

RTM/RTS Assembly Instructions

Please completely read before starting

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!

Modifications to your action

If using A Remington action the projection at the rear of the of the magwell opening will need to be removed , some AICS magazine clones allow a longer cartridge overall length, if you plan on running a COL longer than 2.85” you may also need to cut a small radius at the front of the magwell opening for bullet tip clearance (RTS only). The best way to perform the modifications is with a milling machine but it can be done with a Dremel type tool, just take your time and be careful.



Positive Bolt Stop

Remove the factory bolt stop from the action. On RTS and RTM equipped with the “short box” lower unit, the buttstock will come supplied with a rubber bumper that the bolt shroud makes contact with, RTM’s equipped with the “long box” lower unit will require removal of the rubber bumper to allow additional bolt travel in order to strip a cartridge from the long magazine.

Assembly

Remove any screws plugging the factory scope mounting holes from the action. Test assemble your barreled action into the stock. 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 finish 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 action sleeve, loosely install the action screws to align the holes, stand the sleeve/ action assembly barrel up. Apply down force to seat the recoil disc against the action sleeve and tighten the rear action screw and washer to 65 in. lb. (5/32” allen) Remove the front action screw and install the lower unit. Re-install the front action screw, and washer and rear lower unit allen nut. Tighten the front action screw next to 65 in. lb (5/32” allen), then the rear lower unit allen nut (1/4” allen, careful do not over tighten) Lastly, lightly tighten the brass set screws on top of action sleeve.

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 as well to metal.

Triggers Etc.

Although you can fit a stock Remington trigger, a trigger with captive internal components such as a Jewel is highly recommended. If you need a safety, order the Jewel HVR trigger with a bottom safety (no bolt stop). Be sure to remove the bolt stop mechanism from your action.



Pin The Scope Rail

The scope rail is pre-drilled so it can be pinned to the action sleeve. The rail slot is slightly wider than the rail. This allows you to better center the windage on your scope. After your rifle is assembled, bore site your action and scope on a vertical line, leave the scope rail screws loose enough to allow movement of the scope. When satisfied, remove the scope, tighten the scope rail screws and drill through the holes in the scope rail into the action sleeve with a 3/16 inch drill. **BE CAREFUL NOT TO DRILL INTO THE ACTION!** Then drive the supplied roll pins in flush. I strongly recommend the rail be pinned to eliminate any possibility of movement.

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

Thank you,
Gary Eliseo