



FOREARM UPGRADE KIT INSTALLATION PROCEDURES

TOOLS REQUIRED

1/2" Torque Wrench
1/2" Drive 10" Extension
1/2" Drive 2" Extension
Forearm Coupler Tool
Loctite 243
Vice

PART DESCRIPTION

Receiver



Forearm



Coupler



Forearm Coupler Tool



Forearm Pin



INSTALLATION

1. Place a clean cloth between the jaws of the vise to protect the finish of parts. (Fig. 1)
2. Place Receiver in vise with the rails on top and the front face protruding outward for access to threads inside the Receiver. The Receiver should sit with the jaws of the vise centered on the barrel retention screws. (Fig. 1)
3. Tighten the vise with the Receiver inside, do not over-tighten the vise with the Receiver inside. DO NOT over-tighten the vise and damage the Receiver. The vise needs to be tight enough that the Receiver will not rotate while applying torque to the Forearm Coupler. (Fig. 1)
4. Place Forearm Pin into hole on the front face of the Receiver. (Fig. 2a, 2b)
5. Align the Forearm Coupler with threads on front of Receiver with the notched end out.
6. Begin Screwing the Forearm Coupler into Receiver. The Forearm Coupler is left-hand (reverse) threaded; it turns counter-clockwise to screw inwards. (HTI is right-handed threads/ clockwise, adjust accordingly.)
7. The center of the Forearm Coupler has a space without threads. Stop screwing the Forearm Coupler in when the unthreaded position is about centered to the outside edge of the Forearm Pin. (Fig. 3)
8. Apply a drop about the size of 3 grains of rice of Loctite 243 (Blue) to the top of the coupler on the forearm side about four threads from the center. (Fig. 4)
9. Thread the Forearm onto the notched end of the Forearm Coupler until the rear face of the Forearm nearly touches the Forearm Pin. (Fig. 5)
10. Use the top rail as an alignment reference to ensure proper alignment of the Forearm to the Receiver and the installed Forearm Pin.



Figure 1



Figure 2a

Figure 2b

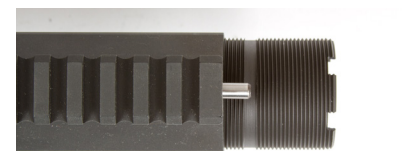


Figure 3



Figure 4



Figure 5

11. Set the 1/2 Torque Wrench to 50 ft/lb.
12. Insert the Forearm Coupler Tool down the center of the Forearm with a 1/2" Torque Wrench and a 1/2" socket extension(s). (Fig. 6)
13. Engage the notches of the Forearm Coupler with the Forearm Coupler Tool.
14. Begin tightening the Forearm Coupler by turning the Torque Wrench counter-clockwise. (HTI is right-handed threads/clockwise, adjust accordingly.)
15. Use one hand to hold the Forearm aligned to its pin hole until the Forearm Pin engages both the Forearm, and the Receiver. (Fig. 7)
16. Once the Forearm and Receiver have made contact, maintain inward pressure and finish tightening by torquing to 50 ft/lb.
17. Ensure proper alignment and remove tools. (Fig. 8)



Figure 6



Figure 7



Figure 8

REMOVAL

1. Place a clean cloth between the jaws of the vise to protect the finish of parts.
2. Place Receiver in vise with the rails on top and the front face protruding outward for access to threads inside the Receiver. The Receiver should sit with the jaws of the vise centered on the barrel retention screws. (Fig. 1)
3. Tighten the vise with the Receiver inside, do not over-tighten the vise with the Receiver inside. DO NOT over-tighten the vise and damage the Receiver. It needs to be tight enough that the Receiver will not rotate while applying torque to the Forearm Coupler.
4. Insert the Forearm Coupler Tool down the center of the Forearm with a 1/2" Torque Wrench and a 1/2" socket extension(s). (Fig 6.)
5. Engage the notches of the Forearm Coupler with the Forearm Coupler Tool.
6. With steady pressure against Forearm Coupler, begin to loosen the Forearm Coupler by turning the Torque Wrench clockwise. (HTI is right-handed threads/ counter-clockwise, adjust accordingly.) This should require no more than 100 ft/lb of torque to break loose. (Reverse/Clockwise of Fig. 7)
7. Once Forearm has been extended past the Forearm Pin, remove the 1/2" Torque Wrench and finish removal by hand. (Fig. 5)