

## **JP Optional Front Sight Mounting Block** **JPSB-1, JPSB-2, JPSB-3**

### **Parts Included:**

- Sight block
- Three (3) 10-32 x 1/4" stainless set screws



### **Installation instructions**

**CAUTION: REMOVE MAGAZINE AND VISUALLY CHECK CHAMBER TO MAKE SURE THAT FIREARM IS UNLOADED.**

This sight block is designed for installation on the end of the barrel to accomplish maximum sight radius with our detachable globe front sight and anti-cant detachable level, as shown above. It is available in three size versions, .732 for standard contour barrels, .925 for the typical bull barrels and .875 for the JP Supermatch 1x9 barrels. The standard unit will fit most original equipment barrels which are about .730 after the gas manifold. If your barrel is larger than .730, the block should be bored to fit. The bull barrel version will fit the most commonly used dimension for those barrels which is .920 at the muzzle and can be bored out to a full inch if so desired.

Remove the upper assembly from the lower and secure in a vice so as not to damage it. Remove the existing flash suppressor or muzzle brake if present. Position the front sight block where you want it and secure with one of the 10/32 set screws. Make sure that the block is level to the receiver. If you have a flat-top upper receiver, a small carpenters level applied to the top of the receiver and then the sight block will give accurate positioning. (It doesn't matter if the assembly is perfectly level in the vice, just get the same reading off the top of both parts.) If you have a good eye, you can probably come close enough.

Note: you may want to position the block just behind the flash suppressor, abutted to it or you may want to eliminate the suppressor and position the block flush to the muzzle. In this case, we make a thread protector which can be attached to the 1/2X28 threaded portion of the barrel to give a finished look when used with the block. (Thread protector available from us direct for \$10.00 plus \$2.00 shipping to the U.S.) If you have a non-threaded barrel which has a step in it with a smaller diameter for some portion at the muzzle end (about .700 O.D.) such as the post ban Colts or Bushmasters, I would recommend wrapping a shim around the end of the barrel where the set screw engagement will be so the block stays parallel to the bore with the set screws installed.

Now with the block positioned and temporarily secured with one screw, use a drill press to create a detente for the other set screw using the block as a guide. Then install the other screw, remove the first screw and drill the detente for it taking care not to lose the position of the block. Now permanently install the block using Loctite 609 (the green stuff) which is specifically formulated for bearing seal usage and you will never experience any slippage. degrease the end of the barrel and the inside of the block to insure a good bond.

If you really do not want to drill the set screw detentes for cosmetic reasons, the Loctite 609 is probably adequate by itself to secure the block while using the set screws for initial tension only. We also stock .5ml capsules of 609.

**THANKS FOR YOUR BUSINESS!**

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