

F1 chassis system assembly instructions, please read and understand before starting, please follow these instructions carefully to achieve best results

#### STEP 1

Carefully mark the location where the block is to be mounted on the barrel, note that your scope rail may need to be shortened to prevent interference with the block, the block must not contact the action or the rail.



STEP2

The barrel section under the block **must** be turned down to 1.2" to allow for proper bond line



### STEP 3

Mask off and blast the turned area with 100-120 grit aluminum oxide, do **not** use glass beads, make certain **all** blast residue is cleaned from the surface, also check the interior of block making sure it is perfectly clean.



Install barrel to action and tighten securely

#### STEP4

After barrel is securely tightened, slip rear O ring into place and slide block over it, use a tool to push front O ring into place



STEP5

Test fit barreled action into chassis making sure everything lines up correctly



### STEP6

Warm the tubes of epoxy in hot tap water for about 15 minutes, block the hole in the tip of the syringe and set syringe in a device to hold it upright while pouring the mixed epoxy into it, **take care to get as much of the epoxy possible from the tubes and into the syringe.**



Install piston and invert syringe to purge all air form it before injection



### STEP7

Holding the barreled action assembly vertically, inject epoxy through the bottom center hole until epoxy exits the sprue hole, block it with your thumb then invert the assembly and continue to inject until epoxy comes from the other sprue hole, note; it will take considerable force to push the epoxy in, use slow constant pressure, it will take a few minutes, you have plenty of working time.



When complete block injection hole with a small piece of tape





### STEP8

Re install assembly into chassis and tighten screws, using a quality level, level the forend (do not go off the top of the block) then level the action assembly off the scope rail, re check level frequently as the epoxy sets, the epoxy level in the sprue holes may drop as remaining air escapes, just drizzle a bit more epoxy into them as needed, insert a few cardboard shims snugly between the barrel and forend and allow the epoxy a minimum of 24 hours to cure.





## STEP9

After epoxy has cured 24 hours remove the action assembly, install trigger and bolt and re assemble, note the location of the bolt handle notch and using a Dremel type tool carefully create clearance for the bolt handle, care must be taken to ensure the bolt handle does **not** contact the chassis in any way.



## NOTE;

If you don't fully understand the instruction or have any questions please call 928-649-0742 before starting the process.

Thank you!

Gary Eliseo