INST-ARC-RAL

ARCA RAIL

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

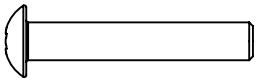
Bravo (Gen 2) and X-Ray (Gen 5) with side magwell threaded mounts

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 30mm** in place of the **M5 x 25mm** that were removed for step 1.

We recommend using blue Loctite on all screws.

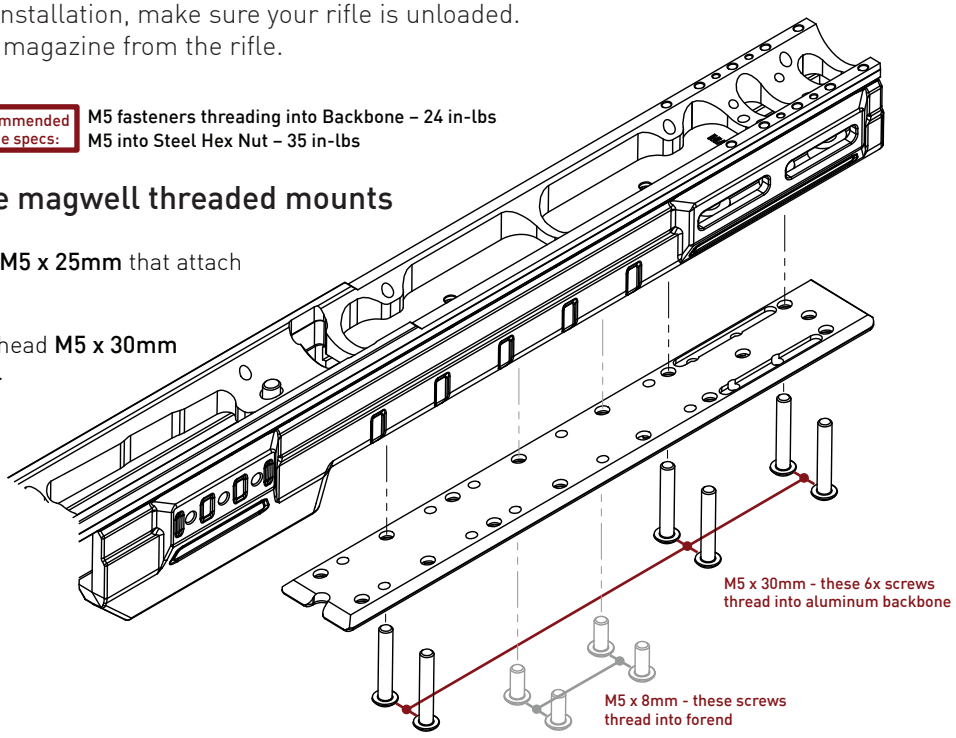
Step 3: Use additional **M5 x 8mm** screws through the rail into the forend if more rigidity is needed.



BUTTON HEAD M5 x 30mm
6 EACH



BUTTON HEAD M5 x 8mm



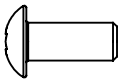
Whiskey-3 Mounting:

Step 1: Using 3mm Hex bit remove the front screws that attach the forend to the backbone. (6 or 8 M5 screws, depending on model)

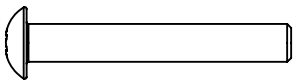
Step 2: Place Arca Rail into place and install 6x button head **M5 x 35mm** in place of the **M5 x 30mm** that were removed for step 1.
We recommend using blue Loctite on all screws.

Step 3: Place remaining button head **M5 x 12mm** screws through rail and thread into forend and tighten, again using blue Loctite for best results. See diagram for mounting positions.

Step 4: If you are having some flex at the rear of the Arca Rail toward the magazine well, you can mount additional screws in the rearmost holes of the Arca Rail. To do this remove the forend and place M5 hex nuts in the appropriate pockets in the forend, then reinstall forend and install **M5 x 12mm** screws through Arca Rail into hex nuts. See diagram.



