



**AMERICAN TACTICAL**

231 Deming Way, Summerville, SC 29483

1-800-290-0065 / customerservice@americantactical.us

## **American Tactical Hybrid Upper Receiver Installation Instructions**

### Tools needed:

- Quality barrel wrench from ATI, Magpul, Brownells, or other reputable manufacturer
- Upper receiver fixture: Geissele Reaction Rod, Brownells Barrel Extension Torque Tool, or Magpul BEV Block. **DO NOT** use any clam shell or takedown pin lug clamp. **ONLY use a vice which holds the upper receiver using the barrel extension.** Damages occurring due to improper mounting procedures are not warrantied.
- Gas tube alignment tool (if required by barrel nut)
- Aeroshell 33, Brownells Copper Anti-Seize, or other high quality high temperature lube/anti-seize.

### Barrel installation procedure:

- Ensure that receiver fixture is firmly clamped into a sturdy vise, preventing it from moving during installation.
- Place a coating of anti-seize on the threaded portion of the upper receiver.
- Place upper receiver onto upper receiver fixture.
- Insert the barrel into the threaded portion and align so the index pin on the barrel extension seats completely in the cut notch on the top of the threaded portion of the upper receiver.
- Install barrel nut and hand tighten. Make sure that the barrel extension remains flush with the receiver face.
- Tighten the barrel nut with the appropriate barrel nut according to manufacturers specified torque. Standard mil-spec barrel nuts should be tightened to minimum 30 of foot pounds. Do not over-torque!
- Remove all torque from barrel nut and re-torque to a minimum of 30 foot pounds
- Remove all torque again and re-torque to a minimum of 30 foot pounds while aligning the slot for the gas tube.
- Check gas tube alignment with alignment tool making minor positive adjustments to achieve proper alignment.

### Notes:

- **ONLY use a fixture which holds the upper receiver using the barrel extension!**
- You may see a small sliver of metal being cut off of the threaded portion when tightening the barrel nut. This is normal.
- Use caution when installing the forward assist roll pin. Ensure that the receiver is fully supported and that your tool does not mar the polymer during installation.
- Your upper may be a bit tight on the bolt carrier group at first. Lubricate thoroughly with CLP and it will loosen up over the first 30-60 rounds.