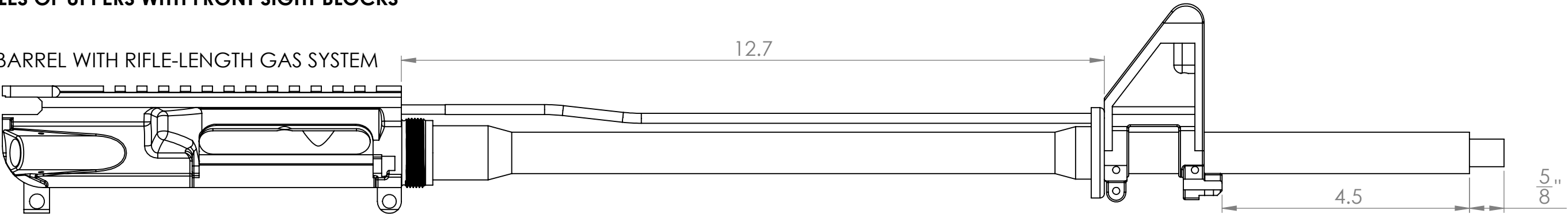
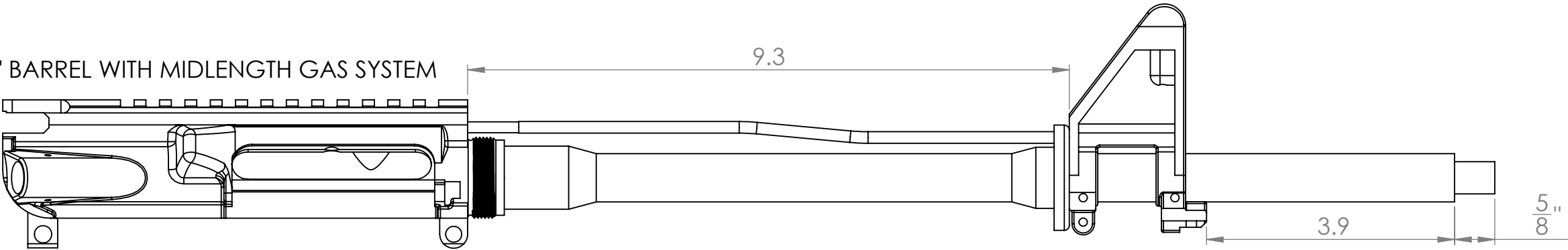


