



## M17s Barrel Removal

1. Remove the barrel nuts and or flash suppressor from the end of the barrel. You will need a  $\frac{3}{4}$ " spanner wrench to do this. I have them for sale on my website. If these have never been removed they are very stubborn to remove as they are put on at the factory with red loctite. You may need to apply heat with a heat gun or propane torch to get them to come off. Once they are off you can also remove the lock washer and barrel sleeve.
2. Remove the lower by pushing out all three pins that hold it on to the receiver tube.
3. Remove the socket head cap screw that is holding the barrel on to the receiver tube. This is also attached with red loctite and may need some heat to break it loose, most of the time it does not.
4. Pull back the charging handle all the way and push the barrel into the receiver tube so it can be removed. If it does not push out of the locator spot easily, thread the cap screw all the way back into barrel without the washer and give it a light smack with a mallet. When you smack it with the mallet make sure the charging handle is pulled all the way back.
5. Once the barrel is loose it will pull out the front of the tube along with the end cap. You may need to hold on to the barrel and twist and pull at the same time till it comes out.

## M17s Barrel Install

6. Clean the residue off of the barrel threads and barrel nuts and barrel cap screw with solvent such as MEK to remove excess loctite before assembly.
7. Pull the charge handle back and install the barrel through the front of the tube. Install the barrel cap screw but leave it loose.
8. Install the front cap, barrel sleeve, lock washer and one of the nuts. Just snug them at this time.
9. Remove the barrel screw and apply blue loctite to the threads and tighten all the way.
10. Now back off the barrel nut and apply red loctite to the nut and tighten. Do not over tighten the barrel nut as it can crack the front cap casting.
11. Install the second nut or flash hider.
12. Attach the lower to the upper with the 3 pins.