



Hey There!

Thanks very much for your purchase of the OCCAM DEFENSE Adjustable Gas Block! This block is 100% made in the USA. The body and windage drum were machined in Moscow, ID, the inconel X750 detent spring was made in a family spring shop in Oregon. The A2 tool steel detent was machined in Ponderay, ID. The 17-4 gas cup was machined on a swiss machine in Texas. The front sight post was sourced from a US manufacturer then post-machined in Moscow, ID. This matters. You are keeping Americans in good paying, meaningful work. At this time the importance of keeping skilled hands in skilled work cannot be overstated. Thank you.

This gas block, as with all of our products, is warranted for life against defects in materials and workmanship. Please take care of it, and it'll take care of you. The only maintenance that you'll need to perform is very occasional cleaning of the gas cup and ports, and if you're feeling generous, drop a couple drops of oil down the detent channel.

We're sorry to live in an age where we need to go over what we hope is obvious:

1. NEVER LET THE MUZZLE CROSS ANYTHING YOU'RE NOT WILLING TO DESTROY
2. TREAT ALL GUNS AS IF THEY ARE LOADED
3. KEEP YOUR FINGER OFF THE TRIGGER UNLESS YOUR SIGHTS ARE ON THE TARGET AND YOU HAVE MADE THE DECISION TO SHOOT
4. ALWAYS BE SURE OF YOUR TARGET AND WHAT IS BEYOND IT
5. SPECIFIC TO THE ADJUSTABLE GAS BLOCK:
  - A. NEVER CROSS THE MUZZLE WHEN ADJUSTING THE GAS BLOCK
  - B. ALWAYS USE A RANGE FLAG (INCLUDED) TO BLOCK THE ACTION OPEN WHEN ADJUSTING OR SERVICING THE GAS BLOCK
  - C. THE GAS KEY CAN GET AS HOT AS 1200F. USE A HEAT RATED GLOVE OR TOOL TO PREVENT POTENTIALLY SEVERE BURNS.

## INSTALLATION TIPS:

1. NECESSARY TOOLS:
  - A. 0-1" MICROMETER THAT READS IN .0001" (MCMMASTER.COM PN 85185A52, CHEAPER USED EBAY)
  - B. TELESCOPE (SNAP) GAUGE FOR 15 MM (MCMMASTER.COM PN 2081A1, CHEAPER ELSEWHERE)
  - C. 15MM ADJUSTABLE LAP (MCMMASTER.COM PN 4548A837)
  - D. DIAMOND COMPOUND (MCMMASTER.COM PN 4776A37)
  - E. ROBERT FORBUS INSTALLATION PIPES (ROBERTFORBUS.COM PN GS-0006)
  - F. DEADBLOW Mallet (HALDER PN AR3366.030 3366.030 AVAILABLE AT AMAZON)
2. MEASURE THE ID OF THE GAS BLOCK AT 4 LOCATIONS (NORTH-SOUTH, EAST-WEST, FORWARD, REAR), AND AVERAGE THE RESULT. THIS IS YOUR INTERNAL DIAMETER (ID). MEASURE TO .0001". TENTHS MATTER HERE.
3. MEASURE THE OUTSIDE DIAMETER OF THE BARREL USING THE SAME METHOD (N/S, E/W, F,R) TO TENTHS. AVERAGE THESE 4 NUMBERS (ADD THEM ALL AND DIVIDE BY 4). THIS IS YOUR OUTSIDE DIAMETER.
4. IF THE BARREL IS MORE THAN .0005-.0008 LARGER THAN THE ID OF THE GAS BLOCK, INCREASE THE ID USING A DRILL, THE LAPP, DIAMOND COMPOUND, AND ANY GOOD OIL. GO SLOW- YOU CAN'T PUT THE MATERIAL BACK. IT MAY PAY TO SAND THE BARREL INSTEAD OF THE BORE-- IT DEPENDS ON YOUR CIRCUMSTANCE.
5. WHEN YOU'RE CLOSE TO .0005" OF INTERFERENCE, PUT ANTISIEZE ON THE BARREL AND BORE, AND TEST FIT USING THE PIPE AND HAMMER. THE BARREL SHOULD BE IN A VISE FOR THIS OPERATION-- NEVER POUND AGAINST THE RECEIVER OR STOCK TANG.
6. THE LOCATION OF THE BLOCK WITH RESPECT TO THE PISTON IS NON-CRITICAL, BUT THE NOMINAL GAP IS .207" BETWEEN THE COUNTERBORE FACE AND THE PISTON FACE.
7. THE GAS BLOCK IS NITRIDED FOR CORROSION RESISTANCE. **YOU'LL NEED A CARBIDE DRILL OR 3MM BOTTOM CUTTING CARBIDE ENDMILL TO CUT THROUGH IT FOR THE CROSS PINS.** AFTER YOU SEE BRIGHT STEEL YOU CAN SWITCH TO A REGULAR COBALT BIT. (MCMMASTER PNs 29605A21, 28765A813, 8803A237, 91595A112)
8. **THESE ARE GENERAL NOTES FOR EXPERIENCED BUILDERS. OCCAM DEFENSE REJECTS ANY AND ALL LIABILITY FOR ANY MISHAP OR INJURY RELATED TO USE OF THESE NOTES.**

# ADJUSTABLE GAS BLOCK VALVE SETTINGS

