



TECHNICAL INFORMATION DOCUMENT FOR THE

IRA-10TM

LOWER RECEIVER

DPMSTM & ARMALITETM COMPATIBLE VERSIONS

THE IRON RIDGE ARMS COMPANY

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TECHNICAL SPECIFICATIONS

Weight <i>(stripped)</i>	347	Grams
Weight <i>(with trigger kit, buffer, buffer tube, buffer spring)</i>	886	Grams
Metal	Certified 7075-T6 billet aluminum	
Caliber	.308	
Base Finish	Black anodized	
Max Length	9.000	Inches
Max Width	1.633	Inches
Max Height <i>(trigger guard to vertical)</i>	2.775	Inches
Front Lug insertion width	0.746	Inches
Rear Lug insertion width	0.496	Inches
Lug Pins OD Armalite™	0.274	Inches
Lug Pins OD DPMS™	0.276	Inches

VERY IMPORTANT INFORMATION REGARDING YOUR IRA-10™ LOWER

1. The Iron Ridge Lowers are made to very accurate specifications and the Lug Pin Holes are one uniform size for all production units. The Iron Ridge Lowers are designed to operate with the manufactures internal parts (Armalite™ and DPMS™). After-market parts are at your own risk for proper functioning of the lower.

2. The factory Lug Pins (and after-market pins) have an incredible variance in size (diameter). They vary from kit to kit even from the same manufacture.

3. The Iron Ridge Lowers have precise standard size Lug Pin Holes. These may be TIGHT for the pins you have and thus hard to insert the Lug Pins. The reason for this is that we have made the Lug Pin Holes sized to the smallest 'average' size Lug Pins found after testing hundreds of different manufactures pins. It is easier to DECREASE the Lug Pin size than to INCREASE the Lug Pin size.

4. It is for this reason that we have included some "Emory Cloth" to assist you in reducing the diameter of the Lug Pins so they will fit into the Lug Pin Holes. **Under no circumstances** should you drill out the Lug Pin Holes to enlarge them. **Please read and follow the instructional guide** on how to fit the Lug Pins to the Lug Pin Holes.

5. This Iron Ridge Lower is a highly precise unit made to extremely tight tolerances. It is because we want all of are customers to have the most precise fit for a precision rifle that we have purposefully designed them this way. In the perpetual quest for extreme accuracy, it is well worth the time and effort to get a precision fit when you make a build.

6. We want everyone to have the best fit possible for their uppers & lowers. Should you be unable to properly fit your upper to your lower we would be more than happy to have one of our Master Gunsmiths fit it for you at our shop. We are always more than happy to take your calls should you need a little advice, phone assistance, or direct answers to your questions.

7. Please look through the following pictorial guide for our recommend method of working on your lower. You may also find some features of your lower that you did not know about by reviewing the material.

FITTING YOUR IRA-10™ LOWER TO YOUR UPPER

(You should read this if you want your system to work properly)

1. **If you are not comfortable with this process, do not feel compelled to do it yourself! We don't expect everyone to be an expert, and there is no shame in asking for assistance!**
2. There are two (2) main areas you will need to check for proper fit. These are the:
 - a. Outside diameter of the front and rear Lug Pins. The Lug Pins for the Armalite™ compatible version should have an OD of 0.274" and the Lug Pins for the DPMS™ compatible version should have an OD of 0.276".
 - b. The outside width of the Front and Rear Lugs of your Upper (Figure 7). Both the Armalite™ and DPMS™ compatible versions take the same width of the Upper's Lugs. The width of these lugs should be – Front Lug 0.746" and the Rear Lug 0.496".
3. Lug Pins are supposed to be a standard size. They are not by any means standard and there is a large variation in the outside diameter (OD) even from the primary manufactures parts supply. We have set the inside diameter (ID) of the lug pin holes to match the smallest of the hundreds of Lug Pins (easier to take away metal than to add it). The goal of adjusting the Lug Pins OD is to make them fit "snug" so that they "tap in" lightly. Be patient, this is a slow process. We want everyone to have a perfect fit.
 - a. Use the enclosed emery cloth to sand down the outside of the pins until they tap in lightly
 - b. DO NOT EVER DRILL out the inside of the Lug Pin Holes
4. The outside width of the Front and Rear Upper's Lugs (Figure 7) may have to be adjusted down to where you get a nice tight fit with no wobble.
 - a. Use a file as demonstrated in (Figure 8) to remove the metal evenly from the outside of the Upper Lugs as needed to get a snug fit. A pair of calipers can make this a little easier.
 - b. DO NOT remove too much metal.
5. The DPMS™ and Armalite™ compatible version comes with a nylon tipped ½" set screw behind the pistol grip screw mount. This is to firmly tighten the rear lug of the upper to the lower and eliminate any wobble. It uses a 1/16" Allen wrench for adjustment. (Figure 3 & 4)
6. The Armalite™ compatible version requires you to replace the Roll Pin on the bolt catch with a 6/32" set screw (included with lower). (Figures 5 & 6)

