

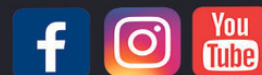


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WARNING: Make sure your rifle is unloaded and pointed in a safe direction.

A detailed list of torque specifications can be found on our website by scanning this QR code.

CHASSIS INSTALLATION INSTRUCTIONS

Tools needed for chassis installation

- **Torque wrench. (Make sure this is in INCH -pounds)**
- **Allen wrench set both standard and metric depending on chassis and components.**
- **Grease (white lithium or similar)**

1) Remove barreled action from original stock or chassis.

- **Factory action screws, bottom metal, and other parts will be removed and will stay with your factory stock.**

2) Clean the barreled action and chassis where the two will contact each other.

- **A dry rag will suffice just make sure there is no moisture/solvent on the receiver.**
- **If humidity is an issue in your area, you can put a very light layer of marine grease on the inlet to ensure corrosion does not occur. NOTE the light layer should be so small that you cannot even see the grease on the chassis.**

3) For TIKKA and CZ-457 actions ONLY- Place recoil lug (small silver bar sent with action screws) in the center of recoil lug pocket.

4) Take actions screws and place a small dab of white lithium grease around the first 2 to 3 threads of the action screws and smear it around the threads.

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5) Grab the appropriate allen wrench for the action screws installation.

- **5MM Allen for Tikka, Weatherby Vanguard and Howa 1500.**
- **4mm Allen for Anschutz and CZ-47.**
- **3/16 for all other standard actions.**

6) Place barreled action into chassis ensuring that barreled action is all the way to the rear.

- **Insert front action screw (short) and start that screw (do not fully tighten).**
- **Insert rear action screw (long) and start that screw (do not fully tighten).**

7) Stand the rifle upright with the recoil pad sitting on a work bench and muzzle pointing up. This will ensure the recoil lug is making solid contact. Tighten the front then the back action screws hand tight.

8) Finally torque the front then the back action screws.

- **For all centerfire receivers including 700 clone rimfires, torque to 65 INCH-pounds.**
- **For CZ-457 and Anschutz torque to 35 INCH-pounds.**

Your installation is now complete. Take the time to make sure your buttstock is setup correctly before heading to the range. If at anytime a bolt is not threading easily do not force it. STOP and call us so we can check and make sure nothing is wrong prior to damage.



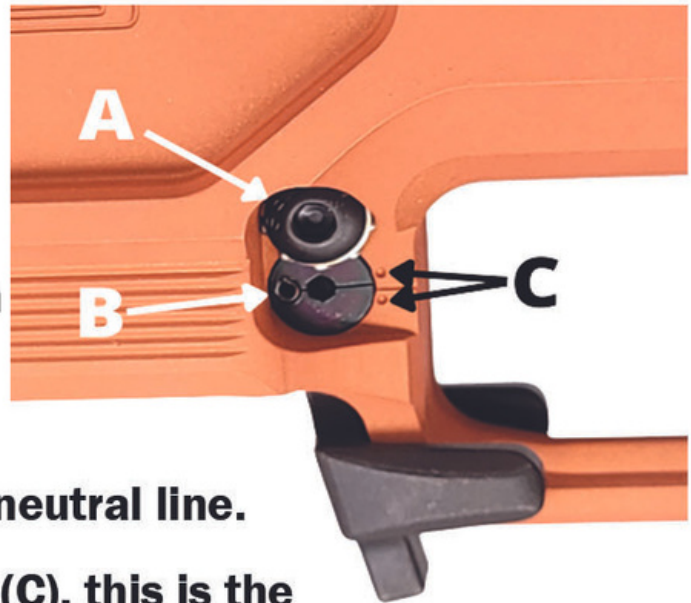
**Need the perfect tool
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NEW Adjustable DBM latch Instructions

- A. Lock bolt – 1/8 Allen
- B. Height ADJ – 3/32 Allen
- C. Min & Max Range



1) Loosen the lock bolt $\frac{1}{2}$ turn (A). This does not need to be removed.

2) The DBM will be set at the neutral line.

3) Notice the Min & Max dots (C), this is the maximum range of adjustment. Do not exceed past either of these marks when tuning the magazine height.

