

Installation of the 1005-306-87

Light Rifle Embedded Front Rail

For use with the A/N PVS-22/27 and similar systems

This work must be performed by an Armorer or Gunsmith familiar with these types of rifles.

Warning: Maximum barrel diameter at tip of forend is 1.175"!

1. Using a 1/2" dia. End mill, Mill a rectangular channel in the forearm of the stock that corresponds with the dimensions in Figures 1&2.

Note 1: CAUTION! You may wish to cut the channel shallow by about .050 to .1" and check to make certain the barrel is centered in the EFR.

2. The through holes in fig. 2 are for Sling swivel studs or the Picatinny rail, holes 1 & 4 are for the rail, Holes 2 & 4 are for studs, but you can choose whatever pattern you like. Drill to .201" (#7 drill).

3. Check your fit! Insert the Bed in tang (#3) of the LR EFR, screw in the LR bottom (#2) and then install barreled action and mount top of EFR (#1). **Check for clearance all around the barrel.**

4. You may need to adjust the inlet so that the barrel is centered in the EFR.

Test fit with Studs or rail and screws before applying adhesive! You may need to shorten the screws/studs to fit your application.

5. After fitting, bed the Bed in stub (#3) into the stock with Marine-Tex fig. 3 (recommended), if you are going to use the rail, use the 2 nylon screws provided to hold the mount in place until it cures. Use release agent on the screws for best results! If you choose to use sling studs (#11) and washers (#12), install them now. It is OK to glue these in place. Again you may need to shorten the sling studs for your stock. Allow the adhesive to fill the tops of the 3 counter bores in the Bed in tang (#3).

6. Make certain you clean all excess adhesive before it sets.

7. When the adhesive is set, install LR bottom (#2) w/ screws (#10) using 5/32 hex wrench(#13).

8. Install barreled action, and EFR top, mount w/ 6 screws (#7) using Torx wrench (#14).

Optional- Install Bipod rail (#5) with low head cap screws (#9)

9. Mount the Modular accessory rail (#4) as needed with Screws (#8) using 5/32 hex wrench(#13).

Make sure your cut is parallel and square with the top line of the stock!

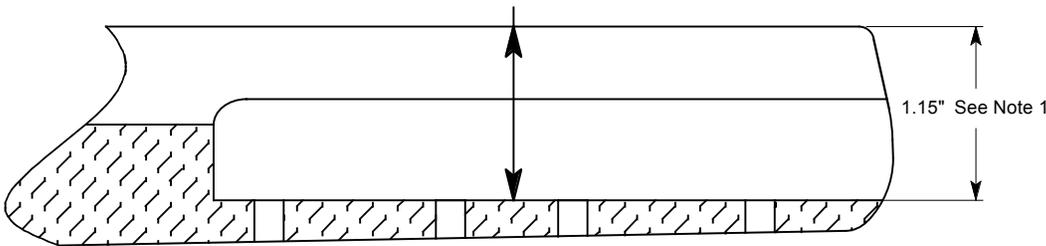


fig.1

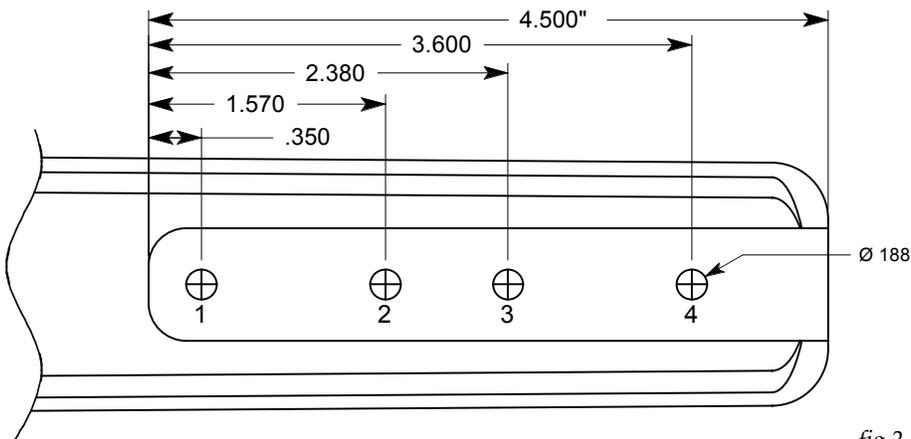
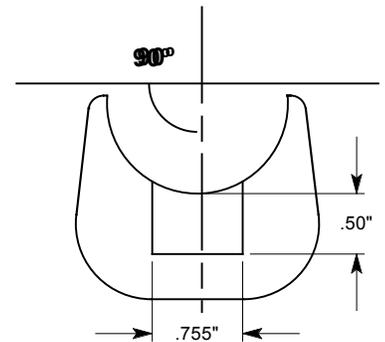


