

Fitting MX Locking Blocks with Giuliani Jig

This document provides instructions to fit a Locking Block for a MX series shotgun. The tools required are: the Giuliani Jig, 8" or 10" mill bastard file, 400 grit emery cloth, feeler gauge set and a straightedge. A dial caliper is recommended to match the external dimensions of your old Locking Block, but not required. Read the instructions and go slow.

Unload your gun and close the gun, nudge the Top Lever to the left to make sure it is all the way left. Make a note of where your Top Lever position is: Left of 6 o'clock, 6 o'clock or right of 6 o'clock.

Remove your existing Locking Block from your gun. For help on disassembly of the receiver go to <http://www.donrackleygunparts.com> to the Downloads/Videos tab and watch the video.

1. Fit the new Locking Block where it will slide in place in your receiver. Some material may need to be filed from the outsides of the Locking Block. File inside of Locking Block "ears" so the new Locking Block will slide into your receiver. A dial caliper is handy to match the dimensions of your existing Locking Block. Flat file the top and bottom of the new Locking Block to remove burrs. Make sure the nib of the Top Lever will fit smoothly into the groove in the new Locking Block. Polish the top and bottom sliding surfaces of the new Locking Block with emery paper backed by the file.
2. Locate the old Locking Block in the fixture. Keep the Locking Block pressed against the same side with the jig each time you move the Locking Block. Using the sloped positioning screw, position the Locking Block barrel lug engagement surface flush with the sides of the jig (use the straightedge to set flush).
3. If your top lever is to the left of the 6 o'clock position, back off locating screw 4 turns or until you can just put a 0.016" feeler gauge between the Locking Block engagement area and straightedge placed across the top of the jig. Skip to Step #6
4. If your top lever is fully at the 6 o'clock position, back off locating screw 3 turns or until you can just put a 0.012" feeler gauge between the Locking Block engagement area and straightedge placed across the top of the jig. Skip to Step #6
5. If your top lever is slightly to the right of the 6 o'clock position, back off locating screw 2 turns or until you can just put a 0.008" feeler gauge between the Locking Block engagement area and straightedge placed across the top of the jig.
6. Tighten the top clamp screw to secure the Locking Block in position.
7. File the Locking Block to be flat with jig surface.
8. Loosen clamp screw and tighten locating screw 1/2 turn. Tighten clamp screw and polish Locking Block area with emery cloth backed by the file.
9. Fit the Locking Block, top lever spring and Top Lever Lock Piece in your receiver and check the top lever position with your barrel on the gun. Repeat step #6-#8 until top lever is where you want it.
10. Reassemble your receiver with firing pins and firing pin return springs.