

## **Instructions**

This front sight consists of a 3d printed base and elevation screw, and some hardware outlined below. There are 4 options for the front sight post to give the user the option to use a nail (strongest), a piece of filament (high visibility), a printed sight post (easiest), or a printed insert (also high visibility).

This is intended for use on a freefloat handguard. DO NOT use on a railed gas block as most 3d printed materials will not withstand the heat.

## **Hardware**

### **Rail mount Hardware**

- 2 x #6 x 1-1/4" screw
- 2 x #6 nut

### **Front Sight Post**

- 1 x 1" long Panel Board Nail, Painted black (*optional-see sight post options below*)

### **Sight lockdown screw**

- 1 x 1/4"-20 x 3/8" long set screw
- 1 x 1/4"-20 x 1/2" long socket head capscrew
- Or
- 1 x 1/4"-20 threaded rod cut to 3/8" long with a slot cut on the end for flathead screwdriver

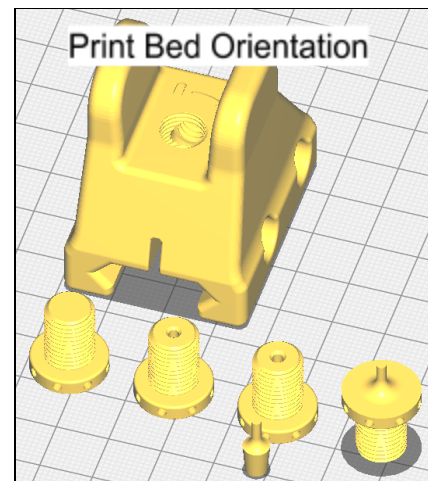
## **Recommended Slicer Settings**

### **Frontsight Base**

- 0.16 mm layer height
- 50%+ infill
- Wall line count = 5
- Supports touching buildplate or tree support

### **Elevation Screw and optional hiviz post**

- 0.12 mm layer height
- 100%+ infill
- Supports for "Printed Post" elevation screw only
- Use very slow print speed (10-20 mm/s) for precision



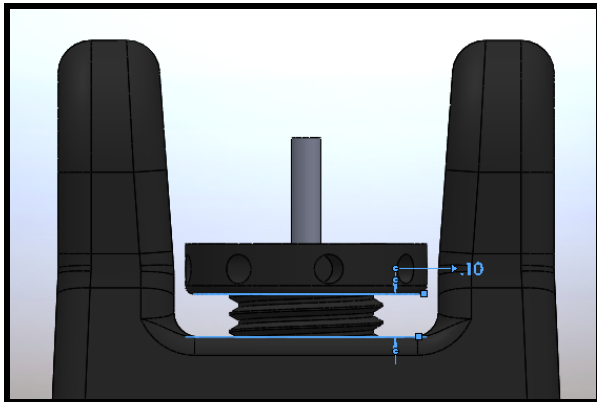
## **Sight Post Options**

There are 4 options for the sight post which determines which elevation screw STL you choose:

- elevation screw nail.STL - Elevation screw has a hole for a panelboard nail to inserted
- elevation screw printed.STL - The sight post is printed onto the elevation screw
- elevation screw filament.STL - Elevation screw has a hole for a bright colored piece of filament to be inserted
- elevation screw hi viz.STL - Elevation screw has a taper hole for a printed sight post to be inserted, can use a bright colored filament \* Also need to print hi viz post.STL

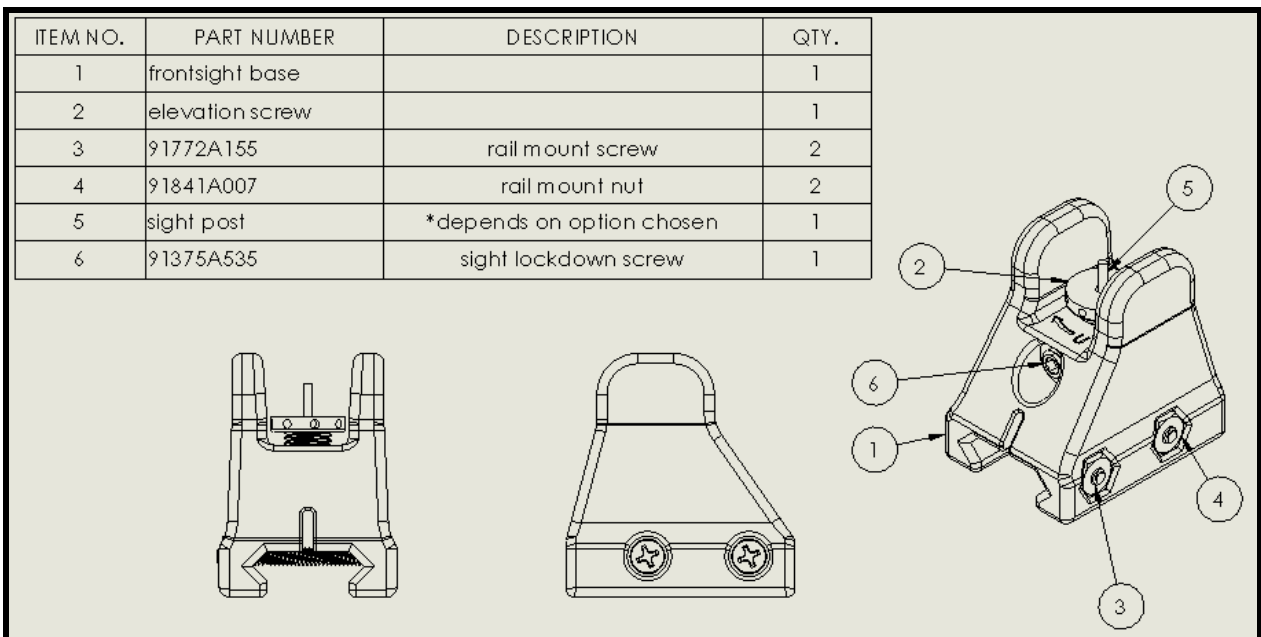
## Post Processing

- Remove all support material
- Install sight base to rail, use mounting hardware to secure
- Prepare elevation screw:
  - elevation screw nail.STL - Carefully hammer in panel board nail, cut off top of nail with approx. 0.25" protruding
  - elevation screw printed.STL - none required
  - elevation screw filament.STL - Insert a piece of filament into the hole. Cut off top with approx. 0.25" protruding. Carefully heat the bottom of the filament with a lighter to expand it or add a drop of glue.
  - elevation screw hi viz.STL - insert hi viz post into elevation screw, glue if necessary
- Thread elevation screw into front sight base. Leave approx. 0.1" from elevation screw shoulder to top of base



- If elevation screw is difficult to turn, use a small allen wrench in the holes on the elevation screw shoulder to assist turning
- Install sight lockdown screw but do not tighten until after sighting in

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	frontsight base		1
2	elevation screw		1
3	91772A155	rail mount screw	2
4	91841A007	rail mount nut	2
5	sight post	*depends on option chosen	1
6	91375A535	sight lockdown screw	1



*Mcmaster-carr hardware part numbers provided in table.*