

CSS R5 assembly instruction

MODIFICATION to your action

A small amount of bullet tip clearance is needed at the bottom of the action. If you don't have access to a milling machine a dermal type tool with a ¼ inch dia. Carbide burr or a ¼ inch dia. round file, cut a small semi circle about .050" deep at the bottom of the feed ramp. Use the opening in the bottom of the action sleeve as a guide as to how much material to remove. The other area that will need a small amount of material removed is the rear of the magazine well. Remove the tip of the projection so that the magazine will fit without interference.





Carefully fare out the transition where the radius meets the feed ramp with a small round file, be careful not to remove any material from the top of the feed ramp!



Gunsmithing

If you have experience with barrel chambering/ installation. Replace the factory recoil lug with the supplied recoil disc and check head space, if not, leave this to your qualified gunsmith!

Assembly

Remove any screws plugging the factory scope mounting holes in the top of the action. Test assemble your barreled action into the stock. Remove the bolt stop mechanism. Pay special attention to the screw locations with supplied washers. Remington actions can vary somewhat on the O.D., so check your action for a smooth non-binding fit. Make sure no bits of powder-coating interfere with the fit. If needed, a 120 grit abrasive flap wheel with extension and drill motor can be used to hone the I.D. of the action sleeve. Your action may require you to file off the raised area around the roll markings in order to fit into action sleeve.

When installing the action into the action sleeve, loosely install the action screws to align

the holes, stand the sleeve/ action assembly barrel up. Apply down force to seat recoil disc against the action sleeve and tighten the rear action screw (5/32 allen) and washer to 65 in.lb. Remove the front action screw and install the lower unit. Re- install the front action screw, add washer and rear lower unit screw. Tighten the front action screw (5/32 allen) next to 65 in.lb., then the rear lower unit allen nut (1/4" allen) last. Lastly, lightly tighten the brass set screws on top of action sleeve.

Magazine

The magazine is precisely machined and designed. It is a single stack design and is loaded similarly to a pistol magazine. Simply push the top round down and slide the front round from front to back. NEVER attempt to force a cartridge straight down between the feed lips. The magazine can be adjusted to correct for certain feeding problems. Loosening the rear screw, slide the rear half of the magazine up if you encounter high angle jams, and down if you encounter low angle jams. Only vary small amounts of adjustment are needed, .025 or less. It comes pre-adjusted and should work fine as received.

Bolt handle extension

If your bolt does not have an existing extension, the supplied extension is easy to install. Grind the factory knob into a pin about 1/2 in., dia.. Precision is not required. Just epoxy the supplied knob over the ground factory knob with a high quality epoxy adhesive. Do not use the five minute type, as they do not bond well to metal.

What is the stud sticking out of the lower unit for?

One of the best ways to operate a pistol grip equipped bolt gun in the rapids is to keep your thumb on the same side as the bolt handle. The thumb rest stud gives you something to leverage off of during rapid fire bolt opening. TRY IT!

Triggers Etc.

Although you can fit a stock Remington trigger into the R5, a trigger with captive internal components such as a Jewel is highly recommended.

If you have any questions please give me a call at (714)630-5734

Thank you,
Gary Eliseo