



*REAP WEAPONRIES*

*SCY*

Bullpup Conversion

# Owner's Manual

MADE IN THE U.S.A.

## **INTRODUCTION**

THANK YOU FOR YOUR PURCHASE OF THE SCY! WE APPRECIATE YOUR BUSINESS AND HOPE YOU ARE AS PLEASED WITH INSTALLING AND USING THE PRODUCT AS WE WERE DEVELOPING AND PRODUCING IT FOR YOU!!

WE HAVE MANUFACTURED WHAT YOU HAVE RECEIVED WITH PRIDE. BEFORE LEAVING OUR FACILITIES, THE PRODUCT WAS INSPECTED FOR WORKMANSHIP, QUALITY, AND FUNCTIONALITY TO STRICT COMPANY STANDARDS INTENDED TO EARN YOUR RESPECT, CONFIDENCE, AND REPEAT BUSINESS!

THE INSTRUCTIONS AND GUIDANCE WITHIN THIS WRITTEN MANUAL ARE MEANT TO SUPPLEMENT: (A) YOUR FIREARM MANUFACTURER'S OWNER'S MANUAL AND, WHEN APPLICABLE, (B) OTHER AFTERMARKET COMPONENT MANUFACTURER'S RESOURCES AND INFORMATION. WE ARE PROVIDING SPECIFIC INFORMATION RELATED TO INSTALLING AND USING OUR PRODUCT ON TYPICAL AND INTENDED INSTALLATIONS FOR SPORTING RIFLES IN HUNTING APPLICATIONS. IF YOU HAVE QUESTIONS OR FEEL UNSURE, PLEASE CALL: (320) 223-5983 FOR ADDITIONAL HELP.

PLEASE READ THIS MANUAL THOROUGHLY AND COMPREHENSIVELY BEFORE INSTALLING AND OPERATING THIS PRODUCT. IF FITMENT FOR YOUR INSTALLATION BECOMES A CONCERN, CONTACT US PRIOR TO PROCEEDING.

FOR LEGAL PURPOSES, FUTURE ASSISTANCE, AND TO BEST SERVE YOU, THERE ARE SEVERAL ASPECTS OF THIS PRODUCT THAT WE NEED TO POINT OUT TO YOU IN THIS DOCUMENT. PLEASE READ FURTHER.

**THIS PRODUCT IS NOT A FIREARM!!**

IMPROPER AND CARELESS HANDLING OF THE PRODUCT AFTER INSTALLATION TO A FIREARM COULD RESULT IN ACCIDENTS, INJURY, DEATH, OR PROPERTY DAMAGE.

THIS PRODUCT SHOULD BE CHECKED UPON DELIVERY AND, IF NECESSARY, SHOULD ONLY BE MODIFIED AFTER AUTHORIZATION FROM REAP WEAPONRIES, LLC.

THIS MANUAL SHOULD ALWAYS ACCOMPANY THE PRODUCT IN THE EVENT OF LOAN OR FURTHER SALE.

**PLEASE SEE OUR WEBSITE FOR A VIDEO WALK THROUGH OF WHAT WAS PACKAGED FOR DELIVERY AND A DEMONSTRATION OF AN INSTALLATION TO ONE OF OUR TEST FIREARMS.**



**GUARANTEE**

REAP WEAPONRIES IS COMMITTED TO CUSTOMER SATISFACTION AND COMPANY TRANSPARENCY. IF YOU HAVE ANY PROBLEMS WITH MANUFACTURING DEFECTS OR PREMATURE WEAR PATTERNS, PLEASE EMAIL US AT [REAPWEAPONRIES@GMAIL.COM](mailto:REAPWEAPONRIES@GMAIL.COM) OR CALL 320-223-5983. EVERYTHING WITHIN REASON WILL BE DONE TO RECTIFY THE SITUATION IN A TIMELY MANNER. WE WILL PRIORITIZE SENDING YOU A REPLACEMENT COMPONENT ON THE GROUNDS THAT THE DEFECTIVE OR DAMAGED COMPONENT IS RETURNED TO OUR FACILITY FOR INSPECTION AND REVISION.

REAP WEAPONRIES REQUIRES PROOF OF PURCHASE REGARDLESS OF WHAT COMPANY YOU PURCHASED FROM. THIS CAN BE IN THE FORM OF A RECEIPT OR ORDER NUMBER. REAP WEAPONRIES WILL PROVIDE REPLACEMENT PARTS TO SOLVE ANY DEFECTS OR DAMAGE BUT DOES NOT PROVIDE FULL REFUNDS UNLESS THE UNIT IS RETURNED TO OUR FACILITY AND FULL INSPECTION WARRANTS AS SUCH.

