



Assembly of the MREX AR MLOK Rail System

This sounds more complicated than it is. Just take your time and work through step by step and you will have no problems.

1. Required materials:
 - a. 1/2" Socket Wrench (to fit custom barrel nut wrench)
 - b. 5/64 Hex Wrench or Driver
 - c. Lithium Grease or equivalent grease
 - d. Upper Receiver Action Block
 - e. Vice
 - f. Barrel must have low profile gas block
 - g. AR15 Action Wrench
 - h. Drift punch for gas tube roll pin

2. Prepare your rifle:

With the muzzle pointed in a safe direction, visually and physically inspect the chamber of the rifle to ensure it is unloaded and on Safe.

Field Strip the rifle removing the upper from the lower receiver and removing the bolt carrier and charging handle.

Drift the gas tube roll pin out with the appropriate sized punch and remove the gas tube retaining the roll pin and the tube. If you are going to salvage the old barrel nut, remove the low profile gas block. If you are going to cut off the barrel nut, leave the gas block in place.

Place the insert from the Action Block inside the upper receiver, and place receiver in the action block.

Place action block containing the upper in the vice with the muzzle pointing away from the bench so you can work on the front end of the weapon.

Use the AR Action wrench and turn off the barrel nut (counter clockwise).

At this point you have the option of cutting off the barrel nut (so you do not have to remove the muzzle device or the gas block), or if you have removed the gas block and muzzle device remove the barrel nut. Leave barrel in the upper receiver.

3. Installing the MREX AR Barrel Nut:

The MREX AR Barrel Nut is double threaded on each side with the thread pitch starting at opposite axis from one another. This will allow you to use the minimum shims required.

Screw on the barrel nut until it stops. If it times from 12 o'clock to 6 o'clock, you have chosen the right side of the barrel nut for your receiver. If it times from 6 o'clock to 11:45, flip the barrel nut around and thread on the other side.

There are four sized shims in the kit (.001, .003, .005 and .010 of an inch) find the shim or combination of shims that allows you to time the barrel nut at 11:45.

Apply lithium grease to the threads on the upper receiver.



Put your wrench on the barrel nut profile and torque to a minimum of 35 foot pounds and maximum of 55 foot pounds until the top of the barrel nut is top dead center and the gas tube hole in the nut aligns with the hole in the receiver. Slide your rail over the barrel and the new barrel nut assuring perfect alignment with the picatinny rail. Remove and adjust the barrel nut as required.

Install, the gas tube, gas block (if necessary), and muzzle device.

Install rail onto the barrel nut and using the supplied 6-32 x 3/8 flat head socket cap screws. It is suggested you use the thread-locker supplied. Do not over-torque the screws. They should be tightened until the allen wrench slightly flexes.

Congratulations! You are ready for the complete modularity of MLOK, Kinect, and SideLoK.

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	ARP-0001	MREX AR RAIL	1
2	ARP-0001B	MREX AR BARREL NUT	1
3	ARP-0001C	MREX AR BARREL NUT WRENCH	1
4	BARREL SHIM KIT	.001, .003, .005, .010	1
5	RAIL SCREW	6-32 X 5/16 FLAT HEAD SOCKET CAP	6

