



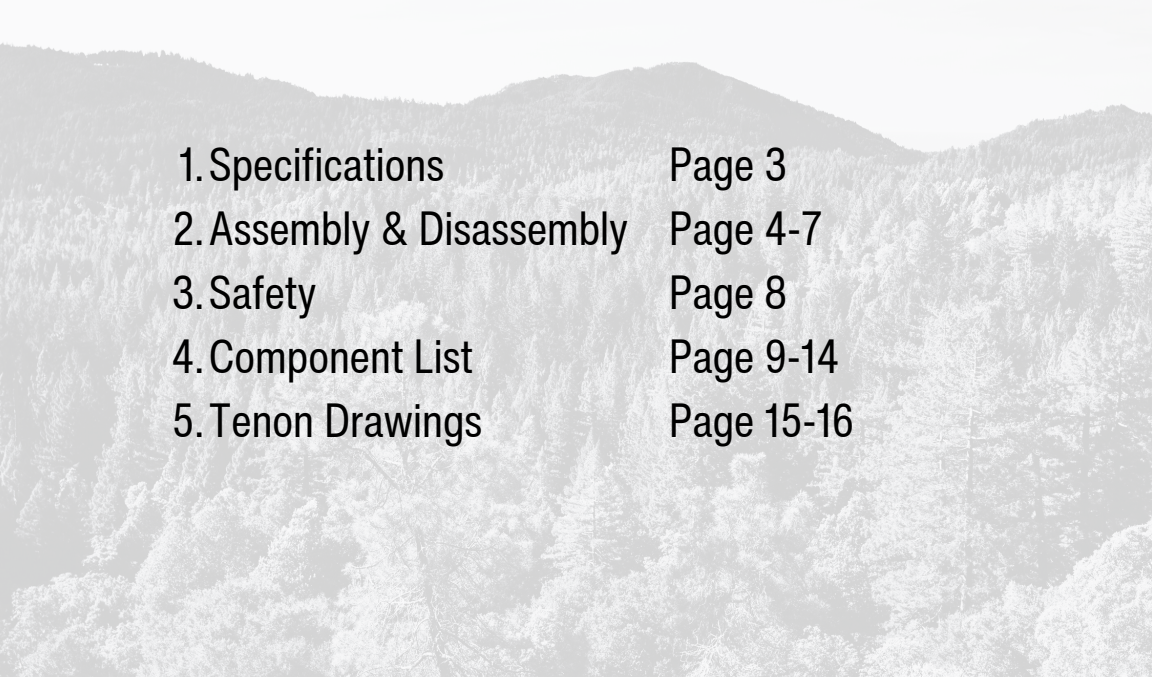
1934

ARMORY

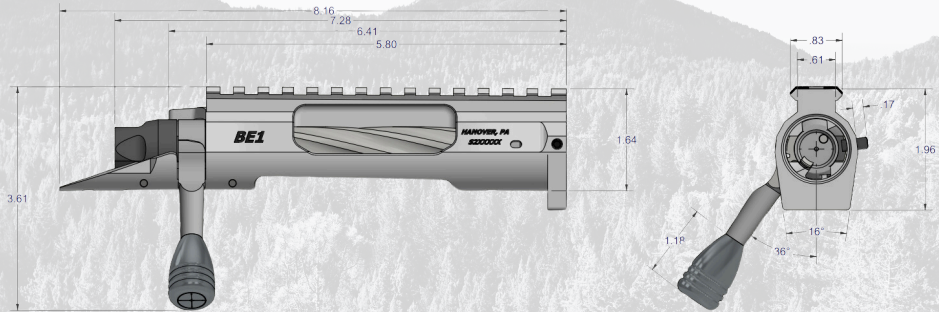


BE1

Owner's Manual

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Action Specs



Total Weight: 32 oz. / 2 Pounds

Barrel Torque: 75 - 85 Foot-pounds

Bolt Through Angle: 90 Degrees

Bolt Material: Hardened 4140 Alloy Steel

Receiver Material: Pre-Hardened 4140 Alloy Steel

Bolt Face DIA: 0.384"(223/5.56x45),
0.481"(Standard), 0.540"(Mag)