## **A REMINDER...**

### **ALWAYS FOLLOW THE RULES OF FIREARM SAFETY!**

(reference <https://www.dnr.state.mn.us/safety/firearms-safety.html> )

- 1. Treat Every Firearm as if it is LOADED.**
- 2. Always control the muzzle.**
- 3. Be sure of your target and what is beyond.**
- 4. Keep your finger off the trigger until you're ready to shoot.**
- 5. Wear appropriate eye and ear protection when shooting and maintaining your firearm.**

**Please ensure proper competency and training prior to using any firearm!!**

## **CAUTIONS**

FOLLOW FEDERAL AND STATE RULINGS, POLICIES, AND GUIDELINES AS WELL AS KNOW AND ADHERE TO YOUR LOCAL JURISDICTIONAL REQUIREMENTS FOR FIREARMS PRIOR TO INSTALLING THIS PRODUCT. THE NATIONAL FIREARMS ACT (NFA) MAY BE APPLICABLE TO YOUR INSTALLATION.

WE HAVE IDENTIFIED A NON-EXHAUSTIVE REFERENCE LIST THAT YOU SHOULD BE AWARE OF PRIOR TO INSTALLING TO A FIREARM. WE CONSIDER INSTALLATIONS DEVIATING FROM THE EXAMPLES AND GUIDANCE WE PROVIDE AS INSTALLATIONS OUTSIDE THE SCOPE OF INTENDED USE OF THIS PRODUCT. DEVIATION IS AT THE OWNER'S OR OPERATOR'S OWN RISK AND RESPONSIBILITY.

FIREARM LENGTH, BARREL LENGTH, CERTAIN STOCKS, AND BRACES IN COMBINATION WITH THIS PRODUCT MAY BE UNLAWFUL IN YOUR JURISDICTION. CONFIRM COMPLIANCE AND LAWFUL USE PRIOR TO PROCEEDING WITH THE INSTALLATION OF THIS PRODUCT.

### **PLEASE VISIT, IF APPLICABLE:**

[HTTPS://WWW.ATF.GOV/FIREARMS/QA/WHICH-FIREARMS-ARE-REGULATED-UNDER-NFA](https://www.atf.gov/firearms/qa/which-firearms-are-regulated-under-nfa)

[HTTPS://WWW.ATF.GOV/FIREARMS](https://www.atf.gov/firearms)

DO NOT INSTALL THE PRODUCT ON ANY FIREARM THAT WOULD RESULT IN OPERATING THE FIREARM WITH A BODY PART FORWARD OF THE MUZZLE. A RULE OF THUMB IS TO ENSURE THE BARREL IS LONGER THAN 11" WITH A SUFFICIENTLY LONG HAND GUARD TO ATTACH THE PRODUCT.

WE DESIGNED OUR PRODUCT AROUND THE MIL-SPEC LOWER RECEIVER AND STANDARD SIZED, M-LOK, KEYMOD™, AND SIMILAR HANDGUARDS.

WE HAVE UTILIZED STANDARD AR-15 COMPONENTS WHERE POSSIBLE.

