

## **Arisaka Zero Retention Clamp – Spear 308**

**03/01/2024**

*Patent Pending*

There are several versions of the Zero Retention Clamp (ZRC). This document pertains only to the version designed for the MCX Spear 308 with OEM handguard, as shown in the following images.

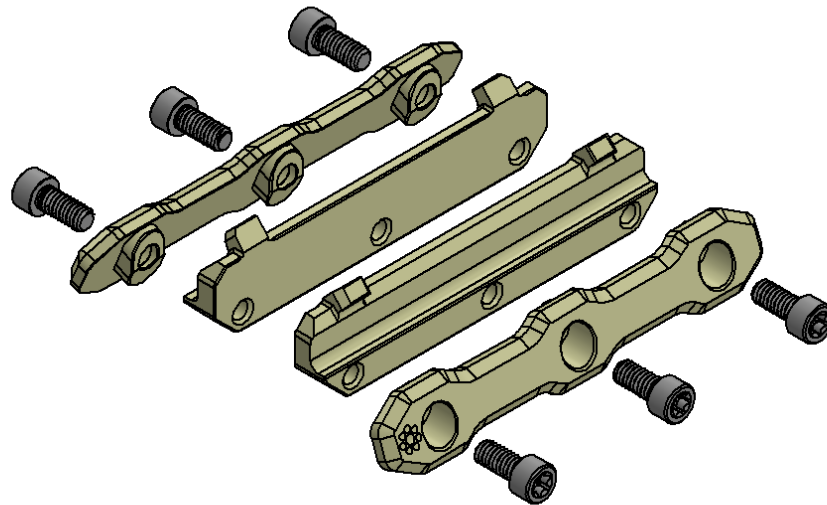
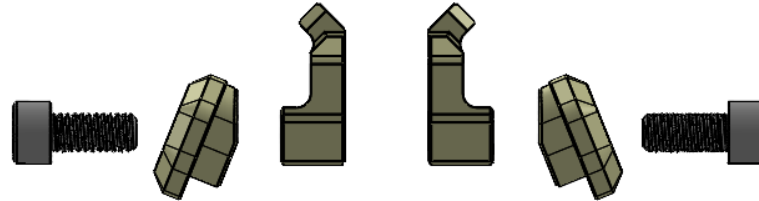
The ZRC for the MCX Spear 308 consists of two inner and two outer clamps, six 8-32x3/8" Torx socket cap head screws, and two 8-32x3/8" Torx flat head screws.



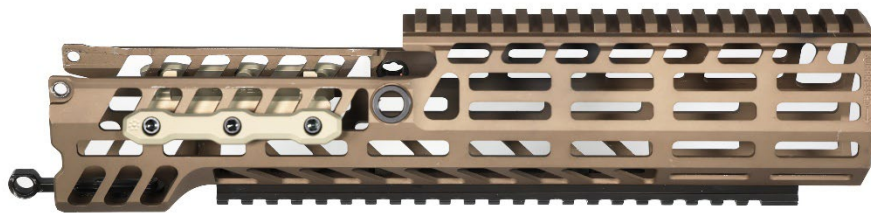
### Installation:

1. Always keep firearms pointed in a safe direction and treat them as if they are loaded. Clear the firearm, verify the chamber is empty, and ensure no live ammunition is present.
2. Remove the two button head screws at the rear of the handguard using a T15 Torx driver. These will no longer be used.
3. Push out the front takedown pin and slide the handguard off the upper receiver.

4. Arrange the inner and outer clamps. The proper orientation is shown below with the inner clamp hooks pointing up, and the outer clamps angled inward. There is no right or left set; each inner clamp is the same and each outer clamp is the same. The Arisaka dot logo will be towards the muzzle on one side and towards the rear on the other.



5. Loosely install an inner and outer clamp on each side of the handguard using the 8-32x3/8" Torx socket head cap screws. The two hooks on each inner clamp should be facing up. Leave the clamps loose so they can move freely within the vent slots and rest as shown.



6. Line up the barrel with the handguard and slide it on until the handguard engages the extended upper receiver, as shown. You may need to adjust the position of the ZRC clamps slightly to clear the gas block.



7. Continue to slide the handguard onto the upper receiver. When the handguard is approximately 1/2" from being fully seated, it will be necessary to gently maneuver the clamp on each side inward and upward so that they clear the barrel extension. You will then be able to seat the handguard fully to the rear.



8. Press the front takedown pin into place and install the two new 8-32x3/8" Torx flat head screws into the holes at the rear of the handguard. Torque to 20 inch lbs.



9. Press the ZRC clamps on each side inward toward the barrel and upwards until you see the two hooks on the inner clamps through the upper vent holes, as shown. Continue to hold the clamp in place while tightening the three screws on each side until finger tight.



10. Torque the Torx socket head cap screws in alternating order on both sides of the handguard evenly. The preferred order is center left, center right, front left, front right, rear left, rear right. You should follow this order sequentially, progressively tightening each screw several times until you reach 25 inch lbs.
11. Test for zero shift. This is most easily done with a laser aiming module that has a visible aiming laser. If the visible aiming laser is adjusted to match the reticle in the primary optic, you can test for deflection and/or zero shift by applying pressure to the handguard and watching the laser dot diverge from the reticle. Once pressure is removed, the laser dot should return to the original position. If it does not, verify that the installation was done correctly and increase the torque on the clamping screws to 30 inch lbs.