



YANKEE HILL MACHINE Co., Inc.

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Installation Instructions For: **Set Screw Type Gas Blocks:**

Four Rail Type Part Number: YHM-9380

Low Profile Type Part Numbers: YHM-9381A, YHM-9383

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.

1. Remove any existing muzzle accessory. If your muzzle accessory has been permanently attached to your barrel, then you must purchase one of our 2-piece gas blocks.
2. Remove the front sight by tapping out the 2 tapered dowel pins using a 1/8" diameter drift pin punch. Be sure to drive the pin out from the SMALL END
3. Remove the sight assembly and gas tube from the barrel.
4. Remove the gas tube using a 1/16" drift pin punch being careful not to lose the roll pin. You will need the roll pin for the new installation.
5. Remove the gas tube and re-install it into your new gas block. Align the roll pin groove with the roll pin hole in the gas block and re-install the roll pin being sure the alignment of the gas block and gas tube is correct. **DO NOT USE EXCESSIVE FORCE TO INSTALL THE ROLL PIN.**
6. Loosen the set screws and slide the gas block assembly onto the barrel being careful to align the gas tube into the upper receiver/ barrel nut assembly.
7. If using a standard forearm slide the gas block all the way on until it hits the metal forearm cup. If you are using an aftermarket forearm **DO NOT PUSH THE GAS BLOCK AGAINST THE SHOULDER OF THE BARREL!** You must leave a 1/32" gap between the shoulder of the barrel and the gas block. ***::Exception::*** The YHM-9383 gas block should not have a gap between the shoulder on the barrel and the gas block.
8. Be certain that the top of the gas block is in alignment with the top of the barrel. A suggested way to do this to hold the firearm in the shooting position and look down the barrel at the gas block, checking for alignment.
9. Firmly tighten the set screws and re-check alignment.

BE SURE NOT TO OVERTIGHTEN! THIS WILL RESULT IN DAMAGE TO YOUR BARREL

Before test firing 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.

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