KeyMod™ vs. M-LOK™
Modular Rail System Comparison
Abstract #19427
Presented By: Caleb McGee
Date: 4 May 2017
Background

History
• The MIL-STD-1913 Accessory Mounting Rail was standardized in 1995.
• MIL-STD-1913 Quad-rail Handguards currently in use.
  – MK18 Mod 1 Carbine.
  – Upper Receiver Group (URG).
• Industry developed, low profile handguards with “as needed” accessory mounting panels.
  – Rail panels can be positioned using holes machined into the handguard.
Background

KeyMod™

- Originated by VLTOR Weapon Systems and released in 2012.
- Developed as a standardized accessory mount platform.
- Supports direct mounting of accessories and 1913 accessory rail sections.
- Current civilian market moving towards direct mounting of accessories.
- KeyMod™ accessories interface with KeyMod™ handguards by:
  - Inserting mounting nuts of accessory through the large portion of the KeyMod™ slot.
  - Sliding the accessory fully forward in smaller front portion of key shaped slot.
  - Tightening accessory bolts to secure in place.
Background

M-LOK™
- Originated and released by MAGPUL in early 2015.
- MAGPUL cites improved performance in polymer accessories using M-LOK™.
- Allows for mounting of accessory rails to low-profile handguard designs.
- Functions by passing mounting T-nuts on an accessory through the slots in the handguard.
- Tightening the accessory bolts rotates the T-nuts to rotate 90° and lock, allowing the bolts to be torqued.
Overview

Objectives

- Qualitative and quantitative comparisons of both the KeyMod™ and M-LOK™ accessory mounting systems.
- Recommendation of which system provides superior performance based on a comparative analysis of the two mounting options.

Scope

- Determination on whether KeyMod™ and M-LOK™ is the superior accessory mounting system in regards to repeatability, endurance, rough handling, drop testing, and failure load.
- Testing was not necessarily focused on simulating exact operational requirements; instead, the tests were designed to provide a direct comparison between the two systems in situations that may far exceed standard field conditions.
Sample Arrangement

Handguards
• Three manufacturers selected that fabricate the same handguard in both KeyMod™ and M-LOK™ variants.
• Three KeyMod™ and three M-LOK™ handguards per manufacturer.
• Total of eighteen handguards used for rail system evaluation.
Sample Arrangement

Weapon Sample ID

- Each handguard was installed on a 14.5-inch URG in place of the MIL-STD-1913 quad-rail.
- Each URG and respective handguard were labeled with a Weapon ID.

<table>
<thead>
<tr>
<th>Weapon ID</th>
<th>LRG</th>
<th>URG</th>
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</thead>
<tbody>
<tr>
<td>A1</td>
<td>M4A1</td>
<td>Aero Precision - KeyMod™</td>
</tr>
<tr>
<td>A2</td>
<td>M4A1</td>
<td>Aero Precision - KeyMod™</td>
</tr>
<tr>
<td>A3</td>
<td>M4A1</td>
<td>Aero Precision - KeyMod™</td>
</tr>
<tr>
<td>A4</td>
<td>M4A1</td>
<td>Aero Precision - M-LOK™</td>
</tr>
<tr>
<td>A5</td>
<td>M4A1</td>
<td>Aero Precision - M-LOK™</td>
</tr>
<tr>
<td>A6</td>
<td>M4A1</td>
<td>Aero Precision - M-LOK™</td>
</tr>
<tr>
<td>B1</td>
<td>M4A1</td>
<td>Midwest Industries - KeyMod™</td>
</tr>
<tr>
<td>B2</td>
<td>M4A1</td>
<td>Midwest Industries - KeyMod™</td>
</tr>
<tr>
<td>B3</td>
<td>M4A1</td>
<td>Midwest Industries - KeyMod™</td>
</tr>
<tr>
<td>B4</td>
<td>M4A1</td>
<td>Midwest Industries - M-LOK™</td>
</tr>
<tr>
<td>B5</td>
<td>M4A1</td>
<td>Midwest Industries - M-LOK™</td>
</tr>
<tr>
<td>B6</td>
<td>M4A1</td>
<td>Midwest Industries - M-LOK™</td>
</tr>
<tr>
<td>C1</td>
<td>M4A1</td>
<td>Seekins - KeyMod™</td>
</tr>
<tr>
<td>C2</td>
<td>M4A1</td>
<td>Seekins - KeyMod™</td>
</tr>
<tr>
<td>C3</td>
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<td>Seekins - M-LOK™</td>
</tr>
<tr>
<td>C6</td>
<td>M4A1</td>
<td>Seekins - M-LOK™</td>
</tr>
</tbody>
</table>
Repeatability

