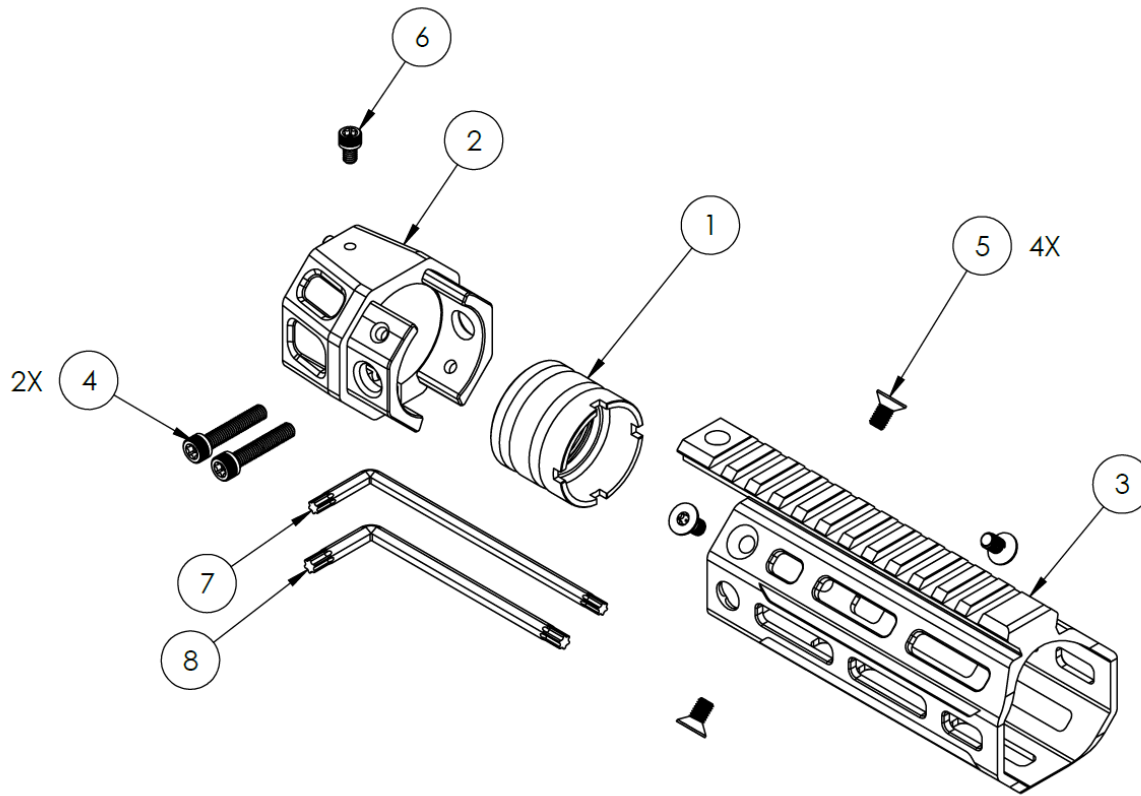


AR9/PCC SR Handguard Installation and Users Guide



Handguard Installation

1. Clear weapon, make safe, then remove existing barrel nut and handguard from receiver. You may also need to remove your muzzle device if it is large enough to obstruct the removal of the barrel nut.
2. Place HBI SR Barrel Nut (Item 1) over barrel and by hand thread the barrel nut onto the receiver. Use of anti-seize or lithium/moly paste on these threads is optional, but recommended. Hand tighten barrel nut to receiver. Using an AR Castle Nut tool (1.5" spanner) torque the barrel nut to 30 ft*lbs. Loosen barrel nut one full rotation, then repeat tighten and torque to 30 ft*lbs. This process will help fit threads and optimize engagement. Loosen barrel nut one full rotation, then tighten again and final torque barrel nut to 45 ft*lbs.
3. Slide the Trunion Adapter Block (Item 2) over the barrel and onto the Barrel Nut (Item 1). Make sure that the Trunion Adapter Block is positioned as shown above, such that the round post on the back of the Trunion Adapter Block slips into the gas tube hole in the upper receiver, and clocks the Trunion Adapter Block into the correct orientation.
4. Install the two 1" long Screws (Item 4) into Trunion Block (Item 2) as shown, making sure that the Screws align with and pass through the mating grooves in the Barrel Nut (Item 1). Torque both screws to 65 in*lbs using T27 driver. Use of Loctite 243 blue is optional but recommended on all threads in this step.
5. Attach AR9 SR Handguard (Item 3) to Trunion Adapter Block (Item 2) using four T25 flat head screws (Item 5) and one T25 socket head screw (Item 6). Start all five screws by hand, then gradually tighten the four flat head screws (Item 5) alternating between left and right sides of handguard to achieve even clamping force and proper alignment of handguard to upper receiver. Torque these four screws (Item 5) to 40 in*lbs. Finally, tighten and torque the one socket head screw (Item 6) to 20 in*lbs. Use of Loctite 243 blue is optional but recommended on all threads in this step.
6. If needed, re-install muzzle device and mount all accessories onto handguard. Installation of HBI AR9 SR Handguard is now complete.

Item	Description
1	AR9 SR Barrel Nut (30-45 ft*lbs)
2	Trunion Adapter Block
3	AR9 SR Handguard (Multiple Types Available)
4	T27 10-32 x 1.0 Socket Head Screw (65 in*lbs)
5	T25 M5x0.8 x 10 Flat Head Screw (40 in*lbs)
6	T25 8-32 x 0.25 Socket Head Screw (20 in*lbs)
7	T25 Torx Key, Short Arm
8	T27 Torx Key, Short Arm



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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	Trunnion Adapter Block Does Not Match Firearm	Make certain that you are using a Mil-Spec AR type upper receiver with a conventional gas tube hole.
	Barrel Nut Needs Deburred or Cleaned	If the tool used to tighten the barrel nut moved or slipped while torquing the barrel nut it is possible that the barrel nut could have burrs or raised edges that must be cleaned up before Trunnion Adapter Block will fit over it again.
Screws loose	Torque	All screws should be torqued according to the installation instructions.
	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.