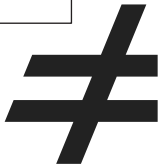


≠ 3BLACKOUT
DEFENSE

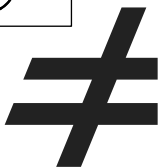
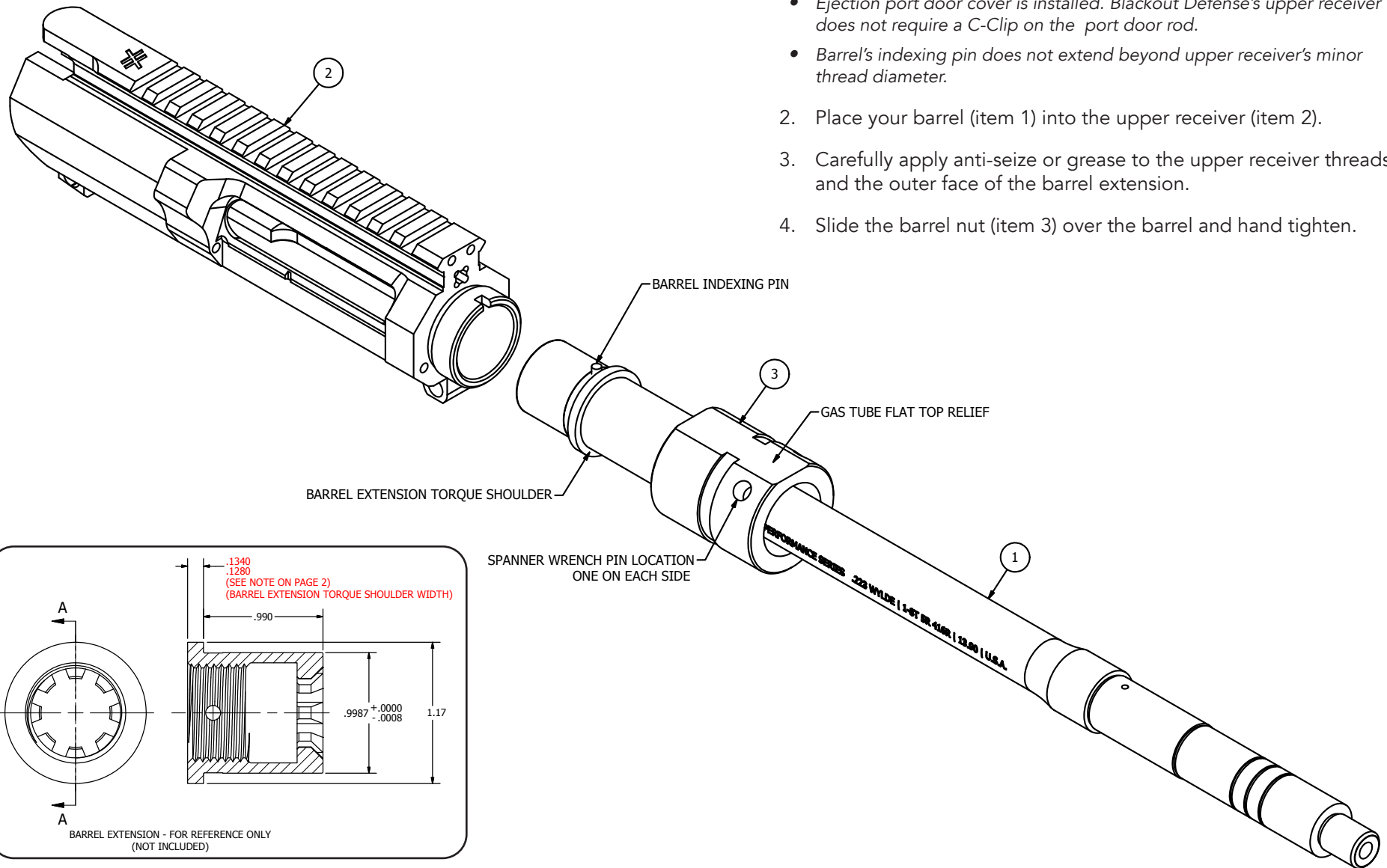
BARREL & HANDGUARD INSTALLATION

