

ACCURACY SPEAKS, INC.

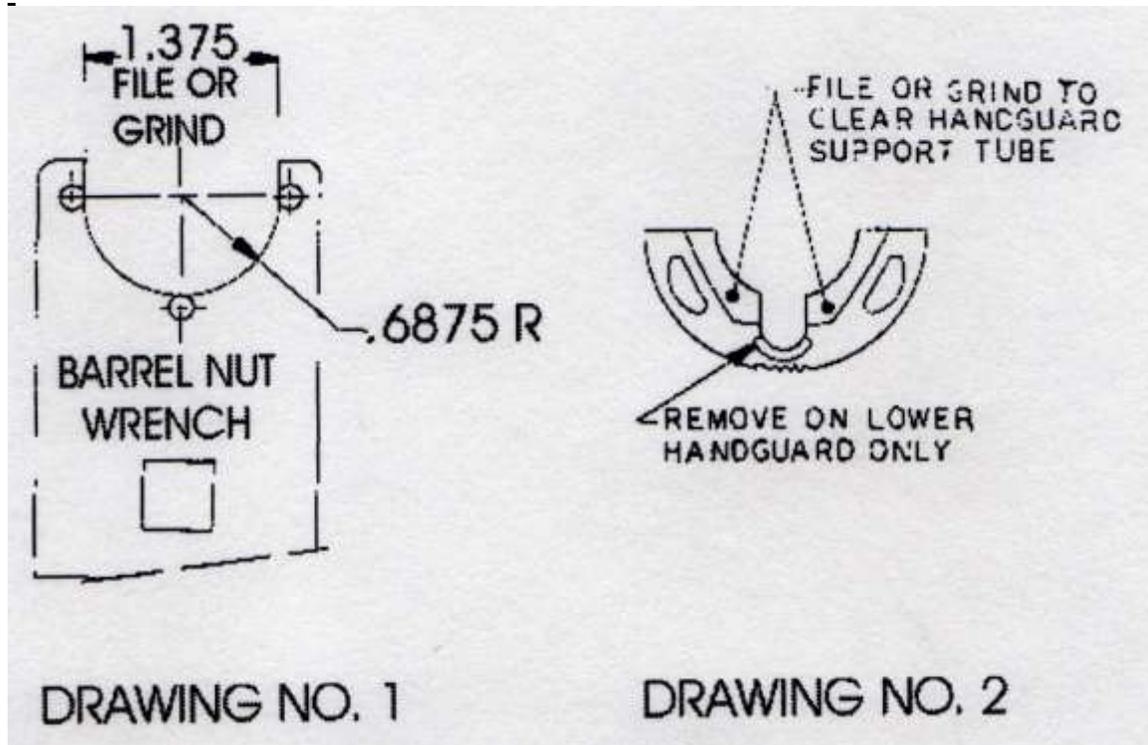
3960 N. USERY PASS RD. • MESA, AZ 85207 • (480)373-9499

SERVICE RIFLE TUBES

This kit contains a new barrel nut and handguard support tube for AR-15 style rifles. To install this kit, you will need some special tools, which can be purchased through Brownell, Inc., 200 S. Front Street, Montezuma, Iowa 50171, (515) 623-5401. You will need either a set of AR-15 Barrel Vise Jaws, or the Peace River Arms Action Block (2219 Olney Road, Lakeland, Florida 33801). It is very handy, as you do not have to remove the rifle during installation. You will also need an AR-15 barrel wrench, modified to match drawing #1.

1. Remove upper receiver, bolt carrier, charging handle, hand guards and flash suppressor.
2. Drive out front sight pins (they are tapered, so drive them the correct direction).
3. Remove front sight base.
4. Remove barrel nut.
5. Transfer delta ring, spring and clip to new barrel nut.
6. Degrease barrel extension, upper receiver barrel support and barrel nut.
7. Put a small amount of Loctite on barrel extension and install in upper receiver.
8. Install barrel nut with a small amount of Loctite (do not use hi-strength loctite). You will need 35 ft/lbs. minimum torque. If you cannot line up the barrel nut without overtightening, mark the obstruction tooth and file or grind it off. This will not effect the finished job at all.
9. Test fit the handguard support tube in the barrel nut. You will need to have $.025\checkmark$ minimum clearance (2 business cards) between the handguard support and the front sight. Each revolution of the tube is $.025\checkmark$. Remember, a little extra clearance is better than not enough. Be sure to use the front sight pins in the front sight, so it will be in its true location.
10. Reassemble and Loctite the handguard support tube in place an set aside to harden

11. Gently pry the heat shields out of the handguards. The handguard support tube will protect the handguards from barrel heat.
12. Use a rat tail file or Moto-Tool to modify the handguards to match drawing #2.
13. Remove the sling swivel from the front sight and install it on the handguard stud with enclosed pin. It may be necessary to file the swivel to fit the stud. Gently drive the pin through the swivel and stud.
14. Reassemble the front sight on the barrel. It may be necessary to bend the gas tube slightly to achieve light contact with the handguard support tube.
15. Install handguards, reassemble your rifle, go shootin



Statement of General Policy
Concerning Warranty or Guarantee

Accuracy Speaks cares about your satisfaction. If you should have a problem with any of our products, please feel free to write us. Please do not call, but give us your phone number.

DISCLAIMERS:

Accuracy Speaks expressly disclaims liability for incidental or consequential damages; and liability for implied warranty, should there be any, is expressly limited to one year. Notice of any claims against Accuracy Speaks shall be made within one year, and all claims shall be waived if not brought within this one year private statute of limitations.

NO WRITTEN WARRANTY: Due to the complexities of complying with the Federal warrant law, Accuracy Speaks does not offer a written warranty. We stand behind our products and care for our customers, but we cannot make guarantees or warranties of any kind.

