

Installing Free Float Handguards with a Standard Front Sight Base

To install the free float handguard with a standard front sight base, you'll need to remove the front sight base and barrel nut that came with the standard barrel.

The tools you'll need are: a number 2 roll pin holder and punch, the taper pin starter, the front sight bench block, a 4oz. ball peen hammer, a barrel tool, a torque wrench and a strap wrench.

1. Place your barrel into the front sight block with the words PINS OUT.
2. Use 3/32" taper punch to drive out the pins from the left side to the right.



3. Slide the front sight base off the barrel and remove the handguard cap.



4. Remove the barrel nut.



5. Place your assembled receiver into the vise blocks and install the insert. Lock this into your vise with firm pressure.

6. Next slide your barrel into the front of the receiver. Make sure you align the pin on top of the barrel with the cut in the threads.

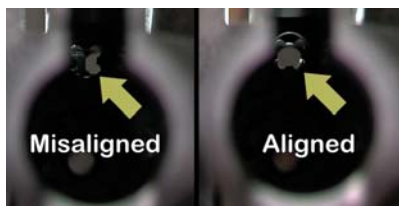


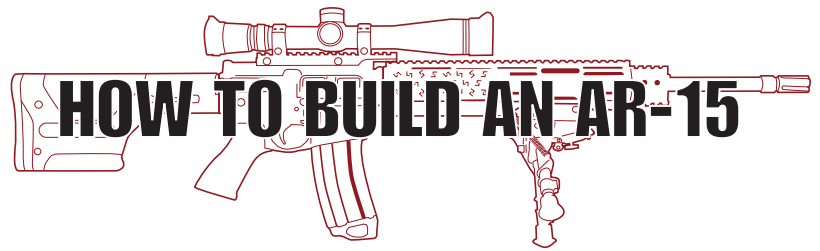
7. Slide the free float barrel nut down the barrel with the outside threaded portion facing forward, and then tighten the barrel nut down finger tight.



8. Set your torque wrench to 30 foot pounds and attach it to the barrel wrench. Tighten the barrel nut down to 30 lbs. 30 foot pounds of torque is the minimum amount needed to secure the barrel. We've found that you'll achieve better accuracy by keeping the torque as close to 30 ft. lbs. as possible. Follow the directions that were provided with your free float handguards for a minimum and maximum torque specifications.

9. Look down the top of the barrel through the holes of the barrel nut and into the receiver. One of the holes in the barrel nut must align with the gas tube hole on the front of the receiver. Typically this doesn't happen with your first turn.





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10. Note the distance that you'll have to turn the nut to align with the next hole on the barrel nut and increase the torque setting on your wrench to 40 lbs.

11. Tighten the barrel nut until you have correct alignment to allow the gas tube to pass through without interference.

12. Slide the handguard down the barrel and hand tighten it onto the threads of the barrel nut. A good option to help secure your threads is blue Loctite.



13. Use your strap wrench to cinch down the handguard, but don't apply too much force, you don't want the barrel nut to turn down any further and cause the holes in the barrel nut to misalign with the receiver.

14. If your handguards have picatinny rails like this one, then you'll want to level them now. For this rifle we'll take a level reading off of the top of the handguard then adjust the handguard so they're level.

15. Now insert the end of your gas tube with the two holes into the front sight block with larger hole facing down toward the gas port on the barrel.

16. Use your number 2 roll pin punch to help locate the through hole in the gas tube with the hole in the gas block.

17. Once you have these two holes aligned, use your number 2 roll pin holder to drive in the gas tube roll pin. Finish driving the roll pin with the punch so that it is flush.

18. Now slide the sight base and tube onto your barrel and slip the gas tube through the barrel nut into the receiver.



19. Place the barrel and front sight base into the front sight bench block with the words PINS IN facing up. It might not fit into front sight block with your handguard installed but the front sight block will still be helpful.



20. Align the bottom taper pin holes of the front sight base with the cuts in the barrel.

21. The narrow end of the taper pins go in first, place both of them into their holes and use the taper pin starter to drive them in. They should stick out on both sides of the front sight base when properly installed. They will, however, typically protrude further on the right hand side of the rifle so they don't need to be even on both sides.

