

FF RAS 5

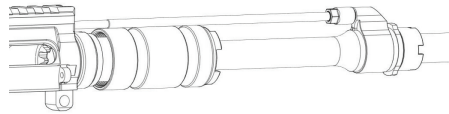
Barrel Nut Installation

NOTE: FF RAS 5 can only be installed on KAC Notched Upper Receivers

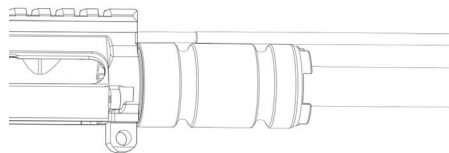
NOTE: Fixture upper receiver so that up to 100 ft/lbs of torque can be applied to the barrel nut without causing damage to any component.

Apply anti-seize grease to the threads of the upper receiver and barrel nut.

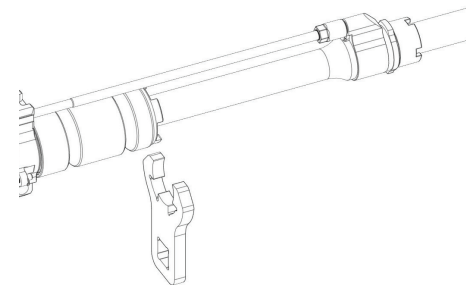
1. Slide barrel nut onto threaded portion of the upper receiver, with the deeply grooved end toward the upper receiver and the square cut-out end toward the muzzle.



2. Hand-tighten the barrel nut and check that all parts are in proper orientation. Check that the barrel extension is flush (minimal ledge) with the inside of the upper receiver.



3. Attach barrel nut wrench to torque wrench and torque to 55 ft/lbs, three (3) times, loosening and then reaching 55 ft/lbs each time. Take care to ensure that if the gas tube is installed, that it will not be pinched by the barrel nut wrench during loosening or tightening .



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Handguard Installation

NOTE: The threaded locking plate on the right side of the handguard may back away from its fully seated position during bolt removal. If this occurs, simply press the plate into the recess with hand pressure or remove until needed for re-installation.

Ensure that the handguard retainer bolts are removed from the handguard.

NOTE: TORQUE VALUES EXPRESSED IN IN/LBS FOR HANDGUARD INSTALLATION. USE OF FT/LBS WILL RESULT IN DAMAGE

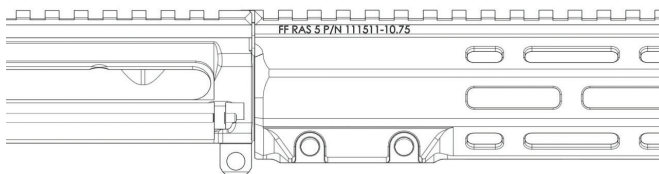
1. Apply a light coat of protectant to all exposed surfaces of the barrel components that will be encased by the handguard to protect against corrosion and fouling accumulation.

2. Lightly lubricate the threads of the handguard retainer bolts and the exterior of the barrel nut with a quality lubricant. Thread-locker is not required or recommended.

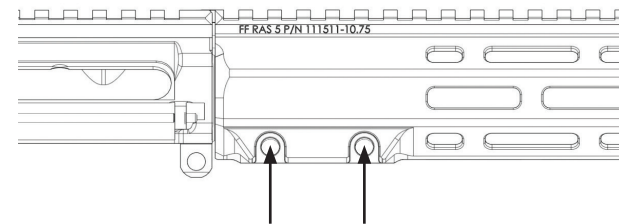
3. Slide the handguard onto the barrel nut.

- a. The anti-rotation tab on the top rail if the handguard will interface with the cutout on the top of the upper receiver to align the rails.

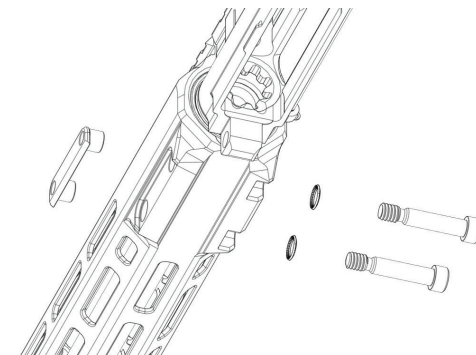
4. Leave approximately a 1/32" gap between the handguard and upper receiver.



5. Check through the handguard retainer bolt holes to ensure that they align with the grooves of the barrel nut.



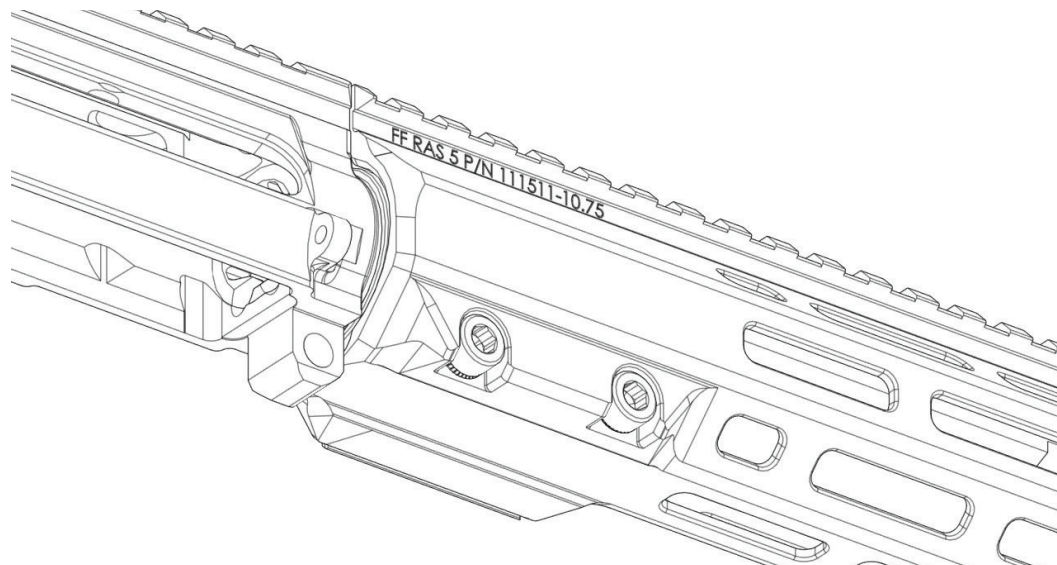
6. Insert handguard retainer bolts (with lock washers) and finger tighten.



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Handguard Installation Continued

7. Set torque wrench to 20 in/lbs.
8. Apply pulling force on the handguard away from the upper receiver, and twist clockwise (when viewed from the muzzle end). This will seat the retainer screws against the front of the barrel nut grooves, and the anti-rotation tab against the right side (as viewed from the muzzle) of the upper receiver anti-rotation/alignment groove. The upper receiver vice will aid in applying seating force to the handguard retainer bolts against the barrel nut.
9. While maintaining forward and twisting force on the handguard, torque bolts to 20 in/lbs, from rear (receiver) to front (muzzle).
10. Set torque wrench to 100 in/lbs, and gradually tighten, alternating from rear to front screws.
11. Fully torque to 100 in/lbs first the rear and then the front bolts, achieving 100 in/lbs on each bolt three (3) times, alternating from rear to front each time.





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