## **INSTRUCTIONS**

### **BEFORE INSTALLING**

1. CHECK THE PRODUCT BOX AND CONFIRM THERE IS NO SHIPPING DAMAGE.  
(FIGURE 1)

**FIGURE 1**

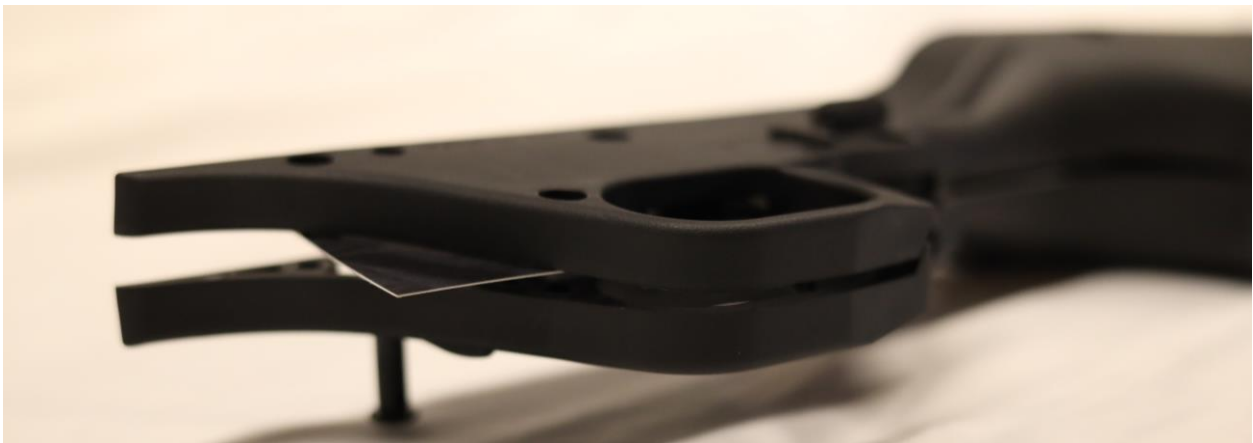


- a. CONTENTS OF BOX:
    - OWNER'S MANUAL
    - RIGHT ASSEMBLY
    - LEFT ASSEMBLY
    - HAND GUARD MOUNTING BRACKET
    - FASTENERS
    - WARRANTY CARD
2. MAKE SURE TO HAVE A CLEAN WELL LIT WORK AREA BEFORE STARTING WORK. IN ORDER TO COMPLETE THE INSTALLATION, YOU WILL NEED:
    - 3/32 ALLEN WRENCH
    - 9/64 ALLEN WRENCH
    - 5/32 ALLEN WRENCH
    - PIN REMOVAL TOOL
    - A SUITABLE GUN OIL, IF DESIRED
    - BUSINESS CARD

3. TO SEPARATE THE KIT UPON ARRIVAL:

- a. YOU MUST FIRST LOOSEN THE FASTENERS MARKED IN RED. (FIGURE 11)
- b. PUSH THE TAKE DOWN PINS TO THE EXTENDED POSITION.
- c. INSERT THE BUSINESS CARD ABOVE THE BUSHINGS AND TRANSFER BAR. (FIGURE 2)
- d. PIVOT THE LH FRAME DOWN 45 DEGREES TO SLIDE AND REMOVE THE SAFETY SELECTOR AND FRAME. (REVERSE FIGURE 10)

**FIGURE 2**



4. CLEAR FIREARM, RENDER IT SAFE, AND ENSURE IT IS CLEAN AND FREE OF DEFECTS. (FIGURE 2)
  - a. REMOVE THE MAGAZINE.
  - b. RETRACT THE BOLT TO FULL REARWARD EXTENSION.
  - c. CHECK THE CHAMBER FOR ANY LIVE AMMUNITION THAT MAY HAVE NOT BEEN EXTRACTED.
  - d. ONCE THE MAGAZINE IS REMOVED AND THE CHAMBER IS EMPTY, THE FIREARM HAS BEEN CLEARED SAFE AND IS READY TO BE PREPARED FOR INSTALLION OF THE BULLPUP CONVERSION KIT.

