



PRECISION REFLEX INC.
710 STREINE DR.
NEW BREMEN, OHIO 45869

PH.419-629-2603
FX.419-629-2173
www.precisionreflex.com

Gen III Forearm Assembly Instructions

1. Parts needed for assembly of the Gen III forearms (A1)

2. Installing the barrel and the barrel nut to the receiver.

Place the receiver block into the vise. Install barrel by pushing the barrel all the way in with the orientation pin in the receiver notch.

3. Apply a small amount of grease or anti-seize onto the threads of the receiver.

4. Next install the barrel nut and the forearm collar. Turn barrel nut all the way down until finger tight. The forearm collar should be loose. See (A2)

5. Then using a barrel torque wrench you tighten to 40~50 ft.lbs. and loosen the nut on the receiver 3 times and the forth time you go for exactly 40lbs on the torque wrench.

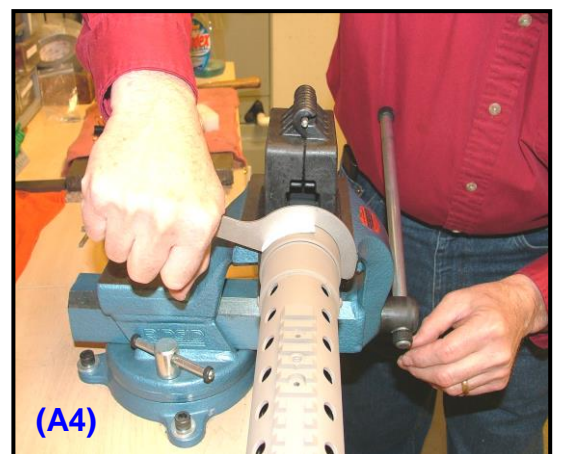
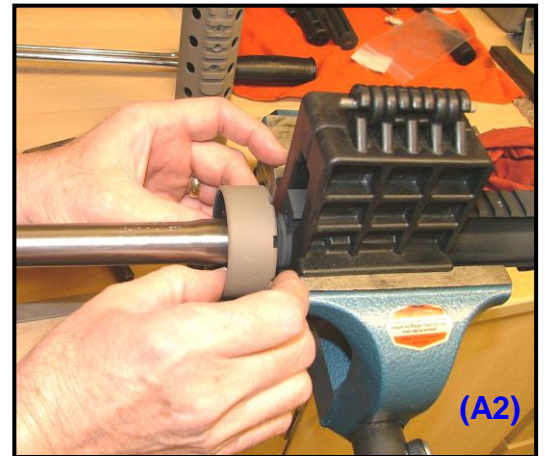
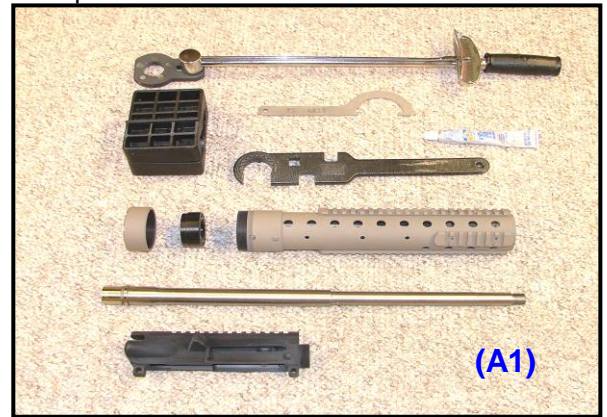
Check your gas tube port alignment on the receiver with the port on the barrel nut. If alignment is off you will need to tighten to maximum of 65ft lbs or loosen the barrel nut and start over to get proper alignment.

6. Position your forearm on the barrel. Then start to feed your front sight with the gas tube into the receiver. Then start turning forearm into collar and working the sight into position. The orientation pins in the forearm will align the forearm into place. Once forearm is in position, align the forearm rails in the orientation you want. Next align and secure your front post / sight. See (A3)

7. Tighten the forearm into place with a forearm wrench.

Use a piece of cloth or rag to protect forearm from scratches.

8. Confirm the alignment of your forearm rail and your receiver rail are aligned with each other. There is a small amount of adjustment in the forearm collar. See (A4)



For technical support or questions call us at 419-629-2603 or
E-Mail us at info@precisionreflex.com
Also reference the How To Tab on our web site
www.precisionreflex.com