



I glue the float tube collar. I use very high sling tension. Permatex Blue is “enough” glue for this job due primarily to the thread pitch and area the threads occupy, but Red makes for a permanent installation. The Blue can be heated to release so the tube can be used again for the next barrel, along with the upper receiver. Oh, and on that topic, there’s been talk for years now that an upper shouldn’t be reused. Not true. That’s the answer. It may be a chore to get all the threads and fitments loosened and the upper re-readied for a new barrel and parts installation, but all those parts can be reused. The only exception is if the upper receiver has a crack, and this crack will usually be near the barrel extension portion of the component.

Make sure you have all these as part of the package. Gas tube, gas tube roll pin; Delta cap, weld spring, retaining clip; sling swivel, sling swivel rivet. And if a stripped bolt was supplied you’ll need all the pieces to assemble it: ejector, ejector spring, ejector roll pin; extractor, extractor spring, extractor pin.

Most tubes come with a swivel that’s either attached (bonus) or must be attached. A standard installation on an A2 handguard cap uses a rivet, and if the swivel must be reused on the new tube, then the rivet must come out. The rivet cannot be reused. There’s a rounded end and an open end on this rivet. Either file down the opened end until the “ears” are gone or, and this will work, just punch it from that end with a punch that fits into the opened area. A solid whack or two will shuck the ears so it will release the swivel.

a good GI parts supplier and it’s nothing tricky, just fully correct. Since the Satern barrel came with a completely assembled bolt, I used it, after disassembly to polish the extractor and work over the ejector.

Since it’s a Service Rifle, nothing changed in the routine-function pieces parts and the only attention paid was to their correctness, deburring, and functional capacity.

Upper and lower are from DPMS and nothing more (or less) than a quality 7075 forged pair. Routine drill-bit-checks of all holes and spring cavities, and overall assessment, were all any got prior to fitting up the hangers-on.

All buffer parts (receiver extension tube, buffer, and spring), butt-stock, and pistol grip are stock stocks from DPMS. The Rock River free-float tube was unboxed with a pair of already modified handguard halves, which were likewise common Thermold items. Some tubes require us to modify the handguards to work with the tube and that process is shown. It’s easy.



This one is from **Accuracy Speaks** and it’s a thing of beauty. It’s also more tedious to install, which is not at all the same as saying it’s difficult. Derrick Martin provides fine instructions. This tube is stainless steel and extremely well made and strong. You will feel a little more like a gunsmith tackling this project because you’ll have to modify some stock parts. The gas tube (maybe) and handguards (surely) both have to be fitted to work within the system. Modifying the handguards is easy. Remove the metal liner and essentially pare away plastic as shown. A hand-held grinder works great for this process.

