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BUILDERS KIT ASSEMBLY INSTRUCTIONS

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9MM, 5.56

How to assemble your upper in 6 easy steps!



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Step One:

Use a quality upper receiver fixture to assemble your upper. We prefer ones that lock into the take down, and pivot pin holes. Clam Shell style fixtures may not work properly.



Mount Upper receiver in the fixture, insert locking pins. Apply anti-seize compound to the external thread on The Upper receiver (shown below).





Step Two:

Slide Barrel into the upper receiver,
Note alignment pin is seated in the upper receiver as shown.
Install barrel nut, tighten it till its snug (hand tight).



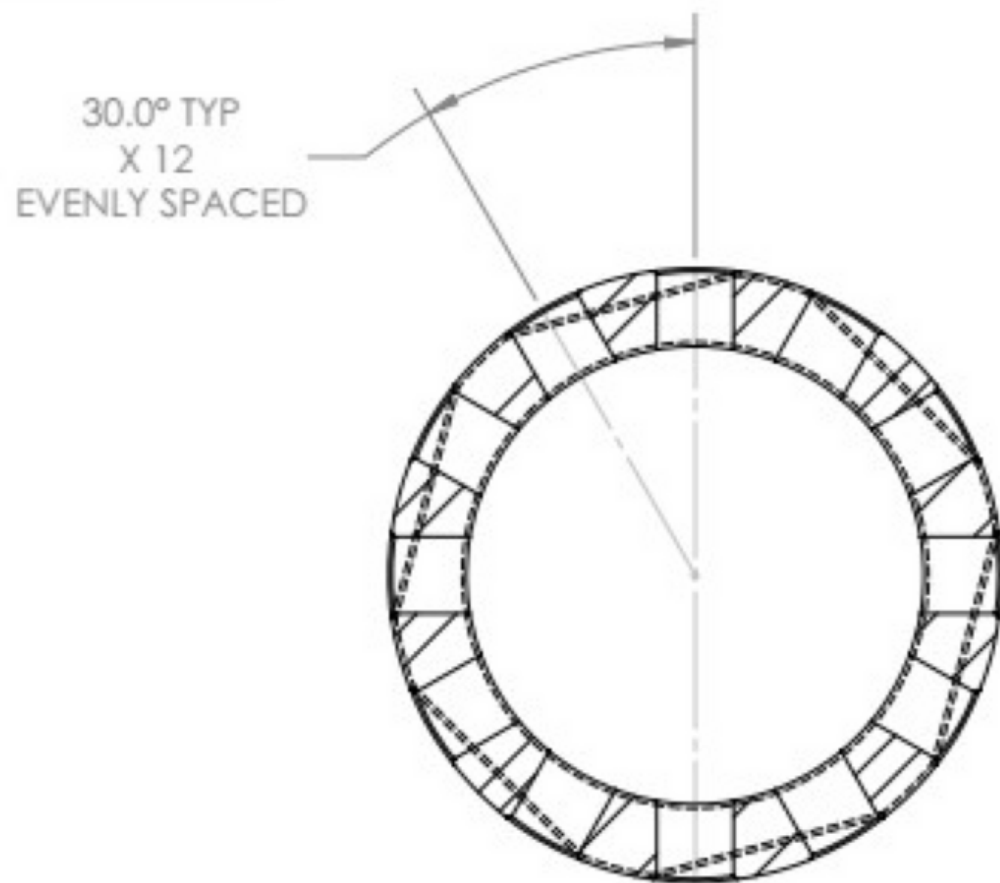
Step Three:

Slide hand-guard onto Barrel Nut, note how much you need to rotate the barrel nut, so holes for screws in the hand-guard, line up with the threaded holes in the barrel nut.





NOTE: Threaded holes in the barrel nut, are spaced 30 degrees apart. The barrel nut will need to rotate clockwise about 25 degrees clockwise. (see picture shown below)



Step Four (setting torque):

We recommend 30-45 Pounds of torque, our proprietary design, has a keyed locking feature, which guarantees the barrel nut will never come loose, once the hand-guard is installed.