Objective
- Quantify repeatability by Point of Aim (POA) shift measurement of accessory rails from repeated installation and removal.

Equipment
- 18 URGs: 3 per handguard configuration
- 3 KeyMod™ 9-slot accessory rails
- 3 M-LOK™ 9-slot accessory rails
- 1 Vice with mounting blocks
- 1 Grid target: 5 graduations per inch
- 1 SL-150M laser boresighter
- 1 Laser sight
Repeatability: Procedure

Procedure

• URG mounted in vice and aimed at grid target.
• 9-slot accessory rail installed on handguard per respective manufacturer instructions.
• Laser sight mounted on a 9-slot accessory rail.
• SL-150M laser boresighter inserted in muzzle end of barrel.
• Laser sight zeroed to boresighter laser POA.
• Accessory rail removed and reinstalled on the handguard.
  – Without removing laser sight from accessory rail.
• Measure distance between projected boresighter laser point and laser sight point.
• Re-installation repeated for total of 5 measurements.
  – Without re-zeroing the laser sight.
Repeatability: Results

Results – POA Shift

- POA shift measurements were converted from Cartesian coordinates to angular measurements.
- Reported as minimum, maximum, and average POA shift of the 5 measurements per handguard in minutes of angle (MOA).

\[
\theta = \tan^{-1}\frac{\sqrt{\Delta x^2 + \Delta y^2}}{R}
\]

where:
\(\Delta x\) is the horizontal POA shift distance
\(\Delta y\) is the vertical POA shift distance
\(R\) is the range from weapon to target

\[
\theta_{MOA} = \theta_{deg} \times 60(MOA/deg)
\]

<table>
<thead>
<tr>
<th>Weapon ID</th>
<th>System</th>
<th>POA Shift (MOA)</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>Avg.</td>
</tr>
<tr>
<td>A1</td>
<td>KeyMod™</td>
<td>4.3</td>
</tr>
<tr>
<td>A2</td>
<td>KeyMod™</td>
<td>4.3</td>
</tr>
<tr>
<td>A3</td>
<td>KeyMod™</td>
<td>4.6</td>
</tr>
<tr>
<td>A4</td>
<td>M-LOK™</td>
<td>2.2</td>
</tr>
<tr>
<td>A5</td>
<td>M-LOK™</td>
<td>0.7</td>
</tr>
<tr>
<td>A6</td>
<td>M-LOK™</td>
<td>2.3</td>
</tr>
<tr>
<td>B1</td>
<td>KeyMod™</td>
<td>4.2</td>
</tr>
<tr>
<td>B2</td>
<td>KeyMod™</td>
<td>5.7</td>
</tr>
<tr>
<td>B3</td>
<td>KeyMod™</td>
<td>11.8</td>
</tr>
<tr>
<td>B4</td>
<td>M-LOK™</td>
<td>0.9</td>
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<td>B5</td>
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<td>2.1</td>
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<td>B6</td>
<td>M-LOK™</td>
<td>0.8</td>
</tr>
<tr>
<td>C1</td>
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<td>2.6</td>
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<td>0.1</td>
</tr>
<tr>
<td>C6</td>
<td>M-LOK™</td>
<td>2.1</td>
</tr>
</tbody>
</table>
Repeatability: Analysis