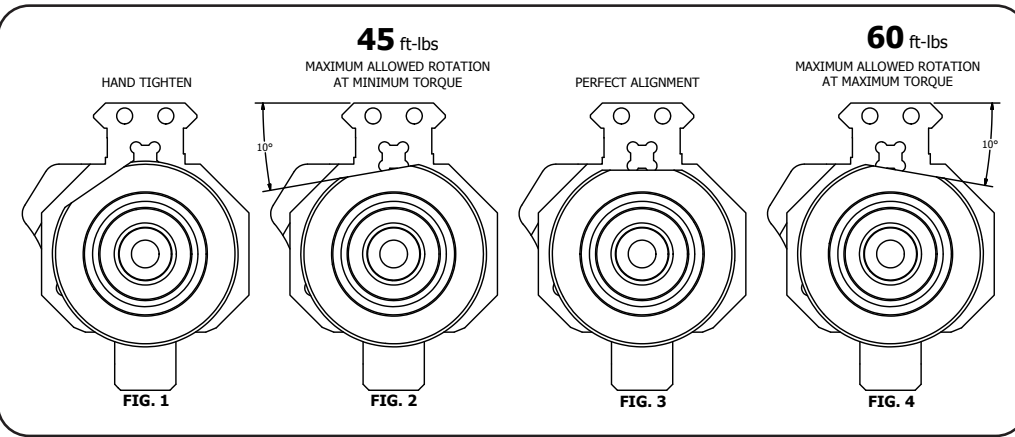
REVISION DATE: OCTOBER 4 2021



BARREL INSTALLATION

1. Before Installing your barrel please make sure:
 - Ejection port door cover is installed. Blackout Defense's upper receiver does not require a C-Clip on the port door rod.
 - Barrel's indexing pin does not extend beyond upper receiver's minor thread diameter.
2. Place your barrel (item 1) into the upper receiver (item 2).
3. Carefully apply anti-seize or grease to the upper receiver threads and the outer face of the barrel extension.
4. Slide the barrel nut (item 3) over the barrel and hand tighten.



