



J P E N T E R P R I S E S

J P A D J U S T A B L E G A S S Y S T E M

.750 bore minimized stainless steel

PARTS INCLUDED

- .750 bore gas block
- Two (2) 5/64 x 5/16 roll pins
- One (1) 5/64 hex key

CAUTION:

REMOVE THE MAGAZINE AND VISUALLY CHECK THE CHAMBER TO ENSURE THAT YOUR FIREARM IS UNLOADED.

This small-bore gas block is designed for use on barrels with a .750 gas block journal and should fit with little or no modification needed. We strongly encourage you to read through these instructions once before beginning the installation process.

This minimized Syrac Ordnance gas system is designed to fit under most models of free-floating hand guards. Keep in mind that while this gas block will function easily with JP MK III Hand Guards, the accessibility of the adjustment screw will vary with other brands.

BARREL PREPARATION

1. If you are installing this device on a barrel that is already in assembly in your upper, first remove the takedown pins and separate the lower and upper assemblies to make the job easier.
2. Secure the upper assembly in an appropriate vise. We recommend using our soft-anodized JP Vise Clamps or padded vise jaws.
3. If you already have a gas block installed, you will need to uninstall it along with any other accessories that will cover or block the gas block such as the hand guard and muzzle treatment, depending on your situation. If you intend to reuse the original gas tube, remove the roll pin securing it in the existing gas block using a 1/16" drift.
4. If you've removed an old gas block or front sight, inspect your gas block journal for any high spots or burrs. File any high spots down to ensure tight seal on the gas block.

INSTALLATION

1. Insert the gas tube into the gas block and secure it using the gas tube roll pin supplied.
2. With the gas tube installed, slide the tube through the gas tube hole in the upper receiver until the gas block butts up against the shoulder behind the gas port collar of the barrel. Take care not to scratch the barrel.

If you find the gas block to be very tight around the barrel, one trick is to insert one of the clamp screws into one of the center positions and slightly tension it against a shim such as a quarter or a disconnecter placed in the slot. This will spread the gas block to allow more clearance. Spread the block as little as necessary to avoid damaging it.

3. Align the gas block to the barrel. If you are using a JP Supermatch or similar barrel, ensure that the gas block is seated against the shoulder of the gas block journal.

If your barrel is designed for a Mil-spec gas block and hand guard spacer, you will need to move the gas block forward approximately .025" from the shoulder to account for the hand guard retainer. Otherwise, you will need to measure the distance from the gas block shoulder to the center of the gas port to ensure proper alignment to the gas block.

4. Use a level to align the top of the gas block to the upper receiver rail. This will ensure the gas ports in the gas block and the barrel are aligned radially.

At this point, you can test the gas block with compressed air to ensure proper alignment. With the bolt inserted and closed, push the air nozzle up to the muzzle and apply air while moving the gas block around until you hear maximum flow.

5. Tighten the clamp screws finger tight. Then, go back and tighten each bit by bit to approximately 20-25 inch-pounds of torque. As an option for added stability, you can apply Loctite® 609 between the barrel and gas block to more permanently secure them. If you use thread locker, make sure the surfaces have been cleaned with solvent. **Before use, allow all thread locker to set up according to the product instructions.**

GAS BLOCK SETUP

Most rifles cycle faster than is necessary, and the resulting “bolt slamming” effect is a noticeable part of the recoil impulse. The main purpose of our adjustable gas blocks is to allow adjustment of port pressure to the operating system, thereby fine-tuning the bolt velocity, which will result in a smoother shooting rifle, especially if you already have a JP Recoil Eliminator or JP Compensator. Additionally, the an adjustable gas system is useful in obtaining optimum port pressure on otherwise difficult to run setups such as suppressed weapons, short-barreled weapons, or nonstandard cartridges.

The adjustment screw of this Syrac Ordnance gas block is click-adjustable to retain your desired setting. Do not force the gas screw when it bottoms out in the gas block, and stop unscrewing the gas screw once you see four threads pass the front of the block. Removing the gas screw will void the warranty.

These steps will walk you through setting your gas block for a particular load.

1. Begin by turning the gas adjustment screw in all the way to close off the valve. The symptoms of too much gas and too little gas can actually appear similar enough to be mistaken for each other at times. So, to determine the optimum gas setting, you'll want to start out at a setting that is definitely too low and work up from there.
2. Back the adjustment screw out one click. Load a single round into the magazine, chamber it, and fire. If the bolt doesn't open at all, open it another click and try again. Most likely, the bolt will short stroke at this setting. Assuming that is the case, clear the rifle before proceeding.
3. Back the screw out by another click and fire again. Repeat this sequence until the carrier locks open after the round has been fired. Verify this setting with a few more rounds. If the bolt consistently locks back, you've effectively found the optimum gas setting, though you may want to open the valve another one to two clicks for reliability, especially if you expect to shoot different or unknown loads.

Keep in mind that the gas block has been set for the specific ammo you've tested it with and still may not cycle reliably or optimally with other loads due to their different pressures. Make sure to test the valve setting with any ammunition you intend to use in competition. If your rifle is used for law enforcement or military purposes, we recommend running your rifle with the gas valve fully open so as not to compromise reliability.

Also, be aware that new bolt assemblies and carriers will have more friction in their relationship than parts that have worn in. These may require a break-in period when the gas block valve will have to be set further open until the friction between the parts is reduced. It helps to polish the bore of the carrier on a new bolt to reduce friction and mate the parts.

THANKS FOR YOUR BUSINESS!

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