

Thank you for purchasing our X-Ray Chassis



X-Ray Chassis

Contents of Package:

- X-Ray Chassis partially assembled – accepts .308 AICS magazines (with or without spacer for T3 version)
- Large baggie with forend and fastener kit consisting of:
 - Bipod/Sling stud
 - Plastic washer for Bipod/Sling stud
 - 2ea M5 hex nut for accessories mounting
 - 4ea M5 flat nut for accessories mounting
 - 4ea M5x 25mm screw for mounting forend to backbone
 - 2ea M5 x 30mm screw (Rem 700 forend only) for mounting forend to backbone
 - 2ea M5 washer for 30mm screws in case they protrude into bedding area
- Baggie with the following contents:
 - Rear action screw- 1ea M6x45mm socket head screw (T3) or 1/4-28TPI X 1 3/4" (Remington)
 - Front action screw- 1 ea M6x 12mm socket head screw (T3) or 1/4-28 X 1/2" (Remington)
 - 3ea washer for action screws (Rem 700 gets two washers in front and one in rear, T3 gets one in front)

Installation Instructions:



Safety Warning: Before you attempt any installation, make sure your rifle is unloaded. Also, before starting remove the bolt and magazine from the rifle.

Part I: Remove action from existing chassis/stock

Step 1: Loosen the two screws that hold the action into the stock. Next pull the barreled action out of the stock. Remove the metal magazine spring plate from the trigger if you have a T3 and re-install trigger. For Remingtons you will need to remove the box magazine parts.

Part II: Install your action into the X-Ray Chassis

Step 1: Install front action screw. To do this, put one or two washers on the shorter action screw and put in place. For Rem 700 stocks, use both included washers on the front action screw.

Step 2: If you plan to torque the action screws using a torque wrench, now is the time to install the action while the forend is off the backbone. Skip step 3 and do it after step 6.

Step 3: With the whole assembly upside down, install the forend onto the backbone. The front of the forend should protrude past the front of the backbone slightly, install the screws as shown below. Do not fully tighten. Insert a magazine and check for the fit of the magazine. You can shift the forend forward or rearward slightly to adjust the fit of the magazine. Choose your desired fit and tighten the forend screws to **no more than 10 in-lbs.**



Step 4: Insert the barreled action into the backbone, tighten the front action screw to finger tight.

Step 5: With the whole assembly upside down, and drop the rear action screw into the hole just behind the trigger guard, turn the screw to engage the threads in the action. Again do not fully tighten.

*****Rear action screw on Remington chassis gets one washer**

Step 6: Pull the action towards the rear of the stock while holding the stock stationary. This is to seat the action against the recoil lug. A good way is to set the rifle vertical on the buttpad and bounce it on the ground a couple times.

Step 7: Making sure the action is level and not canted to the left or right in the chassis, begin tightening the actions screws starting with the front screw, tightening a little and then moving to the back screw and tightening a little. Keep switching back and forth to ensure even tension until the screws are fully tightened.

Step 8: Torque both screws to 35-50 in-lbs of torque in an incremental manner, moving back and forth between the two screws until full torque is reached. We recommend experimenting with the torque settings to find the best accuracy for your rifle. In our experience, some rifles shoot better with lower torque, around 40 in-lbs. Lubricating the action screws with oil or heavy grease will ensure that they hold tension even at lower torque settings (in fact lower torque values are suggested for lubricated fasteners).

Step 9: Insert a magazine to test for fit, the forend can be moved forward or backward a small amount to adjust the magazine fit as noted in step 3. Additionally, the trigger guard can be moved a small amount as well if necessary, this will require removal of the barreled action. If you experience some bolt drag on the feed lips of the magazine, you can help this by widening the feed lips of the magazine a little. Also you can remove a little material from the top of the magazine release but that is almost never necessary. Due to the magazine design of the AICS magazine and the magwell of the W3C, it may be possible to put pressure on the mag and push it up against the bolt. For this reason we do not recommend resting the gun on the magazine when firing.