fig.2

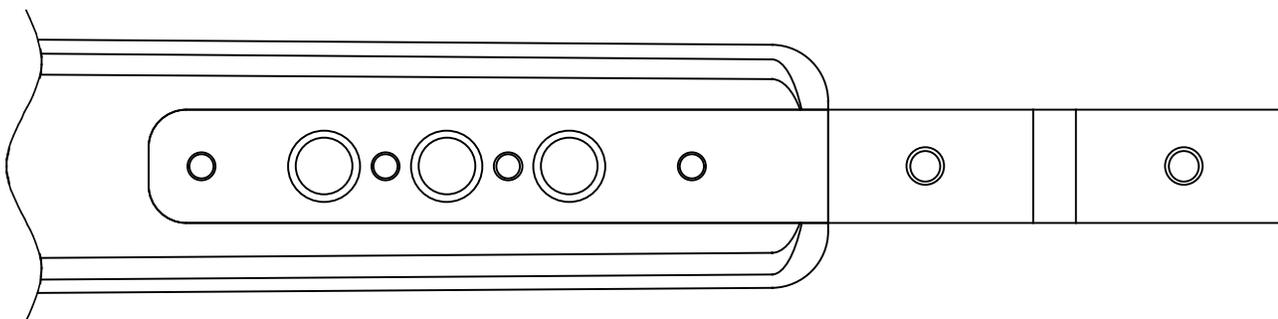
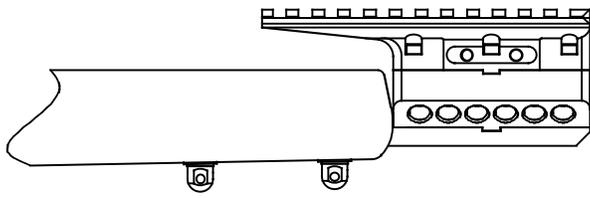
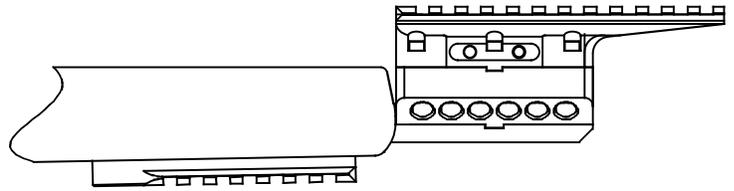


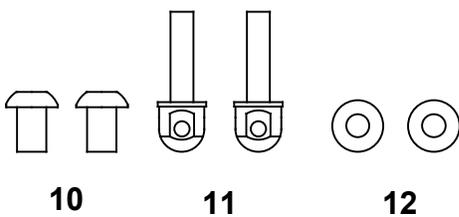
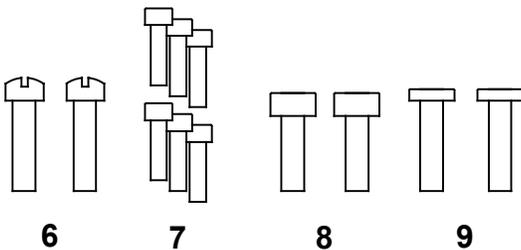
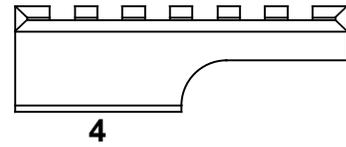
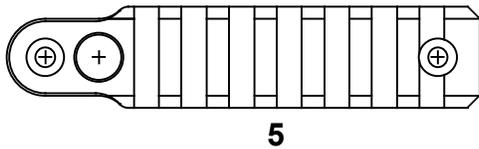
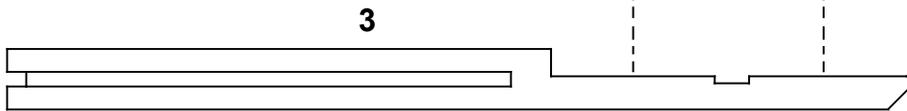
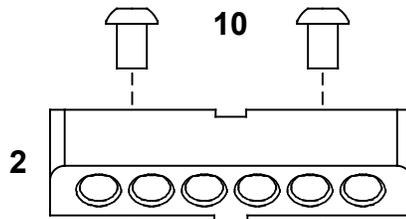
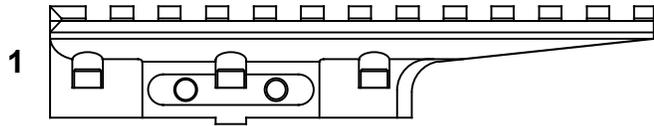
fig.3



With sling studs



With Picatinny rail



Name	Qty.	P/N
EFR, Top	1 ea.	1
LR, Bottom	1 ea.	2
Bed in Tang	1 ea.	3
Rail, Modular	1 ea.	4
Rail, Bipod	1 ea.	5
Screw, Nylon 10-32 X 1	1 ea.	6
Socket head cap screw, 6-32X .5	6 ea.	7
Socket head cap screw, 10-24 X .625	2 ea.	8
Low head cap screw, 10-32 X 1	2 ea.	9
Button head cap screw, 1/4-20 X .375	2 ea.	10
Sling studs, 10-32 X .75	2 ea.	11
Washer, Sling stud	2 ea.	12
Wrench, Hex 5/32"	Not shown	1 ea. 13
Wrench, Torx T15	Not shown	1 ea. 14