Primer Strike Depth: 0.060"

Quick Change screw Torque: 25 - 29 Inch-pounds

Headspace Tolerance: +/- 0.001"

Integrated Rail Angle: 20 MOA

Recoil Lug Thickness: 0.300"

Assembly

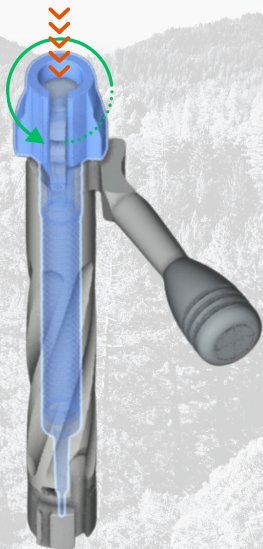
Firing Control Assembly

To assemble the firing control into the bolt:

1. Make sure that the firing control is clean and free of any dirt.
2. Lightly coat firing pin spring, internal bolt bore and the ears of the bolt shroud with gun oil.
3. With the bolt in the upright position, insert the firing control into the bolt.
4. Apply downward pressure to the bolt shroud until it bottoms out on the bolt's face, then turn counterclockwise until the roller cam sits in the resting position.

Note:

If the roller cam is rotated past its resting point, it will travel to the bottom of the bolt cam pocket, making it difficult to get back to the resting position.

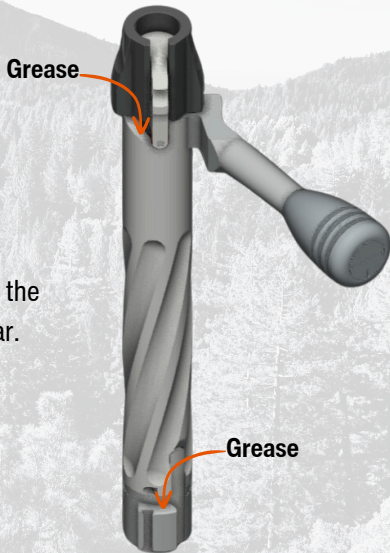


Assembly

Bolt Installation

Before installing the bolt into the receiver:

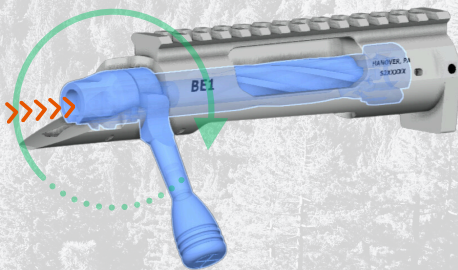
1. Make sure that the bolt is clean and free of any dirt.
2. Lightly coat the outside of the bolt and the internal raceways of the receiver with gun oil.
3. Apply a small amount of lithium grease to the back of the bolt lugs and the bolt roller cam pocket to reduce wear.



Assembly

Bolt Installation Continued...

4. Aline bolt lugs with the raceways in the receiver and push the bolt past the bolt stop catch.
5. Push the bolt forward and lock the bolt into battery. Repeat the lock-up process once or twice to ensure the grease is evenly applied to the intended surfaces.

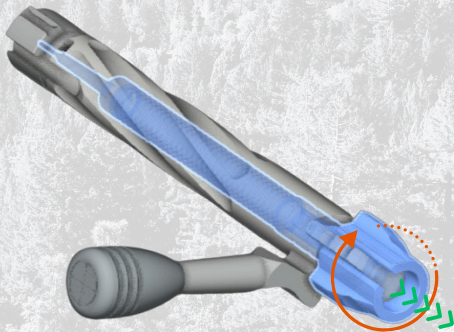


Disassembly

Firing Control Disassembly

To remove the firing control assembly from the bolt:

1. Turn the bolt over so the bottom of the bolt is facing up.
2. Use the bolt shroud to rotate the firing control clockwise.
3. Once the roller cam is over the resting position, the firing control will separate from the bolt.