4) A small amount of adjustment on the eccentric roller (B) can make a large difference in magazine height, which results in bolt face to case head engagement. The result can help with feeding on both centerfire and rimfire rifles.

5) Tighten the lock bolt (A) after any adjustment is made, just hand tight. Checking this bolt routinely is recommended to make sure nothing has changed.

Disclaimers:

1) When using cleaning solvents, make sure none of the liquids seep through the action screw threads and get between chassis and action. Uncleaned solvents can cause corrosion over time.

2) If removing the buttstock, insure to remove set screw behind the grip.

3) Every 100-200 rounds you should ensure that all screws are staying torqued to proper spec.

Note: XLR Industries shall not be responsible for injury, death or damage to property resulting from the improper installation or misuse of this product.



XLR

Buttstock Installation & Fitment Instructions

WARNING: Make sure your rifle is unloaded and pointed in a safe direction.

XLR Buttstock Instructions

1) Prior to removal or installation of a new XLR buttstock, check the bottom of the chassis behind the grip or folding adapter for a set screw. This set screw needs to be removed with a 3/32" allen.

2) Apply a light layer of white lithium grease or similar to the inside of the buffer tube threads on the chassis.

3) Thread the buffer tube or buttstock into the chassis.

4) Once the buffer tube/stock bottoms out, back it out just enough for the groove on the buffer tube threads aligns with the hole for the set screw.

- **The contoured buffer tube on TR-2 buttstocks does not have this groove. Simply torque the buffer tube using the 1/4" allen provision in the rear of the tube.**

5) Any stock/tube that uses a castle nut can now be tightened. Keep the buttstock straight while doing this. The grip can be a great reference for alignment in relation to the bottom of the stock.

6) Thread the set screw back into the bottom of the chassis or folding adapter until it bottoms out making sure it is in the machined groove.

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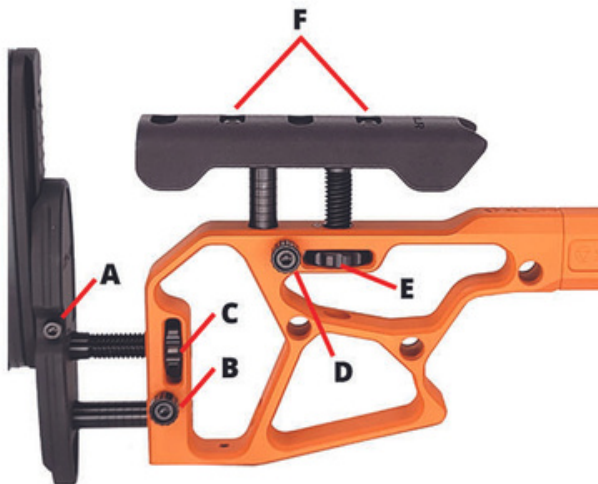
Buttstock Fitment

Measuring length of pull (LOP)

- 1) Start by curling your finger 90-degrees for natural trigger position.
- 2) Make a 90-degree angle with your shooting arm.
- 3) Measure from the pad of your trigger finger to the inside of your elbow joint.
- 4) Write down the measurement you get. Average in the US is 13.5".
- 5) Now measure where the LOP is currently set on the rifle, by measuring from the middle of the trigger shoe to the middle of the recoil pad in a straight line.

C-6 Buttstock Adjustments

- 1) To adjust the LOP on the C-6 buttstock, loosen the knurled tension knob "B" shown on the C-6 image.
- 2) You can now adjust wheel "C" until desired LOP is met. Snug the knurled knob "B" back to hand tight.



- 3) To adjust cheek rest height, loosen the knurled tension knob "D".

- 4) Turn the adjustment wheel "E" until you obtain the desired height for your cheek weld. Snug the knurled knob "D" back to hand tight.

