

PRIMARY WEAPONS SYSTEMS

EVOLVE

INSTRUCTIONS FOR MOD 1-M (MK1 AND MK2) HANDGUARD REMOVAL AND REINSTALL:

- 1.) Remove original handguard by loosening all 6 screws by hand. Note that Red Loc-Tite is typically applied by the factory, but it is still possible to loosen screws without heat or special tools. A 9/64" Allen Key is required. These fasteners are no longer needed and can be discarded at this time.
- 2.) Slide the handguard forward away from the receiver. Note that if it does not move easily, a soft hammer or plastic block applied against the picatinny rail notches should suffice. It will take about 1" of forward movement to slide clear of the trunnion.
- 3.) Take out the Replacement Handguard, line up with the flats on trunnion and move rearward until it is mounted flush with the receiver. Note that if it does not slide easily, the same soft hammer or plastic block can be applied as needed.
- 4.) Once you have made sure that the handguard is flush against the receiver, apply a light coating of Red Loc-Tite (included) to the screw threads of the 6 new fasteners that are included with the package. The same 9/64" Allen Key can be used. Do not tighten the handguard screws at this time. Use an alternating pattern of Left Hand, Right Hand, and Bottom to attach the screws by hand until snug.
- 5.) Look for a small air gap between the top radius of the gas block and the interior radius of the handguard. This air gap is important in maintaining alignment of the free-float barrel attachment system with the receiver. Lack of an air gap can affect accuracy.
- 6.) While ensuring that the air gap is in place, (the tapered cap of a Loc-Tite bottle or a wooden dowel pin that is wedged between the top of the barrel and the inside of the handguard works well) use a torque wrench set to 60 in-lbs. to finish tightening the screws in the same alternating pattern – Left Hand, Right Hand, and Bottom.
- 7.) Contact PWS Customer Service if there are any questions or issues with your installation.