EXAMPLES OF UPPERS WITH FRONT SIGHT BLOCKS

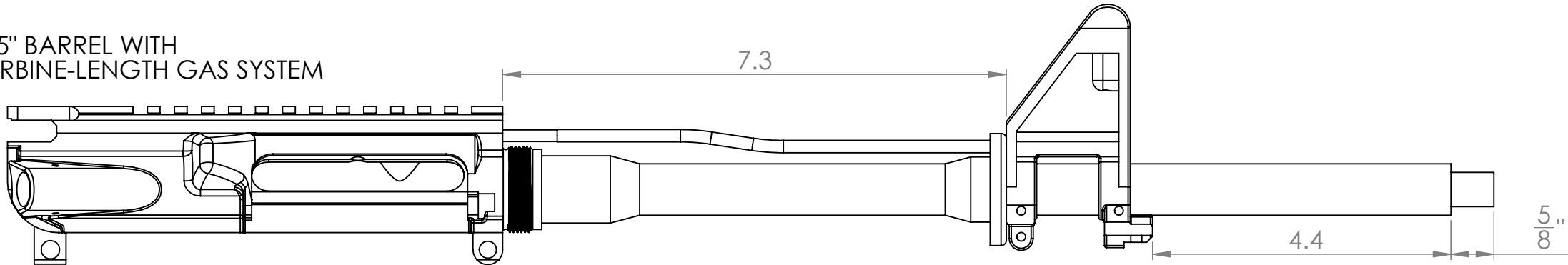
20" BARREL WITH RIFLE-LENGTH GAS SYSTEM



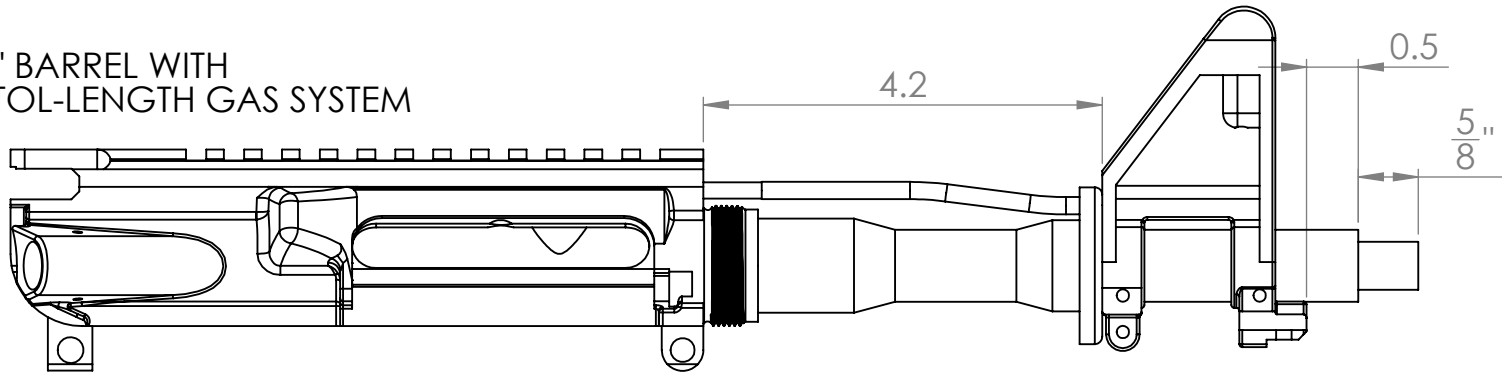
16" BARREL WITH MIDLENGTH GAS SYSTEM



14.5" BARREL WITH CARBINE-LENGTH GAS SYSTEM



7.5" BARREL WITH PISTOL-LENGTH GAS SYSTEM



General formula for distance from bayonet lug to muzzle thread shoulder

Rifle	[Barrel length] - 15.5
Midlength	[Barrel length] - 12.1
Carbine	[Barrel length] - 10.1
Pistol	[Barrel length] - 7.0

UNLESS OTHERWISE SPECIFIED:

DIMENSIONS ARE IN INCHES

TOLERANCES:
FRACTIONAL $\pm 1/128"$
ANGULAR: MACH \pm BEND \pm
TWO PLACE DECIMAL $\pm 0.005"$
THREE PLACE DECIMAL $\pm 0.001"$

BREAK ALL EDGES 1/64"

MATERIAL

FINISH

DO NOT SCALE DRAWING

DRAWN

CHECKED

ENG APPR.

MFG APPR.

Q.A.

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NAME

DATE

TRUE NORTH ARMS CORP.

TITLE:
Upper Barrel and Gas System Dimension Guide

SIZE **B**

DWG. NO.

REV

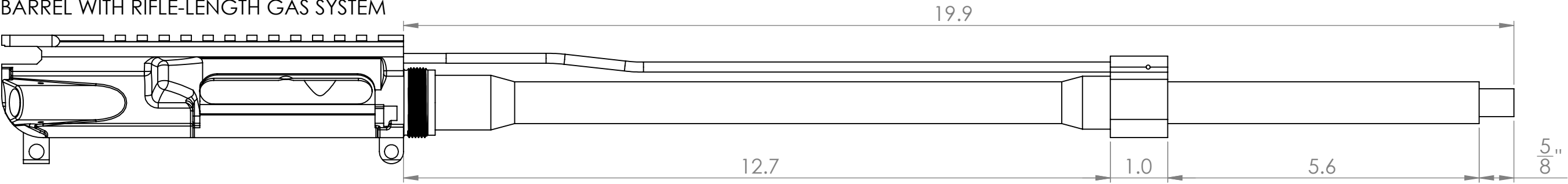
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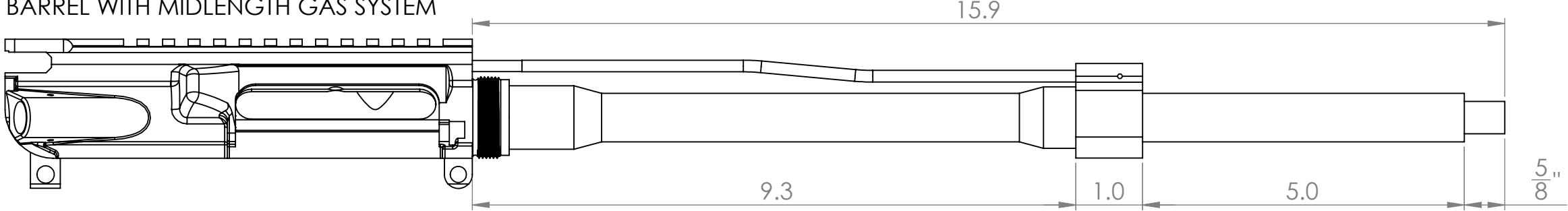
SHEET 1 OF 4

