Assembly Instructions (refer to drawings above):
1. Insert nozzle, propellant grains, grain spacer o-ring(s) (if used), and forward seal disk assembly (if used) into liner, then push liner assembly into case until recessed about 3/4" from end of case.
2. Install forward insulator (if used) and forward o-ring into 3/4" recessed end (forward o-ring also seats against forward seal disk).
3. Assemble floating forward closure with smoke charge components per reload kit instructions and install into case against forward o-ring.
4. If using spacers, insert spacers into case against floating forward closure and push into case until recessed about 1/2".
5. Thread retaining ring into forward closure end of case and tighten.
6. Assemble aft o-ring and aft closure into motor per reload kit instructions.

Forward Insulator
2.730" O.D. × .875" I.D.

Forward & Aft O-rings
2-3/4" × 1/8" 230

Grain Spacer O-ring
2-1/2" × 1/16" 036

Forward Seal Disk O-ring
Nozzle Spacer O-ring (M650W)
2-9/16" × 3/32" 142

Inst. P/N 20058-3 Rev. 12/21/09