

Always check to make sure any weapon you are working on is unloaded

The 308 QRB Kit can only be used on Barrels with a maximum outside diameter of 1.200" and Free Float Hand Guards with a maximum width of 2.2"

Tools that may be needed for the install: a barrel nut wrench, a set of Allen Keys, a small scaled ruler (or calipers) and an Upper Vise or equivalent. A bottle of Loctite 242 or equivalent is highly recommended.

NOTE: Make sure your barrel goes smoothly into the upper receiver before starting install. If there is resistance or tightness, address these issues before beginning. The barrel must easily slide in/out for a successful install.

1. Starting with a bare Upper Receiver, place a few drops of oil on the threads and start threading on the Receiver Plate; grove on the front side of the Receiver Plate away from the upper receiver. Next completely tighten down till flush on receiver, then loosen till the Gas Tube Extension hole lines up with the gas tube hole in the receiver.
2. Install the Gas Tube Extension into the Receiver Plate with the large flat area facing the threads of the extension. Apply force till completely seated in the Receiver Plate and stopping against the upper receiver.
3. Apply Loctite 242 to the set screw on the top of the Receiver Plate and tighten till resistance is met, then apply to the nylon tipped set screw on the underside of the Receiver Plate and tighten till resistance is met. Let set per Loctite's instructions.

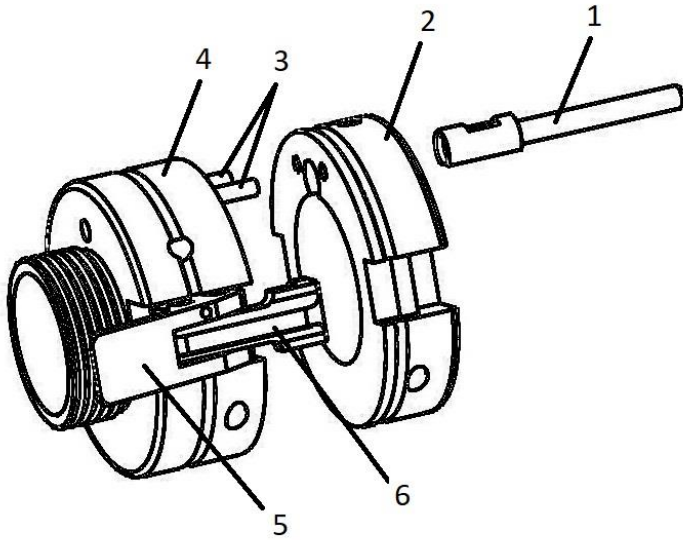
MAKE SURE THERE IS CLEARANCE BETWEEN DUSTCOVER ROD AND REAR OF RECEIVER PLATE

4. Install the barrel into the upper receiver and install the Barrel Plate over the muzzle end of the barrel. (Make sure the set screws in the plate are out enough not to impact the barrel while installing). Keeping the Hooks and Levers clear, slide the Barrel Plate down the barrel. Make sure to align the pins on the Barrel Plate with the holes in the Receiver Plate when seating.
5. Locate the adjustment screws on the back of the Hooks. Remove and apply Loctite 242 and re-install. Engage Hooks into the slots of the Receiver Plate. Place tension on BOTH Levers towards the barrel till resistance is felt, then while keeping under tension, adjust one screw until the tip of the Lever is 1.65" to 1.75" from the center of the barrel and repeat for the other side. A diagram of this adjustment is provided on the back of these instructions. Once this adjustment is done on both sides, the Levers can be set into their locked positions by pushing in towards the barrel. You should feel and hear them "snap" into the lock position as they move towards the barrel. Unlock/lock a few times and if possible, you should cycle the bolt a few times on an empty chamber and recheck the Lever adjustment. This cycling will help set all the parts into the proper alignment. Check the measurements again adjust if necessary. Let set per Loctite's instructions.
6. Once the Levers have been adjusted properly, tighten the 3 retaining screws. Remove and apply Loctite 242, then starting with the two screws at the top of the Barrel Plate, tighten till resistance is felt. Next tight lower screw to secure whole assembly. Adjust the screws if necessary to center the barrel in hand guard.
7. Install the supplied gas tube into your gas block. Assemble gas tube assembly and your Free Float Hand Guards by following the manufacturer's instructions on the barrel/Barrel Plate. Any tightening must be done with at least one Lever engaged or damage will occur. Never exceed 40 ft/lbs of force while tightening the Free Float Hand Guards on the Barrel Plate. If the Free Float Hand Guards are a little loose to achieve proper alignment (by not exceeding the maximum torque as an example), remove and use Loctite 271 on the threads and re-install. Because the hand guards are no longer holding barrel into place, securing with Loctite should be enough to keep everything secure. Let set per Loctite's instructions.

You are now ready to test fire your QRB equipped rifle.

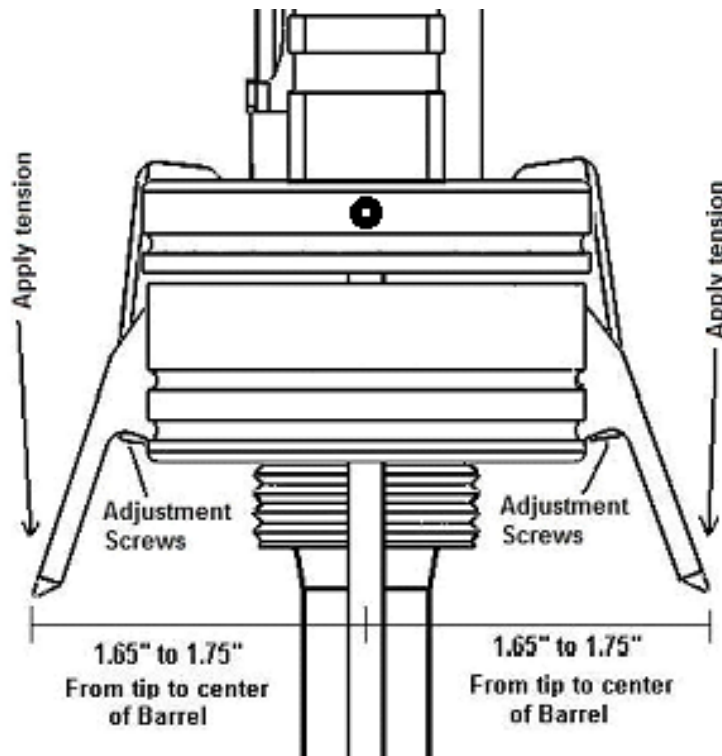
Both Levers must be locked when firing

General Parts Layout



1. Gas Tube Extension
2. Receiver Plate
3. Barrel Plate Alignment Pins
4. Barrel Plate
5. Lever
6. Hook

Top View of Tension Adjustment



FOLLOW THESE SPECIFICATIONS OR DAMAGE/INJURY WILL OCCUR

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