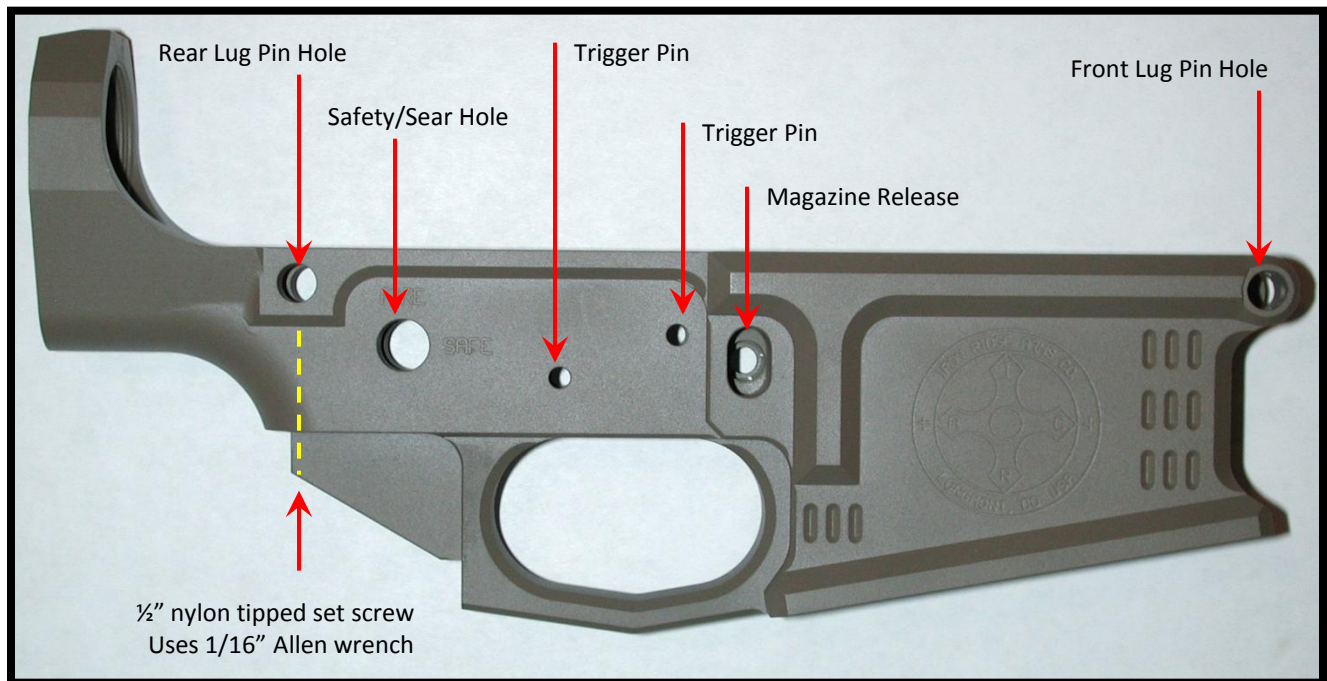


Figure 1

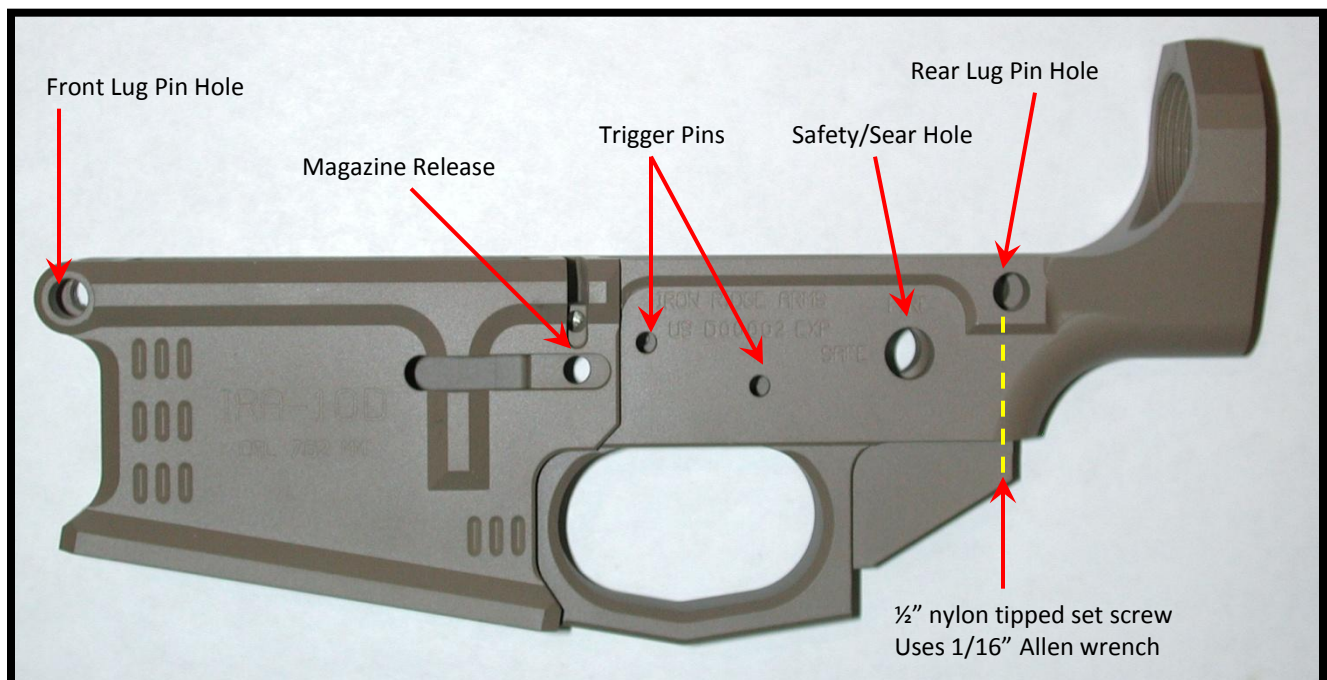


Figure 2

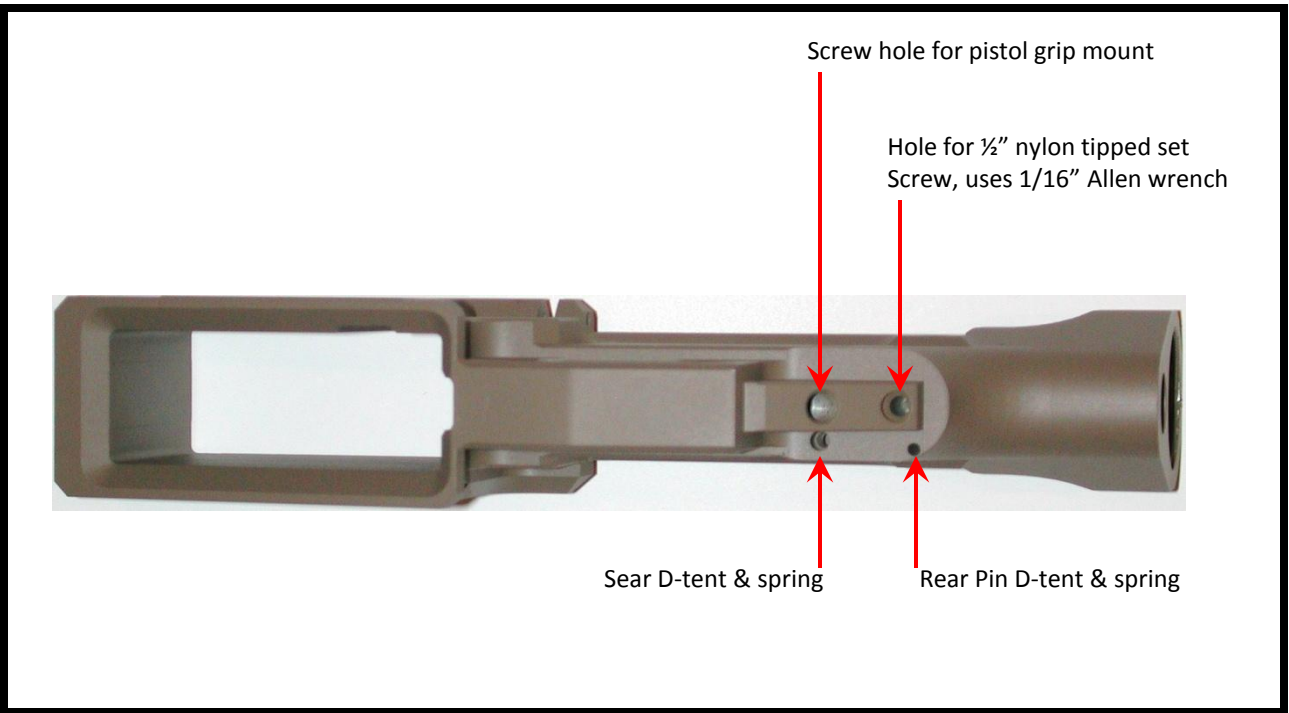


Figure 3

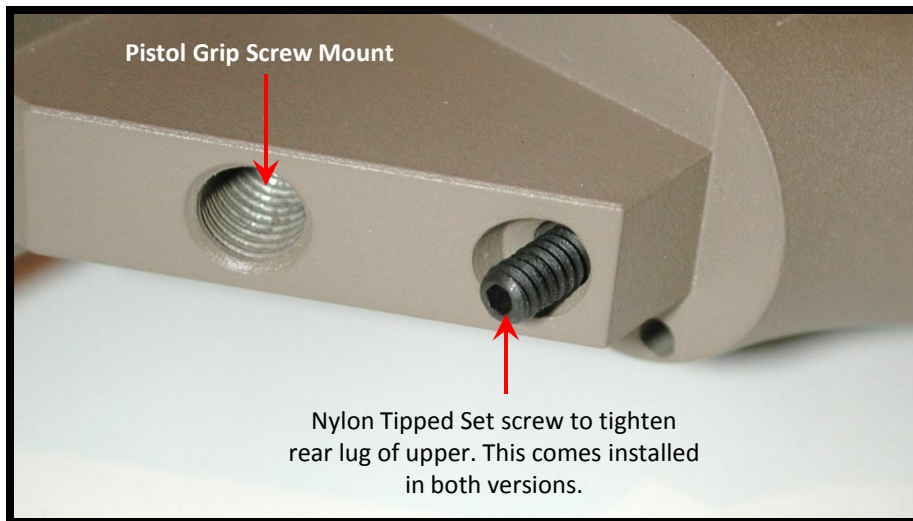


Figure 4



