

# GRIND-TO-FIT RECOIL PAD

- Removal of existing recoil pad:** Remove the recoil pad using a Phillips screwdriver through the two holes/slits located at the top of the recoil pad. (If your recoil pad has been glued on, please see a gunsmith.)
- Wood stock prep:** (If your stock does not need to be cut to adjust length or to flatten, skip steps 2-4.)  
Determine how much of the stock has to be cut off to obtain the length of pull desired. Caution: Allow for enough pad thickness and enough material to sand smooth.
- Wrap the stock to protect the finish while handling.
- Masking tape should be used over the cut line to prevent splintering and chipping. Use tape that won't damage the finish. Saw off the stock.
- Plug and glue both screw holes in the gun stock with appropriate sized wood dowels if necessary. Ensure that the stock is flat and square with sides. Re-seal the cut surface with wood sealer or stain.
- Cut out the enclosed paper template with scissors. Center the template card on the gun stock. When the template is centered, hold the template firmly in place. Using a center punch, mark the screw hole locations through the paper template into the gun stock.
- Drill two 1/8" pilot holes for the screws 3/4" deep.
- Lubricate the screws (use parafin wax or Vaseline) and fasten pad to stock. Lubricate the screwdriver to prevent damage to the pad.
- Use a sharp-pointed scribe to accurately mark stock on pad back. This line is the key to an accurate installation.
- Remove the pad and fasten it upside down on the B-square jig with the bolts furnished with the jig. (Lubricate bolts.) Use washers under bolt heads. Be sure that the pad toe and the jig toe match. Important! Do not tighten the bolts enough to squeeze and distort pad.
- Loosen the pad jig center bolt, then place the base of the jig on the stock.
- Use a square and align the jig so that the pad back and the stock's toe line are square.
- Tighten the jig to maintain this angle on the sanding table.
- Carefully sand with a belt sander the toe end of the pad. Lubricate sanding belt with W-D 40 or equivalent often. Use 60-80 grit belt for rough. Stay away from your scribe line 1/16th of an inch, then change the belt to 120-240 grit belt for finish. Use a new belt for best results.
- Loosen the jig's center bolt with a wrench and place the pad jig on the gun butt.

# INSTALLATION INSTRUCTIONS

- Use a square and align the pad jig so that the back of the pad and the stock's upper surface (comb line/heel) are square.
- Tighten the jig clamp bolt to maintain this angle on the sanding table.
- Carefully sand the heel end of the pad to the scribe line. Carefully blend the sides from the heel to the toe.

**Option:** To give your pad a clean finished look freeze your pad overnight, and use Scotchbright® or 240 grit sandpaper lubricated with W-D 40 or equivalent to remove any burs and smooth the pad.

