



KAK Industry LLC
OE Manufacturing Solutions
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KAK Free Float Handguard Installation

Thank you for purchasing a KAK Industry free float handguard. These handguards are intended for use on mil-spec style upper receivers. Installation on certain billet or non-standard upper receivers may require modification of the handguard or receiver. Please note that modifying the handguard will void any warranty. Please follow the instructions below to ensure the safest and most reliable installation of your new handguard.

1. Ensure that the upper receiver is free of any defects or damage to the threads.
2. Apply an anti-seize compound such as Aeroshell 64 to the threading on the receiver.
3. Insert the barrel into the upper receiver. Ensure that the barrel index pin is fully seated in the index pin slot and that the barrel is seated in the upper so that the lip of the receiver is touching the lip of the barrel extension.
4. Keeping the barrel in the receiver, thread the barrel nut that was included with the handguard onto the upper receiver. Be sure not to cross thread and seat the barrel nut firmly with hand pressure.
5. Install the upper receiver into a quality fixture that prevents excessive torque on either the upper receiver or the barrel.
6. Using a torque wrench and either the supplied wrench or a standard castle nut barrel wrench, tighten the barrel nut using the following procedure:
 - a. Tighten the barrel nut to 35 foot pounds
 - b. Loosen the barrel nut
 - c. Tighten the barrel nut to 35 foot pounds
 - d. Loosen the barrel nut
 - e. Tighten the barrel nut one final time to 35-55 foot pounds
7. Install gas block assembly and any other accessories that may be covered by the handguard.
8. Slide the handguard over the barrel nut allowing the index tabs to fit on each side of the upper receiver. To fit some bulkier billet upper receivers, these tabs may need to be modified or removed. This will void any warranty and the part will not be returnable.
9. The handguard installs with two aluminum clamps. These clamps can be inserted from either side. Tightening these clamps pulls the handguard down into the barrel nut ensuring that it will not move and that the top rail stays level. Install the clamps using the following procedure:
 - a. Place the clamp on each side of the barrel nut
 - b. Apply a small amount of medium strength thread locker to each cap screw
 - c. Thread the two screws into the clamps from the side with the larger diameter hole.
 - d. Alternately tighten the two screws until they both reach 45 inch pounds. Check each screw to confirm the proper torque.