1/2" Nylon Tipped Set screw. Uses 1/16" Allen wrench.

Part #: IRA10RLSS



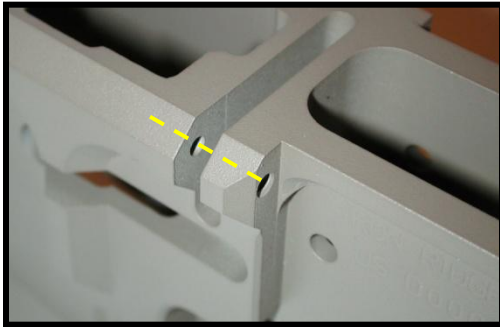


Figure 5

The **Armalite™** compatible version requires you to replace the Roll Pin on the bolt catch with a **7/16" x 6/32 pitch set screw** (preinstalled with the **Armalite™** compatible version).

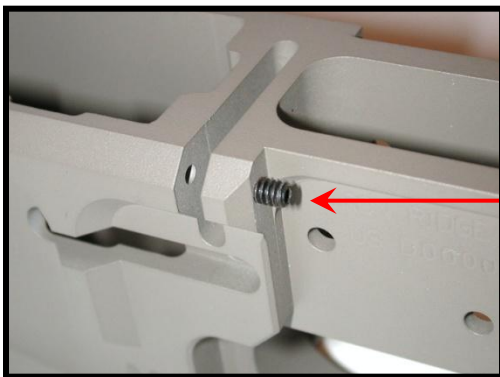


Figure 6

This is the 6/32 pitch x 7/16" set screw that comes installed with the Armalite compatible version. Tighten until snug.



