

NOTES:-

- 1-BEDDING MATERIAL:-
BISONITE RIFLE BEDDING R1888
AVAILABLE AT:
H & S PRECISION, INC.
P.O. BOX 512
PRESCOTT, AZ 86302
- 2-BEDDING COMPOUND SHALL BE THOROUGHLY PACKED INTO ALL ROUTED IN SUCH A MANNER TO ELIMINATE AIR BUBBLES, ASSURE 100% CONTACT WITH MATING PARTS. CAUTION: PARAGRAPHS 4.5 AND 6 MUST BE ACCOMPLISHED WITHIN 15 MINUTES.
- 3-PLACE SUFFICIENT BEDDING MATERIAL ALONG RECEIVER RAILS AND OTHER STOCK CONTACT SURFACES TO INSURE AN EXCESS OF BEDDING AT INTERFACING SURFACES.
- 4-LOCATE ASSEMBLY FIXTURE AGAINST FRONT FACE OF STOCK FERRULE AND MAINTAIN A PRESSURE AGAINST THE FERRULE WHILE CAREFULLY LOWERING THE ACTION INTO STOCK.
- 5-ASSEMBLE FIRING MECHANISM INTO STOCK. CLOSE TRIGGER GUARD TO DIMENSION SHOWN.
- 6-ON COMPLETION OF GLASS BEDDING, ALL EXCESS MATERIAL IN SOFT STATE AROUND PERIPHERY OF MATING COMPONENTS OR ASSEMBLIES SHOULD BE REMOVED.
- 7-BEDDING COMPOUND SHALL BE ALLOWED TO CURE PER MANUFACTURER'S INSTRUCTIONS.
- 8-PRIOR TO REMOVAL OF METAL PARTS, ALL PROJECTING MATERIAL SHOULD BE REMOVED TO ALLOW FOR EASY REMOVAL.
- 9-DISASSEMBLE BARREL AND RECEIVER ASSY AND FIRING MECHANISM FROM STOCK. REMOVE ALL CLAY MASKING, DEGREASE BARREL, RECEIVER ASSY AND FIRING MECHANISM.
- 10-THE FINISHED BEDDING SHALL BE FREE OF ALL VOIDS, CHIPS, AND CRACKS IN THE AREAS CONTACTED BY THE RECEIVER AND FIRING MECHANISM.
- 11-TRIM, REMOVE AND SMOOTH OUT ALL EXCESS BEDDING MATERIAL.
CAUTION: NO MATERIAL SHALL BE REMOVED FROM THE INTERFACE AREAS.
- 12-ASSEMBLE THE OPERATING COMPONENTS TO THE BARREL AND RECEIVER ASSEMBLY AND REINSTALL IN THE STOCK. OPERATING COMPONENTS SHALL NOT CONTACT THE STOCK. REMOVE SUFFICIENT MATERIAL FROM STOCK TO ELIMINATE ALL CONTACT OF OPERATING COMPONENTS.
- 13-THE LAST FOUR DIGITS OF THE RECEIVER SERIAL NUMBER SHALL BE INSCRIBED IN THE STOCK CHANNEL.

14-REWORKING, PATCHING, OR OTHERWISE REPAIRING THE STOCK BEDDING IS NOT PERMISSIBLE.

15-FINISH OF STOCK AFTER BEDDING:

PROTECTIVE FINISH AND COLOR:

A-FINAL PROTECTIVE FINISH:-FINISH 29.7 OF MIL-STD-171 (DIPPED A MINIMUM OF 3 MINUTES)

B-NO AREAS SHALL BE LIGHTER THAN THE APPLICABLE COMPARISON COLOR GAGE:

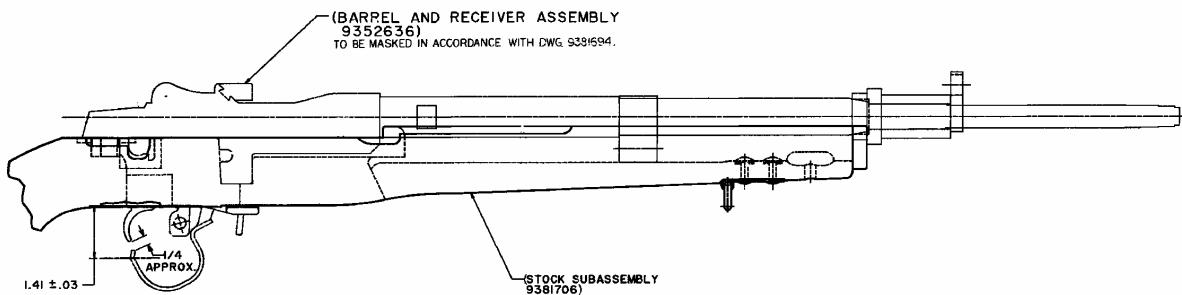
TYPE I WOOD: COMPARISON GAGE NO 11018988-W

TYPE II WOOD: COMPARISON GAGE NO 11018988-B

C-PRIOR TO APPLICATION OF FINAL PROTECTIVE FINISH, LIGHT AREAS SHALL BE STAINED USING A SPIRIT BASE STAIN, AS NECESSARY, TO MEET THE SPECIFIED COLOR REQUIREMENT.

16-AFTER APPLICATION OF PROTECTIVE FINISH, STOCKS SHALL BE FREE OF CRACKS, SPOTS, GLOSSY PATCHES, LIGHT STREAKS, RUNS, CONTACT MARKS, STICKINESS AND CRAZING. EXTERIOR STOCK CONTOUR SHALL BE SMOOTH AND EXHIBIT NO BUILD-UP OR RAISED GRAIN.

REV	DESCRIPTION	DATE	APPROVAL
1	PRODUCTION RELEASE SEE ERM W52051/040224 ECP W52069R1/ 8512231	860121	Jim



PART NO. 9381705

REVISIONS	DO NOT SCALE DRAWING	REVISION DATE OF DRAWING	84-05-09
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STOCK, SHOULDER, GUN
GLASS BEDDING
REQUIREMENTS FOR

19200 9381705

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