EXAMPLES OF FREE-FLOAT UPPERS

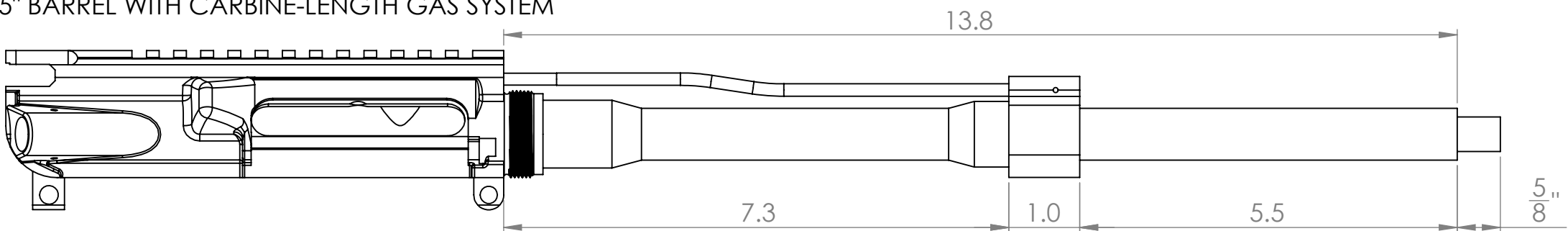
20" BARREL WITH RIFLE-LENGTH GAS SYSTEM



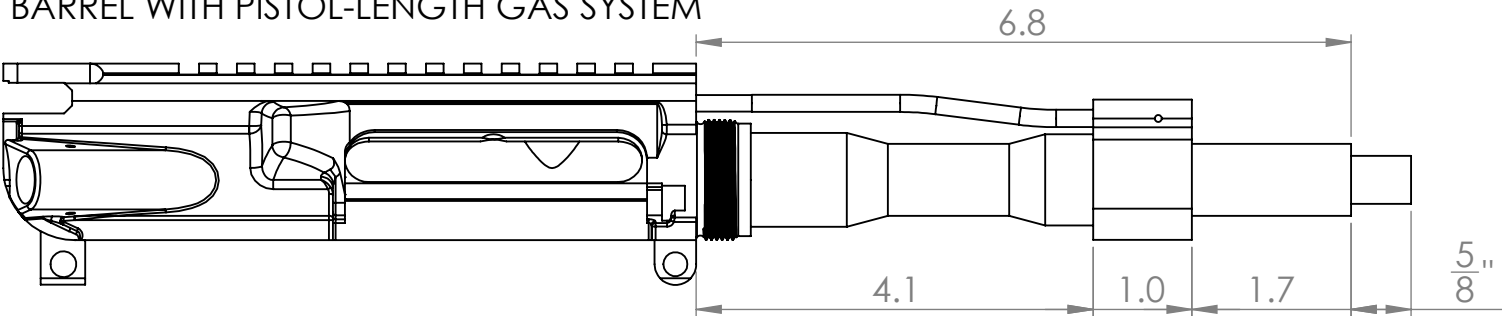
16" BARREL WITH MIDLENGTH GAS SYSTEM



14.5" BARREL WITH CARBINE-LENGTH GAS SYSTEM



7.5" BARREL WITH PISTOL-LENGTH GAS SYSTEM



General formula for distance from gas block to muzzle thread shoulder

Rifle	[Barrel length] - 14.4
Midlength	[Barrel length] - 11
Carbine	[Barrel length] - 9
Pistol	[Barrel length] - 5.9

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DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL ± 1/128" ANGULAR: MACH ± BEND ± TWO PLACE DECIMAL ± 0.005" THREE PLACE DECIMAL ± 0.001"	DRAWN			TITLE: Upper Barrel and Gas System Dimension Guide free-float		
	CHECKED					
	ENG APPR.					
	MFG APPR.					
BREAK ALL EDGES 1/64"	Q.A.			SIZE DWG. NO. REV B		
MATERIAL	PROPRIETARY AND CONFIDENTIAL THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF TRUE NORTH ARMS CORP. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT WRITTEN PERMISSION IS PROHIBITED.					
FINISH						
DO NOT SCALE DRAWING						
SCALE: 1:2		WEIGHT:		SHEET 2 OF 4		

