Follow the repair guide for piercing nozzle gasket replacement. If the magazine continues to leak afterwards, contact MILO Customer Service.

Repair Guide

Magazine CO2 Port Gasket

- 1) Remove any CO2 cartridge in the magazine.
- 2) Hold the magazine and remove the coupler from the top of the magazine using the provided tool.
- 3) Pull the black gasket out of the magazine and discard it. Verify that the ball bearing is still in the magazine.



- 4) Place a new gasket into the magazine and secure it firmly in place using the provided gasket installation tool. Make sure that it is seated fully in the recessed area.



**NEW SEAL INSERTED
INTO THE SEAL
REPLACEMENT TOOL**



**INSERT SEAL REPLACEMENT
TOOL INTO THE TOP PORT
OF MAGAZINE**



**PRESS THE PLUNGER
INTO THE SEAL
REPLACEMENT TOOL,
UNTIL YOU FEEL THE
SEAL CLICK INTO PLACE**



**PROPERLY REPLACED TOP
SEAL**

- 5) Secure the coupler back onto the magazine.



- 6) Grease the opening at the top of the magazine.



Magazine Piercing Nozzle Gasket

- 1) Remove any CO2 cartridge in the magazine.
- 2) Hold the magazine upside down and pry out the piercing nozzle gasket. . Place a new gasket on the piercing nozzle and ensure that it is fully seated.

