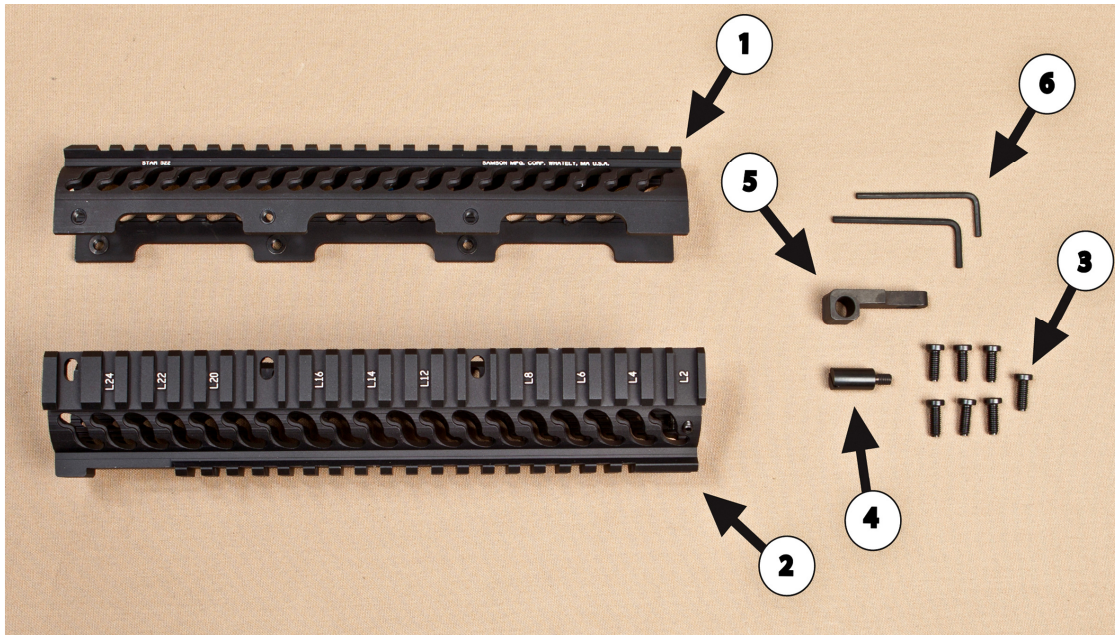


STAR SIG 522 RAIL SYSTEM



PARTS LIST

- 1.) 1x Star Sig 522 upper rail 10" long
- 2.) 1x Star Sig 522 lower rail 10" long (with 2x 8-32 x 3/8 set screws installed)
- 3.) 7x #10-32 x 1/2 low head socket cap screw
- 4.) 1x S.S. pin 1" long with #10-32 threads
- 5.) 1x S.S. hinge bracket
- 6.) 1x 3/32 allen key, 1x 5/64 allen key

INSTALLATION INSTRUCTIONS

- 1.) First you will have to remove any rail system or hand guards that are now on the rifle (Note: Loctite may have been applied to the original screws).
- 2.) Install hinge bracket (item 5) utilizing the rifle's front takedown pin hardware.
- 3.) Secure lower rail (item 2) to rifle by installing the 1" stainless steel pin (item 4) through the bayonet hole into the lower rail (item 2) and tighten with a screwdriver.
- 4.) Tighten this pin fully. The lower rail has a thread-locking heli-coil installed so no Loctite should be necessary.
- 5.) Install screw (item 3) through lower rail into the hinge bracket (item 5). Apply Loctite to screw, utilize 3/32 allen key and tighten.
- 6.) Apply Loctite to set screws that were pre-installed in lower rail (item 2). Utilize allen key (5/64) and tighten until they make contact with the barrel nut. Make sure to alternate and to tighten evenly.
- 7.) When you have the lower rail lined up, insert the upper rail (item 1) and start the 6x Screws (item 3) through the lower rail assembly into the upper rail (item 1). Apply Loctite to the 6x screws and utilize a straight edge or flat surface to align the top rail and receiver.
- 8.) Utilize 3/32 allen key and tighten 6x side screws fully.
- 9.) Check hand guard for any interference. It should feel solid and not rattle.

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