## **PREPARATION OF FIREARM RECEIVING INSTALLATION**

1. REMOVE GRIP SCREW AND GRIP FROM FIREARM. (FIGURE 3)

a. SET ASIDE

- GRIP
- SELECTOR DETENT SPRING
- SELECTOR DETENT PIN
- GRIP SCREW

2. REMOVE TRIGGER GUARD ROLL PIN AND SCREW. (FIGURE 3)

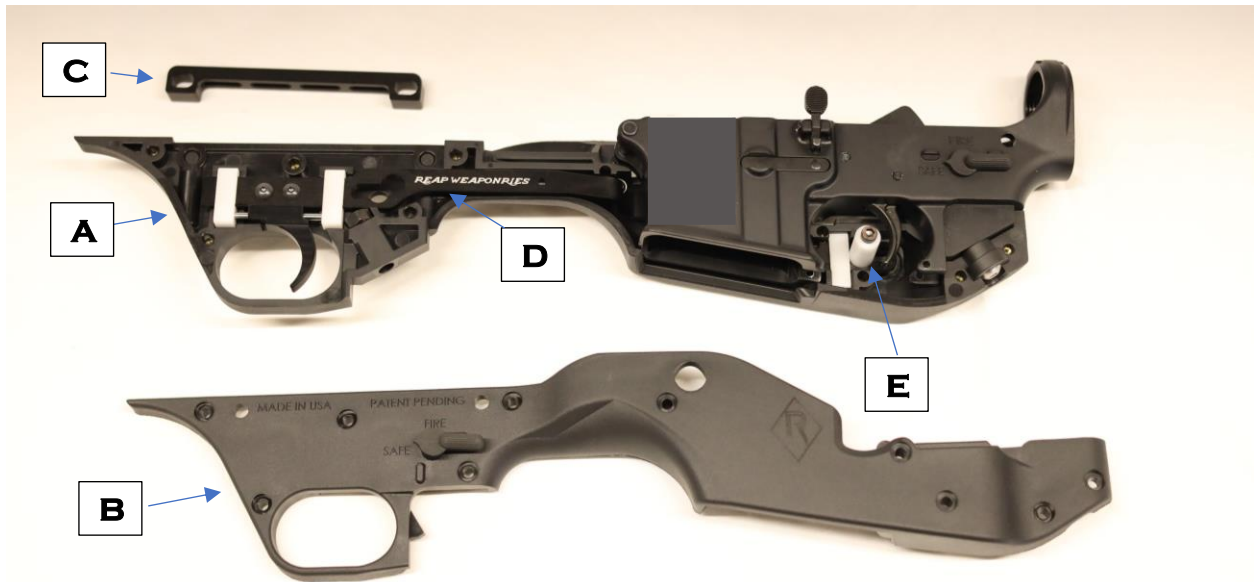
**FIGURE 3**





## BULL PUP CONVERSION KIT ASSEMBLY TO FIREARM

FIGURE 4



- A: RIGHT ASSEMBLY
- B: LEFT HAND FRAME
- C: MOUNTING BLOCK
- D: TRIGGER TRANSFER BAR (pre-assembled to Right Assembly A)
- E: TRIGGER CONTACT BUSHING (pre-assembled to Trigger Transfer Bar D)

1. INSERT SELECTOR DETENT INTO RECEIVER. (FIGURE 5)
2. MOUNT RIGHT SIDE ASSEMBLY (A) ONTO ORIGINAL GRIP MOUNTING LOCATION TAKE CARE TO ALIGN SELECTOR DETENT SPRING.
3. FASTEN RIGHT SIDE ASSEMBLY (A) LOOSELY ONTO LOWER RECEIVER.

**FIGURE 5**



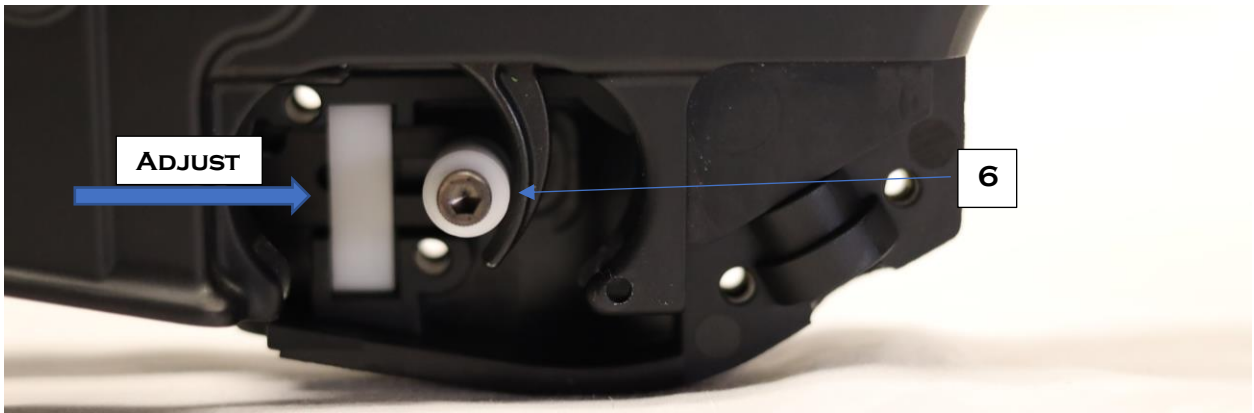
4. INSTALL SAFETY SELECTOR THROUGH TRIGGER TRANSFER BAR (D) AND RIGHT-SIDE ASSEMBLY (A) TEMPORARILY. (FIGURE 6)
5. HOLD SAFETY SELECTOR AT 90 DEGREES IN THE SAFE POSITION. (FIGURE 6)

**FIGURE 6**



6. ADJUST TRIGGER CONTACT BUSHING (E) TO GENTLY TOUCH EXISTING FIREARM TRIGGER WITH FIREARM IN SAFE POSITION. TORQUE TO (20 INCH LBS) (FIGURE 7)

