

Barreled Action Installation Procedure for Chassis with Lug-Lock

1. Before installing barreled action into a chassis with a lug lock, you will thread in the Flat Head Cap Screw into the barrel insert 1.5-2 full turns. This will provide enough clearance for the recoil lug on the barreled action to sit down into the recoil lug slot in the chassis without interference from the lug lock barrel insert.
2. Turn the chassis up to a 45 degree angle to install the barreled action.
3. Seat the barreled action into the chassis making sure the action is sitting flush on the v-bedding without interference from the lug lock barrel insert. There should not be any "rock" or tilt to the action when this is done properly.
4. Install the front action screw into the action through the hole in the chassis until the action screw is "snug" but not torqued." (Stops turning without any extra pressure)
5. Repeat the process for the rear action screw.
6. Using a 1/8" driver, torque the Flat Head Cap Screw for the lug lock system to 25-30 inch lbs.
7. Then torque the front action screw down to 65+ inch lbs.
8. Repeat the process on the rear action screw.
9. If you are using our new special lock washers, after you have completed the above installation procedure, check to make sure the lock washers are working properly.
 - a. To do this, loosen one of the action screws. When you do this, you should hear/feel a slight "pop". This is the sound from the lock washers breaking loose from each other.
 - b. If you do not hear this sound, increase the final torque rating for the action screws to 75 inch lbs.
 - c. Repeat this test.
 - d. Verify the lock washer function and torque requirements for both the front and rear action screws.