

4. A good quality masking tape or duct tape should be firmly applied to the exterior of the stock in the area where the hole is to be drilled to prevent damage to the finish of the stock. The exact location of the hole to be drilled into the stock can be marked on the tape.

ATTENTION: Care must be given to avoid intersecting a butt plate or recoil pad mounting screw, through bolt, etc. that may be present in the butt stock and/or any insert or through bolt device that may be present if a "fore end tip" is on the stock when drilling the holes for the wood screw swivel base.

5. Having determined the correct location of the wood screw swivel base, center punch the exact location of the hole to be drilled.

6. The fore end material (wood, laminated, synthetic, etc.) must be 5/8" or greater in thickness to accommodate a wood screw swivel base (SEE ILLUSTRATION "C").

7. Carefully drill the countersink hole with the 7/32" drill bit to a depth of 1/4". No more for either the 1/2" or 3/4" wood screw swivel base. The hole(s) should be perpendicular (90°) to the exterior surface of the stock.

8. For the 3/4" wood screw swivel base, use the 5/32" drill bit to drill a second hole down through the center of the countersink hole to a depth of 7/8" minimum to 1" deep (SEE ILLUSTRATION "B").

9. For the 1/2" wood screw swivel base, use the 5/32" drill bit to drill a second hole down through the center of the countersink hole to a depth of 5/8" minimum to 3/4" deep (SEE ILLUSTRATION "C").

10. The hole in the fore end barrel channel of the stock must be centered in the bottom of the barrel channel (SEE ILLUSTRATION "C").

11. Carefully remove the tape.

12. Place the black synthetic spacer onto the wood screw swivel base and carefully screw the base into the prepared hole in the stock. Please use an appropriate tool, pin, punch, etc. to install the wood screw swivel base. Do not use a detachable swivel to turn the wood screw swivel base into the stock. A very small amount of grease applied to the threads of the wood screw will assist in turning the wood screw into a wood or laminated stock.

13. For synthetic (plastic) stocks, a small amount of an epoxy glue can be placed on the threads of the wood screw base and into the prepared hole in the stock. This will secure the swivel base firmly in the stock. Remember, a little epoxy goes a long way. Remove excess epoxy, as it appears, while turning the wood screw into the synthetic stock. You should allow the epoxy to fully cure/set up (per instructions), before attaching your swivels and sling.

14. Examine and make sure the tip/end of the wood screw swivel base does not protrude into the barrel channel. Contact with the barrel by the wood screw swivel base can affect the accuracy of your firearm.

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- "THE RIGHT TOOL" FOR THE TASK
- CLEAN CUTTING, NO SPLINTERING

! WARNING ! WARNING ! WARNING !

Firearm safety is your individual responsibility. You must carefully examine and be sure the firearm is unloaded before you attempt to install the TOC Swivel Bases. You must visually inspect the chamber and the magazine to make sure they are clear/empty. You must remove the cartridge clip, if present. These activities must be performed without failure before you begin to install the TOC Swivel Bases.

! CAUTION ! CAUTION ! CAUTION !

You must read all of the enclosed instructions thoroughly. The instructions must be followed explicitly for correct installation of the TOC Swivel Bases. If you do not feel confident in attempting to install the wood screw(s) and/or machine screw/knurled nut swivel base, please secure the services of your local gunsmith or someone capable of performing these tasks.

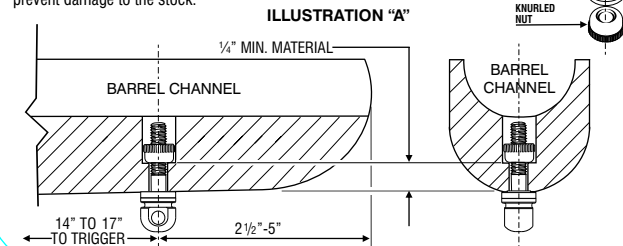
Following the firearm manufacturer's instructions, carefully remove the barrel and action/receiver assembly from the stock.

7/8" MACHINE SCREW/KNURLED NUT TOC SWIVEL BASE

Two sizes of drill bits are required to install the machine screw/knurled nut TOC Swivel Base: 3/16" diameter and 23/64" diameter.