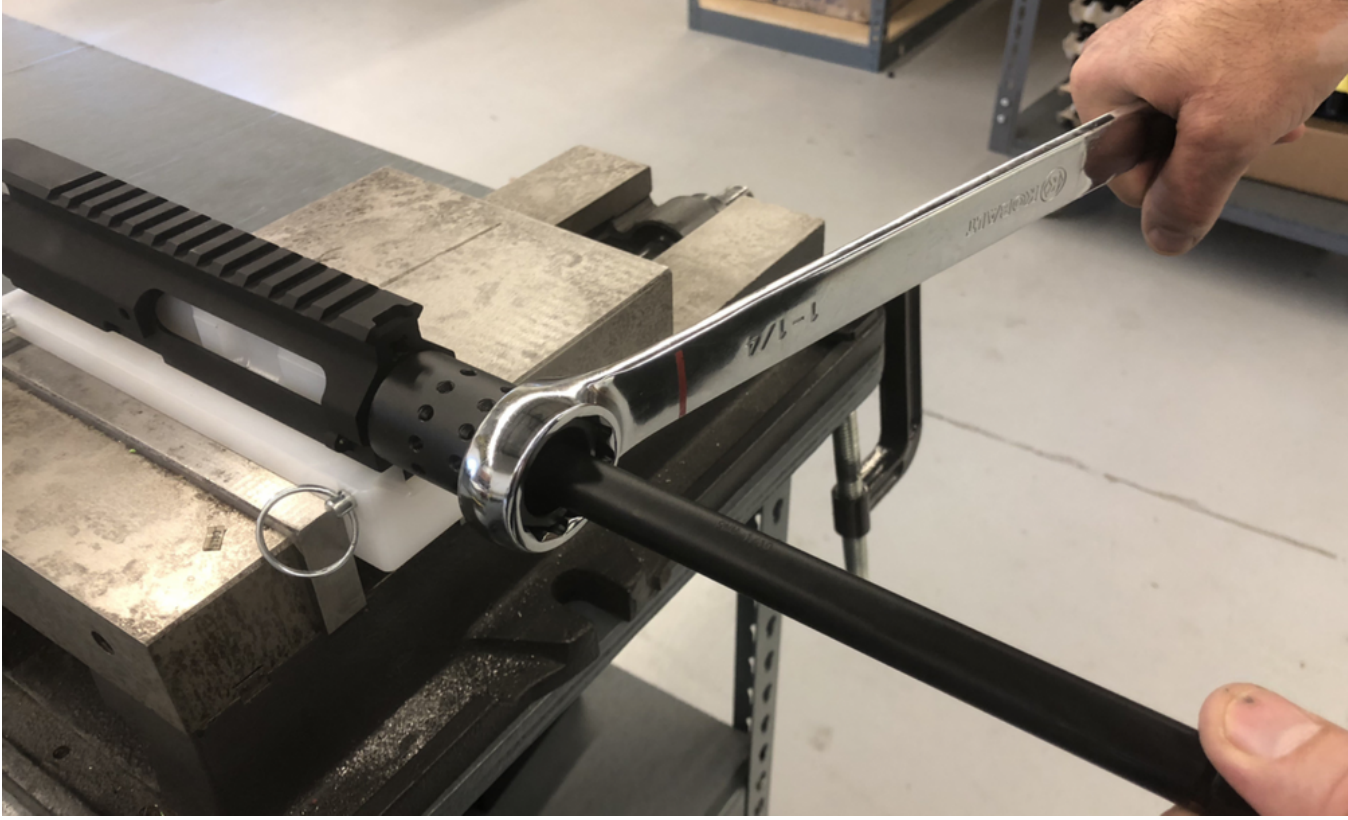
If you are using a torque wrench, be sure torque wrench is originated 90 degrees from 1 1/8" wrench attachment. This avoids torque multiplication.





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NOTE: It is acceptable to use a 1 1/8" box wrench to install the barrel nut, due to this proprietary feature. Tightening it to the next threaded hole, generally gets the barrel nut to the desired torque range.



If you need more or less torque, we include shims for users to adjust the torque as required (see picture below).



There are (2) thicknesses of shims included, try one shim at a time until you get the correct torque settings.



To install the shims, place them in the barrel nut as shown below. Try one at a time, until you get the required torque.