FIGURE 7



7. REMOVE SAFETY SELECTOR.
8. SLIDE BUSINESS CARD UNDER THE FRONT BUSHING SET TO GENTLY RAISE THE TRANSFER BAR SO THE SAFETY SELECTOR AND LH FRAME (B) CAN BE INSTALLED. (FIGURE 8) (SEE STEP 9 AND WARNING)

FIGURE 8

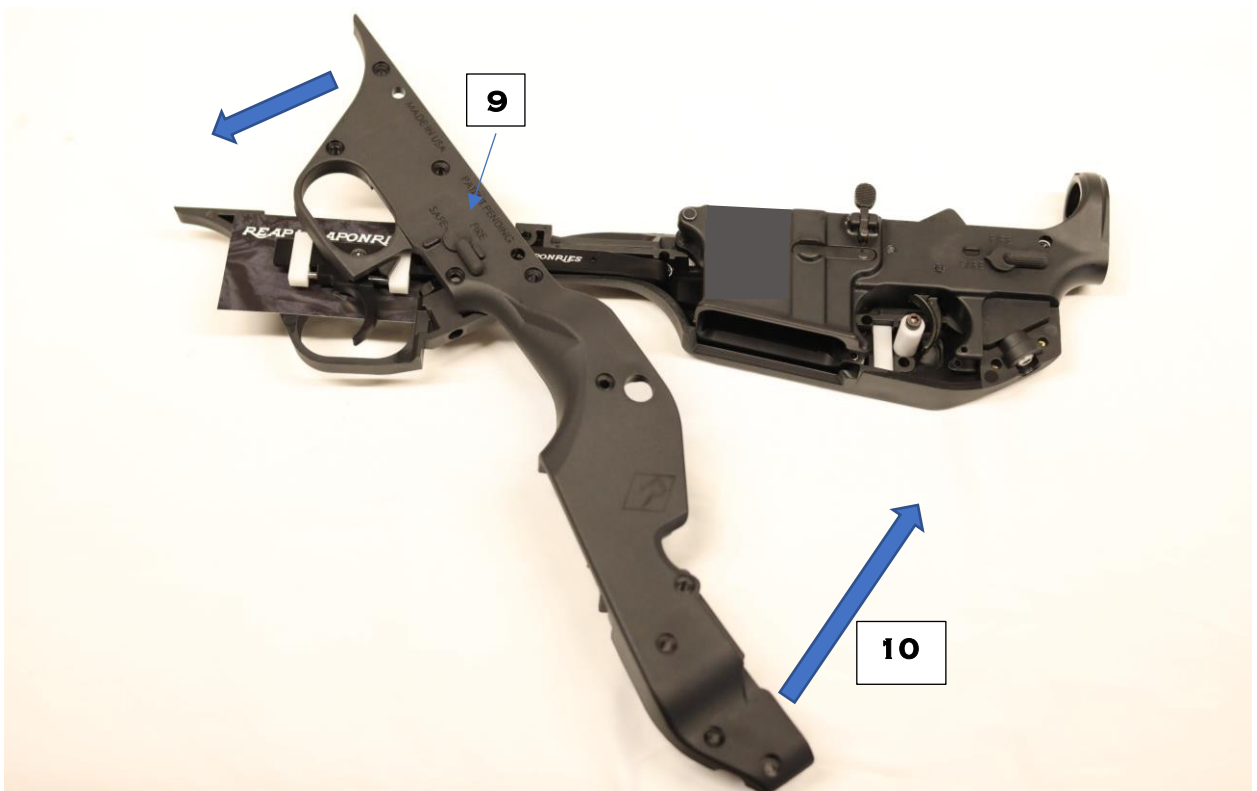


9. INSTALL LH FRAME (B) ONTO RIGHT SIDE ASSEMBLY (A) AT A 45 DEGREE ANGLE WHILE GUIDING THE SAFETY SELECTOR INTO PLACE. (FIGURE 10)  
THE SAFETY SELECTOR NEEDS TO BE INSERTED AT THE TOP OF THE SLOT AND SLID DOWN AND LEFT AT A 45 DEGREE ANGLE TO GET INTO ITS HOME POSITION. (FIGURE 9)

FIGURE 9



FIGURE 10



10. PIVOT THE LH FRAME (B) COUNTERCLOCKWISE INTO PLACE AND REMOVE THE BUSINESS CARD, ADJUST BUSHINGS TO ALLOW THE ASSEMBLY TO FALL INTO PLACE. (FIGURE 10)
11. FASTEN THE TWO BODIES (A) AND (B) TOGETHER USING SUPPLIED FASTENERS. (\*\*DO NOT OVER TIGHTEN\*\* – (16 INCH LBS) (FIGURE 11)