Analysis – POA Shift

- KeyMod™ POA shift:
  - Absolute minimum: 0.2 MOA
  - Absolute maximum: 14.6 MOA
  - System average: 4.9 MOA

- M-LOK™ POA shift:
  - Absolute minimum: 0.0 MOA
  - Absolute maximum: 6.6 MOA
  - System average: 1.3 MOA
Repeatability: Analysis

Analysis – M-LOK™ Installation Sensitivity

- M-LOK™ repeatability dependent on correct installation.
- Tested worst case repeatability incurred when M-LOK™ accessory is not properly installed per manufacturer instructions.
  - Installed M-LOK™ accessory rail per manufacture instructions and zeroed laser sight.
  - Removed and reinstalled accessory rail at maximum angle allowed within the M-LOK™ slot.
  - Improperly installed average POA shift: 18.4 MOA
  - Properly installed average POA shift: 1.3 MOA

<table>
<thead>
<tr>
<th>Weapon ID</th>
<th>POA Shift (MOA)</th>
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<tbody>
<tr>
<td></td>
<td>Left</td>
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<tr>
<td>A4</td>
<td>21.4</td>
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<td>A6</td>
<td>27.8</td>
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<tr>
<td>B4</td>
<td>19.3</td>
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<tr>
<td>B5</td>
<td>19.3</td>
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<tr>
<td>B6</td>
<td>17.1</td>
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<td>C4</td>
<td>14.6</td>
</tr>
<tr>
<td>C5</td>
<td>13.3</td>
</tr>
<tr>
<td>C6</td>
<td>17.1</td>
</tr>
</tbody>
</table>
Endurance

Objective

- Evaluate mounting systems in an environment simulating M4A1 full-auto fire in an aggressive firing schedule.
  - Cost and time savings.
  - Avoids cook-off hazards incurred above 120 rounds during live full-auto fire.

Equipment

- 1 Cyclic load machine
- 1 M4A1 lower receiver
- 6 URGs: 1 per handguard configuration
- 3 KeyMod™ 5-slot accessory rails
- 3 KeyMod™ 9-slot accessory rails
- 3 M-LOK™ 5-slot accessory rails
- 3 M-LOK™ 9-slot accessory rails
- 1 Weapon light, rail-mounted
- 1 Laser sight, unserviceable
- 1 Flash hider shim set
Endurance: Procedure

Procedure

• Barrel threaded to barrel adapter plate on the cyclic load machine.
  – Flash hider shims used to control weapon orientation.
• Weapon light mounted to 5-slot accessory rail at 9 o’clock position.
• Laser sight mounted to 9-slot accessory rail at 3 o’clock position.
• Accessory rail fastener inspected periodically using index marks.
Endurance: Procedure

Procedure (cont’d)

- Aggressive firing schedule at full-auto firing rate.
  - 0.15 in displacement per cycle.
    - Generate recoil inertial forces.
  - 17 Hz cycle rate.
    - Simulate 1020 rounds per minute (RPM).
  - 30 cycle bursts separated by 2 second pauses.
    - Simulate live fire of one 30-round magazine with a pause to change magazines.
  - 17 simulated magazines or 510 simulated rounds per iteration.
  - 20 Iterations for 10,200 simulated rounds per handguard.

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Setting</th>
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<tr>
<td>Waveform</td>
<td>Sinusoidal</td>
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<tr>
<td>Frequency</td>
<td>17 Hz</td>
</tr>
<tr>
<td>Amplitude</td>
<td>0.15 in</td>
</tr>
<tr>
<td>No. of Cycles</td>
<td>30 Cycles</td>
</tr>
</tbody>
</table>
Endurance: Results & Analysis

Results & Analysis

• No failures or fastener loosening observed for KeyMod™ or M-LOK™ systems.
• Both KeyMod™ and M-LOK™ demonstrated ability to withstand cyclic forces at the M4A1 maximum cyclic rate.
  – All handguards resisted system failure and fastener loosening.
Rough Handling

Objective
• Evaluate mounting system performance when subjected to forces in excess of typical usage and endurance test loading.