4

3

2

1

1:1 GAS SYSTEM GAUGE

RIFLE-LENGTH GAS SYSTEM

12.7

MIDLENGTH GAS SYSTEM

9.3

CARBINE-LENGTH GAS SYSTEM

7.3

PISTOL-LENGTH GAS SYSTEM

4.1

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DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL $\pm 1/128"$ ANGULAR: MACH \pm BEND \pm TWO PLACE DECIMAL $\pm 0.005"$ THREE PLACE DECIMAL $\pm 0.001"$	DRAWN			TITLE: Upper Barrel and Gas System Dimension Guide free-float	
	CHECKED				
	ENG APPR.				
	MFG APPR.				
BREAK ALL EDGES 1/64"	Q.A.			THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF TRUE NORTH ARMS CORP. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT WRITTEN PERMISSION IS PROHIBITED.	
MATERIAL	PROPRIETARY AND CONFIDENTIAL			SIZE	DWG. NO.
FINISH				B	REV
DO NOT SCALE DRAWING	SCALE: 1:1		WEIGHT:	SHEET 3 OF 4	

4

3

2

1

B

B

A

A

4

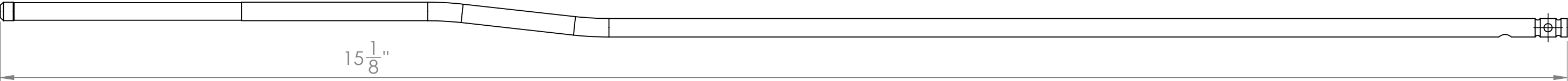
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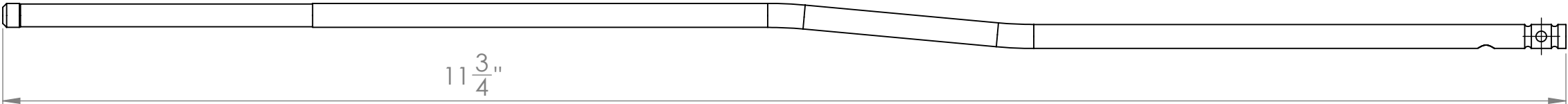
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1:1 GAS TUBE GAUGE

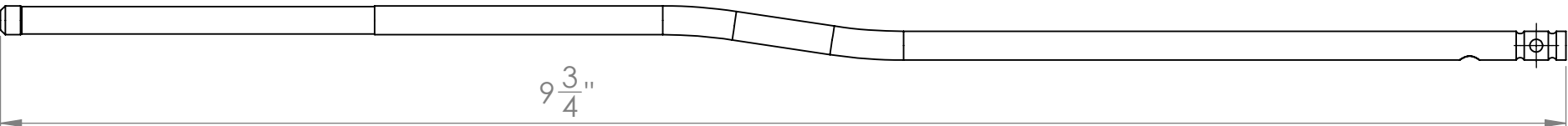
RIFLE



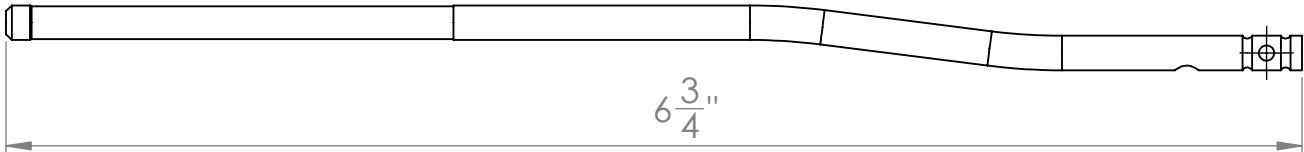
MIDLENGTH



CARBINE



PISTOL



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DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL $\pm 1/128"$ ANGULAR: MACH \pm BEND \pm TWO PLACE DECIMAL $\pm 0.005"$ THREE PLACE DECIMAL $\pm 0.001"$	DRAWN			TITLE: GAS TUBE		
	CHECKED					
	ENG APPR.					
	MFG APPR.					
BREAK ALL EDGES 1/64"	Q.A.			PROPRIETARY AND CONFIDENTIAL THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF TRUE NORTH ARMS CORP. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT WRITTEN PERMISSION IS PROHIBITED.		
MATERIAL				SIZE	DWG. NO.	REV
FINISH				B		
DO NOT SCALE DRAWING				SCALE: 1:1	WEIGHT:	SHEET 4 OF 4

4

3

2

1