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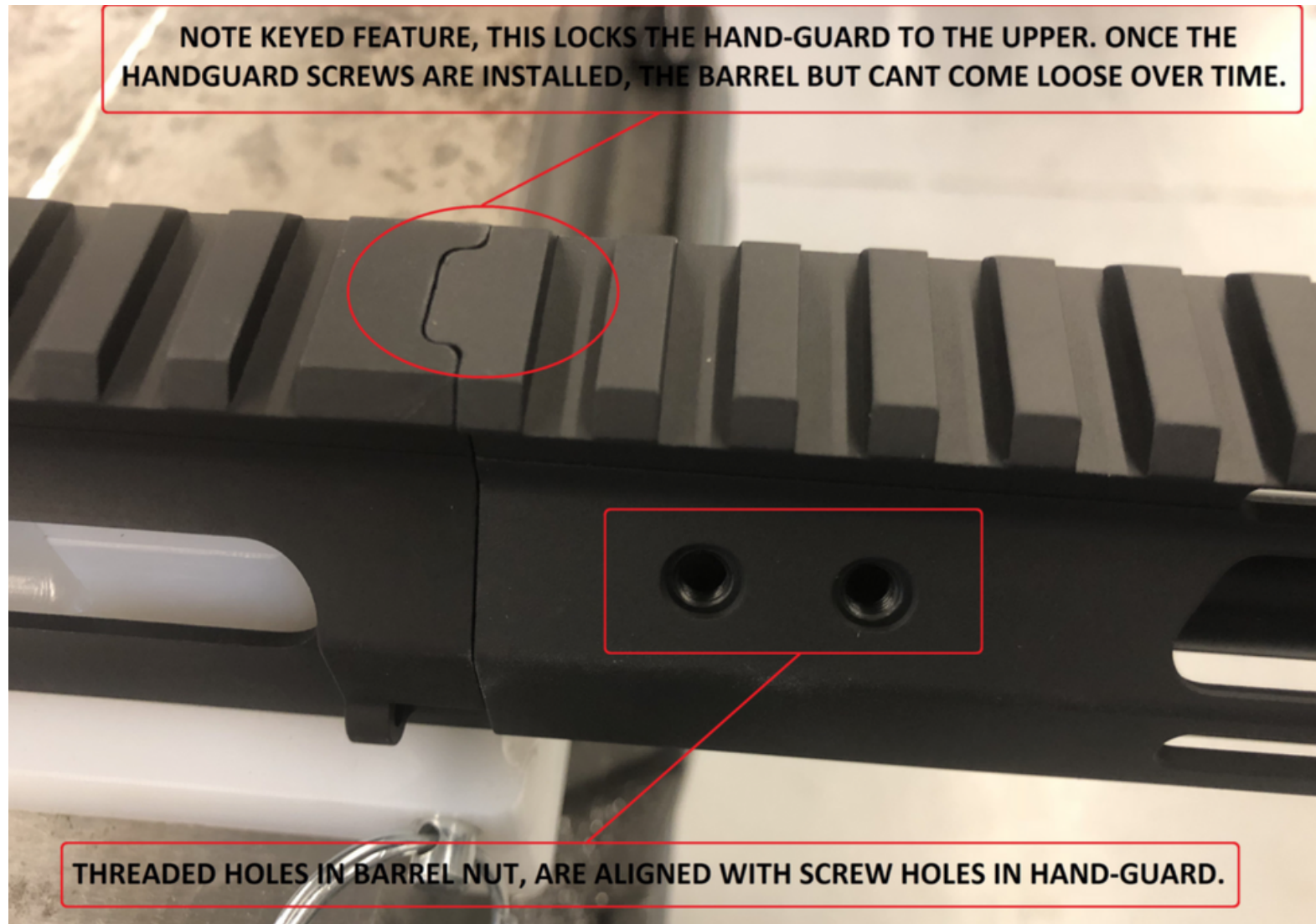


