



Instruction Manual

1. **Clear your action to be sure it is not loaded before proceeding! Always point the weapon in a safe direction! Remove the bolt from the action.**
2. Install your AR-15 buttstock in standard fashion into rear trunnion
3. Install your AR-15 grip in standard fashion
 - A. If you ordered a (type 1) rear trunnion, you can only install a grip without a beavertail.
 - B. If you ordered a (type 2) rear trunnion, you can install a grip with a beaver tail
4. The recoil lug slot is approximately **.375"** wide without any shims installed and the clamp fully relaxed.



- 4.1 Measure the recoil lug on the receiver you are installing.
- 4.2 Add the appropriate shim or shims to the face of the clamp to take up as much of the extra space as possible between your recoil lug and the clamp. The shims are .063" thick. (Example: if your recoil lug measured .312" you would install 1- .063" shims.)



The shims have a strip of double stick tape on one side. Peel the tape and stick the shim to the clamp as shown in the photo above. If you need to add the second shim, stick it to the back of the first shim. (Note: removing the floating half round makes this process easier. It is just held in with a magnet.) Be sure to install the shims all the way down in the pocket and not sticking up above the clamp.



Note: The torque sequence to install your barreled action in the chassis is critical and **requires** an inch pound torque wrench with the appropriate bits. The torque range on the wrench needs to be 10-60 in.-lb. **Do not attempt this installation without the appropriate torque wrench!!! Any attempt to do so could cause permanent damage to the receiver and/or chassis.**

5. Make sure there is a light coating of grease between the half round and the chassis to allow free movement and self-adjustment when the clamp is tightened.
6. Clean all mating surfaces on your action and the chassis.
7. With the bolt handle removed, place your action in the chassis, and while holding them together stand the chassis upright, standing it on the buttstock, muzzle pointing up. (Do not let your barreled action fall out of the chassis!)
8. Install the front and back action screws finger tight or until they stop without any torque.
9. **Torque sequence: (with the muzzle pointing up)**
 1. **Torque front action screw 10in.-lb.**
 2. **Torque back action screw 10in.-lb.**
 3. **Torque clamp screw 60in.-lb. (this seats the recoil lug into the half round)**
 4. **Loosen clamp screw until completely loose.**
 5. **Re-torque clamp screw 10in.-lb.**
 6. **Torque front action screw 48in.-lb.**
 7. **Torque back action screw 48in.-lb.**

Your action is now installed in the chassis! Check your AI magazines (or equivalent) to be sure your ammo is feeding correctly. (Note: We have noticed some brands of magazines are not very consistent and may need the feed lips adjusted to work properly.) See photos below for NV Mount installation.

