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INSTALLATION INSTRUCTIONS FOR THE WOP SERVICE RIFLE FLOAT TUBE

1. Disassemble Upper

- A. Remove handguards.
- B. If your front sight is held on with pins you need to remove them. To do this, I like to clamp the barrel in the vise as close to the front sight as possible to get the best support for driving out the pins. You can also remove the gas tube roll pin at this time. Remove the front sight from barrel and remove gas tube from front sight.
- C. Mount the upper receiver in an armorers action block and place in a solid bench vise. With an armorers wrench, remove the barrel nut.

2. Prepare Parts for Assembly

- A. Using a hack saw, cut the sling swivel lugs off the front sight. You may want to mount the front sight on the barrel for this operation and clamp the barrel in your vise. Just be sure not to scratch up your barrel with the saw. Dress up the area with a file, belt sander, or grinder, and then blacken with some instant gun blue.
- B. Remove the heat shields from the handguards. Next, open up the forward end of the handguards to clear the tube. A Dremel with a sanding drum works very well for this. Go slow and check your progress often so you get a good snug fit.
- C. Remove the delta ring and weld spring and install on new barrel nut.

3. Assemble

- A. Use a little grease or anti-seize compound on the receiver threads and install the new barrel nut. Tighten to 35 foot-pounds and then continue tightening until the next notch lines up with the gas tube hole in the upper. If you feel that you can not reach the next notch without using excessive torque, sometimes backing off and

retightening the nut several times will allow you to get a little more rotation on it. You can use the new gas tube as an alignment tool. With the end of the gas tube through the hole in the delta ring, and into the upper receiver, you should be able to place the other end of the gas tube directly over the gas port hole in the barrel without putting any stress on the gas tube. Once you have the barrel nut tightened to your satisfaction install the lock ring and screw it all the way onto the barrel nut.

- B. Screw the float tube onto the barrel nut. You want to screw the tube far enough onto the nut that when the front sight is installed you have clearance between the end of the tube and the front sight base. Keep in mind that if you have a GI contour barrel, the front sight will be about .035 away from the shoulder when you install the pins due to the fact that we no longer have the handguard cap sandwiched between the shoulder and front sight. Keep this in mind when you slide the front sight on to check your clearance. If you have a WOP or WOA barrel, they were contoured with a float tube in mind and you will want to slide the front sight all the way against the shoulder.
- C. Tighten float tube. Once you have determined where the float tube needs to be, unscrew the lock ring until it touches the float tube, but do not tighten. Now, leave the lock ring where it is and unscrew the float tube. Put a small amount of removable loctite on the end of the barrel nut threads. Now, screw the float tube back on the nut. As you screw it on, the loctite will be distributed on the threads. The reason we did it this way was that we do not want any loctite on the lock ring. You will understand why when it is time to rebarrel. After you have the tube screwed back on to your predetermined position, back it off about 20 degrees and hand tighten the lock ring against the tube. Now, using a strap wrench tighten the tube against the lock ring until it is level. You can determine the correct position by sighting along the top of the rifle and through the notch in the end cap for the gas tube. This notch should be in line with the gas port hole in the barrel. You can also check it by making sure the sling swivel lug is level.
- D. Install front sight and secure. Install gas tube and secure with roll pin provided.
- E. Install handguards and go shooting.