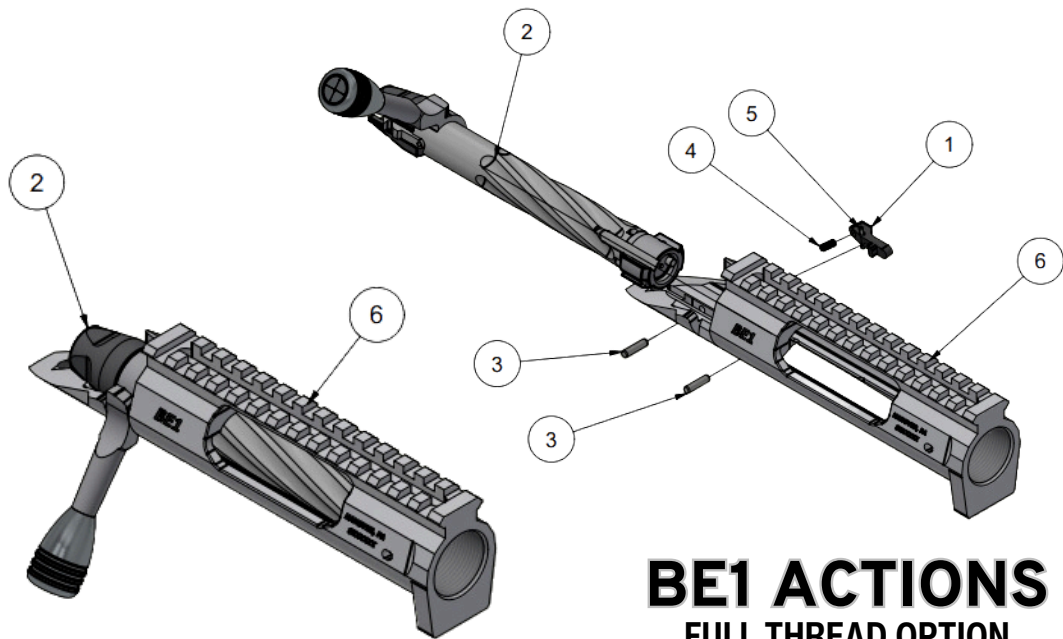
Safety

Installation Safety.

1934 Armory recommends that a certified gunsmith install any of our actions to ensure proper installation of barrels, triggers, stocks, and chassis, and it refers to the specific torque specs provided for barrel installation.

When installing chassis and stocks, one should follow the installation instructions and specifications provided by the chassis or stock manufacturer.

For ease of installation, 1934 Armory offers a 2-lug action wrench that makes torquing down barrels simple and easy. Please visit 1934Armory.com to purchase.



BE1 ACTIONS

FULL THREAD OPTION

BE1-SP22PV1IRHFT - Parts List

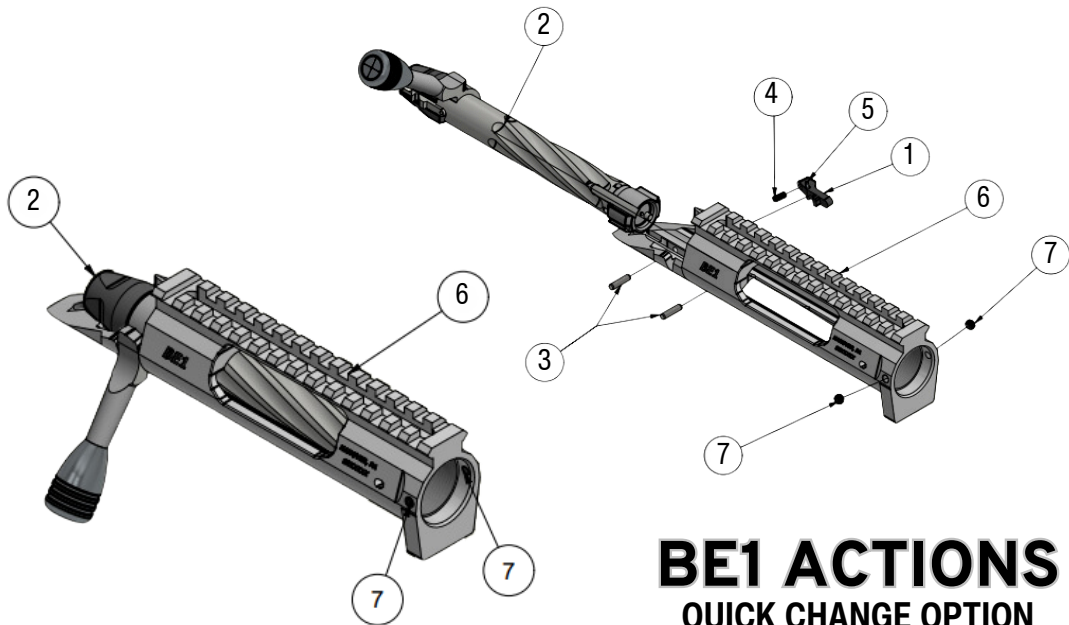
| ITEM# | Description | Part# |
|-------|--|------------|
| 1. | BOLT STOP | BE-0008 |
| 2. | VARMINT 2 LUG BOLT ASSEMBLY (0.384" BOLT FACE) | BE-A0002V |
| 3. | TRIGGER PIN | P-1000-002 |
| 4. | BOLT STOP SPRING | P-5925-273 |
| 5. | BOLT STOP PIN | P-8201-827 |
| 6. | BE1 RECEIVER, SHORT, 2 LUG, INTEGRATED 20 MOA RAIL AND RECOIL LUG, FULL THREAD | BE-0001FT |

