



AR-7002AB-1: XS® Armorers Block for AR Platforms Gen 2

Thank you for purchasing the XS® Sights AR Armorers Block for Upper and Lower Receivers!

The XS® AR Block is designed to allow the user to secure an AR-15/M4, AR-10, SR-25 or DPMS GII upper receiver in a bench mounted vise for assembly, modification and maintenance.

Caution: Before working on any weapon, ensure it is unloaded and all ammunition removed.

Clamp the block in a bench vise. For an AR-15/M4 or DPMS GII receiver, place the side with three pin holes up. The side with two pin holes is for AR-10 or SR-25 pattern upper receivers.

At the end of the block labeled FRONT, place the pivot pin hole of the upper receiver in the slot. This will give you the maximum clearance for your handguard. The takedown pin hole will then be automatically aligned with the correct pin hole in the upper receiver block for your particular AR variant. Insert the pins provided to secure the upper receiver to the block.



Keep in mind the maximum forces that can be applied to your upper. Using this block will increase its rigidity and make it easier to exceed the maximum forces allowed, resulting in damage. This block should not be used to torque barrel nuts to lightened or non-aluminum uppers such as a Mag Tactical Systems Magnesium Alloy upper.

For mounting of the lower receiver there are two methods:

1. For AR-15 lowers insert the tensioning screw (#8-32) in the screw hole next to the recessed face. Then insert the lower until the mag catch locks on the mag catch cut out. To work on the underside of the lower receiver flip the receiver around and perform the same action until the mag catch latches onto the other mag catch cut out.
2. For AR-10 lowers, you will need the AR-10 lower receiver adapter, insert this into the slot that matches on the AR-10 side of the block. Use the tensioning screw to secure the adapter on to the block then insert the lower onto the block until the mag catch locks on the mag catch cut out.

While not in use, place the pins in the holes on top of the block, keeping the kit together while allowing for flat storage.

Experienced gunsmith? Need more? These holes can be used in conjunction with a mandrel which you would make or have made. Turn a mandrel that is a close slip fit (0.990" - 1.00") in the upper receiver. Drill and tap (2) ¼-28 holes so receiver with mandrel can be snugged down against the block to increase rigidity. The second hole should be drilled and tapped 1.500" from the first hole.