

INSTRUCTIONS 28SEP16

These instructions are for the XCR-L & M Parts Spread Sheets.

X, L, M

As part of the renumbering scheme, all parts numbers begin with X, L, or M. The X parts are used on all XCRs both L and Ms. The L parts are used exclusively on the XCR-Ls; the M parts exclusively on the XCR-Ms. It's very

Type 1, Type 2, and Type 3 Parts

There have been some changes to certain XCR-L Parts. The XCR-L was designed before the XCR-M. In 2014 we changed some of the basic design of the XCR-L parts to be more like the XCR-M parts. Some of these Parts were Bolt, Carrier, and Firing Pin. We also added to Parts – The Carrier Tail and Carrier Tail Retaining Pin.

These new parts for 2014 are referred to as Type 2 parts; while the older parts will be referred to as Type 1 Parts. The same parts in the XCR-M will also be referred to as Type 2 parts even though there were never any

The Type 1, Type 2, and Type 3 designations really refer to a Design type and not necessarily a Part type.

There are other Parts which have changed. The original of these parts are also referred to as Type 1. An Examples of such parts are the XCR-L Lower Receiver and Magazine Release. The original XCR-L Lower Receiver had a Magazine Release which had a square end. The newer one had a round one. So the older one is Type 1 and the newer one is Type 2. The 2014 receivers themselves have a different hole cut in the back for the newer Type 2 Bolt and Carrier. So the 2014 receivers are Type 2. Again, all of XCR-M parts of this kind are Type 2

In 2015 we designed a Type 2 Operating System (OS) composed of a Type 2 Gas Block, Gas Tube, and Operating Rod for the XCR-L Rifle. Some of these parts are identical to those used on the XCR-M and some are not. In this year, we also designed a Type 3 OS consisting of a Type 3 Gas Block, and Gas Tube. The Type 3 OS is compatible with and uses the older Type 1 Operating Rod. The Type 3 OS was designed so that the Gas Block and Gas Tube could be completely buried inside the Upper Receiver for applications like our XCR-L .300 Blackout and

Parts of the same Type in an assembly are meant to go together. For instance, the Type 2 Bolt, Carrier, and Firing Pin assembly go together. Likewise, a Type 1 Gas Block, Operating Rod, and Gas Tube go together. However, a particular rifle may have a Type 2 Bolt Carrier Assembly and a Type 1, 2, or 3 OS Assembly.

There is now a Parts Identification Page on our website which has pictures of the various part Types so that you may easily identify them.

Lastly, many parts in **Bold** type are assemblies and the parts listed below them are included in the assembly.

If you have questions, don't hesitate to contact us.

XCR-M BARRELS PRICE LIST

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XCR-M BARRELS, GAS BLOCKS, MUZZLE DEVICES**Barrels with Gas Blocks and Muzzle Devices**

