

# Sig Cross Barrel Installation

## Tool List:

- AR Barrel Nut Wrench
- 1 1/16" twelve point box end wrench
- Strap Wrench
- Barrel Vise
- Torx Wrenches (for scope base and forearm removal)
- Small Punch ( for ejector removal)
- Small Gunsmith Hammer
- Set of Headspace Gauges (cartridge specific)
- Masking Tape

## Steps:

**Read through these steps before beginning the barrel installation.**

1. Clear the rifle and remove the bolt.
2. Remove the scope base and forearm.
3. Place the barrel in the barrel vise and tighten down securely.
4. Using the AR barrel wrench loosen the mounting nut from the receiver.
5. Remove the receiver from the barrel.
6. Remove the barrel from the barrel vise.
7. Slide the 1 1/16" box end wrench over the barrel and index it on the barrel's jam nut
8. Reinsert the barrel into the barrel vise and tighten.
9. Loosen the jam nut and remove the barrel extension and the jam nut.
10. Remove the ejector from the bolt with a punch and hammer.
11. Place a piece of masking tape on the back of the Go Gauge and trim off the excess.
12. Screw the jam nut on the new barrel.
13. Screw the barrel extension on the new barrel also.
14. Ensure the chamber is clean on the new barrel and insert the Go Gauge with the masking tape on the back.
15. Screw down the barrel extension with the bolt inserted and rotated to the firing position.
16. Tighten the barrel extension down until the bolt face fits snug against the Go Gauge.
17. Place the new barrel back into the barrel vise with the box end wrench over the barrel.
18. Ensure the barrel extension and bolt are still snug against the Go Gauge.
19. Use the strap wrench to counter torque the barrel extension in place while torquing down the jam nut against it, torque the jam nut to approximately 80-90 ft. lbs.
20. Remove the bolt and Go Gauge.
21. Remove the tape from the back of the Go Gauge.
22. Reinsert the Go Gauge
23. The bolt should close with no resistance against the Go Gauge.
24. Remove the Go Gauge and insert the No Go Gauge.

25. The bolt should not close on the No Go Gauge.
26. If the bolt closes on the No Go Gauge then loosen the jam nut and barrel extension and repeat steps 18 thru 25. (*you can try without the tape on the back of the Go Gauge, but may need to reapply as in step 11*)
27. Once the headspace is confirmed you can remove the barrel from the barrel vise again and set aside the box end wrench and strap wrench.
28. Insert the new barrel into the receiver and reinstall the AR type nut onto the receiver hand tight.
29. Reinsert the barrel back into the barrel vise and torque down the AR type barrel mounting nut to 35-40 ft.lbs. Watch to make sure the barrel extension does not loosen when torquing down the mounting nut.
30. Recheck the headspace with the barrel completely installed.
31. If the rifle does not pass headspace you must go back to step 14. (*If the barrel extension continues to back off during mounting, you can remove the jam nut and barrel extension, degrease the barrel, barrel extension and jam nut threads and apply blue or red thread locker.*) Then go back to step 14.
32. Allow the thread locker to cure for at least 30 minutes before torquing the barrel mounting nut back onto the receiver.\**Heat will need to be applied to remove the barrel extension and jam nut if thread locker is used.*
33. Reinstall the forearm and scope base.
34. Reinstall the ejector into the bolt.

\* You should be technically proficient with tools and knowledgeable in firearms to perform the barrel installation. Working on firearms is inherently dangerous and can be deadly to the end user if an improper installation is performed. Acquire the service of a professional gunsmith if you do not have the confidence in your skills to perform a proper installation.