INST-ARC-RAL-HVY

ARCA RAIL HEAVY

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

Installation Instructions:

Recommended torque specs:
M5 fasteners threading into Backbone – 24 in-lbs
M5 into Steel Hex Nut – 35 in-lbs

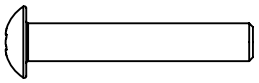
Bravo (Gen 2) and X-Ray (Gen 5) with side magwell threaded mounts

Step 1: Using 3mm Hex bit remove the front 6x screws **M5 x 25mm** that attach the forend to the backbone.

Step 2: Place Arca Rail into place and install 6x button head **M5 x 35mm** in place of the **M5 x 25mm** that were removed for step 1.

We recommend using blue Loctite on all screws.

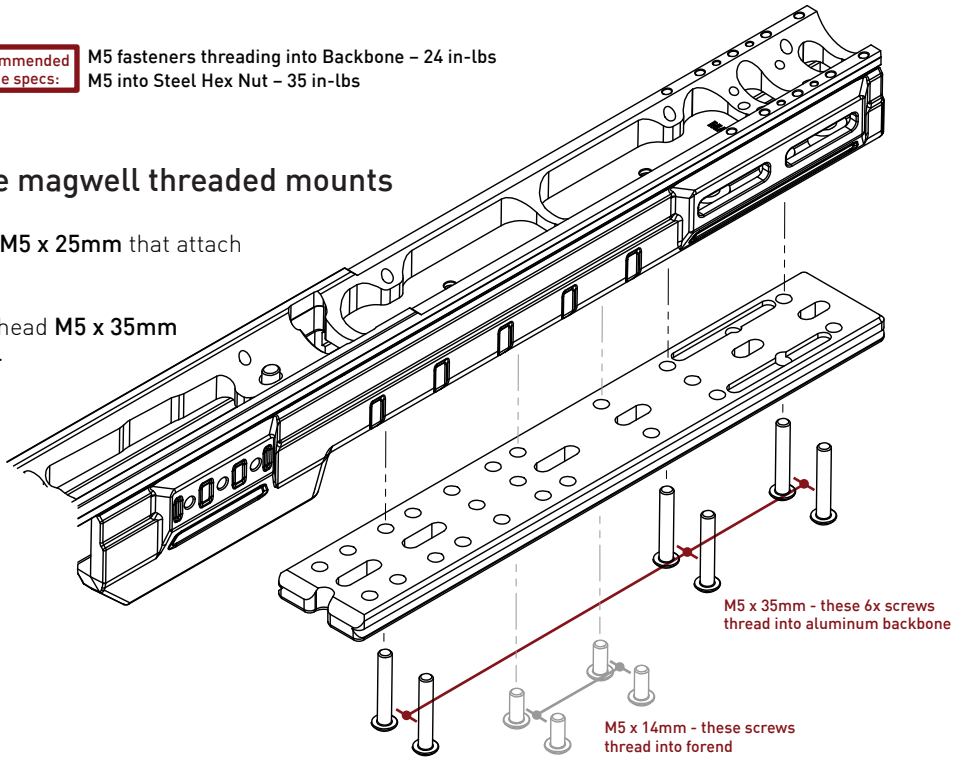
Step 3: Use additional **M5 x 8mm** screws through the rail into the forend if more rigidity is needed.



BUTTON HEAD M5 x 35mm
6 EACH



BUTTON HEAD M5 x 14mm

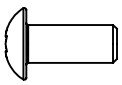


Whiskey-3 Mounting:

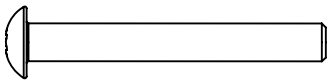
Step 1: Remove the front 6x screws that hold the forend onto the backbone from the bottom of the forend.

Step 2: Place Arca Rail into place and install 6x button head **M5 x 40mm** in place of the **M5 x 30mm** that were removed for step 1.
We recommend using blue Loctite on all screws.

Step 3: Place remaining button head **M5 x 14mm** screws through rail and thread into forend and tighten, again using blue Loctite for best results.
See diagram for mounting positions.

