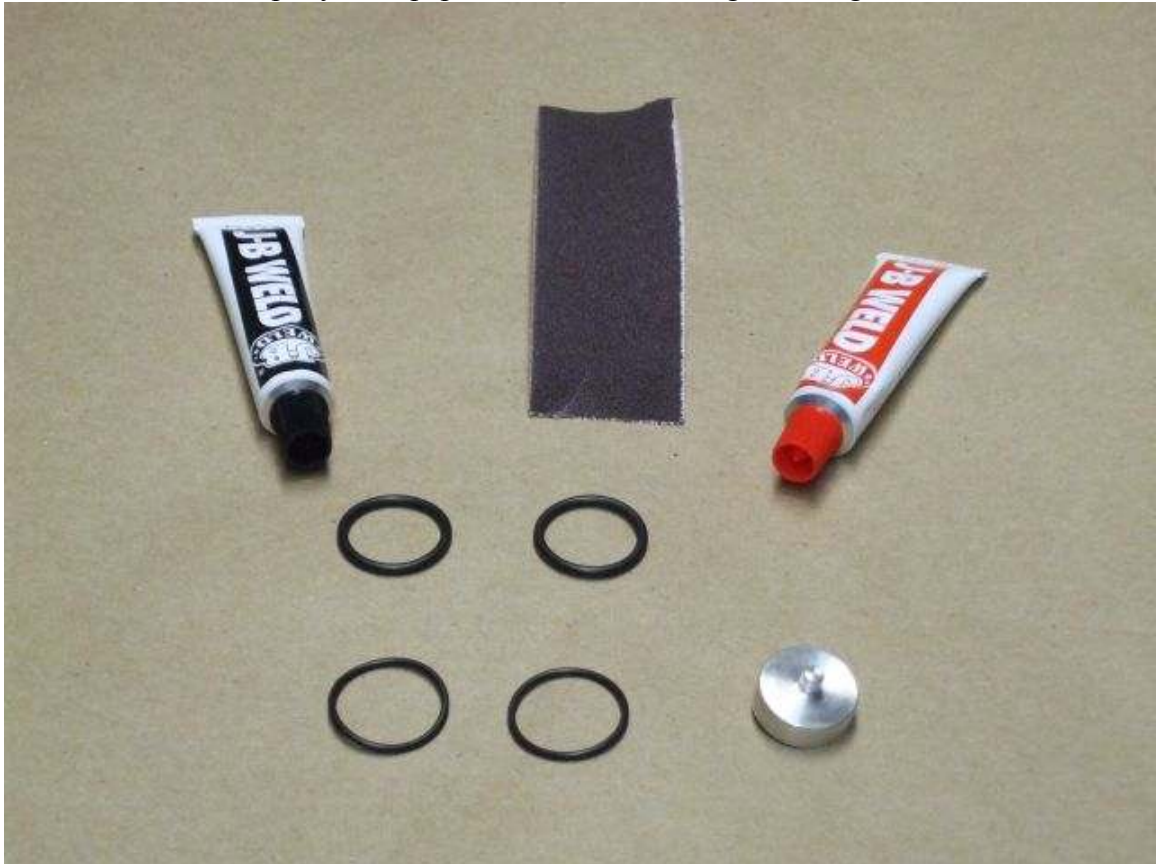


## AN 1 assembly instructions

The kit comes with epoxy, sandpaper, two sizes of O rings and alignment tool





Remove the trigger, bolt stop, ejector and follower from the barreled action



Remove the two E clips and the safety mechanism from the outside of the trigger



Choose the appropriate size O rings for your barrel diameter



Test assemble your action into the stock and make sure everything lines up correctly





Carefully remove the barrled action and note the distance from the sleeve to the action



Sand the barrel where the epoxy will be applied and clean up with acetone



Slide the first O ring into place and apply a thin coat of epoxy to both the barrel and inside of sleeve





While sliding the sleeve into place use a syringe to fill in the gap between the barrel and sleeve



Insert the second O ring and clean up everything thoroughly with acetone



Adjust the location of the sleeve to the dimension previously noted during test assembly



Apply a light coat of oil to the outside of the sleeve and carefully assemble the barreled action into the stock then insert the alignment tool into the hole in the bottom to hold the barreled action in it's proper location while the epoxy cures





Roll up a couple of sheets of copy paper and slide into the gap between the action and sleeve to maintain uniform clearance, set the assembly muzzle down to cure, a hole in a scrap of wood large enough to allow the barrel to pass through so the assembly sets on the knurled action retaining nut works best.

After overnight cure the rifle is ready to assemble!