BE1-SP32PV1IRHFT - Parts List

| ITEM# | Description | Part# |
|-------|--|------------|
| 1. | BOLT STOP | BE-0008 |
| 2. | STANDARD 2 LUG BOLT ASSEMBLY (0.481" BOLT FACE) | BE-A0002S |
| 3. | TRIGGER PIN | P-1000-002 |
| 4. | BOLT STOP SPRING | P-5925-273 |
| 5. | BOLT STOP PIN | P-8201-827 |
| 6. | BE1 RECEIVER, SHORT, 2 LUG, INTEGRATED 20 MOA RAIL AND RECOIL LUG, FULL THREAD | BE-0001FT |

BE1-SP42PV1IIRHFT - Parts List

| ITEM# | Description | Part# |
|-------|--|------------|
| 1. | BOLT STOP | BE-0008 |
| 2. | MAGNUM 2 LUG BOLT ASSEMBLY (0.540" BOLT FACE) | BE-A0002M |
| 3. | TRIGGER PIN | P-1000-002 |
| 4. | BOLT STOP SPRING | P-5925-273 |
| 5. | BOLT STOP PIN | P-8201-827 |
| 6. | BE1 RECEIVER, SHORT, 2 LUG, INTEGRATED 20 MOA RAIL AND RECOIL LUG, FULL THREAD | BE-0001FT |



BE1 ACTIONS

QUICK CHANGE OPTION

BE1-SP22PV1IIRH - Parts List

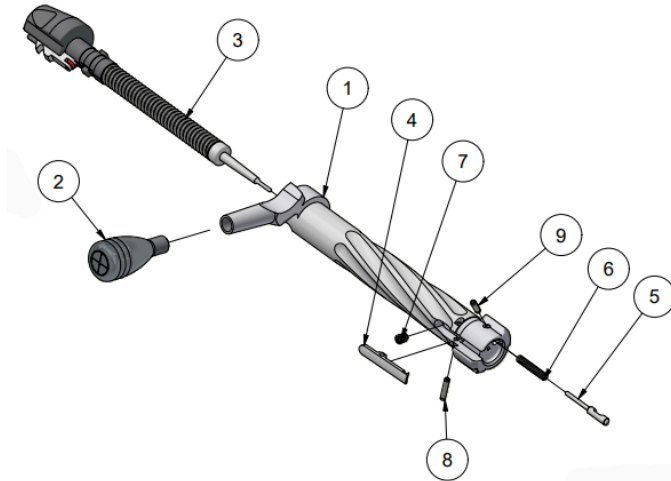
| ITEM# | Description | Part# |
|--------------|---|--------------|
| 1. | BOLT STOP | BE-0008 |
| 2. | VARMINT 2 LUG BOLT ASSEMBLY (0.384" BOLT FACE) | BE-A0002V |
| 3. | TRIGGER PIN | P-1000-002 |
| 4. | BOLT STOP SPRING | P-5925-273 |
| 5. | BOLT STOP PIN | P-8201-827 |
| 6. | BE1 RECEIVER, SHORT, 2 LUG, INTEGRATED 20 MOA RAIL AND RECOIL LUG, QUICK CHANGE | BE-0001 |
| 7. | QUICK CHANGE SET SCREW | P-8201-880 |