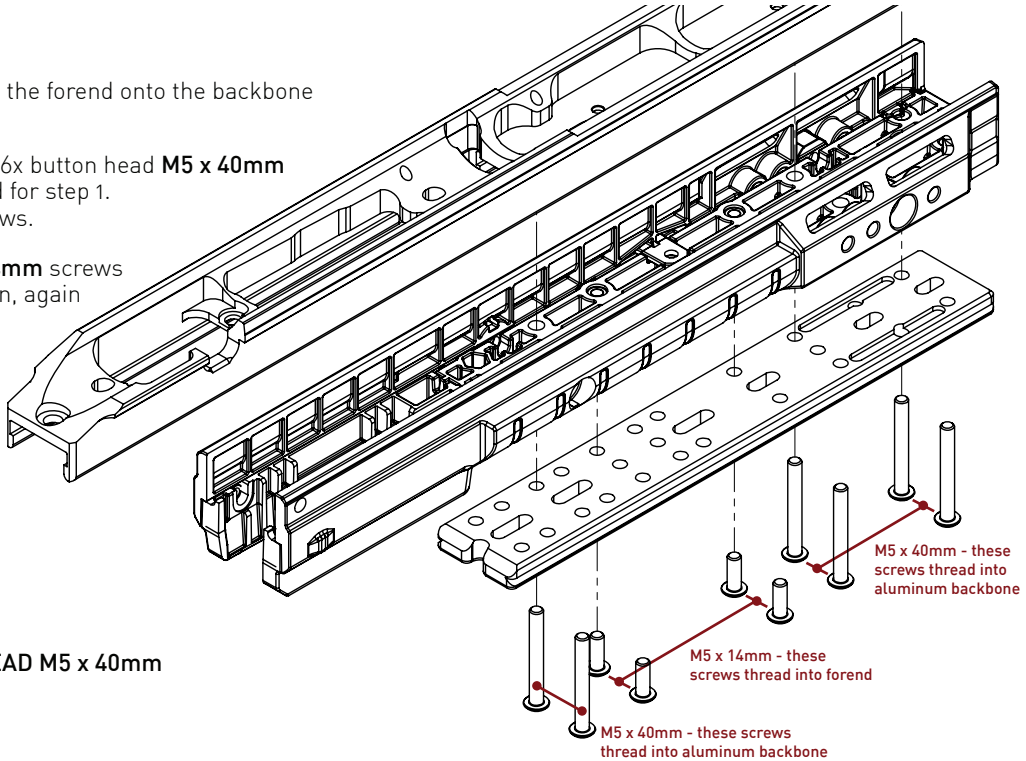


BUTTON HEAD M5 x 14mm
4 EACH



BUTTON HEAD M5 x 40mm
6 EACH

SCALE 1:1



Bravo and X-Ray with MLok side forend slots

(Bravo and X-Ray for Rem 700 LA use Whiskey-3 version instructions below)

Method A (mount forend to backbone, then Arca Rail to forend):

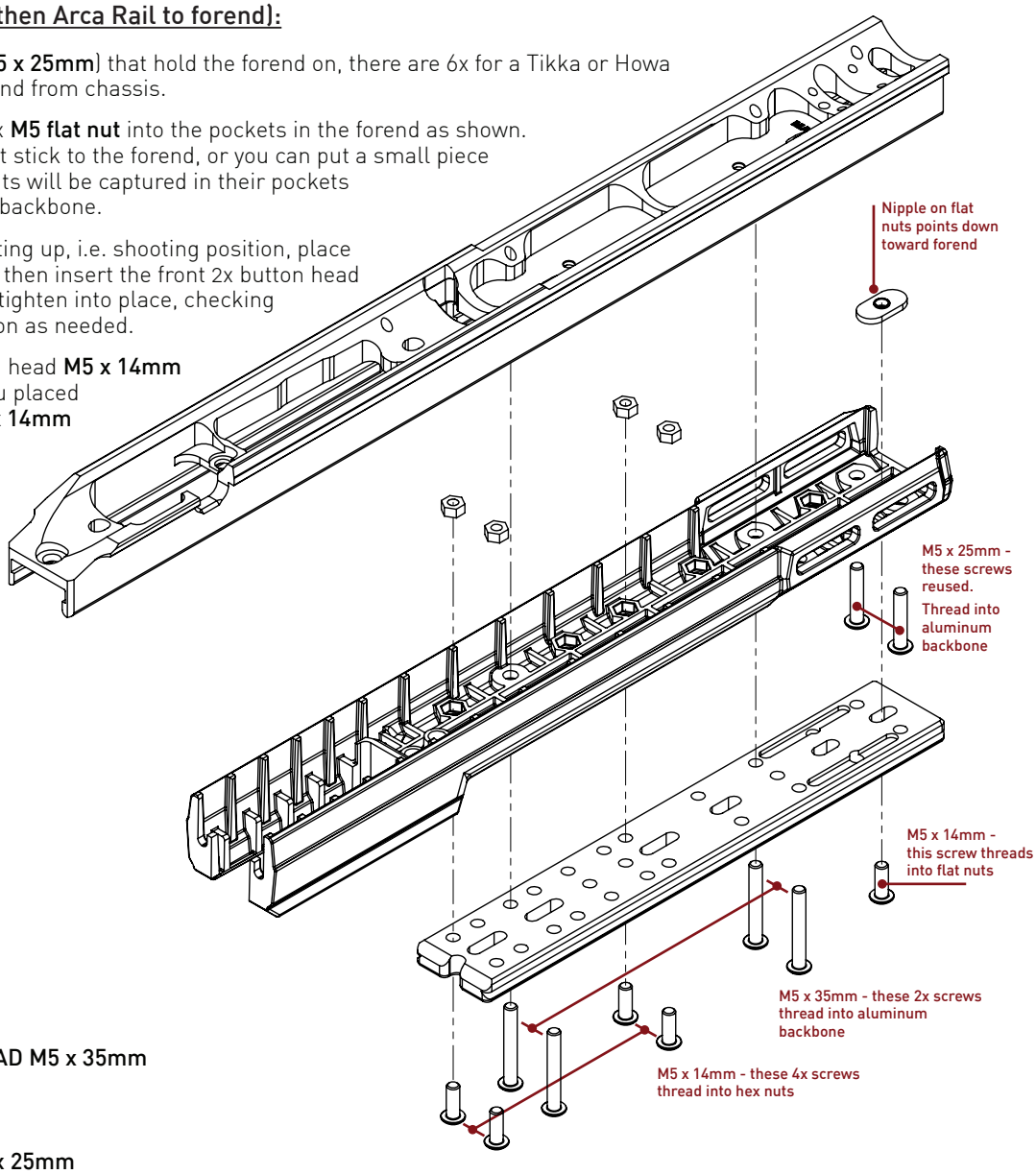
Step 1: Remove the button head screws (**M5 x 25mm**) that hold the forend on, there are 6x for a Tikka or Howa and 8x for a Remington 700SA. Remove forend from chassis.

