

## **Custom Laminated Wood AR Stock Installation**

**CAUTION: REMOVE MAGAZINE AND VISUALLY CHECK CHAMBER BEFORE FURTHER HANDLING OF YOUR RIFLE TO VERIFY THAT IT IS NOT LOADED!**

This laminated wood stock is made to fit the contours of standard AR-15 lowers. However, it represents a compromise of dimensions to enable it to be fitted to most lower receivers. As the AR-15 lower receiver was never intended to be fitted to a unitized stock, the pistol grip relief cut varies significantly in its relationship to the extension tube position. Therefore, it is impossible to make a stock that is a drop in fit for all receivers. **IF YOU DO NOT FEEL COMFORTABLE DOING SOME MINOR INLETTING AND GLASS BEDDING, HAVE A COMPETENT GUNSMITH INSTALL THE STOCK OR CALL US FOR INSTALLATION.** In addition, this is not a "combat" stock. It is an exotic commercial stock and should not be abused or exposed to extreme conditions. Always transport your rifle in a hard case to prevent it from being stressed at the stock area and causing fractures. **NO WARRANTY WILL BE MADE FOR STOCKS DAMAGED DURING INSTALLATION OR DAMAGED BECAUSE OF POOR INSTALLATION.** (Installation by JPE including glass bedding to receiver available for \$55.00 plus shipping. Send lower only.)

### **INSTALLATION PROCEDURE:**

First remove the existing butt stock and pistol grip. Remove and set aside the take down detente plunger and spring from the back of the lower receiver and the safety detente plunger and spring and selector from the pistol grip area. Take care not to lose these small parts. Check the web area between the grip and the extension tube hole for excess glue that may prevent the stock from sliding all the way up on the receiver and remove any such material. Slide the laminated stock on the extension tube for a trial fit. It may stop at the pistol grip cut out on the receiver. The pistol grip relief cut on the receiver varies quite a bit from manufacturer to manufacturer and the upper surface of the grip interface is set high for the highest receivers we have found to minimize this gap for cosmetic reasons. This feature may have to be lowered on the stock by file fitting until the grip area of the stock clears the grip relief feature on the receiver. With the stock butted up to the pistol grip relief cut on the receiver, try holding a straight edge against the lower edge of the receiver and drawing a line with a pencil to indicate how much material must be removed to allow the stock to fit the pistol grip relief cut. (See "A" on diagram)

Once you have cleared the grip relief cut and the stock slides up on the receiver, it may again seem to stop at the flange on the extension tube. Press a little harder and it will usually pop over the flange and butt up to the receiver. Do not use excessive force, if it won't slide on there may be something unseen interfering. Check the web area and the extension tube hole for obstructions. Now try again to slide the stock all the way up on the receiver. If it will not engage, there may be some excess glue in the bore of the stock causing a misalignment problem. We have tried to clean the residual glue out as best as possible, but sometimes this problem doesn't present itself until actual installation. If this appears to be the problem, remove any remaining excess glue and try to engage the butt screw again. The flange on the extension tube may be a bit too large for the flange cut in the stock. You may take a Dremel tool with a sanding drum and further relieve that area or remove the extension tube and turn it down a few



Hold ruler on this receiver and draw a line to indicate inletting necessary to clear receiver.

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## ***LAMINATED STOCK INSTALLATION, PG. 2***

thousands. Now, slide the stock on and try to engage the pistol grip screw. If it will not engage, remove it and look down the hole with a flashlight to determine if the stock is lined up with the receiver. Determine where inletting must be done to clear the pistol grip screw. We have eliminated the extension tube butt stock screw for cosmetic reasons and also due to the fact that it is not needed on a unitized stock. The pistol grip screw is all that is needed to retain a unitized stock. **BE CAREFUL NOT TO OVER TIGHTEN THE SCREW.**

If you have been successful up to this point and have the pistol grip screws engaged, it is strongly recommended that the stock be glass bedded to the back of the receiver to evenly distribute the recoil impulse and strengthen the stock/receiver interface to reduce the possibility of future cracking. The web area between the extension tube and pistol grip may need to be bedded if a significant gap exists between the stock and the back of the receiver. Be sure to tape over the safety detente hole and reapply release agent to the receiver. The web area of the stock is purposely over relieved to allow for variations in receivers, so it may require a significant quantity of bedding compound. Install the grip screw and allow to cure.

After the bedding has cured, remove the stock and clean up the release agent from the receiver. Now assemble the complete system. You will not be using the original safety detente spring. Supplied with the stock kit is a short conical shaped spring which must be held in place with a knife blade while sliding the stock over it. With the lower receiver supported up-side-down in a padded vice, insert the take down detente plunger and spring (narrow end into the hole in the receiver) and slide the stock over it carefully snugging it up to the receiver. Test the safety detente pressure. If it is acceptable, install the hex bolt in the pistol grip and test again. If there is too much detente pressure on the safety, slide the stock off, taking care not to launch the spring. Cut 1/2 coil off the spring, re-install the stock and test the safety detente again. Repeat until acceptable safety detente is achieved and finish the installation.

**Do not attempt to drill a hole for the original spring** as you may ruin the stock and if you try and install the spring in the stock as in the original pistol grip, it locks the new stock in place and makes it nearly impossible to remove because it is a one piece unit. The short spring provided will give acceptable safety detente pressure when properly fitted and installed.

Again, if you don't feel comfortable doing any of this, don't feel embarrassed. This kind of work is not for everybody. That's why you have us. If you need the stock installed, we charge \$55.00 installation plus return shipping.

### **CARE AND MAINTENANCE:**

We have opted for a flat oil finish on these stocks which makes it easy to repair a scratch or ding and to modify the stock somewhat and easily match the finish. The high gloss poly finishes, once scratched are nearly impossible to repair. However, we realize that some of you may prefer the more refined gloss finishes. If you would like, you can bring your stock up to any level of finish from semi-gloss to a glass like finish using Birchwood Casey Tru-oil. Any respectable gun shop would carry it and it can be applied right over the oil finish in as many coats as you wish. With sanding and polishing, you can get a glass like finish if you desire. You may also use the Tru-oil for an occasional maintenance coat to keep the wood sealed from moisture. However, we feel the best "oil" finish is Watco Danish Oil Finish, available at hardware stores.

***THANKS FOR YOUR BUSINESS!***

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