

# YANKEE HILL MACHINE Co., Inc.

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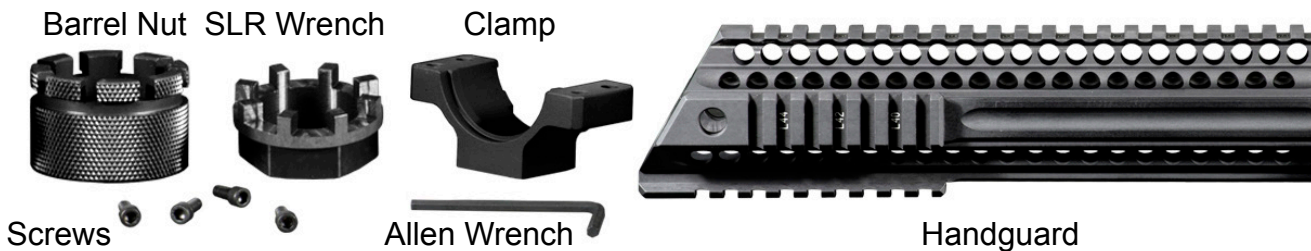
PHONE: 1-877-892-6533

FAX: 1-413-586-1326

Installation Instructions For:

### SLR-Slant Handguards (YHM-5145 & YHM-5155) SLK Handguards (YHM-5220, YHM-5240, & YHM-5260) SLM Handguards (YHM-5270, YHM-5280, & YHM-5290)

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. This forearm cannot be installed on a rifle utilizing a pinned, welded, or otherwise permanently mounted muzzle accessory unless a two-piece gas block will also be installed.



*If you did not receive everything seen above, please contact us as soon as possible.*

*Note: the screws are contained in your handguard and clamp*

#### Recommended Tools:

- 9/64" Allen wrench (Included with instructions)
- Soft hammer, or dead blow hammer (NOT Brass)
- Torque Wrench
- YHM Picatinny Vise Jaws (YHM-7350)
- 1 1/8" Wrench
- Benchtop Vise

*Remove any existing handguard, front sight/gas block and any muzzle accessory per the manufacturer's instructions*

#### Assembly of your new handguard

**1.** Clean and degrease the threads on the upper receiver and Barrel Nut and let them dry. Install the new barrel nut until it is tightened by hand. Using the supplied SLR wrench and an 1 1/8" wrench tighten to 80 ft.-lbs. *Note: When guiding both the barrel nut and the wrenches over your barrel, be careful not to scratch the finish.*

**\*If you are installing a low-profile gas block inside your new forearm, install it at this time according to the manufacturers instructions.**

**2.** Place your forearm directly on top of the barrel nut so that the groove on the barrel nut lines up with the protrusion within the forearm (See picture to the right). Line up the rails of your upper receiver with the top rail of your forearm.\* Using a soft hammer tap the forearm into the groove of the barrel nut.

**\*The YHM Picatinny Vise Jaws (YHM-7350) will perfectly align the top rail of the forearm to the rail on the upper receiver.**

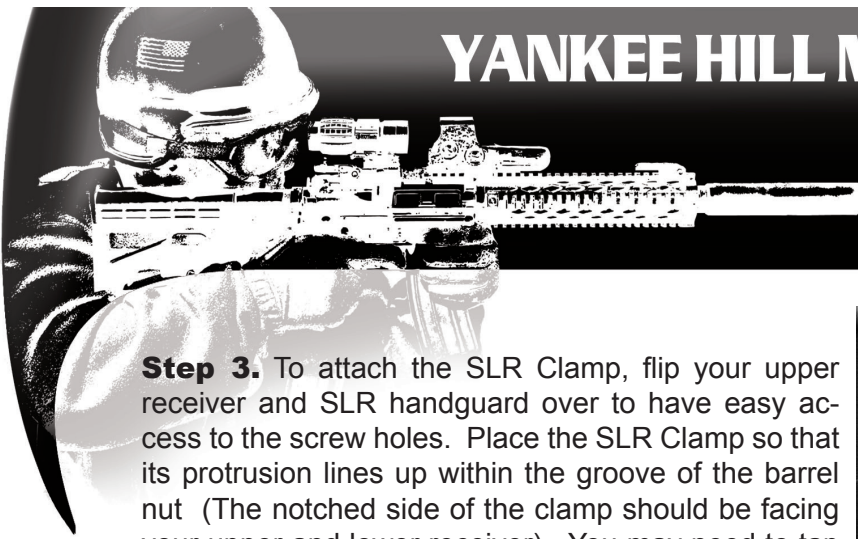


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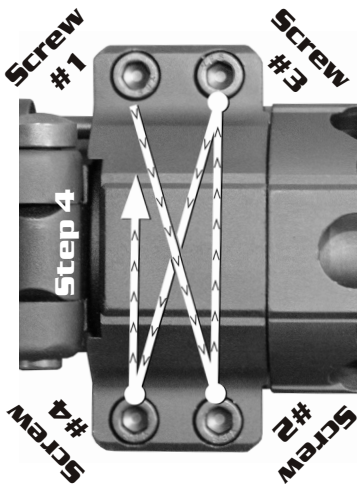
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**Step 3.** To attach the SLR Clamp, flip your upper receiver and SLR handguard over to have easy access to the screw holes. Place the SLR Clamp so that its protrusion lines up within the groove of the barrel nut (The notched side of the clamp should be facing your upper and lower receiver). You may need to tap it with a soft hammer again. (See Picture to the right).

•YHM Picatinny Vise Jaws (YHM-7350) are designed to perfectly align your upper receiver and your forearm.



**Step 4.** Screw the SLR clamp down gradually. It is not important which screw you start with, it is important to gradually tighten the clamp in a cross pattern seen to the left. Screw in each screw a little bit at a time, always using the cross pattern. Rotate each screw a maximum of 3 rotations before moving on to the next one, and repeat these steps until all screws are HAND TIGHT. This will ensure that the clamp tightens down evenly and gradually. Complete the installation by using your torque wrench, and tightening each screw to 18 inch-lbs.

**Congratulations your YHM handguard is now installed!**

**5.** Install any front sight/gas block and any muzzle accessory per the manufacturers instructions

Before testing the firearm, be sure all 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.

