

Instructions for installation of Samson Manufacturing Evolution Free Float System

Thank you for your purchase of what we at Samson Mfg believe is the best One Piece Free Float Tube System available the Samson Evolution Rail Series. We are sure you will be completely satisfied with our products or get a complete refund. We appreciate your confidence in us and look forward to serving you in the future.

Scott W. Samson
President
Samson Mfg Corp.

Remove magazine and clear weapon - make sure rifle is unloaded;
Failure to do so could cause injury or death.

Parts List:

- Evolution Rail with 2x 8-32x 7/16" Allen Head Cap Screws installed
- 1 Thermal Bushing Set (consisting of a left and right)
- 2x 2" Rail Kit (2" Rail sections with steel backing plates and 10-32x 3/8 low head cap screws installed)
- 1x 4" Rail Kit (1x Rail section with steel backing plate and 10-32 x 3/8 low head cap screws installed)
- 2x Allen Wrenches (3/32 & 9/64)

Installation of the Evolution hand guard will require the removal of the delta ring assembly and the front hand guard cap. Please visit our web sight (<http://www.samson-mfg.com/Install.htm>) for instructions.

Full video instructions can be found at: <http://www.youtube.com/watch?v=XwIBJQo4qeA>

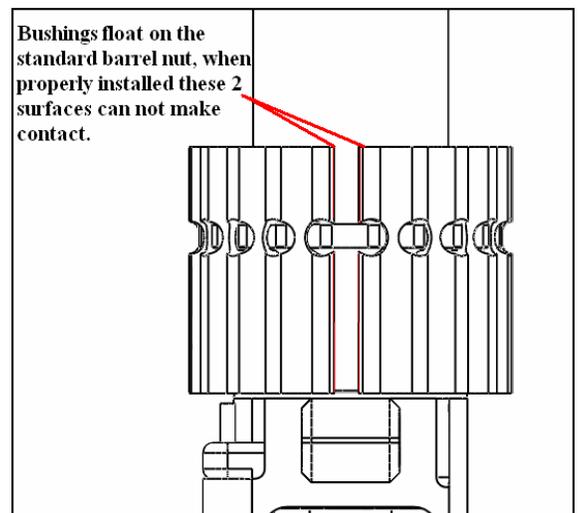
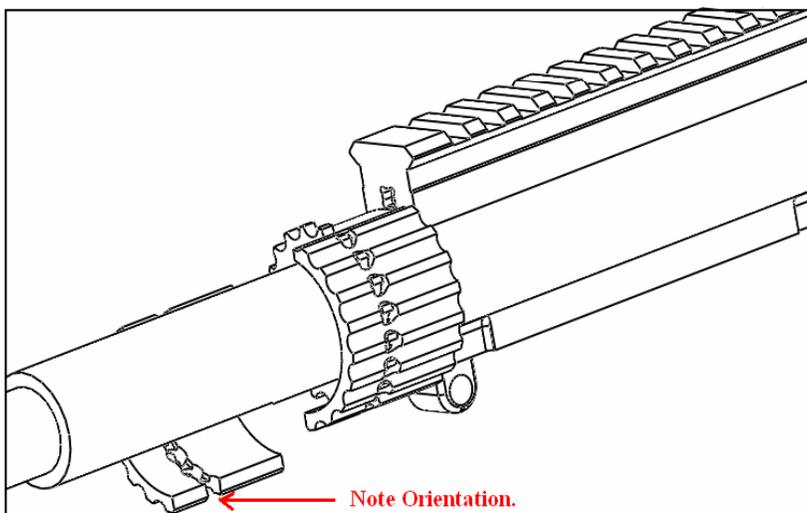
Upper Receivers:

The anti rotation tabs on the Evolution hand guard will fit most upper receivers; some billet may require modification to the anti rotation tabs on the hand guard with a file or Dremel tool. We tried to accommodate as wide a selection of uppers as possible.

Installation with a low profile gas block:

Installation of the Evolution hand guard on an upper assembly with a low profile gas block is extremely easy and straight forward.

