

Thank you for purchasing our new X-Ray Chassis (Gen 4). We hope that you enjoy your chassis and we think that you'll find it to be high quality and an exceptional value.

INST-XRY-R7S/T3S



X-Ray Chassis (Gen 4)

Contents of Package:

- X-Ray Chassis assembled – accepts .308 AICS magazines (with or without spacer for T3 version)
- Baggie with fastener kit consisting of:

Remington 700 version:

- 1ea 1/4-28 x 1 3/4 Socket Head Screw (Rear Action Screw)
 - 1ea M6 Washer for Rear Action Screw
 - 4ea M5 Hex Nut
 - 4ea M5 Flat Weld Nutt
- 1ea KRG L2 Rail Kit
 - 1ea 1-3 LOP Spacer Set

Tikka T3 version:

- 1ea M6 x 45mm Socket Head Screw (Rear Action Screw)
- 1ea M6 Washer for Rear Action Screw
- 4ea M5 Hex Nut
- 4ea M5 Flat Weld Nut

Installation Instructions:

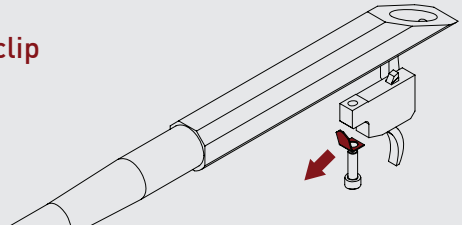


Safety Warning: Before you attempt any installation, make sure your rifle is unloaded. Also, before starting remove the bolt and magazine from the rifle.

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.

For Tikka T3
remove spring clip

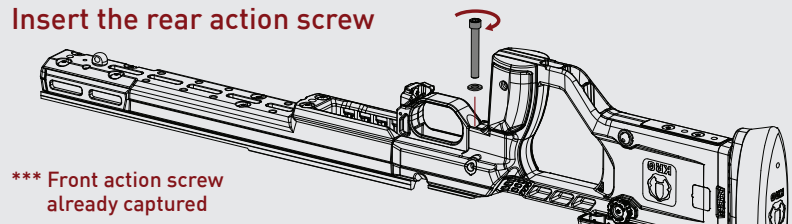


Part II: Install your action into the X-Ray Chassis

Step 1: Insert the barreled action into the backbone, tighten the front action screw to finger tight. Front action screw is in place already and captured by forend.

Step 2: With the whole assembly upside down, drop the rear action screw and washer into the hole just behind the trigger guard, turn the screw to engage the threads in the action. Again do not fully tighten.

Insert the rear action screw



Step 3: 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 lightly on the ground a couple times.

Step 4: 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 5: Torque both screws to 65 in-lbs of torque in an incremental manner, moving back and forth between the two screws until full torque is reached.

Step 6: Insert a magazine to test for fit, the forend can be moved forward or backward a small amount to adjust the magazine fit. Additionally, the trigger guard can be moved a small amount as well if necessary, this will require removal of the barreled action. Due to the magazine design of the AICS magazine and the magwell of the X-Ray, 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.

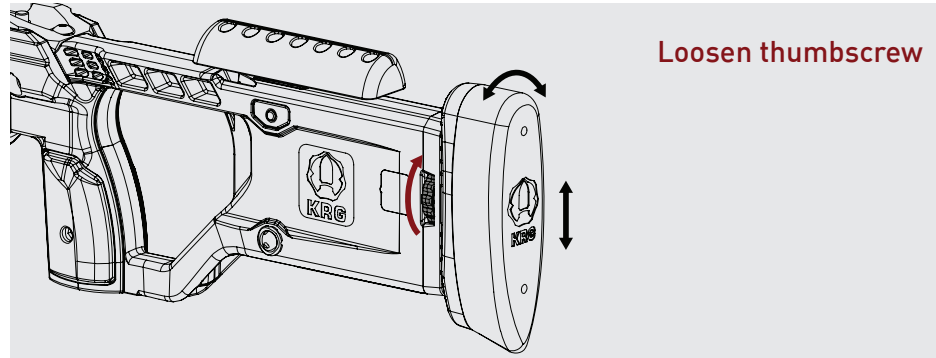
Time to adjust the stock to fit you!

Tool-less Buttpad Height and Cant Adjustment

Step 1: Loosen thumbwheel.

Adjust recoil pad height or cant to desired position.

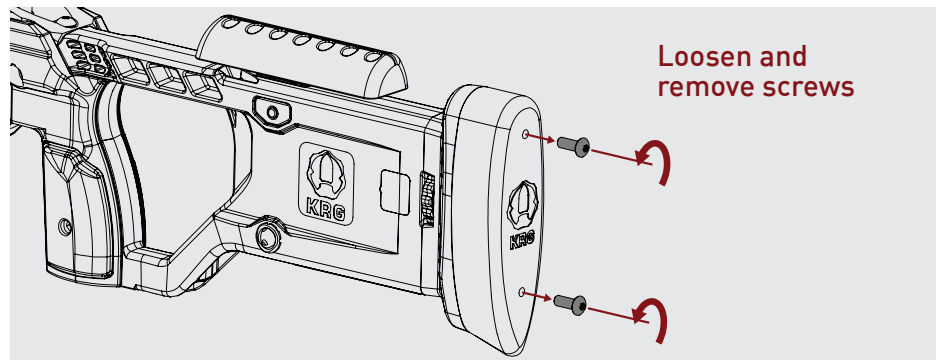
Ensure notches are lined up before retightening the thumbwheel.