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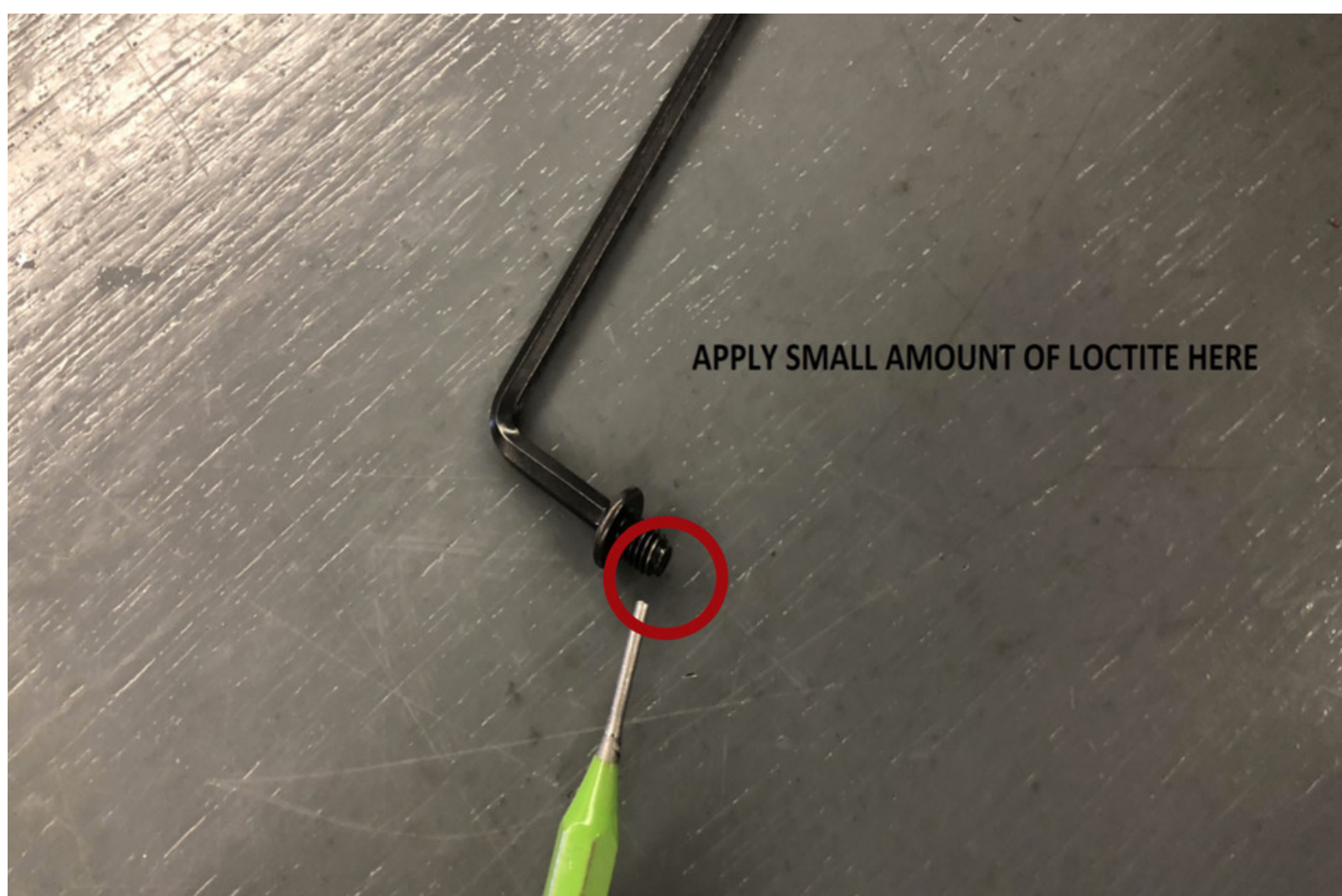


Step Five (installing handguard):

Once the threaded holes align with the hand-guard, And proper torque is achieved, its time to install the hand-guard.



NOTE: Apply Loctite to the 10-32 Button Head screws.