Part Number	Part Name	Retail
M-BL243-CM08-N160H	XCR-M Barrel .243 Chrome Moly 1/8 Twist Mini 16" Heavy	\$ 600.00
M-BL243-CM08-N160L	XCR-M Barrel .243 Chrome Moly 1/8 Twist Mini 16" Light	\$ 600.00
M-BL243-CM08-N186H	XCR-M Barrel .243 Chrome Moly 1/8 Twist Mini 18.6" Heavy	\$ 600.00
M-BL243-CM08-N186L	XCR-M Barrel .243 Chrome Moly 1/8 Twist Mini 18.6" Light	\$ 600.00
M-BL243-CM08-S160H	XCR-M Barrel .243 Chrome Moly 1/8 Twist Standard 16" Heavy	\$ 600.00
M-BL243-CM08-S160L	XCR-M Barrel .243 Chrome Moly 1/8 Twist Standard 16" Light	\$ 600.00
M-BL243-CM08-S186H	XCR-M Barrel .243 Chrome Moly 1/8 Twist Standard 18.6" Heavy	\$ 600.00
M-BL243-CM08-S186L	XCR-M Barrel .243 Chrome Moly 1/8 Twist Standard 18.6" Light	\$ 600.00
M-BL243-CM08-S200H	XCR-M Barrel .243 Chrome Moly 1/8 Twist Standard 20" Heavy	\$ 600.00
M-BL243-CM08-S200L	XCR-M Barrel .243 Chrome Moly 1/8 Twist Standard 20" Light	\$ 600.00
M-BL260-CM08-N160H	XCR-M Barrel .260 Chrome Moly 1/8 Twist Mini 16" Heavy	\$ 600.00
M-BL260-CM08-N160L	XCR-M Barrel .260 Chrome Moly 1/8 Twist Mini 16" Light	\$ 600.00
M-BL260-CM08-N186H	XCR-M Barrel .260 Chrome Moly 1/8 Twist Mini 18.6" Heavy	\$ 600.00
M-BL260-CM08-N186L	XCR-M Barrel .260 Chrome Moly 1/8 Twist Mini 18.6" Light	\$ 600.00
M-BL260-CM08-S160H	XCR-M Barrel .260 Chrome Moly 1/8 Twist Standard 16" Heavy	\$ 600.00
M-BL260-CM08-S160L	XCR-M Barrel .260 Chrome Moly 1/8 Twist Standard 16" Light	\$ 600.00
M-BL260-CM08-S186H	XCR-M Barrel .260 Chrome Moly 1/8 Twist Standard 18.6" Heavy	\$ 600.00
M-BL260-CM08-S186L	XCR-M Barrel .260 Chrome Moly 1/8 Twist Standard 18.6" Light	\$ 600.00
M-BL260-CM08-S200H	XCR-M Barrel .260 Chrome Moly 1/8 Twist Standard 20" Heavy	\$ 600.00
M-BL260-CM08-S200L	XCR-M Barrel .260 Chrome Moly 1/8 Twist Standard 20" Light	\$ 600.00
M-BL308-CM07-C095H	XCR-M Barrel .308 Chrome Moly 1/7 Twist Micro 9.5" Heavy	\$ 600.00
M-BL308-CM07-C095L	XCR-M Barrel .308 Chrome Moly 1/7 Twist Micro 9.5" Light	\$ 600.00
M-BL308-CM10-N120H	XCR-M Barrel .308 Chrome Moly 1/10 Twist Mini 12" Heavy	\$ 600.00
M-BL308-CM10-N120L	XCR-M Barrel .308 Chrome Moly 1/10 Twist Mini 12" Light	\$ 600.00
M-BL308-CM10-N130H	XCR-M Barrel .308 Chrome Moly 1/10 Twist Mini 13" Heavy	\$ 600.00
M-BL308-CM10-N130L	XCR-M Barrel .308 Chrome Moly 1/10 Twist Mini 13" Light	\$ 600.00
M-BL308-CM10-N147H	XCR-M Barrel .308 Chrome Moly 1/10 Twist Mini 14.7" Heavy	\$ 600.00
M-BL308-CM10-N147L	XCR-M Barrel .308 Chrome Moly 1/10 Twist Mini 14.7" Light	\$ 600.00
M-BL308-CM10-N160H	XCR-M Barrel .308 Chrome Moly 1/10 Twist Mini 16" Heavy	\$ 600.00
M-BL308-CM10-N160L	XCR-M Barrel .308 Chrome Moly 1/10 Twist Mini 16" Light	\$ 600.00
M-BL308-CM10-N186H	XCR-M Barrel .308 Chrome Moly 1/10 Twist Mini 18.6" Heavy	\$ 600.00
M-BL308-CM10-N186L	XCR-M Barrel .308 Chrome Moly 1/10 Twist Mini 18.6" Light	\$ 600.00
M-BL308-CM10-S147H	XCR-M Barrel .308 Chrome Moly 1/10 Twist Standard 14.7" Heavy	\$ 600.00
M-BL308-CM10-S147L	XCR-M Barrel .308 Chrome Moly 1/10 Twist Standard 14.7" Light	\$ 600.00
M-BL308-CM10-S160H	XCR-M Barrel .308 Chrome Moly 1/10 Twist Standard 16" Heavy	\$ 600.00
M-BL308-CM10-S160L	XCR-M Barrel .308 Chrome Moly 1/10 Twist Standard 16" Light	\$ 600.00
M-BL308-CM10-S186H	XCR-M Barrel .308 Chrome Moly 1/10 Twist Standard 18.6" Heavy	\$ 600.00
M-BL308-CM10-S186L	XCR-M Barrel .308 Chrome Moly 1/10 Twist Standard 18.6" Light	\$ 600.00
M-BL308-CM10-S200H	XCR-M Barrel .308 Chrome Moly 1/10 Twist Standard 20" Heavy	\$ 600.00
M-BL308-CM10-S200L	XCR-M Barrel .308 Chrome Moly 1/10 Twist Standard 20" Light	\$ 600.00