Length of Pull (LOP) Adjustment

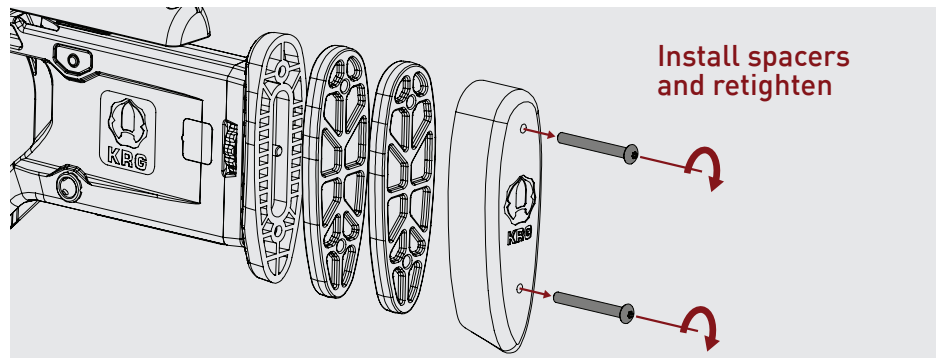
Step 1: Remove the buttpad using a 3mm metric hex/allen wrench.

Push the installed M5 buttpad mount screws out of the buttpad.



Step 2: 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

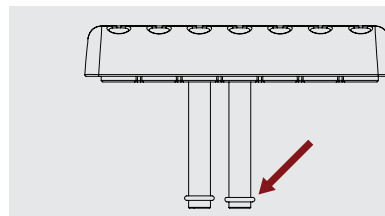
Install the buttpad back onto the buttpad stock with the spacers captured between them.



Cheek Height Adjustment

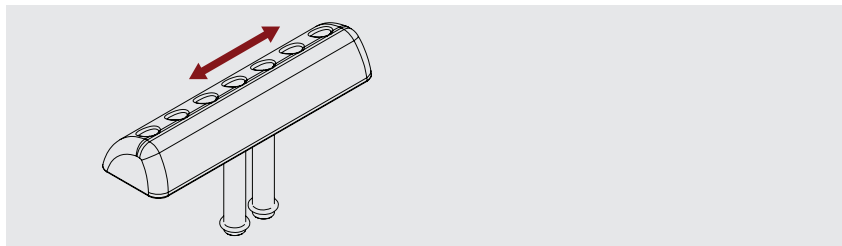
Tool-less cheek height adjustment with a simple return to zero feature

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.



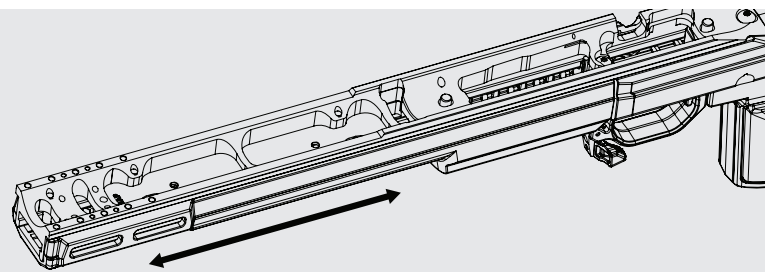
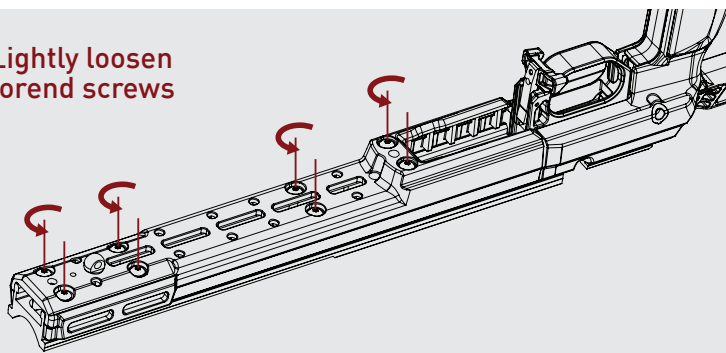
Step 2: Getting into position behind the rifle, place your head gently on the cheekpiece. The cheekpiece should be too high for a proper view through the scope. With the thumbscrew slightly loose, push the cheekpiece down with your head until it rests in the proper position so you have a perfect view 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).



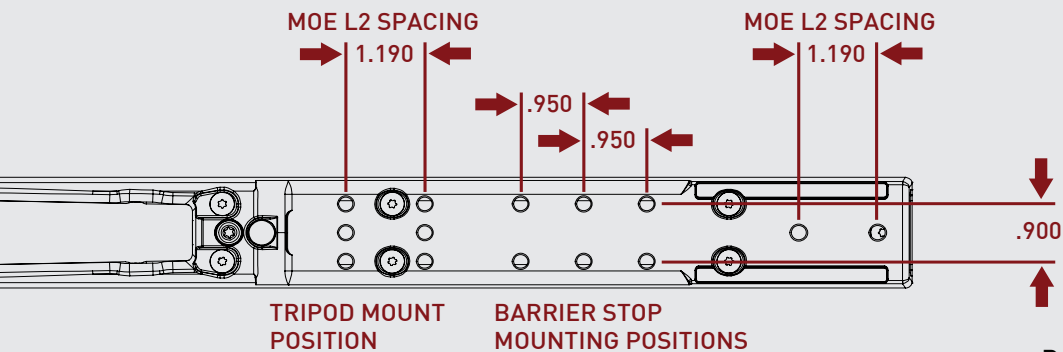
Mag Fit Adjustment

Lightly loosen forend screws



Adjust forend back and forth with mag in place to your fit preference

Mounting Options Data



Rem 700 SA shown

