



Barrel Installation Guide



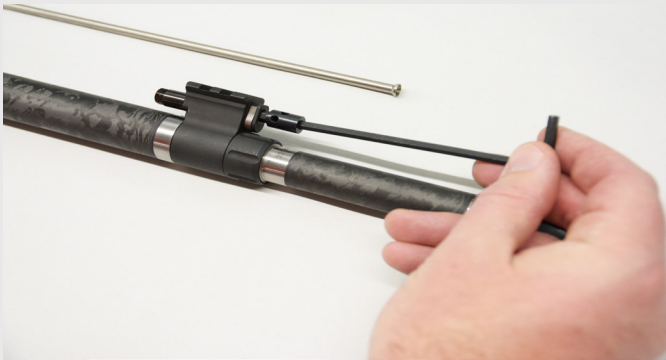
INSTALLATION:

Please read through the entire procedure before starting. If you are uncomfortable with performing any of the required tasks please seek the help of a qualified gunsmith. Know and follow the rules for safe gun handling at all times.



* A vise with soft jaws is recommended for removing and installing parts.

- Using a 5/32 hex wrench, remove gas plug:



- Using 7/8" spanner wrench, remove muzzle brake:



- Using 15/16" spanner wrench, remove gas block nut:



- Light tapping with a soft face mallet may be needed to remove gas block. Tap only where shown.



- Remove gas tube retention nut and ferrule with a 5/16" spanner wrench. All parts are now removed and barrel is ready for install:



- Slide your barrel nut onto barrel and install barrel into upper receiver as normal.



- Insert gas tube into upper receiver and into the gas key on the bolt carrier. Slide gas block onto barrel as shown. The gas block should seat against the gas journal shoulder when properly aligned.



- Install gas block nut being careful not to pinch the silver gas plug detent spring. Torque nut to 35 ft-lbs



- Position gas tube flare onto gas block and tighten gas tube retention nut to 8 1/2 ft-lbs.



- Unscrew muzzle brake jam nut from muzzle brake slightly as shown creating a ~1/16" gap between the brake and nut. Note that this is a left hand thread. Install muzzle brake on barrel by screwing muzzle brake nut onto the muzzle. Try and maintain the slight gap between the nut and the brake. The brake should seat against the taper on the end of barrel before the nut tightens against the muzzle shoulder



- Before tightening the nut, align the brake to the barrel as shown. Note that the small round hole in the brake will point up and the large round ports in the brake should be horizontal. Tighten the muzzle brake nut to 30 ft-lbs.



- Reinstall the gas plug into the gas block. Screw the plug all the way in tight and then back it out 4 turns as shown.



The proper setting of the gas plug for your rifle is determined by live fire testing with your chosen ammunition. Turn the plug in (close) to decrease the amount of gas for rifle operation and turn the plug out (open) to increase the amount of gas. The goal is to find the setting where the bolt just locks back on an empty magazine and then back the plug out 1-2 clicks to allow for adverse conditions. Note that ammunition using lighter weight bullets will generally need more open gas setting than heavier bullets.

Recommended Starting Positions:

223 Wylde - 3 2/3 turns out

224 Valkyrie - 4 turns out for 75gr & heavier ammunition. 6 turns out
6 turns out for 60gr ammo

308 Win - 4 turns out

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