NOTICE: There should be a minimum of 1/4" thickness/depth of material remaining in the bottom of the barrel channel after the knurled nut is installed correctly. Any less material may be structurally inadequate to support the weight of the firearm (SEE ILLUSTRATION "A").

1. While attempting to install the machine screw/knurled nut swivel base, securely position/hold the stock in a padded work vice or a similar device to prevent damage to the stock.



2. The correct installed location for the 7/8" machine screw/knurled nut swivel base is approximately 14" to 17" in front of the trigger or 2 1/2" to 5" from the forward end of the fore end of the stock, measured along the underside of the stock. Do not attempt to install a swivel base in the "add-on fore end tip", if the stock is so equipped (SEE ILLUSTRATION "A").

3. A good quality masking tape or duct tape should be firmly applied to the exterior of the stock in the area where the hole is to be drilled to prevent damage to the finish of the stock. The exact location of the hole to be drilled into the stock can be marked on the tape.

ATTENTION: Care must be given when drilling the hole to avoid intersecting any insert or through bolt device that may be present, if a "fore end tip" is on the stock.

4. Having determined the correct location of the machine screw/knurled nut swivel base, center punch the exact location of the hole to be drilled.

5. Carefully drill a 3/16" diameter hole from the outside of the stock into the bottom center of the barrel channel. The drilled hole(s) should be perpendicular (90°) to the exterior surface of the stock (SEE ILLUSTRATION "A").

6. Drill a countersink hole 1/4" deep in the 3/16" hole in the bottom of the barrel channel using the 23/64" diameter drill bit. Exercise extreme care to not drill through the fore end of the stock with the countersink drill (SEE ILLUSTRATION "A").

7. Carefully remove the tape.

8. Press the knurled nut into the countersink hole in the bottom of the barrel channel. The knurled nut must recede below the surface of the barrel channel bottom.

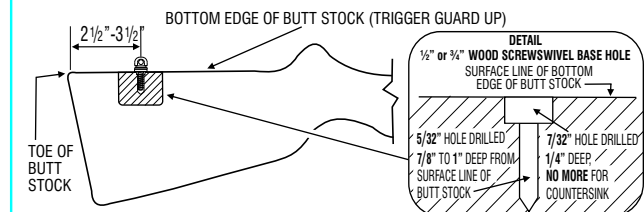
9. Place the black spacer onto the machine screw swivel base and screw the base through the 3/16" diameter hole into the knurled nut seated in the bottom of the barrel channel. The firearm barrel must not contact the knurled nut or the tip/end of the machine screw.

10. Do not use a detachable swivel to install the machine screw. Please use an appropriate tool, pin, punch, etc. to install the machine screw swivel base. The machine screw will need to be cut off, if necessary, to be flush with the top of the knurled nut. Contact of the barrel with the installed machine screw/knurled nut swivel base will affect the accuracy of the firearm.

11. After a satisfactory installation of the machine screw swivel base has been made, a small amount of a quality epoxy glue, thread lock material, etc. can be applied to the exterior of the nut and the threads of the swivel base to ensure a secure installation of the machine screw/knurled nut swivel base assembly. Remember, a little of the locking material goes a long way. Use care to avoid getting any of the locking material on the finish of the stock.

3/4" AND 1/2" WOODSCREW TOC SWIVEL BASE

ILLUSTRATION "B"



Two sizes of drill holes are required to install a wood screw TOC Swivel Base: 5/32" diameter and 7/32" diameter.

1. While attempting to install the wood screw swivel base, securely position/hold the stock in a padded work vise or a similar device to prevent damage to the stock.

2. The correct installed location on the butt stock for the wood screw base is approximately 2 1/2" to 3 1/2" from the toe of the butt stock, measured along the bottom edge of the butt stock (SEE ILLUSTRATION "B").

3. The correct installed location on the fore end of the stock for the wood screw swivel base is approximately 14" to 17" in front of the trigger or 2 1/2" to 5" from the forward end of the fore end measured along the underside of the stock (SEE ILLUSTRATION "C"). Do not install a swivel base in the "add-on fore end tip", if the stock is so equipped.

ILLUSTRATION "C"