Time to adjust the stock to fit you!

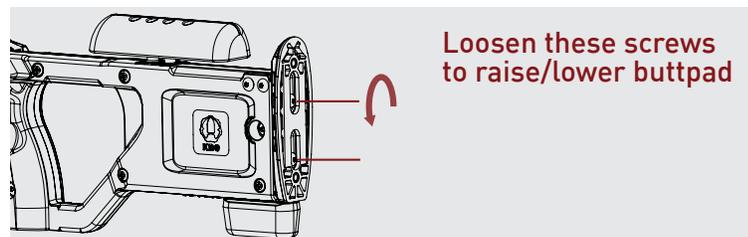
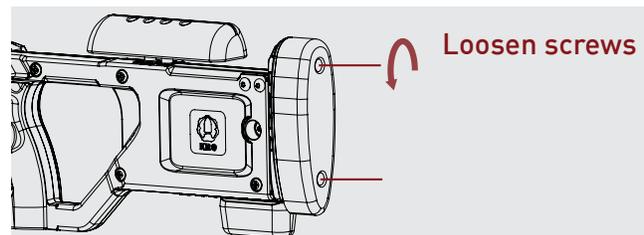
Length of Pull (LOP) Adjustment

Step 1: Remove the buttpad using a 3mm metric hex/allen wrench. Don't lose the T-nuts that are housed in the buttpad mount plate!

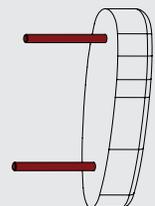
Step 2: Loosen but do not remove the two M5 button head screws that hold the buttpad mount plate onto the buttstock. Once loose, the mount plate can be shifted up or down. There are notches in the mount plate that correspond to protrusions on the buttstock. Line these two features up at your desired height and retighten the two screws. We recommend a buttpad in a higher position for prone shooting and a lower position for bench shooting or where your body is more upright.

Step 3: Push the installed M5 buttpad mount screws out of the buttpad. Replace these screws with the longer screws which are long enough to go through your desired amount of spacers. Insert desired quantity of spacers onto the longer screws.

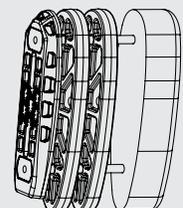
Step 4: Install the buttpad back onto the buttpad mount plate with the spacers captured between them.



Remove buttpad screws



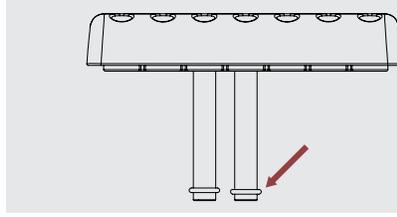
Install buttpad onto mount plate



Cheek Height Adjustment

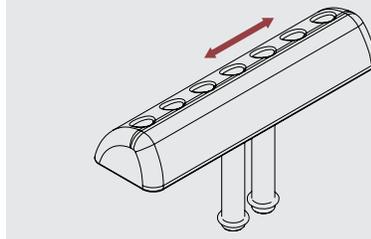
Tool-less cheek height adjustment with a simple return to zero feature

Step 1: Loosen the thumbscrew and remove the cheek piece, then slide the o-rings toward the bottom of the riser posts and re-insert the cheekpiece.



Step 2: Getting into position behind the rifle, place your head gently on the cheekpiece. The cheekpiece should be too high for a proper view through the scope. With the thumbscrew slightly loose, push the cheekpiece down with your head until it rests in the proper position so you have a perfect view through the scope. Tighten the thumbscrew to lock the cheekpiece in that position. When you need to remove the rifle bolt from the action for cleaning, the o-rings will keep the position you selected when you re-install the cheek piece.

Step 3: Optional – You can move the cheek piece forward and backward by removing the two screws holding the cheek piece to the two cheek riser posts and then switching the holes in which the riser posts sit. (use 3mm hex wrench.)



Mounting Options Data