**FIGURE 11**



12. FINAL TORQUE GRIP SCREW FIRMLY. (94 INCH LBS) (FIGURE 11)
13. INSERT SAFETY SELECTOR DETENT INTO SCY KIT. (FIGURE 11)
14. ATTACH GRIP AND SAFETY SELECTOR DETENT SPRING. (FIGURE 11)
15. TEST TRIGGER TO ENSURE IT OPERATES SMOOTH AND FREE.
16. FUNCTION TEST SAFETY SELECTOR TO ENSURE PROPER OPERATION.
17. FUNCTION TEST TRIGGER PULL AND TRIGGER RESET TO ENSURE PROPER OPERATION.
18. INSTALL MOUNTING BLOCK ONTO HANDGUARD  $2 \frac{7}{8}$  INCHES FORWARD FROM THE FRONT OF THE UPPER RECEIVER BLOCK. (FIGURE 12)

**\*\*INCLUDED ARE TWO SHIM WASHERS FOR ANY SPACING THAT MAY BE NEEDED TO ALIGN THE MOUNTING BLOCK FOR THE SCY. ALL RECEIVERS ARE UNIQUE AND YOURS MAY OR MAY NOT NEED A SPACER\*\***

**FIGURE 12**



19. SLIDE ALL TAKE DOWN AND PIVOT PINS TO THE EXTENDED POSITION.
20. BRING THE UPPER AND LOWER RECEIVER BACK TOGETHER. (FIGURE 13)

**FIGURE 13**



21. CLOSE ALL TAKE DOWN AND PIVOT PINS TO LOCK THE SYSTEM TOGETHER. (FIGURE 14)

**FIGURE 14**

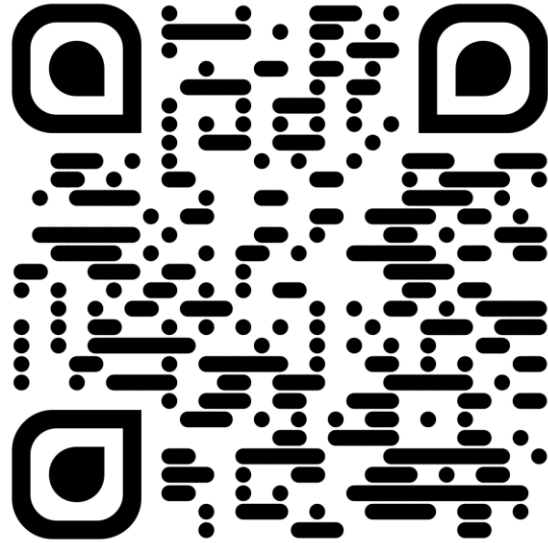


**\*\*IF THE PIVOT PIN IS NOT COMING INTO ALIGNMENT USE AN EMPTY MAGAZINE FOR LEVERAGE AND PULL THE RECEIVERS TOGETHER. THE SCY IS MEANT TO BE A TIGHT FIT TO AVOID UNNECESSARY SLOP IN THE SYSTEM\*\***

**\*\*IF ISSUES ARE STILL PRESENTING, PLEASE CALL OR EMAIL\*\***

22. NOW THAT ALL COMPONENTS ARE ASSEMBLED, PLEASE FINAL FUNCTION TEST THE SYSTEM. (STEPS 23-25)
23. TEST TRIGGER TO ENSURE IT OPERATES SMOOTH AND FREE.
24. FUNCTION TEST SAFETY SELECTOR TO ENSURE PROPER OPERATION.
25. FUNCTION TEST TRIGGER PULL AND TRIGGER RESET TO ENSURE PROPER OPERATION .

**PLEASE SEE OUR WEBSITE FOR A VIDEO WALK THROUGH OF INSTALLATION**



**ONCE AGAIN, THANK YOU FOR YOUR PURCHASE!!!**



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2. ANY DELIVERABLES OR SERVICES PROVIDED TO IT ARE NOT INTENDED TO BE SHIPPED DIRECTLY OR INDIRECTLY TO ANY COUNTRY SUBJECT TO RESTRICTION UNDER APPLICABLE LAWS AND REGULATIONS OF THE UNITED STATES AND OTHER NATIONS AND THAT PURCHASER OR END USER IS NOT LOCATED IN, UNDER THE CONTROL OF, OR A NATIONAL OF ANY SUCH COUNTRY;
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