Equipment
• 1 Cyclic Load Machine
• 1 M4A1 lower receiver
• 6 URGs: 1 per handguard configuration
• 3 KeyMod™ 5-slot accessory rails
• 3 M-LOK™ 5-slot accessory rails
• 1 Weapon light, rail-mounted
• 1 Flash hider shim set
Rough Handling: Procedure

Procedure

- Weapon light mounted to 5-slot accessory rail at 9 o’clock position.
- Test parameters setup to generate a triangular waveform.
  - Triangular waveform generates larger peak loads than sinusoidal waveforms at the same frequency and amplitude.
  - Sharp peaks require higher peak acceleration of actuator to reverse direction.
- 4 iterations of increasing peak load.
  - Frequency held constant across all iterations.
  - Displacement iteratively increased to produce higher peak loads.
  - First iteration has similar peak loads to endurance testing.
  - Fourth iteration produces the maximum load produced by cyclic load machine.
    - Limited by the relatively mass of the M4A1.

![Sine and Triangle Waveforms](image-url)
Rough Handling: Results

Results

• The position vs. time and load vs. time curves for each iteration recorded.
  – Similar results observed for each handguard tested.

• Iteration 1:
  – Input displacement: 0.1 in
  – Actual displacement: <0.1 in
  – Peak load: ~200 lbf

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Setting</th>
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<tbody>
<tr>
<td>Waveform</td>
<td>Triangle</td>
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<tr>
<td>Frequency</td>
<td>17 Hz</td>
</tr>
<tr>
<td>Amplitude</td>
<td>0.1 in</td>
</tr>
<tr>
<td>No. of Cycles</td>
<td>30 Cycles</td>
</tr>
</tbody>
</table>

Endurance Test – Handguard A2 – Iteration 1 – Position vs. Time & Load vs Time – First 30 Rounds
Rough Handling: Results

Results (cont’d)

• Iteration 2:
  – Input displacement: 0.2 in
  – Actual displacement: 0.13 – 0.14 in
  – Peak load: ~300 lbf

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Setting</th>
</tr>
</thead>
<tbody>
<tr>
<td>Waveform</td>
<td>Triangle</td>
</tr>
<tr>
<td>Frequency</td>
<td>17 Hz</td>
</tr>
<tr>
<td>Amplitude</td>
<td>0.2 in</td>
</tr>
<tr>
<td>No. of Cycles</td>
<td>30 Cycles</td>
</tr>
</tbody>
</table>

Iteration 2: 300 lbf

Endurance Test – Handguard A2 – Iteration 2 – Position vs. Time & Load vs Time – First 30 Rounds
Rough Handling: Results

Results (cont’d)

- Iteration 3:
  - Input displacement: 0.27 in
  - Actual displacement: 0.13 – 0.15 in
  - Peak load: ~350 lbf
  - Peak load less consistent, small deviations.

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Setting</th>
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</thead>
<tbody>
<tr>
<td>Waveform</td>
<td>Triangle</td>
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<tr>
<td>Frequency</td>
<td>17 Hz</td>
</tr>
<tr>
<td>Amplitude</td>
<td>0.27 in</td>
</tr>
<tr>
<td>No. of Cycles</td>
<td>30 Cycles</td>
</tr>
</tbody>
</table>

Endurance Test – Handguard A2 – Iteration 3 – Position vs. Time & Load vs Time – First 30 Rounds
Rough Handling: Results

Results (cont’d)

• Iteration 4:
  – Input displacement: 0.5 in
  – Actual displacement: 0.13 – 0.15 in
  – Peak load: ~400 lbf
  – Peak load varied significantly.