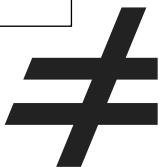
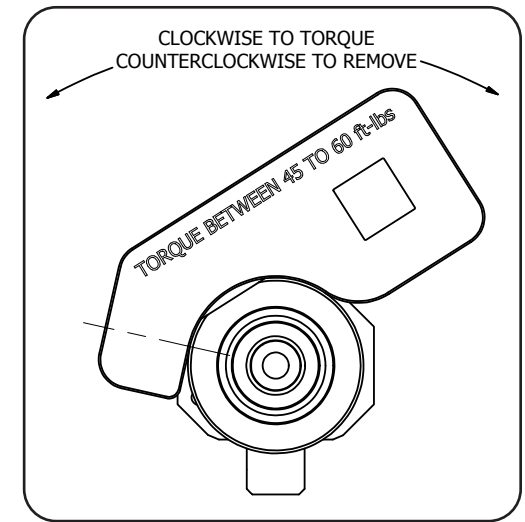
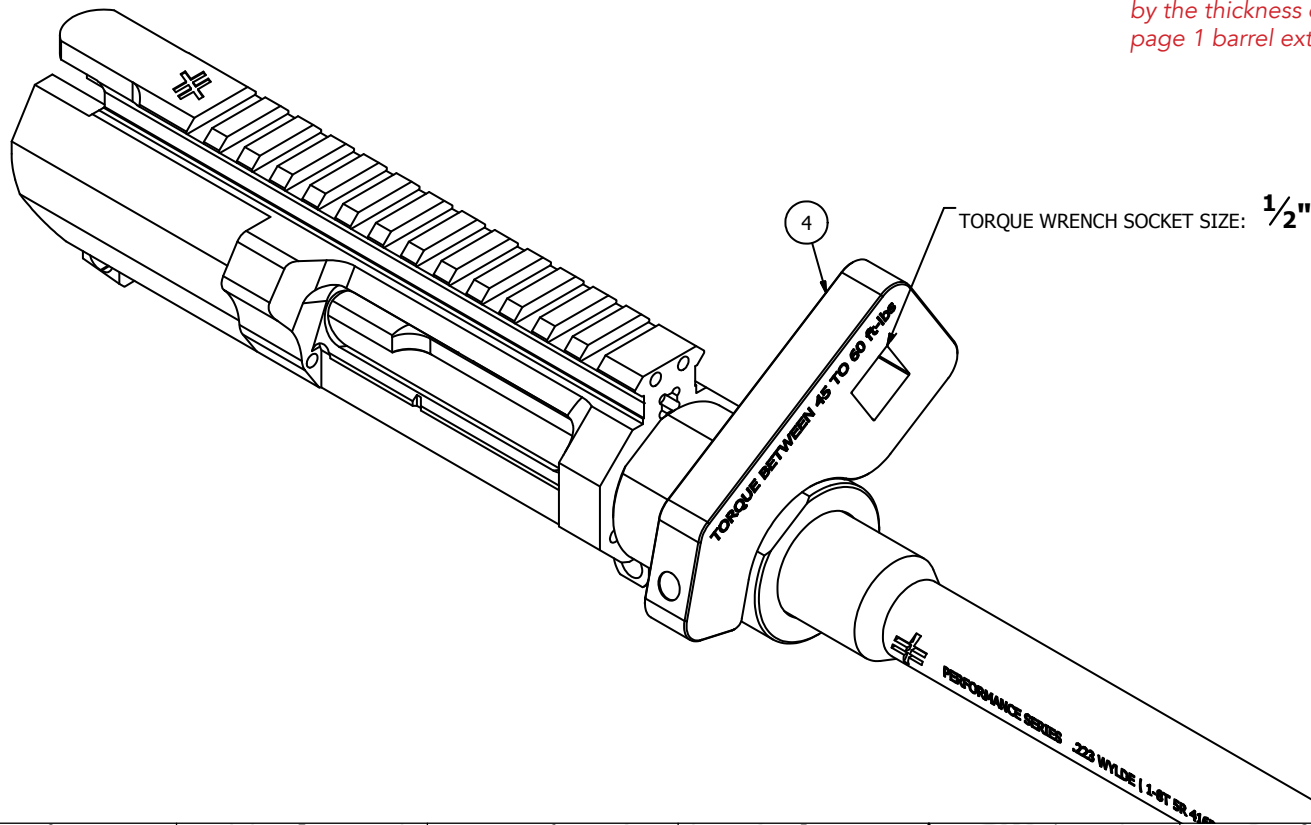


TORQUE BARREL NUT

Our barrel nut allows install on barrels and upper receivers within MilSpec standards. This allows a 10° shift in the barrel nut from perfect alignment.

1. Hand tighten your barrel nut (Figure 1)
2. Using the included spanner wrench torque barrel nut between 45 ft-lbs and 60 ft-lbs until perfect alignment is achieved.
3. Acceptable alignment for the gas tube is achieved when barrel nut alignment matches Figure 1, 2, or 3, AND is torqued between 45 and 60 ft-lbs.

- *Note: The position of the flat top relief for the gas tube is influenced by the thickness of the barrel extension torque shoulder width. See page 1 barrel extension schematic.*



