



## M-LOK SERIES HAND GUARDS

Thank you for purchasing this **M-LOK Series** hand guard. Prior to attempting the installation described below, make sure to read the entirety of these instructions thoroughly. The following steps assume that you know how to disassemble your particular upper assembly if you are replacing an existing hand guard. Since there are so many possible components and configurations, it is not feasible to relay comprehensive disassembly procedures for every circumstance. As with all our products, if you do not feel comfortable disassembling your upper or performing the steps laid out in these instructions, please contact JP or a qualified gunsmith to perform the installation.

### PARTS INCLUDED

- Hand Guard Tube
- Barrel Nut
- Barrel Retainer Nut
- Two (2) Clam Screws
- Clamp Shim
- Clamp Backer Plate

Use of Loctite® 271, 263 (or equivalent) is required for installation but not included.

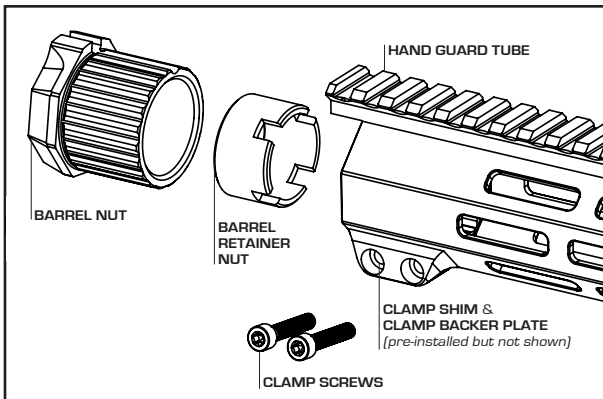
## INSTALLATION

Before beginning this installation, use a nylon brush and solvent to thoroughly clean the threads of all components of any obstructions, grit or particulate. Any such material could cause irreparable damage to the threads during assembly.

1. Lock your upper receiver in a set of JP Vise Clamps, suitable action block or other means while taking care not to crush the receiver. If you use a bench vise without an aid, grip as close to the front pivot lug as possible.
2. Remove the following from the upper receiver: sights or scopes mounted to the upper receiver, compensator/muzzle treatment (if fitted), existing hand guard tube, gas block/front sight post and gas tube, existing hand guard barrel nut.
3. Clean the threads on the receiver barrel collar with a brush and solvent. We also recommend removing any Teflon® coating on these threads with a steel brush to help the thread locker bond. Coat these threads with Loctite® Red 263 or 271 and then install the Barrel Nut by turning it down until it stops and then backing it off until the gas tube holes are in alignment.

Make sure to leave a slight gap between the back face of the Barrel Nut and the front of the receiver. While the cosmetic appeal of having the Barrel Nut flush against the receiver is obvious, do not (as we have seen on occasion) attempt to face the back of the nut in order to make it torque tightly against the receiver. This will cause some degradation in accuracy and point of impact during prolonged fire.

4. Insert the barrel, extension piece first, into the upper receiver while making sure that the barrel extension pin is on top and aligns with the corresponding notch in the upper receiver so that the barrel seats fully.



5. Apply anti-seize compound to the threads of the Barrel Retainer Nut and insert this into the Barrel Nut. Using the supplied tensioning tool, tighten the Barrel Retainer Nut down against the barrel's extension piece until it is hand tight. Make sure you retain gas tube hole alignment of the Barrel Nut.

Allow the Loctite® to set overnight before continuing.

6. Using a 1-3/8" wrench and the included tensioning tool, partially tighten and loosen the Barrel Retainer Nut three to four times to seat the barrel. On the last tightening, torque the Barrel Retainer Nut to 45-80 foot-pounds. You may wish to use a crow's foot wrench along with a torque wrench for this step.
7. Fully install your gas block, passing the gas tube through the hand guard into the receiver.
8. Install the hand guard tube by aligning the interrupted threads and sliding the tube all the way onto the Barrel Nut. Turn the tube to align the gas tube hole and top rail.
9. Tighten the Clamp Screws until the hand guard tube grips the nut but can still be turned.
10. Verify the alignment of the hand guard top rail with the receiver, and then tighten the Clamp Screws down securely.
11. Removing one Clamp Screw at a time, apply Loctite® Red 263 or 271 and tighten to 30-25 lbs. If the Clamp Shim on the bottom is not positively captured by the flanges at this torque, continue to tension the screws until it is.
12. Reassemble the upper assembly and allow thread locker to set before use.

**THANKS FOR YOUR BUSINESS!**