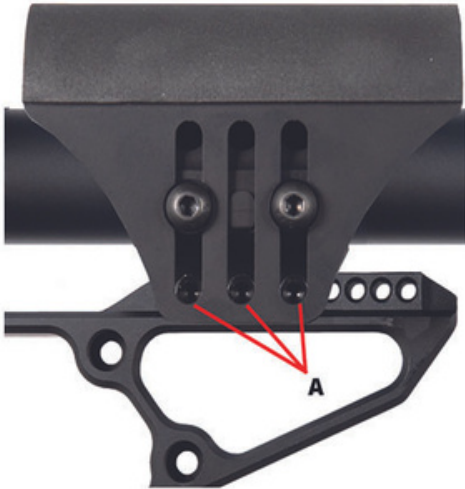
- 5) The C-6 will have a socket cap bolt "A" in the diagram located on the side of the rear recoil pad

plate. Push this in and you will be able to slide the recoil pad up or down. Do not tighten or loosen this bolt.

- 6) On the top of the C-6 buttstock cheek rest you will have two buttonhead bolts labeled "F" in the diagram. Loosen these bolts to adjust cast in the cheek rest or repositioned if the entire comb needs to be moved forward or aft.

Setting LOP for TR-2 Buttstock

1) Behind the TR-2 cheek there will be three allen screws shown as "A" in the below image. Loosen these three bolts with a 5/32 allen. The two bolts on the opposing side do not need to be loosened.



2) You might have to raise or lower the cheek rest to access these three bolts depending on where it is set.

3) Once the 3 bolts are loosened, you can set your desired LOP by sliding the entire assemble fore and aft on the buffer tube.

4) Once desired length is set, make sure the buttstock assemble is in proper alignment with the rest of the rifle and torque the three allen screws back to 35 inch-pounds for the TR-2.

Additional Notes For TR-2 (LOP)

- This is a great starting point for most, but not every shooter will use the LOP that they measure. Spend some time behind the rifle and make small changes that work best for you.
- Keep in mind that you can also finetune the LOP and your cheek rest to recoil pad distance by moving the interface between the cheek rest clamp and the butt stock triangle.

Recoil pad height and cant for TR-2 Buttstock

1) Begin by using a 3/16" allen wrench to remove the recoil pad.

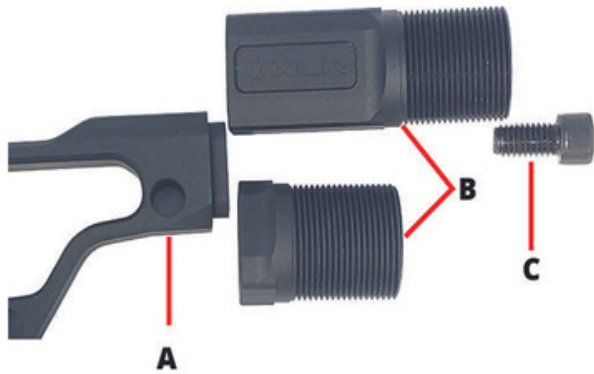
2) The first plate adjusts for pad height. Loosening the two bolts with a 5/32" allen and set the desired height. Torque bolts when done.

3) The height plate can be flipped for more adjustment either direction.

4) If you would like cant induced into the recoil pad, remove the first recoil pad height plate and loosen the two attachment screws for the second plate. Set the desired cant angle and torque screws.

Changing C-6 LOP Adapter

The C-6 Buttstock can have 3 different LOP ranges depending on if it is fixed or folding. Changing the range is done with the LOP adapter that threads into the chassis. In the image below shown as “B”.



1) Remove the set screw on the bottom of the chassis behind the grip or on the bottom of the folder with a 3/32” allen.

2) Break the castle nut loose and unthread the buttstock from the chassis.

3) On the inside of the threaded section of the LOP adapter “B” there will be a large socket cap bolt “C”. Remove this bolt with a 5/16 allen allowing the C-6 Main “A” and the LOP adapter “B” to be separated.

4) Swap the adapter and tighten the bolt down to 65 INCH pounds.

5) Re-install the castle nut to the farthest back thread. Apply a small amount of white lithium grease to the inside of the chassis threads and reinstall the C-6 buttstock.

6) Once the buttstock is threaded in all the way, back it out until the machined groove in the LOP adapter threads is aligned with the set screw provision.

7) Lock the castle nut down and re-insert the set screw.

Disclaimers

- When using cleaning solvents, make sure the cheek rest is properly covered or removed as the solvents will ruin the foam and adhesive used.
- A light coat of oil on the buttstock fasteners can help prevent rust over time.
- Every 100-200 rounds you should ensure that all screws are staying torqued to proper spec.

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