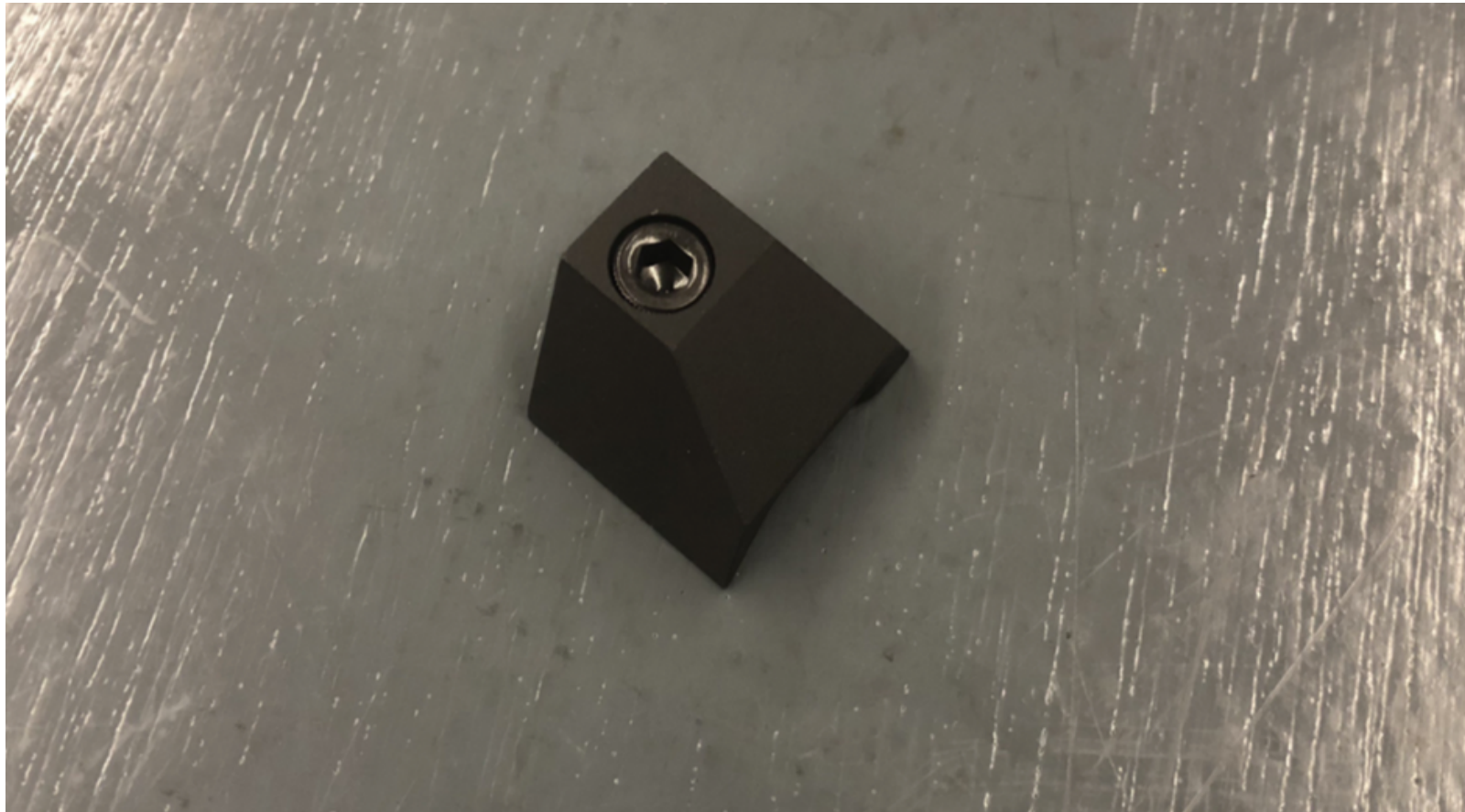
Install the (8) Button Head Screws, being careful not to cross thread the screws. Only tighten them snug, until all 8 screws are installed. Go back around and tighten each of the (8) Button Head Screws.





Step Six (installing dust cover):

Find the Case Deflector and 10-32 Socket Head Cap Screw
And install screw into the Case Deflector as shown below.



Next: Take the Dust Cover, Dust Cover Pin and Dust Cover Spring, and assemble as shown below.