Gas Blocks

Part Number	Part Name	Retail
M-GB-2-A	XCR-M Gas Block Type 2 Assembly	\$ 120.00
M-GB-2	XCR-M Gas Block Type 2	\$ 75.00
X-GB-2-DT	XCR Gas Block Detent Type 2	\$ 5.00
X-MP-SP	XCR Multi Purpose Spring	\$ 1.00

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X-GB-SS	XCR Gas Block Set Screw	\$ 1.00
X-GB-2-CP	XCR Gas Block Cap Type 2	\$ 10.00
X-GB-2-PT	XCR Gas Block Piston Type 2	\$ 12.00
X-GB-2-VL	XCR Gas Block Valve Type 2	\$ 15.00
X-GB-2-VC	XCR Gas Block Valve Clip Type 2	\$ 1.00

Muzzle Devices

Part Number	Part Name	Retail
X-FH-5824	XCR A2 Flash Hider 5/8x24 (For 6.5, 6.8, 7.62x39, & .300)	\$ 20.00
X-FH-1228	XCR A2 Flash Hider 1/2x28 (for 5.56 & 5.45x39)	\$ 15.00
X-MB-58-3S	XCR Muzzle Brake 5/8x24 3 Slot	\$ 55.00
X-MB-58-2S	XCR Muzzle Brake 5/8x24 2 Slot	\$ 50.00
X-MB-12-3S	XCR Muzzle Brake 1/2x28 3 Slot	\$ 55.00
X-MB-12-2S	XCR Muzzle Brake 1/2x28 2 Slot	\$ 50.00
X-BL-CW-5824	XCR Crush Washer 5/8x24	\$ 3.00
X-BL-CW-1228	XCR Crush Washer 1/2x28	\$ 2.00

XCR-M LOWER RECEIVER PARTS LIST

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XCR-L LOWER WITH ALL INTERNAL PARTS

Part Number	Part Name	Retail
M-LR-2-S-A	XCR-M Type 2 Lower Assembly	\$ 500.00

XCR-M Lower Parts

Part Number	Part Name	Retail
M-LR-2-S	XCR-M Lower Receiver Type 2	\$ 300.00
M-LR-MP	XCR-M Main Pin	\$ 4.00
X-LR-PC	XCR Lower Receiver Main Pin Clip	\$ 1.00
X-LR-AP-CP	XCR Axis Pin Cotter Pin	\$ 2.00
X-LR-BC-2	XCR Bolt Catch Type 2	\$ 16.00
X-LR-BC-BT	XCR Bolt Catch Foot Bolt	\$ 2.00
X-LR-BC-FT	XCR Bolt Catch Foot	\$ 12.00
X-LR-2-DC	XCR Disconnect Type 2	\$ 33.00
X-LR-DC-SP	XCR Disconnect Spring	\$ 2.00
X-LR-2-HM	XCR Hammer Type 2	\$ 33.00
X-LR-HM-AP	XCR Hammer Axis Pin	\$ 3.00
X-LR-HM-SP	XCR Hammer Spring Regular	\$ 5.00
X-LR-MR-BU	XCR Magazine Release Button	\$ 3.00
X-LR-MR-SP	XCR Magazine Release Spring	\$ 1.00
X-LR-PG-A2	XCR Pistol Grip	\$ 7.00
X-LR-PG-BT	XCR Grip Bolt	\$ 3.00
X-LR-PG-LW	XCR Grip Lock Washer	\$ 1.00
X-LR-2-SS	XCR Safety Selector Body Type 2	\$ 20.00
X-LR-2-SS-AM	XCR Safety Selector Ambi Lever Type 2	\$ 10.00
X-LR-SS-BT	XCR Safety Selector Ambi Bolt	\$ 1.00
X-LR-SS-DT	XCR Safety Selector Detent	\$ 1.00
X-LR-SS-SP	XCR Safety Selector Spring	\$ 1.00
X-LR-TR-2	XCR Trigger Type 2	\$ 33.00
X-LR-TR-AP	XCR Trigger Axis Pin	\$ 3.00
X-LR-TR-SP	XCR Trigger Spring	\$ 3.00
M-LR-2-MR-A	XCR-M Magazine Release Type 2 Assembly	\$ 46.00