1/16" Allen wrench

Part #: IRA10ARPSS



Tools needed

1. 1/16" Allen wrench

Tools recommended

1. Analog or digital caliper
2. Files for fitting (if needed) front & rear lugs of upper to lower
3. Masking tape

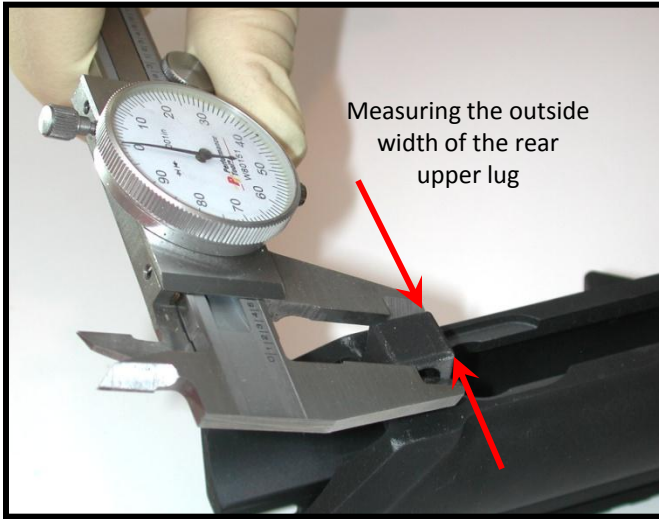


Figure 7

Adjusting the Upper Lugs

1. If the uppers lug(s) are too wide to fit in the lower then some adjustments must be made.
2. The use of calipers to measure the outside width of the uppers lugs and the inside width of the lowers lugs helps you know how much metal must be removed. **NEVER** take off too much metal.
3. When filing of the metal from the outside of the uppers lugs, be sure to remove it **EQUALLY** from both sides.
4. The goal is a snug fit (obviously)

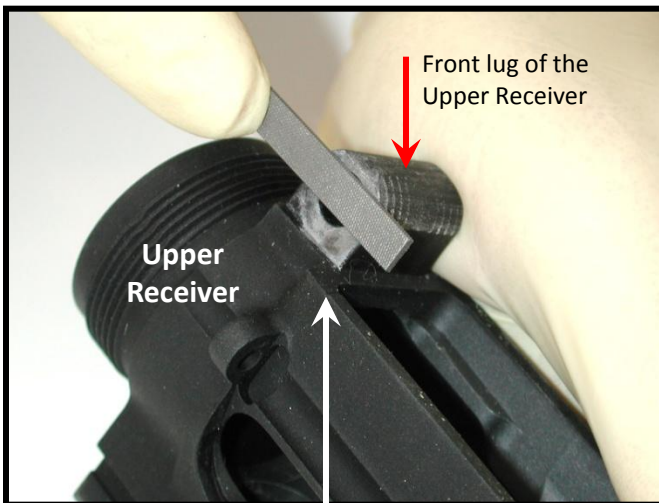


Figure 8

Try not to nick or scratch the nearby surfaces

Filing the Uppers Lugs

1. If the upper lug(s) are too tight for the lower than you will need to file some metal off of them.
2. You may want to put some masking tape on the areas not to be filed so you don't nick or scratch them.
3. Be patient and remove small amounts **EQUALLY** from both sides and then check the fit.
4. Be patient, removing too much metal is, well let's just say, a disaster.

IRON RIDGE ARMS COMPANY LIMITED WARRANTY

rev 1.2, August 2009

The Iron Ridge Arms® IRA-10™ style lower rifle receivers are warranted to be free from defects in material or workmanship for the period of one (1) year from the date of purchase. This warrantee applies only to the original purchaser and is thus void after sale or transfer of the receiver. The Iron Ridge Arms® warrantee only applies to the proper function of the receiver when original factory trigger group components (Armalite™ for the 'A' model and DPMS™ for the 'D' model) are used. The warrantee does not cover failure of function and/or damage to the lower receiver and other components of the rifle when after market components are used.

Claims can be made by contacting Iron Ridge Arms Company in writing at 1110 Delaware Avenue, Suite A, Longmont, CO 80501 or by calling 303-772-4365. The defective unit will be exchanged for a new one when it is received by Iron Ridge Arms®. The new replacement unit will be warranted to be free from defects in material or workmanship for the period of one (1) year from the date of replacement.

This warrantee shall be null and void in the event that Iron Ridge Arms® determines that the rifle receiver was intentionally altered in any way from its original dimensions. The rifle receiver should not be machined, sanded, ground, filed, or drilled for any reason. Any alterations or work to the lower receiver other than described in this instruction manual shall void the warrantee and possibly render the receiver dangerous and unusable. The extent of this warrantee is limited solely the replacement of the lower receiver.

There are no warrantees other than those described herein.