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Crosman 13xx/22xx Steel Breech Installation (or Alliance Hobby Aluminum Breech Installation)

Depending on your purchase, the photocopied Crosman instructions may be included, but I kept receiving so many complaints on them that I have chosen to write my own. There are also plenty of other instructions, YouTube videos, etc online to help with first time installers.

Attention: Alliance Hobby, time providing, tests each breech prior to shipment. However, if you have bolt problems (handle won't thread into probe, probe jams in chamber, etc), try rotating the probe 180deg and threading in handle from opposite side.

- 1) Remove any Powerlets from the gun (if applicable) and dry fire to ensure there is no charge in the gun.
- 2) If installing on a 22xx, loosen barrel band screws with 5/64" hex wrench (included).
- 3) Cock and lock bolt in rear position to display the tiny front breech screw.
 - a. Loosen with .050" hex wrench (included).
- 4) Remove rear sight screw with flat head screwdriver.
- 5) Breech and barrel are now free to be removed.
 - a. Be careful not to scratch barrel on barrel band (22xx only).
- 6) Included in the kit is a tiny grub screw that fits into the top-center of the steel breech. This holds the barrel in place.
 - a. If not already done for you, thread this screw into the breech via the large wrench (included).
There may be loc-tite on the screw, but it will fit.
- 7) Slide barrel into steel breech.
 - a. Flip breech over so that bottom side is exposed. Line up barrel's transfer port hole with hole on breech.
 - b. Meanwhile, tighten grub screw to lock barrel in place, ensuring that the barrels' exhaust hole is perfectly centered with breech's exhaust hole.

- 8) If the aluminum transfer port bushing came loose during disassembly, reinsert into main tube's exhaust hole. You'll notice the bushing has a wide center with two narrower ends. Each end is a different length. The SHORTER end goes into the main tube and the LONGER end goes into the barrel.
 - a. There is a rubber sleeve that sits in the main tube's hole. It's doubtful that it slid out, but if it did, reinsert. The bushing then rests inside this sleeve.
- 9) Cock the gun (if uncocked) so that the hammer and hammer pin slide freely in its slot.
 - a. Position hammer pin as far back as it will go, then push forward 2mm.
- 10) Slide bolt (don't use the handle, bolt only) into bolt area of breech. It can slide as forward as possible for the next step.
- 11) After sleeve and bushing are installed, position breech/barrel assembly onto top of gun. The critical part of this is that the hammer pin sits behind the bolt. If the bolt is too far back or the hammer pin is too far forward, the assembly won't rest on the gun correctly.
 - a. Ensure that the hammer pin does not get hemmed up in the rear sight screw hole. It has to be in the bolt slot.
- 12) You'll know everything is correct when the breech/barrel assembly sits easily and naturally on the top of the gun. Everything will sit flush after ensuring the breech bushing is centered.
- 13) Thread front breech screw into its hole.
- 14) Thread rear sight screw into its hole.
- 15) Thread bolt handle into bolt.
- 16) Tighten all screws.
 - a. Barrel band (if applicable).
 - b. Barrel set screw.
 - c. Front breech screw.
 - d. Rear sight screw.
- 17) Ensure smooth operation of the action.
 - a. Slightly loosen rear breech screw, front breech screw, barrel set screw and barrel band screw just so there is a tiny bit of slop. Then retighten in this order:
 1. Front breech screw, barrel set screw, rear breech screw, barrel band set screw.

Purchase and installation of this product absolves Alliance Hobby, LLC of any liability, expressed or implied. Airguns can and are dangerous and should be treated with the same respect as firearms. Modifications of any Crosman gun, such as installing a power spring, surely voids the warranty.

Correct installation: Shorter end of bushing goes into sleeve, into main tube. Longer end goes into breech, into barrel.