XCR-M Lower Subassemblies

Part Number	Part Name	Retail
M-LR-2-MRA-A	M Magazine Release Type 2 Ambi Assembly	\$ 46.00
M-LR-2-MR-A	XCR-M Magazine Release Type 2	\$ 30.00
X-LR-MR-RP	XCR Magazine Release Roll Pin	\$ 1.00
X-LR-MR-AB	XCR Magazine Release Ambi Button	\$ 15.00

XCR-M UPPER RECEIVERS**XCR-M Upper Receiver Stripped**

Part Name	Part Number	Retail
M-UR-K-S	XCR-M Upper Keymod Standard	\$ 570.00
M-UR-K-N	XCR-M Upper Keymod Mini	\$ 570.00
M-UR-K-C	XCR-M Upper Keymod Micro	\$ 570.00
M-UR-4-S	XCR-M Upper 4-Rail Standard	\$ 570.00
M-UR-4-N	XCR-M Upper 4-Rail Mini	\$ 570.00
M-UR-4-C	XCR-M Upper 4-Rail Micro	\$ 570.00
M-UR-2-S	XCR-M Upper 2-Rail Standard	\$ 570.00
M-UR-2-C	XCR-M Upper 2-Rail Micro	\$ 570.00
M-UR-2-N	XCR-M Upper 2-Rail Mini	\$ 570.00

XCR-M Upper Receiver Parts & Kits

Part Name	Part Number	Retail
M-UR-K	XCR-L Upper Receiver Kit	\$ 67.00
X-UR-BR-BT	XCR Barrel Retention Bolt	\$ 7.00
M-UR-CS-A	XCR-L Charging Slide Assembly	\$ 20.00
M-UR-CH-K	XCR-M Charging Handle Kit	\$ 12.00
X-UR-BD-BT	XCR Brass Deflector Bolt	\$ 1.00
X-UR-BR-HC	XCR Barrel Retention Helicoil	\$ 4.00
X-UR-BD-HC	XCR Brass Deflector Helicoil	\$ 2.00
M-UR-BD	XCR-M Brass Deflector	\$ 5.00
M-UR-EJ-K	XCR-M Ejector Kit	\$ 16.00

Part Name	Part Number	Retail
M-UR-CH-K	XCR-M Charging Handle Kit	\$ 12.00
X-UR-CH-KN	XCR Charging Handle Knob	\$ 6.00
X-UR-CH-RP	XCR Charging Handle Roll Pin	\$ 1.00
M-UR-CH-SH	XCR-M Charging Handle Shaft	\$ 5.00

Part Name	Part Number	Retail
M-UR-CS-A	XCR-M Charging Slide Assembly	\$ 20.00
X-UR-CH-SP	XCR Charging Handle Spring	\$ 2.00
X-UR-CS-DT	XCR Charging Slide Detent	\$ 3.00
X-UR-CS-RP	XCR Charging Slide Roll Pin	\$ 1.00
M-UR-CS	XCR-L Charging Slide	\$ 14.00

