

Instructions for installation of STAR Free Float system

Thank you for your purchase of what we at Samson Mfg believe is the best Free Float system available the STAR Samson Tactical Accessory Rail. 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.

1.) Remove upper receiver, bring to the condition in the pic below. Use whatever method you feel comfortable with to remove Delta ring and springs.



2.) Layout the parts for the STAR:

- Upper half STAR
- Lower half STAR
- Attachment clamp assembly with take down pin

3.) Slide the upper over the barrel nut and in place as shown.



- Four 8-32 x 1/2 long Socket head cap screws.
With Allen Key

4.) Turn upside down and put Attachment clamp in assembly place



5.) STAR are equipped with locking helicoils - Loctite is optional. Try it without

6.) Using the 8-32 x 1/2 Socket head cap screws tighten the screws down evenly down. Use a corner to corner pattern for tightening. Do not worry about alignment at this point. Just pull the upper down around the barrel nut and tighten bolts to a medium hand pressure to pre-seat the upper.

7.) Now loosen the four 8-32 bolts evenly just enough to rotate the upper rail into alignment. Now Retighten. Check alignment. Sometimes it takes a few tries to get this where you want it.

8.) Turn the upper upside down. Apply some lubricant to the slide area. It is better to be a bit generous with this and wipe some off later. The slide surfaces will need to be worked in a little and the lubricant will help this. Align slots and notches push down and slide fully to the back. Push takedown pin in to secure lower in place. The head of the takedown pin should be flush with the clamp when fully engaged.

Find some time and get out and Shoot

If you encounter any problems contact our customer support at: 413-665-1162 or Scott@samson-mfg.com