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Setting</th>
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</thead>
<tbody>
<tr>
<td>Waveform</td>
<td>Triangle</td>
</tr>
<tr>
<td>Frequency</td>
<td>17 Hz</td>
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<tr>
<td>Amplitude</td>
<td>0.5 in</td>
</tr>
<tr>
<td>No. of Cycles</td>
<td>30 Cycles</td>
</tr>
</tbody>
</table>

Endurance Test – Handguard A2 – Iteration 4 – Position vs. Time & Load vs Time – First 30 Rounds
Rough Handling: Analysis

Analysis

- No failures or fastener loosening observed for KeyMod™ or M-LOK™ systems.
- Both KeyMod™ and M-LOK™ systems found to be adequate for securing accessories when subjected to high frequency, high acceleration vibrational loads.
  - No damage observed to the handguards or accessory rails.
  - No fastener loosening observed.
Drop Test

Objective
- Evaluate mounting system performance from dynamic, impact loads including impacts directly on the accessory.

Equipment
- 1 M4A1 lower receiver
- 6 URGs: 1 per handguard configuration
- 3 KeyMod™ 5-slot accessory rails
- 3 M-LOK™ 5-slot accessory rails
- 6 Weapon light mounts
- 1 Simulated weapon light
Drop Test: Procedure

Procedure
• Simulated weapon light installed on 5-slot accessory rail.
• Accessory rail installed at 9 o’clock on handguard in forward most position.
• 6 drops per handguard of the 6 specified orientations.
• All samples were dropped from a height of 5ft onto steel plate.
• Handguard and accessory examined after each drop.

<table>
<thead>
<tr>
<th>Drop Number</th>
<th>Orientation</th>
</tr>
</thead>
<tbody>
<tr>
<td>Drop 1</td>
<td>Major axis horizontal - normal firing orientation</td>
</tr>
<tr>
<td>Drop 2</td>
<td>Major axis vertical - buttstock down</td>
</tr>
<tr>
<td>Drop 3</td>
<td>Major axis vertical - muzzle down</td>
</tr>
<tr>
<td>Drop 4</td>
<td>Major axis 45° from vertical - buttstock down</td>
</tr>
<tr>
<td>Drop 5</td>
<td>Major axis 45° from vertical - muzzle down</td>
</tr>
<tr>
<td>Drop 6</td>
<td>Major axis vertical - muzzle down – weapon light impact</td>
</tr>
</tbody>
</table>
Drop Test: Results

Results – KeyMod™ – Handguard A1

• Drop 1 – no damage.
• Drop 2 – accessory rail loose, but in position.
• Drop 3 – no damage.
• Drop 4 – rear mounting nut to pulled through handguard.
  – handguard fractured between KeyMod™ slots.
• Drop 5 – accessory rail detached from handguard.
• Drop 6 – not conducted.
Drop Test: Results

Results – KeyMod™ – Handguard B1

- Drop 1 – fractures on the 12 o’clock rail.
- Drop 2 – no new damage.
- Drop 3 – handguard slid forwards off the barrel nut approximately 0.5 in.
  - *accessory rail loose.*
- Drop 4 – handguard rotated on the barrel nut ~30° **CW**.
  - *fracture between the KeyMod™ slots.*
- Drop 5 – handguard slid further off barrel nut.
  - barrel was no longer parallel handguard.

Drop 4
Results – KeyMod™ – Handguard B1 (cont’d)

- Drop 6A – failed drop, simulated weapon light missed raised block.
  - handguard completely separated from barrel nut.
  - simulated flashlight missed the raised block.
- Drop 6B – handguard was reattached to the weapon.
  - accessory rail detached from handguard on impact.
  - final position 8ft-4in (2.5 m) from handguard.
Drop Test: Results

Results – KeyMod™ - Handguard C1

• Drop 1 – no damage.
• Drop 2 – scrape at 3 o’clock position on the handguard.
• Drop 3 – slight gap was between the handguard and receiver.
  – weapon light slid forward ~2 mm (~0.08 in) within the flashlight mount.
• Drop 4 – scraping on handguard.
• Drop 5 – fracture between the KeyMod™ slots.
• Drop 6 – major handguard damage around accessory rail.
  – accessory rail loosened but remained attached to the deformed handguard.
Results – M-LOK™ - Handguard A4