Part Name	Part Number	Retail
M-UR-EJ-K	XCR-M Ejector Kit	\$ 16.00
M-UR-EJ	XCR-M Ejector	\$ 12.00
X-UR-EJ-BT	XCR Ejector Bolts (2X Required)	\$ 3.00
X-UR-EJ-LW	XCR Ejector Lock Washer (2X Required)	\$ 1.00

XCR-M BOLTS, FIRING PINS & CARRIERS**Bolts**

Part Number	Part Name	Retail
M-BT-2-308-A	XCR-M Bolt .308 Type 2 Assembly	\$ 125.00
M-BT-2-308	XCR-M Bolt .308 Type 2	\$ 105.00
M-BT-2-EX308	XCR-M .308 Extractor	\$ 14.00
X-BT-EX-SP	XCR Bolt Extractor Spring	\$ 3.00
X-BT-EX-DT	XCR Bolt Extractor Detent	\$ 3.00

Firing Pins

Part Number	Part Name	Retail
M-FP-2-A	XCR-M Firing Pin Assembly	\$ 30.00
M-FP-2	XCR-M Firing Pin Type 2	\$ 9.00
M-FP-2-CT	XCR-M Carrier Tail Type 2	\$ 15.00
M-FP-SP	XCR-M Firing Pin Spring	\$ 4.00
X-FP-RP	XCR Firing Pin Roll Pin	\$ 2.00

Carriers

Part Number	Part Name	Retail
L-BC-2-A	XCR-M Bolt Carrier Type 2 Assembly	\$ 85.00
M-BC-2	XCR-M Carrier Type 2	\$ 72.00
M-BC-2-OR	XCR-M Bolt Carrier O-Ring Type 2	\$ 1.00
M-BC-2-RB	XCR-M Recoil Buffer Type 2	\$ 9.00
M-BC-2-RP	XCR-M Carrier Pin Type 2	\$ 3.00

XCR-M OPERATING SYSTEM (OS) ASSEMBLIES & PARTS

Note: When ordering Operating System (OS) parts, make sure that you match the length (Standard, Mini, Micro) with your gas port position on your barrel (Standard, Mini, or

XCR-M Operating Rod Type 2 Assemblies

Part Number	Part Name	Retail
M-OR-2-S-A	XCR-M Operating Rod Standard Type 2 Assembly	\$ 75.00
M-OR-2-N-A	XCR-M Operating Rod Mini Type 2 Assembly	\$ 75.00
M-OR-2-C-A	XCR-M Operating Rod Micro Type 2 Assembly	\$ 75.00

Oprod Type 2 Parts

Part Numbr	Part Name	Retail
M-OR	XCR-M Operating Rod	\$ 60.00
M-OR-2-PS-S	XCR-M Piston Standard Type 2	\$ 15.00
M-OR-2-PS-N	XCR-M Piston Mini Type 2	\$ 15.00
M-OR-2-PS-C	XCR-M Piston Micro Type 2	\$ 15.00

Gas Tubes Type 2 Parts

M-GT-2-S	XCR-M Gas Tube Standard Type 2	\$ 20.00
M-GT-2-N	XCR-M Gas Tube Mini Type 2	\$ 20.00
M-GT-2-C	XCR-M Gas Tube MicroType 2	\$ 20.00

Recoil Spring Asm & Parts

Part Number	Part Name	Retail
M-RS-A	XCR-M Recoil Spring Assembly	\$ 60.00
M-RS	XCR-M Recoil Spring	\$ 7.00
M-RS-GI	XCR-M Recoil Spring Guide Inner	\$ 15.00
M-RS-BU-A	XCR-M Recoil Spring Guide with Button	\$ 31.00
X-RS-GC	XCR Recoil Spring Guide Clip	\$ 7.00

XCR FAST STOCK & PARTS

Part Number	Part Name	Retail
X-FS-1-A	XCR Fast Stock Assembly Type 1	\$ 225.00
X-FS-3-A	XCR Fast Stock Assembly Type 3	\$ 275.00
X-ST-M4-AD	XCR M4 Stock Adapter	\$ 75.00
X-ST-AR-AD	XCR AR Stock Adapter	\$ 75.00