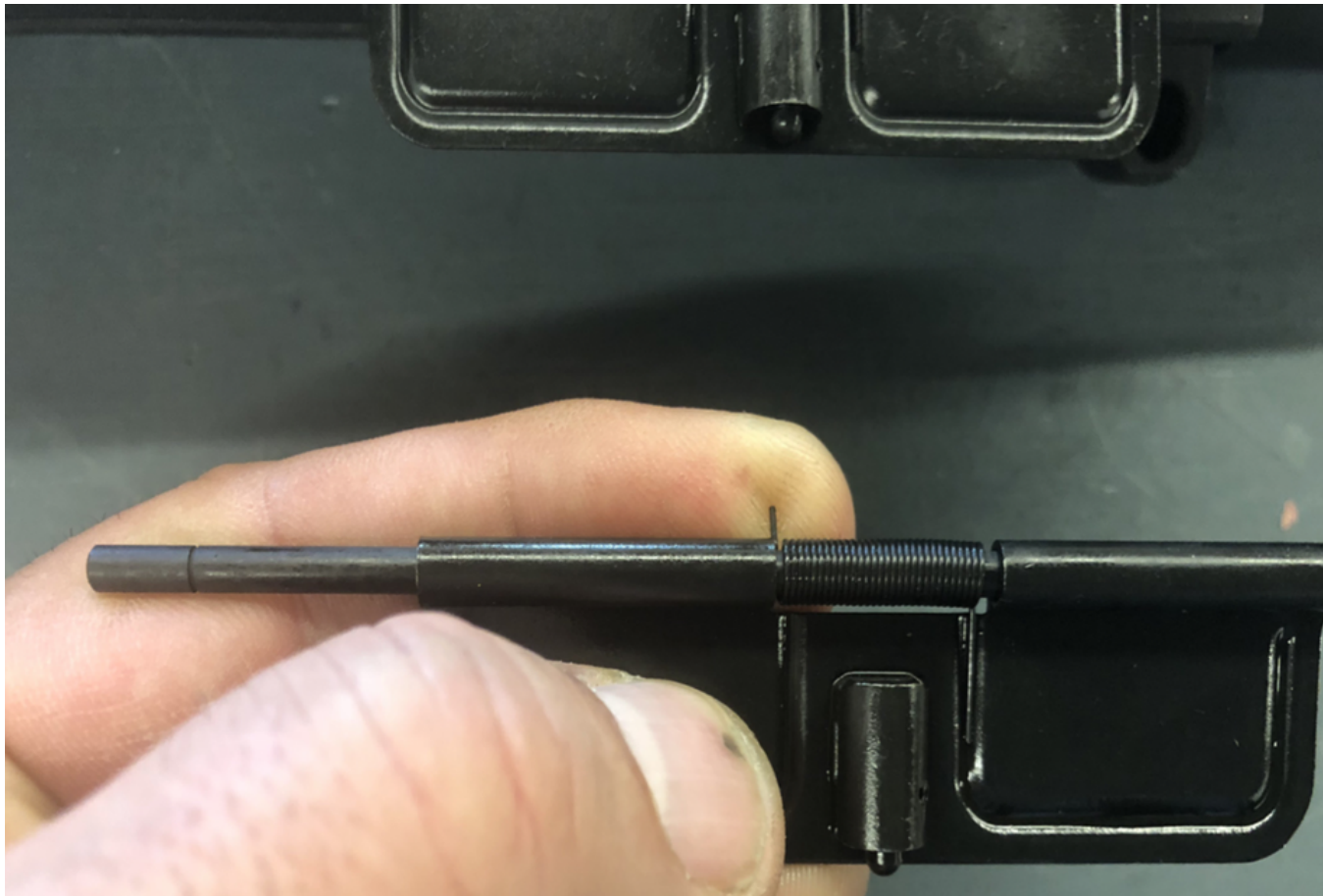
The long leg of the spring is towards the front of the upper.
Now take the long leg of the spring and rotate it, and rest it
against the dust cover (see picture on next page).





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NOTE: hold tension on the short leg of the spring as shown below.



Next: Slide the Dust Cover Pin, into the Case Deflector as shown below.



Next: Slide the pin into the hole in the Upper Receiver as shown below. Maintain pressure on the small leg of the Dust Cover Spring, it will rest against the upper receiver, keeping pressure on the Dust Cover Spring.