BE1-SP32PV1IIRH - Parts List

| ITEM# | Description | Part# |
|--------------|---|--------------|
| 1. | BOLT STOP | BE-0008 |
| 2. | STANDARD 2 LUG BOLT ASSEMBLY (0.481" BOLT FACE) | BE-A0002S |
| 3. | TRIGGER PIN | P-1000-002 |
| 4. | BOLT STOP SPRING | P-5925-273 |
| 5. | BOLT STOP PIN | P-8201-827 |
| 6. | BE1 RECEIVER, SHORT, 2 LUG, INTEGRATED 20 MOA RAIL AND RECOIL LUG, QUICK CHANGE | BE-0001 |
| 7. | QUICK CHANGE SET SCREW | P-8201-880 |

BE1-SP42PV1IIRH - Parts List

| ITEM# | Description | Part# |
|--------------|--|--------------|
| 1. | BOLT STOP | BE-0008 |
| 2. | MAGNUM 2 LUG BOLT ASSEMBLY (0.540" BOLT FACE) | BE-A0002M |
| 3. | TRIGGER PIN | P-1000-002 |
| 4. | BOLT STOP SPRING | P-5925-273 |
| 5. | BOLT STOP PIN | P-8201-827 |
| 6. | BE1 RECEIVER, SHORT, 2 LUG, INTEGRATED 20 MOA RAIL AND RECOIL LUG, QUICK CHANGE | BE-0001 |
| 7. | QUICK CHANGE SET SCREW | P-8201-880 |



BE1 BOLT

OPTIONS

BE-A0002V (VARMINT) - Parts List

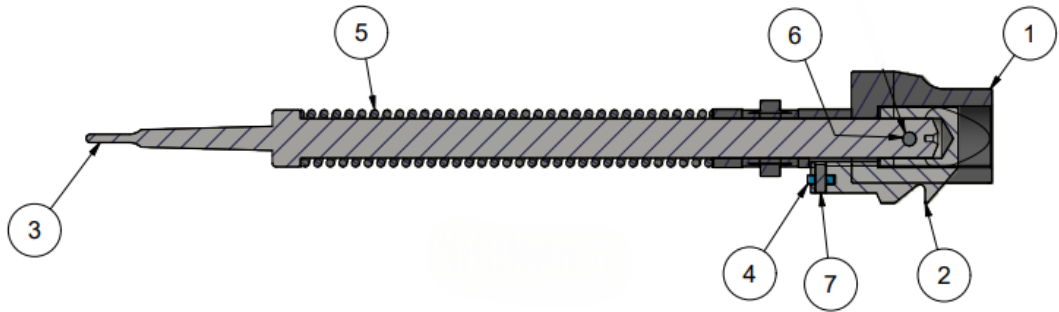
| ITEM# | Description | Part# |
|--------------|---------------------------------------|----------------|
| 1. | VARMINT 2 LUG BOLT (0.384" BOLT FACE) | BE-0002V |
| 2. | 1934 ENGRAVED BOLT KNOB | BE-0014 |
| 3. | SHORT FIRING PIN ASSEMBLY | BE-A0003 |
| 4. | EXTRACTOR | FAP-8271-A-010 |
| 5. | PLUNGER | FAP-8271-A-011 |
| 6. | PLUNGER SPRING | P-5925-279 |
| 7. | EXTRACTOR SPRING | P-5925-280 |
| 8. | EXTRACTOR PIN | P-8201-863 |
| 9. | PLUNGER PIN | P-8201-864 |