BUTTON HEAD M5 x 12mm
6 EACH

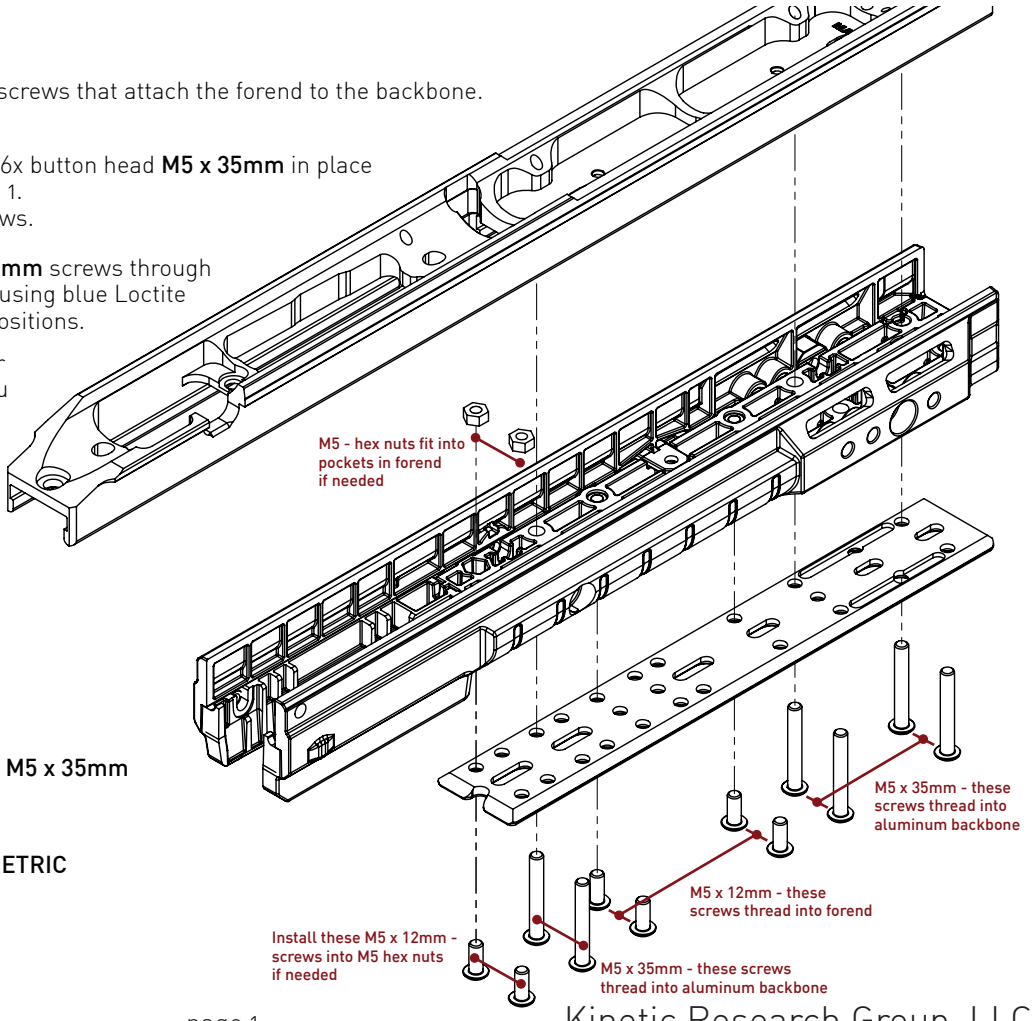


BUTTON HEAD M5 x 35mm
6 EACH

SCALE 1:1



HEX NUT M5 METRIC
2 EACH



Bravo (Gen 1), X-Ray (Gen 4) and Bravo 10/22 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 (**M5 x 22mm** for 10/22 Bravo Chassis). Remove forend from chassis.

Step 2: Insert the 6x M5 hex nuts and the 2x M5 flat nuts into the pockets in the forend as shown. Put a dab of grease on each one of the flat nuts to make it stick to the forend, or you can put a small piece of tape over them to hold them 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 4x 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 6x button head **M5 x 8mm** screws through the rail into the hex nuts you placed in the forend. Then use 2x button head **M5 x 8mm** screws at the front along the centerline threaded into the flat nuts, see diagram. We recommend using a small amount of blue Loctite on all screws.

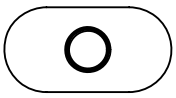
Step 5: Use the 2x button head **M5 x 30mm** (**M5 x 25mm** for 10/22 Bravo Chassis only) screws to go through the rail, through the forend, and thread into the aluminum backbone, then tighten all screws.



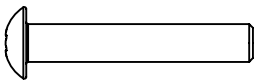
BUTTON HEAD M5 x 8mm
8 EACH



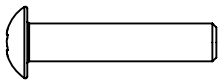
HEX NUT
M5 METRIC
6 EACH



FLAT NUT
M5 METRIC/10-32
2 EACH



BUTTON HEAD M5 x 30mm
2 EACH



BUTTON HEAD M5 x 25mm
USE 4 EACH
THESE ARE ALREADY IN PLACE
HOLDING FOREND ON

SCALE 1:1

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 6x **M5 hex nuts** and the 2x **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 6x button head **M5 x 8mm** screws through the rail into the hex nuts you placed in the forend. Then use 2x button head **M5 x 8mm** screws at the front along the centerline threaded into the flat nuts, see diagram. 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 30mm** screws to go through the rail, through the forend, and thread into the aluminum backbone.