



Item	Description
1	Handguard (Micro/K, Pistol, or Carbine)
2	Trunnion Adapter Block
3	T25 M5x0.8 x 10 Flat Head Screw (65 in*lbs)
4	T25 M5x0.8 x 20 Cap Head Screw (80 in*lbs)
5	Handguard Pin
6	Charging Handle Cross Pin
7	Reduced Pressure Charging Handle Spring
8	T25 Torx Key, Short Arm

Handguard Installation

1. Unscrew and remove flash hider, brake, faux suppressor, or any other muzzle device from the barrel.
2. Remove factory barrel nut and factory handguard retaining collar. The Scorpion S1 Pistols will require a 20mm wrench to remove the factory barrel nut. Scorpion S1 Carbines will require a 21mm socket to remove the factory barrel nut. Specialty tools are available through HBI.
3. Separate the factory handguard from the upper receiver and remove the factory charging handle by sliding it out of the receiver end of the charging handle channel. Remove factory sling mounts.
4. Install HBI Trunnion Adapter Block (Item 2) onto CZ barrel trunnion. Staking marks made by CZ where the barrel shoulder meets the trunnion may need to be filed down in order to fit mounting block onto the trunnion. Dowel pins on HBI adapter block (Item 2) must face the upper receiver. When correctly installed, the pins will index mounting block to trunnion such that handguard and charging handle channels line up correctly with upper receiver.
5. Affix HBI Trunnion Adapter Block (Item 2) to CZ barrel trunnion using T25 cap head screw (Item 4). Use Loctite 243 blue or 271 red and torque to 80 in*lbs.
6. Attach HBI Handguard (Item 1) to HBI Trunnion Adapter Block (Item 2) using T25 flat head screws (Item 3). Gradually tighten all four screws alternating between left and right sides of handguard to achieve even clamping force and proper alignment of charging handle channels. Torque screws to 65 in*lbs. Use of Loctite 243 blue is optional on these screws.
7. Using a 1/16" or 1.5mm punch, remove the retaining spring from the factory charging handle by driving out the roll pin. Install the HBI Reduced Pressure Charging Handle Spring in the reverse order, making sure that the "hump" on the spring protrudes from the side of the charging handle opposite the finger catch. If the factory roll pin is damaged, replace with Item 6. Double check that the roll pin does not protrude from either side of the charging handle, then install the charging handle into the handguard. TIP: Hold charging handle by the finger catch in a vise while removing pin/spring.
8. Drive the Handguard Pin (Item 5) through the cross hole in the handguard to retain the charging handle. Use a 3mm or 5/32" punch and drive pin (Item 5) such that it is centered in the handguard.
9. If needed, re-install front sight onto handguard. The factory sights use a 3mm hex key. Installation of HBI Handguard is now complete.



CZ Scorpion Handguard Installation and Users Guide

Safety Warnings

Your new HBI Handguard is made from aerospace grade aluminum. Firearms generate heat during operation and as with any other aluminum handguard, the material itself can heat up faster and hold temperature longer than a polymer or plastic equivalent. It is important that the user become familiar with the temperature characteristics of the aluminum handguard and if used in prolonged shooting activities consider using gloves to protect hands from excess heat.

Maintenance

Your new HBI Handguard is hard coat anodized type 3 class 2 black per MIL-A-8625. This is the same finish found on many other firearms, including M16/AR15 rifles. All conventional cleaning methods and chemicals can be used on the handguard, the hardware, and the trunnion mounting block.

Troubleshooting Chart

Below is a chart with possible causes and solutions for symptoms that could occur during installation and use of an HBI handguard.

Symptom	Possible Cause	Possible Fix
HBI trunnion adapter block does not fit	Staking on outside diameter of trunnion	Lightly file or sand the raised factory stake marks such that they are flush with the rest of the outside diameter of the factory trunnion/barrel fixation.
	HBI adapter block inside diameter too narrow	Remove the cap screw (Item 4) from HBI adapter block (Item 2), fit the adapter block to the trunion, then install the screw.
Charging Handle Drag or Binding	Handguard not indexed properly	Verify that trunnion adapter block (Item 2) is correctly installed with the dowel pins facing lower receiver.
	Using aluminum charging handle	Lubricate charging handle (Hornady One Shot # 9990 is a good choice, but all conventional lubricants will work). Install polymer/plastic charging handle (original CZ charging handle recommended).
	Retaining spring pressure too high	Install reduced pressure charging handle retaining spring (Item 7).
	Roll Pin is dragging	Center 1.5mm roll pin in charging handle, if needed replace with supplied extra (Item 6)
Screws loose	Torque	All screws should be torqued to 65 in*lbs. The cap screw in the trunnion adapter block (Item 4) can be torqued to 80 in*lbs.
	Thread locking compound	Use blue Loctite 243 on all hardware.
		Red Loctite 271 can also be used, but must be heated to 500F in order to be removed. Use very carefully.

IMPORTANT: Gunsmith installation is recommended for all HB Industries firearm products.