BE-A0002S (STANDARD) - Parts List

| ITEM# | Description | Part# |
|--------------|--|----------------|
| 1. | STANDARD 2 LUG BOLT (0.481" BOLT FACE) | BE-0002S |
| 2. | 1934 ENGRAVED BOLT KNOB | BE-0014 |
| 3. | SHORT FIRING PIN ASSEMBLY | BE-A0003 |
| 4. | EXTRACTOR | FAP-8271-A-010 |
| 5. | PLUNGER | FAP-8271-A-011 |
| 6. | PLUNGER SPRING | P-5925-279 |
| 7. | EXTRACTOR SPRING | P-5925-280 |
| 8. | EXTRACTOR PIN | P-8201-863 |
| 9. | PLUNGER PIN | P-8201-864 |

BE-A0002M (MAGNUM) - Parts List

| ITEM# | Description | Part# |
|--------------|--------------------------------------|----------------|
| 1. | MAGNUM 2 LUG BOLT (0.540" BOLT FACE) | BE-0002M |
| 2. | 1934 ENGRAVED BOLT KNOB | BE-0014 |
| 3. | SHORT FIRING PIN ASSEMBLY | BE-A0003 |
| 4. | EXTRACTOR | FAP-8271-A-010 |
| 5. | PLUNGER | FAP-8271-A-011 |
| 6. | PLUNGER SPRING | P-5925-279 |
| 7. | EXTRACTOR SPRING | P-5925-280 |
| 8. | EXTRACTOR PIN | P-8201-863 |
| 9. | PLUNGER PIN | P-8201-864 |

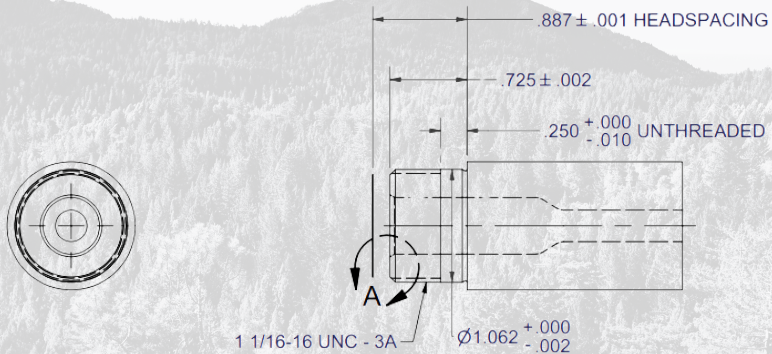


BE1 FIRING PIN ASSEMBLY

BE-A0003 - Parts List

| ITEM# | Description | Part# |
|--------------|---------------------------|----------------|
| 1. | BOLT SHROUD | BE-0005 |
| 2. | COCKING PIECE | FA-8271-A-016 |
| 3. | FIRING PIN - SHORT | FAP-8271-A-001 |
| 4. | COCKING PEICE CAM BEARING | FAP-8271-A-015 |
| 5. | FIRING PIN SPRING - SHORT | P-5925-272 |
| 6. | COCKING PIECE PIN | P-8201-832 |
| 7. | CAM BEARING PIN | P-8201-859 |

BE1 QUICK-CHANGE TENON

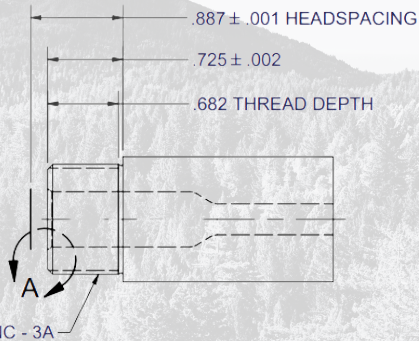
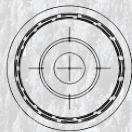


$.025\ \text{X}\ 60^\circ$ Chamfer

$.050\ \text{X}\ 45^\circ$ Chamfer
MAX

DETAIL A
SCALE 2 : 1

BE1 FULL THREAD TENON

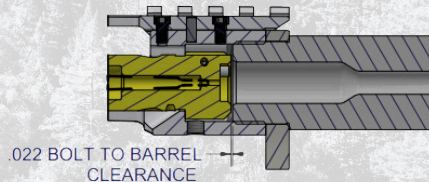


.025 X 60° Chamfer



.050 X 45° Chamfer
MAX

DETAIL A
SCALE 2 : 1





1934

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