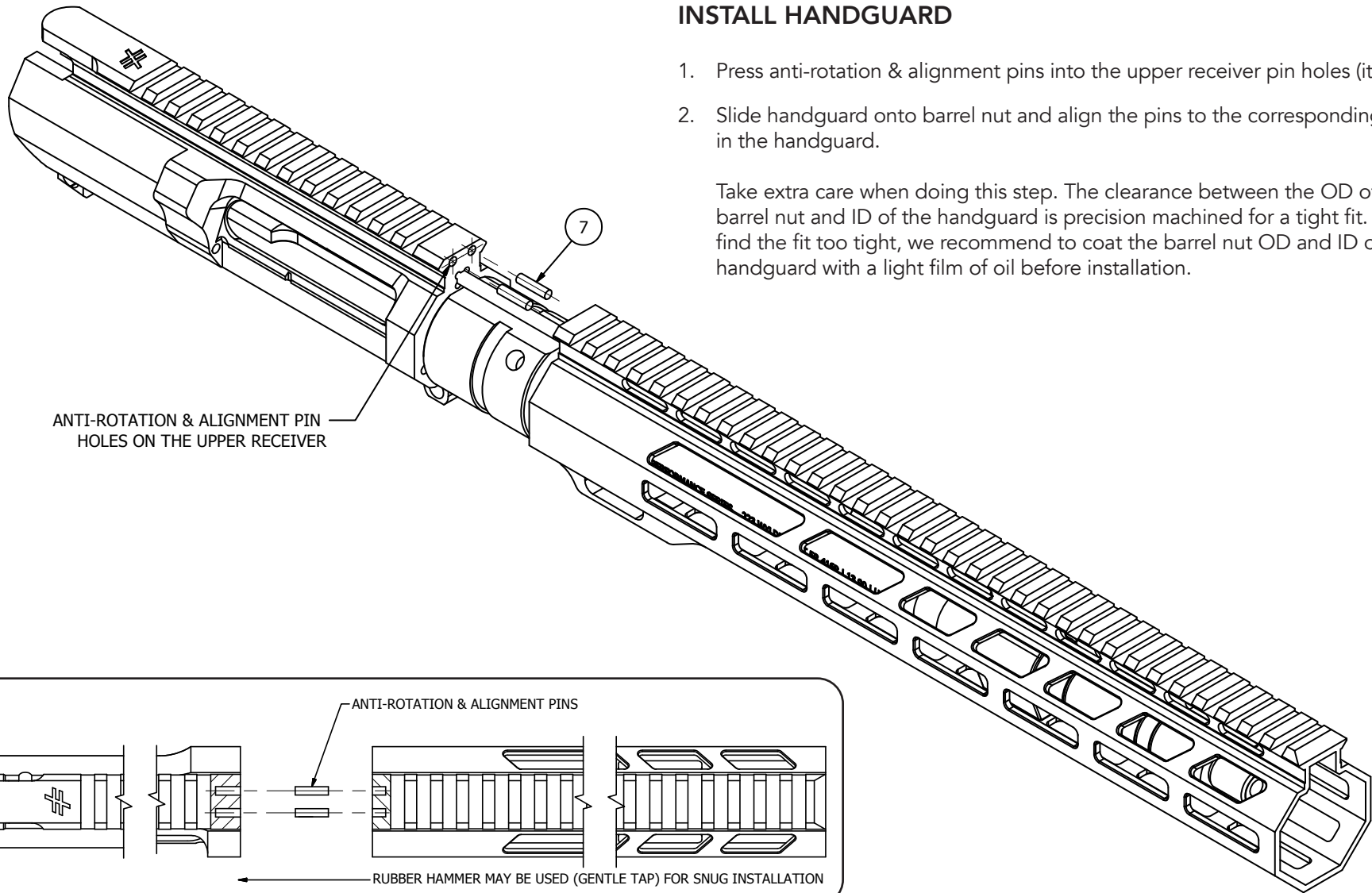
INSTALL GAS BLOCK PER MANUFACTURER'S INSTRUCTIONS

- Ensure gas tube does not contact barrel nut.

INSTALL HANDGUARD

1. Press anti-rotation & alignment pins into the upper receiver pin holes (item 7).
2. Slide handguard onto barrel nut and align the pins to the corresponding holes in the handguard.

Take extra care when doing this step. The clearance between the OD of the barrel nut and ID of the handguard is precision machined for a tight fit. If you find the fit too tight, we recommend to coat the barrel nut OD and ID of the handguard with a light film of oil before installation.



INSTALL HANDGUARD MOUNTING HARDWARE

1. Place barrel nut hardware (item 8 & 9) inside through cavity of handguard
2. Insert barrel nut screws (item 10) into barrel nut hardware (item 9).
3. We recommend adding blue Loctite® to both screws.
4. Use a 9/64 drive (not included) and torque both screws in a "left/right - left/right" pattern to 50 in-lbs.