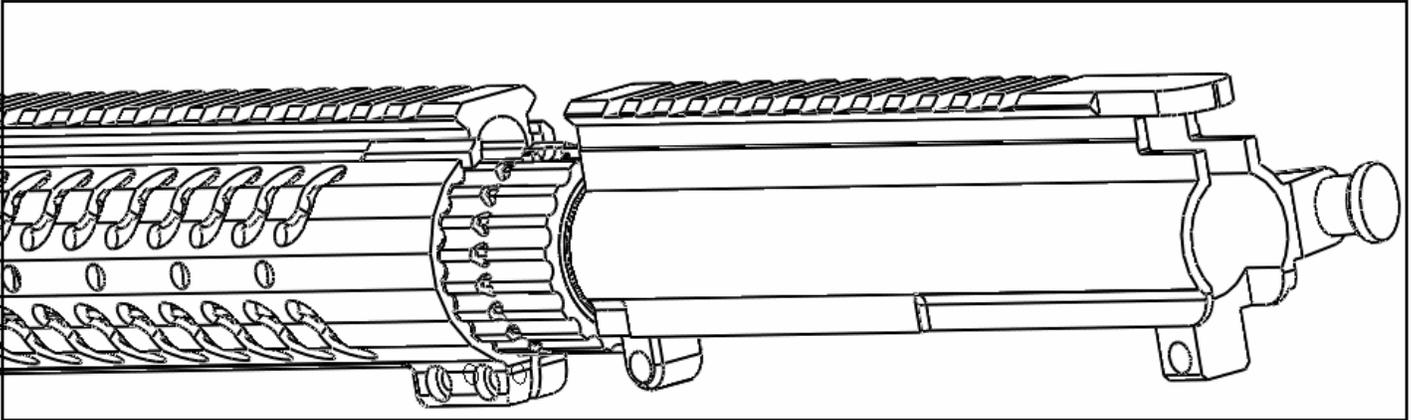
With the low profile gas block and gas tube already installed on your upper assembly, simply snap the thermal bushings around your barrel nut, ensure that the bushings are properly orientated (see illustrations below).



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Ensure the hand guard is properly clocked with the receiver and slide it back into position. Tighten the two pre-installed 8-32 screws alternating between the two screws until evenly tightened, a small gap may be present after fully tightening. A medium strength Locktite is recommended.

***** Do Not Over Tighten *****



Installation with a Standard Front Sight/Gas Piston System and removable muzzle device:

Remove magazine and clear weapon - make sure rifle is unloaded;
Failure to do so could cause injury or death.

Installation on a system with a standard front sight or piston system will require the muzzle break to be removed along with the front sight/gas block. After removing the front sight/gas block follow the previous instructions and then re-install your previously removed hardware.

If you are installing an EX model hand guard, we recommend leaving the hand guard loose until you have successfully re-installed your piston system or front sight assembly. The hand guard will not clear the bayonet lug or front sling loop and while removed we recommend following these modification instructions: (http://www.samson-mfg.com/sub-pages/additional_steps/Additional_steps_install_Star.html)

Installation with a Standard Front Sight/Gas Piston System and a pinned on muzzle device:

Remove magazine and clear weapon - make sure rifle is unloaded;
Failure to do so could cause injury or death.

The Evolution hand guard can be installed on a system with a pinned on muzzle device since we utilize the stock barrel nut. Installation requires the removal of the stock hand guard, the sight assembly/gas block to be unpinned and slide up to the end of the barrel and the barrel to be removed from the upper assembly.

Upon removing the barrel, remove the delta ring assembly and slide the Evolution hand guard over the barrel. Re-install the barrel assembly onto the upper assembly ensuring to properly seat the barrel and torque the barrel nut. Install the thermal bushings as previously illustrated, slide the hand guard in place and tighten. Re-install your front sight assembly/gas block and enjoy.

Full video instructions can be found: <http://www.youtube.com/watch?v=XwIBJQo4qeA>

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