- Drop 1 – no damage.
- Drop 2 – slight deformation of accessory rail.
- Drop 3 – weapon light slid forward in weapon light mount.
- Drop 4 – fracturing of handguard, not near accessory rail.
- Drop 5 – no new damage.
- Drop 6 – significant rearward displacement of accessory rail in M-LOK™ slot.
Drop Test: Results

Results – M-LOK™ - Handguard B4

- Drop 1 – significant damage to 12 o’clock rail.
- Drop 2 – no new damage.
- Drop 3 – handguard displacement on barrel nut.
  - slight handguard rotation on barrel nut.
- Drop 4 – increased handguard displacement on barrel nut.
- Drop 5 – handguard rotation ~45° on barrel nut.
  - increased handguard displacement on barrel nut.
- Drop 6 – handguard pushed rearward onto barrel nut, damaging torque plate.
  - accessory rail remained in place with minimal movement.
Drop Test: Results

Results – M-LOK™ - Handguard C4

• Drop 1 – slight rotation of simulated weapon light in mount.
• Drop 2 – no new damage.
• Drop 3 – slight rearward displacement of accessory rail in M-LOK™ slot
  – simulated weapon light slight displacement in mount.
• Drop 4 – slight rearward displacement of accessory rail in M-LOK™ slot.
• Drop 5 – no new damage.
• Drop 6 – significant rearward displacement of accessory rail in M-LOK™ slot.
  – minor deformation of handguard behind the accessory rail.
Drop Test: Analysis

Analysis

- 1 M-LOK™ system: secured and in initial position.
  - Handguard B4
- 1 KeyMod™ system: loosely secured in initial position with major handguard damage.
  - Handguards C1
- 2 M-LOK™ systems: secured but displaced rearwards in mounting slots.
  - Handguards A4 & C4
- 2 KeyMod™ systems: accessory detached.
  - Handguards A1 & B1

<table>
<thead>
<tr>
<th>Weapon ID</th>
<th>System</th>
<th>Status</th>
<th>Final Condition</th>
</tr>
</thead>
<tbody>
<tr>
<td>A1</td>
<td>KeyMod™</td>
<td>Detached</td>
<td>Fractured KeyMod™ Slots</td>
</tr>
<tr>
<td>B1</td>
<td>KeyMod™</td>
<td>Detached</td>
<td>Fractured KeyMod™ Slots</td>
</tr>
<tr>
<td>C1</td>
<td>KeyMod™</td>
<td>Attached</td>
<td>Loosened Bolts</td>
</tr>
<tr>
<td>A4</td>
<td>M-LOK™</td>
<td>Attached</td>
<td>Pushed Rearward</td>
</tr>
<tr>
<td>B4</td>
<td>M-LOK™</td>
<td>Attached</td>
<td>Intact &amp; Initial Location</td>
</tr>
<tr>
<td>C4</td>
<td>M-LOK™</td>
<td>Attached</td>
<td>Pushed Rearward</td>
</tr>
</tbody>
</table>
Drop Test: Analysis

Analysis (cont’d)

- **KeyMod™ Damage:**
  - Complete separation of accessory rail from handguard.
  - Fracture between the two KeyMod™ slots utilized.
  - Fracture between utilized KeyMod™ slot and an adjacent slot.
  - No major damage to KeyMod™ fasteners.
  - Front of KeyMod™ slots damaged where fasteners were mounted.
  - No removed material captured between accessory rail and mounting nut.

![A1 and B1 images with marked areas showing damage](image-url)
Analysis (cont’d)

- **M-LOK™ Damage:**
  - Accessory rail remained intact and securely attached to the handguard.
  - Accessory rail pushed rearwards from initial index location.
  - Scraping marks on the handguards from the rearward displacement of accessory rail.
- **M-LOK™ impact damage initiates with rearward displacement of accessory rail.**
- **KeyMod™ impact damage initiates with fracturing between slots contributing to detachment of accessories.**
Failure Load

Objective
- Evaluate failure mode and quantify the failure load of mounting systems when subjected to a tensile normal to the primary axis of the handguard.

