



M17s Disassembly

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.
6. Remove the 2 cap screws for the charging handle. To do this pull back the handle and apply pressure with your finger from the inside of the receiver tube to the slide bar that the charging handle is attached to. Before you remove it make sure that you notice how the charge spring assembly looks as it is attached.
7. Remove the Cap screw that is attaching the charging spring to the inside of the receiver tube. This also attaches the carry handle to the receiver tube.
8. Remove the Cap screw at the front of the carry handle. You will use this one to attach the new top rail and charging spring on the inside of the receiver tube.

Install new K&M Top rail and charging handle

9. Place the Top rail on top of the receiver tube. Attach the rail first by using the cap screw that you removed from the front of the carry handle. You will also be attaching the return spring for the charging handle at this time. So it will go top rail, receiver tube, spring bracket, lock washer, cap screw. This will then position it correctly on top of the receiver.
10. Align the top rail so that it is straight and then tighten the cap screw all the way so the top rail does not move.
11. You now need to mark the locations for the front and back hole. This can be done 3 ways. First is with a $\frac{1}{4}$ transfer punch. Second way is to take a $\frac{1}{4}$ drill and lightly start to drill the hole just so it marks the location and starts the hole. The preferred method is to take a #3 center drill and drill up to where the countersink starts.
12. Once the locations are marked remove the top rail and drill the front and back hole with a #21 drill bit.
13. Tap the front and back holes with a 10-32 tap. And deburr the holes.
14. Attach the top rail again as in step #9. Install the (2) 10-32 FHMS screws that were provided with the kit. Do not over tighten as there is not much thread engagement.
15. Pull the charging handle return bracket back and hold with your fingers on the inside of the receiver tube. Attach the new charge handle with the existing screws that were holding on the original charge handle.
16. 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.
17. Pull the charge handle back and install the barrel through the front of the tube. Install the barrel cap screw but leave it loose.
18. Install the front cap, barrel sleeve, lock washer and one of the nuts. Just snug them at this time.
19. Remove the barrel screw and apply blue loctite to the threads and tighten all the way.
20. 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.
21. Install the second nut or flash hider.
22. Attach the lower to the upper with the 3 pins.