

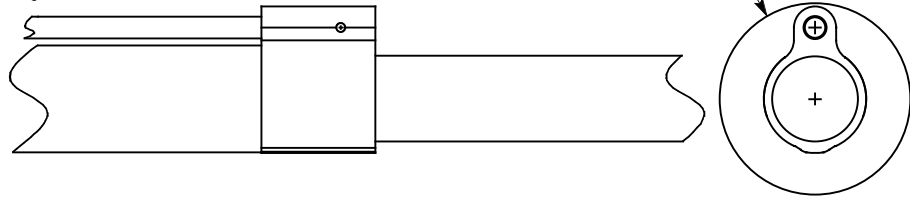
NOTE:

**THIS GAS MANIFOLD IS A PRESS FIT PER MILITARY SPECIFICATION!**

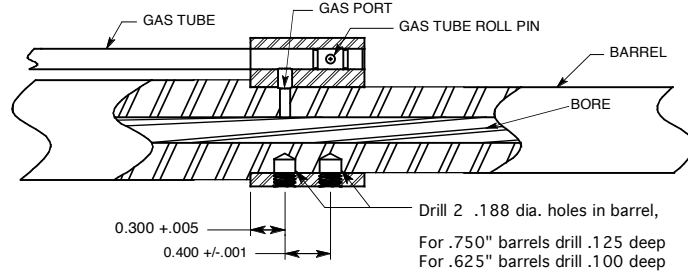
1. ASSEMBLY MUST BE PERFORMED BY A COMPETENT GUNSMITH.
2. DRILL BLIND HOLES 180° FROM GAS PORT.
3. LOCATE FIRST HOLE .300" FROM BARREL SHOULDER.
4. DRILL TO APPROPRIATE DEPTH AS INDICATED BELOW.
5. INSTALL GAS TUBE INTO MANIFOLD.
6. HEAT TI ABOUT 150-170° F
7. INSTALL MANIFOLD ONTO RIFLE, USE OF LOCTITE IS NOT REQUIRED BUT IS RECOMMENDED.

RECOMMENDED TORQUE 20 INCH-POUNDS

Minimum inside diameter of handguard 1.675" Dia.



**WARNING:** This manifold is intended to be a press fit per US Military specifications.



**RECOMENDED:**  
Apply a small amount of #262 (red)  
Loctite to the set screws.

Unless otherwise specified  
Diminions are in Inches  
TOLERANCES:  
ANGLES ± 30°  
FRACTIONS ±.015  
.00- .01  
.000- .005  
.0000- .0005

**BADGER ORDNANCE**

1830 Jasper St  
816 421-4956

N. Kansas City, MO. 64116  
FAX 816 421-4958

**TDX Manifold assy**

Dwg No. 249-69-1 Part No. 249-69 249-70 Date 1 Mar 2022 REV 3

ENGINEER: M. BORDSON

Scale NTS

Mat: Stainless steel

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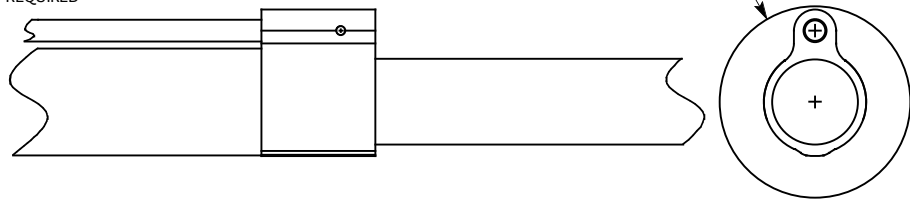
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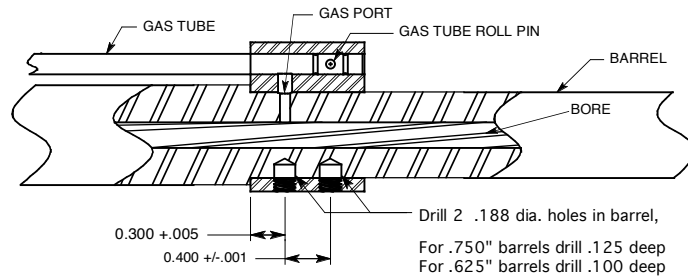
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