Equipment
- 1 Cyclic load machine
- 1 Test stand
- 12 URGs: 1 per handguard configuration
- 6 KeyMod™ 5-slot accessory rails
- 6 M-LOK™ 5-slot accessory rails
- 6 Weapon light mounts
- 1 Handguard test fixture
- 1 Simulated weapon light
- 1 3/4-16” eyebolt
- 1 3/4-24” eyebolt
- 1 Steel chain
- 1 Steel quick-link
Procedure

Test parameters:
- Linear displacement ramp
- Single direction: tensile load
- Constant rate: 0.1 in/s

Force applied to the accessory rail through the simulated weapon light.
- Steel chain, eyebolts, and quick links used to connect the simulated flash light to the actuator.

Purpose-built handguard fixture secured samples to the test stand.
- U-blocks with adjustable position along the handguard.

Each accessory rail was pulled by the simulated weapon light until failure occurred.
Failure Load: Results

Normal Force Failure Load

<table>
<thead>
<tr>
<th>Handguard</th>
<th>KeyMod™</th>
<th>M-LOK™</th>
</tr>
</thead>
<tbody>
<tr>
<td>A2/A5</td>
<td>338</td>
<td>1121</td>
</tr>
<tr>
<td>A3/A6</td>
<td>464</td>
<td>1502</td>
</tr>
<tr>
<td>B2/B5</td>
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<td>1351</td>
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<td>B3/B6</td>
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<td>380</td>
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<td>C3/C6</td>
<td>462</td>
<td>1193</td>
</tr>
</tbody>
</table>

Distribution Statement A – approved for public release; distribution unlimited
Failure Load: Analysis

Analysis
- KeyMod™ system loading shows mostly linear, elastic properties.
- M-LOK™ system loading shows non-linear properties, especially at high loads.
- Some momentary load drops from fixture slipping.
Analysis (cont’d)

- KeyMod™ systems showed nearly identical failure mode to that observed in drop testing.
  - Complete separation of accessory rail from handguard.
  - Fracture between the two KeyMod™ slots utilized.
  - Fracture between utilized KeyMod™ slot and an adjacent slot.
  - No major damage to KeyMod™ fasteners.
  - Front of KeyMod™ slots damaged where fasteners were mounted.
  - No removed material captured between accessory rail and mounting nut.
Failure Load: Analysis

Analysis (cont’d)

• All M-LOK™ tests featured failure modes at the weapon light mount.
  – 1/6 samples: mount fractured near clamping end.
  – 5/6 samples: mount pulled off of the deformed accessory rail.
• Increase of 215% in average sustained load of M-LOK™ over KeyMod™.
• M-LOK™ system tests showed 140-220% increase in sustained load over the maximum KeyMod™ load observed.
Conclusions

- **Repeatability**
  - M-LOK™ achieved a 73% improvement in average POA shift over KeyMod™.

- **Endurance**
  - KeyMod™ and M-LOK™ system performance exceeded cyclic load test conditions.

- **Rough Handling**
  - KeyMod™ and M-LOK™ system performance exceeded cyclic load test conditions.

- **Drop test**
  - 100% of M-LOK™ accessories remained attached.
    - 1/3 M-LOK™ accessories remained in-place.
    - 2/3 M-LOK™ accessories slid rearwards but remained secure.
  - 33% of KeyMod™ accessories remained attached.
    - 1/3 KeyMod™ accessories remained attached, but severely damaged handguard.
    - 2/3 KeyMod™ accessories completely detached.

- **Failure Load**
  - Average M-LOK™ test failure load over 3 times greater than average KeyMod™ system failure load.
  - All KeyMod™ failures occurred at the interface between the handguard and accessory rail.
  - All M-LOK™ system tests failed at weapon light mount or mount to accessory rail interface.
Contact Information

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