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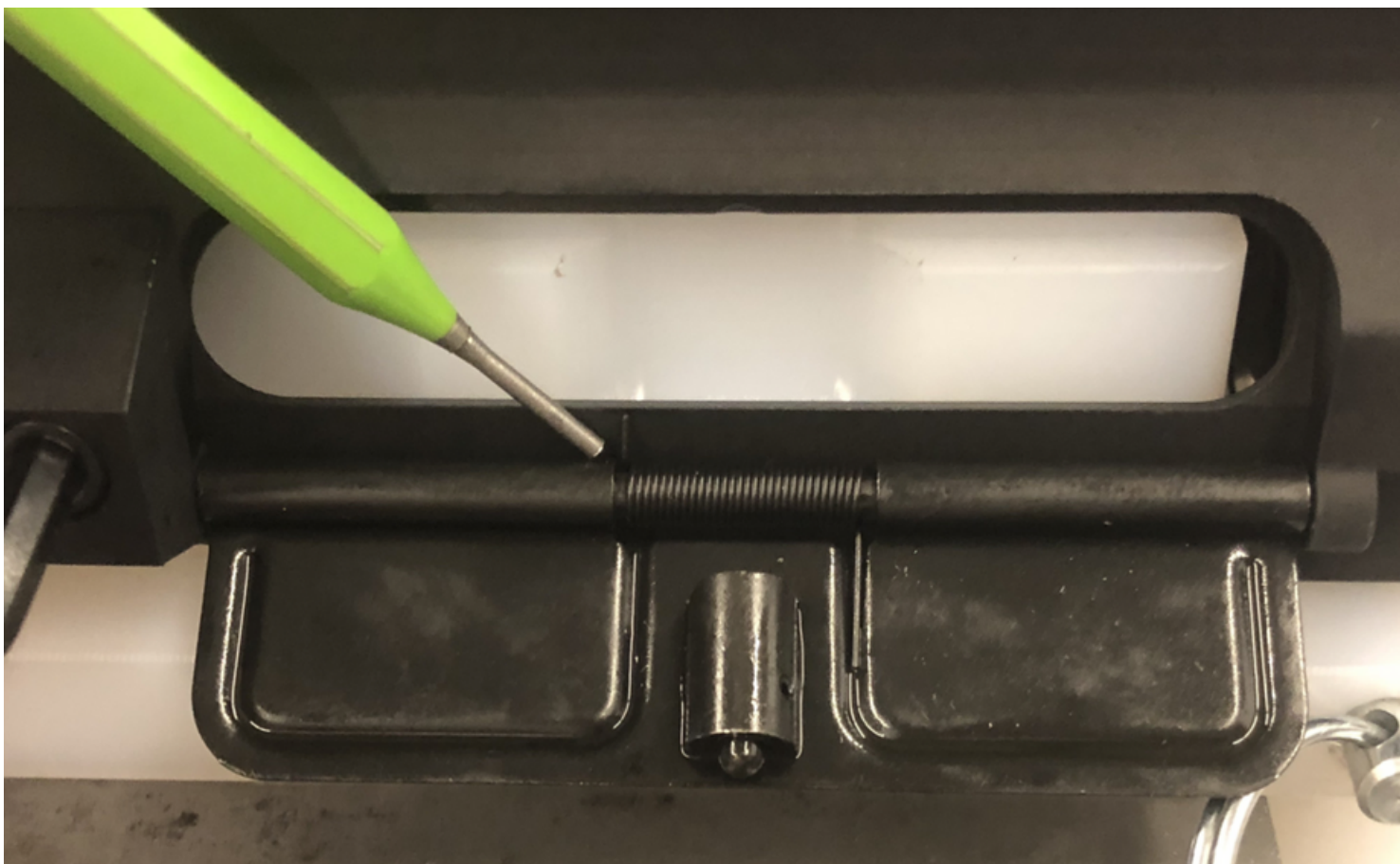


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Once the Dust Cover is in place, its time to tighten the Socket Head Cap Screw. This will lock everything in place. Make sure the screw is good and tight.



This is how it should look when you are done.
Note orientation of Dust Cover Spring as shown below.



Next: YOU ARE DONE! Go grab a cold one from the fridge!



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Notes:

Hope this instruction manual was useful guide that helped you with assembling of our product.

Here at FM Products we strive to deliver the best value to our customers all the time.

If you have any suggestions or concerns please contact us by filling out the form at:
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