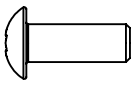
Step 2: Insert the 4x **M5 hex nuts** and the 1x **M5 flat nut** into the pockets in the forend as shown. Put a dab of grease on the flat nut to make it stick to the forend, or you can put a small piece of tape over it to hold it in place. The hex nuts will be captured in their pockets by the backbone once forend is placed onto backbone.

Step 3: Keeping the forend with inside pointing up, i.e. shooting position, place the forend back on the aluminum backbone then insert the front 2x button head **M5 x 25mm** screws through the forend and tighten into place, checking the magazine fit and adjusting forend position as needed.

Step 4: Attach the Arca Rail using 4x button head **M5 x 14mm** screws through the rail into the hex nuts you placed in the forend. Then use 1x button head **M5 x 14mm** screws at the front along the centerline threaded into the flat nut, see diagram. We recommend using a small amount of blue Loctite on all screws.

Step 5: Use the 4x button head **M5 x 35mm** screws to go through the rail, through the forend, and thread into the aluminum backbone, then tighten all screws.

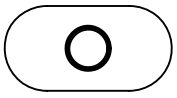




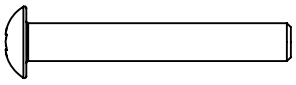
BUTTON HEAD M5 x 14mm
5 EACH



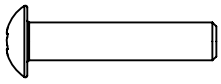
HEX NUT
M5 METRIC
4 EACH



FLAT NUT
M5 METRIC/10-32
1 EACH



BUTTON HEAD M5 x 35mm
4 EACH



BUTTON HEAD M5 x 25mm
USE 2 EACH
THESE ARE ALREADY IN PLACE
HOLDING FOREND ON

SCALE 1:1

For mounting on 10/22 Bravo Chassis use 6x button head M5 x 30mm screws to got through the rail, through the forend, and thread into aluminum backbone.
NOT INCLUDED IN THE SCREW KIT

Method B (mount Arca Rail to forend, then that assembly to backbone):

Step 1: Remove the button head screws (**M5 x 25mm**) that hold the forend on, there are 6x for a Tikka or Howa and 8x for a Remington 700SA. Remove forend from chassis.

Step 2: Insert the 4x **M5 hex nuts** and the 1x **M5 flat nut** into the pockets in the forend as shown.

Step 3: Insert the 4x button head **M5 x 25mm** screws through the front holes in the forend that correspond with the threaded holes at the front of the backbone.

Step 4: Capture the 4x button head **M5 x 25mm** screws by attaching the rail to the forend using the following steps.

Step 5: Attach the Arca Rail using 4x button head **M5 x 14mm** screws through the rail into the hex nuts you placed in the forend. Then use 1x button head **M5 x 14mm** screws at the front along the centerline threaded into the flat nut. We recommend using a small amount of blue Loctite on all screws.

Step 6: Place forend/Arca Rail assembly onto aluminum backbone, threading the captured front 4x button head **M5 x 25mm** screws into the backbone a little at a time, alternating between each of the 4x screws until the forend is fully seated.

Step 7: Use the 2x button head **M5 x 35mm** screws to go through the rail, through the forend, and thread into the aluminum backbone.