

SIG522 BARREL REMOVAL AND REPLACEMENT

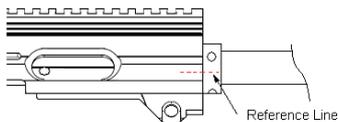
This instruction sheet is designed to assist you in removing and replacing the barrel in your SIG522 COMBO KIT. Please read these instructions and familiarize yourself with the parts and tools required to perform the required steps. Refer to your owner's manual as you carry out the procedure. If you have any doubts about your ability to perform this task you should return the rifle to SIG SAUER for installation or seek the help of a qualified gunsmith. Refer to page 48 of your owner's manual for information in regards to returning the rifle to SIG SAUER Inc.

REMOVING BARREL

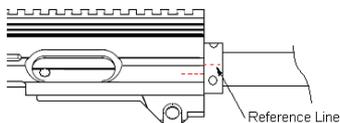
1. Unload and clear the rifle (Refer to owner's manual section 5.0 on page 33).
2. Separate the upper receiver from the lower receiver (Refer to section 7.0 steps 1-9 for the following steps on page 39).
3. Remove the charging handle (7.0 step 5 & 6).
4. Retract the bolt from receiver (7.0 step 7).
5. Remove the hand guards (7.0 steps 8 & 9).
6. Using a 3/32" hex wrench, loosen the set screw on the right side of the gas block.
7. Slide the gas block off the barrel toward the muzzle end (You do NOT need to remove the flash compensator as the gas block will slide over it).
8. Using the supplied barrel nut wrench, unscrew the barrel nut counterclockwise from the upper receiver.
9. Remove the barrel by pulling it straight out of the receiver. Do not wiggle the barrel side to side as this could damage the receiver. If the barrel is tight in the receiver you may insert a wooden dowel in through the rear of the receiver and lightly tap out the barrel making sure you do not damage the ejector.

REPLACING BARREL

1. Clean the threads in the receiver and on the barrel nut.
2. Align the barrel and push the barrel completely into the receiver.
3. Slide the barrel nut over the barrel and tighten by hand until snug.
4. Mark a reference line across the receiver and the barrel nut using a pencil.



5. With the supplied barrel nut wrench, tighten the barrel nut until it moves 1/4" from its original location. Measure the distance between the two lines from where they separate. DO NOT OVERTIGHTEN!



6. Re-attach the gas block aligning the set screw with the slot on the right side of the barrel and tighten it with the 3/32" hex wrench until it is snug.

Refer to the Owner's Manual Section 7.1 on page 41 for the remaining steps.

7. Replace the upper and lower hand guards.
8. Install the bolt and the charging handle.
9. Re-attach the upper and lower receivers.
10. Perform a function check per Section 7.2 page 42.