



YANKEE HILL MACHINE Co., Inc.

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Installation Instructions For:

YHM Forearm Tubes

Part Number(s): YHM-9645, YHM-9649, or YHM-9810A

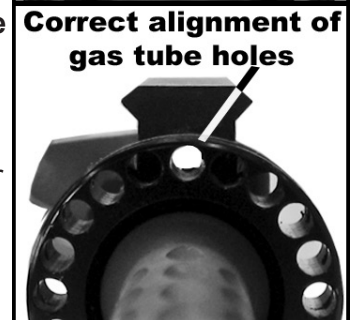
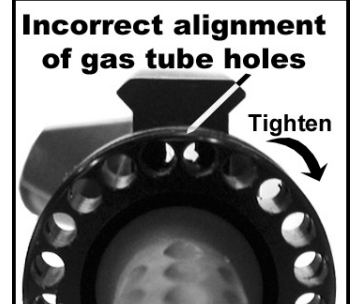
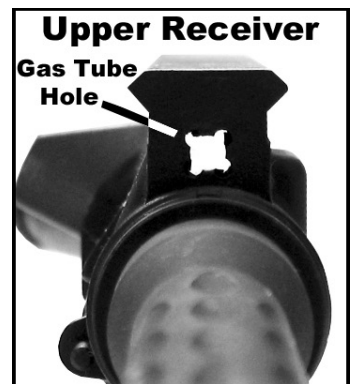
ONLY a licensed gunsmith experienced with your model of firearm should install this product. Failure to install this product correctly voids any warranties of the product and removes any liabilities against the manufacturer. Be certain the firearm is unloaded and the muzzle is pointed in a safe direction before starting this removal and installation process.

Strongly Recommended Tools: YHM Forearm Wrench (YHM-9621)

1. Remove the existing forearm per the firearms manufacturer's instructions.
2. Unscrew the muzzle brake or flash hider and set aside, if applicable.
3. Remove the front sight by tapping out the 2 tapered dowel pins at the bottom of the sight that hold it onto the barrel using a 1/8 diameter drift pin punch being sure to drive the pin out from the **SMALL END**.
4. Remove the sight assembly and gas tube from the barrel and set aside. Retain the tapered dowel pins for re-assembly.
5. Remove the front plate of the old forearm and set aside. This will not be reused.
6. Remove the combination delta ring/barrel nut using a proper armorer's barrel nut removal wrench. This will not be reused.
7. Clean the threads on the upper receiver. The barrel nut is shipped within the forearm tube, you may remove it at this time.
8. Degrease the threads on the barrel nut and forearm tube.
9. Screw the barrel nut onto the upper receiver until it is tight by hand. Using our forearm wrench (YHM-9621) tighten the barrel nut until the next gas tube hole lines up with the upper receiver's gas tube hole (using a rubber mallet). Take special care in aligning the gas tube hole in the receiver to the gas tube hole in the barrel nut. See diagram to the right.

***At this point, generously put loctite on the outside of the barrel nut threads. Screw on the forearm tube. Remove any excess loctite. The loctite must cure for 24 hours.**

10. Re-install the front sight being careful to align the gas tube through the barrel nut and upper receiver.
11. Re-install the tapered dowel pins being careful to install them in the proper direction of the taper. Set pins firmly with larger punch.
12. Re-install the muzzle brake or flash hider to manufacturer's specifications if applicable. Note: Always use a new crush washer when installing a muzzle brake or flash hider.



Before test firing, be sure all applicable components that were removed are reinstalled and tightened correctly. It is recommended that you bench fire the firearm first to be sure everything is operating smoothly. Always handle your firearm with care being sure the muzzle is pointing in a safe direction and wear approved shooting glasses and hearing protection when using your firearm.

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