



MCSRv2 BARREL NUT MOUNTING

WARNING: Make sure your firearm is UNLOADED first!!

- When using the IMRT-R upper, the black mounting nut that comes with the rail is not used and the steel barrel nut will thread directly into the upper.
- The steel barrel nut will need a 1 1/8" crow's foot, end wrench, or adjustable crescent wrench, and a torque wrench to fit any of these.
- The screws in the screw pack will need a T20 torx bit. The screw size is 8-32x3/8" (quantity of 8) flat-head cap screws.

The MCSRv2 rail comes with a black aluminum mounting nut with steel barrel nut threaded into it. The mounting nut threads onto the front of any standard upper. To install, back the steel nut out completely, and then thread the MCSRv2 mounting nut onto your upper. Place the threaded screw holes towards the muzzle end. Tighten the black mounting nut until it bottoms out or lightly contacts the dust door rod. Back off the mounting nut until the first gas tube hole in the mounting nut lines up with the gas tube hole in the receiver. Install the MCSRv2 handguard and check the alignment of the 8 mounting screw holes. If the mounting holes are not aligned, back off mounting nut until the next gas tube hole is aligned with the corresponding hole in the receiver and check handguard fit again. Repeat as necessary. Remove the MCSRv2 handguard.

The MCSRv2 mounting nut will turn when torquing the barrel in with the barrel nut. Backing the MCSRv2 nut off 1/8th turn, positioning the gas tube hole around the 11 o'clock position will help index it for proper torque of the barrel nut. Insert the barrel into the upper and then thread the steel barrel nut into the black mounting nut. Torque on the barrel nut should be a minimum of 35 ft. lbs. and a maximum of 60 ft. lbs, with the gas tube hole lining up at the 12 o'clock position. Once proper barrel torque is met, you are now able to put your MCSRv2 rail onto your upper. It will slide onto the mounting nut with some force as the tolerances are close.

Once aligned slide on the handguard. Next install all torx screws using a T20 torx wrench. If you choose to use Blue Loctite, use sparingly, although it is not needed and we do not recommend it. Too much and it will be difficult to remove the screws in the future. Tighten the screws no more than 30 INCH lbs.

MCSRv2 sides: The MCSRv2 rail will accept most manufacturers M-LOK accessories at the 3, 6, and 9 o'clock positions