



TAC21 **GEN 2**

OWNERS MANUAL

CHASSIS SYSTEM FOR BOLT-ACTION RIFLES



MDTTAC.COM

Shoot Better.™

TAC21 GEN2 CHASSIS SYSTEM



TAC21 Gen 2 Chassis System For Savage

Thank you for choosing the MDT TAC21 Gen 2 Rifle Chassis System.

Like the MDT TAC21 this chassis has been developed by MDT to provide the ultimate in benchrest accuracy, recoil reduction and follow up shot speed with its inline design.

- Crafted from 6061 aluminum - eliminating warping and distortion.
- The rifle receiver only makes contact with the V-shape bedding area, thereby floating the entire barrel.
- The recoil lug mating surface area ensures the best accuracy and repeatability.
- The built-in mounting rail has 20 MOA (Minutes of Angle) on the action housing and is parallel to the barrel axis on the fore-end.
- Accepts standard AR-style and vertical pistol grips

The MDT TAC21 Gen 2 chassis allows the shooter to add tactical components, leading to better accuracy and functionality:

- New fore-end options with various lengths that all allow the installation of M-Lok accessories
- New barricade grooves to the front of the lower receiver for a firm hold when shooting off of barricades
- New rear end cap cam-lock system to ensure a rock solid connection between your chassis and buttstock

CAUTION: AVOID RESTING OR HITTING THE BARREL AGAINST ANY SURFACE WHILE HANDLING THE ACTION, STOCK, AND CHASSIS.

TOOLS REQUIRED

- 1/8" Allen wrench
- 3/16" Allen wrench
- 5/32" Allen wrench
- Small hammer
- Tweezers
- Inch-lb torque wrench (optional)

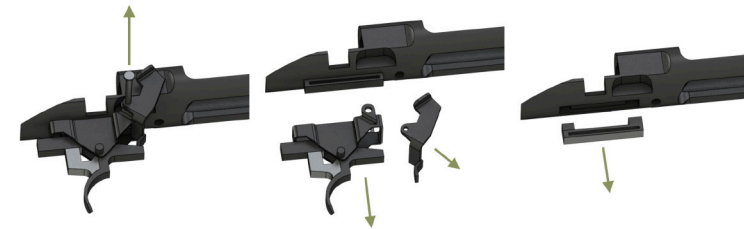
NOTE: THESE INSTRUCTION APPLY ONLY FOR STOCK OEM SAVAGE SHORT ACTION RIFLES WITH TOP BOLT RELEASE.

REMOVING THE ACTION

1. Ensure that the firearm is unloaded.
2. Remove the magazine (if inserted) and bolt.
3. Using the appropriate Allen wrench for your firearm, release and remove the two screws holding the stock to the action.
4. Set these screws aside as they are no longer needed.
5. Remove the barralled action from the stock.
6. If your action has not had a scope on it previously remove the set screws from the scope base mount holes

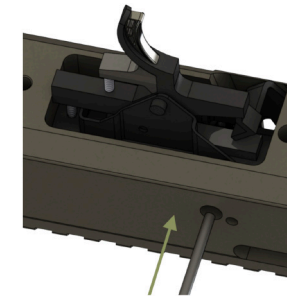
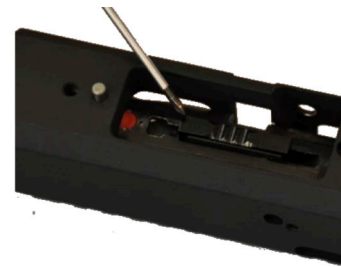
REMOVING THE TRIGGER

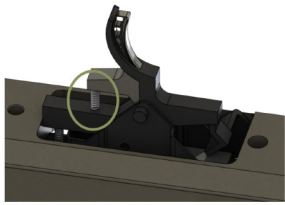
1. With a 1/8" drift punch or a small Phillips screwdriver, push out the sear pin towards the side where the bolt release is. Be sure to retain bolt stop/sear spring from flying out.
2. Your trigger will be loose and can now be removed from the action. Make sure you do not lose the sear spring.
3. Slide the safety all the way to the rear of the action, now you can remove the safety bar. You do not need to remove the safety tab.



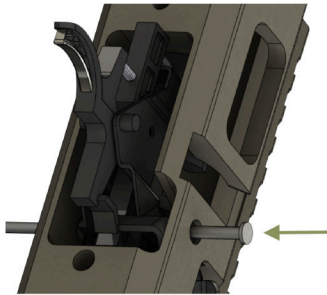
CHASSIS INSTALLATION

1. Place action housing with the rail side down in a vice with soft jaws or on a padded table with soft cloth or old towel.
2. Slide the action without its trigger into the upper housing until the recoil lug of the action makes contact with the chassis housing
3. Reinstall safety bar and slide forward, make sure it is connected with the safety tab.
4. Reinstall sear and trigger, making sure that the rear of the trigger is hooked into the action housing and the trigger spring is in its proper place.
5. With a small punch or Phillips screw driver line up and capture trigger and sear into action by sliding the tool through the front hole and through the trigger and sear.

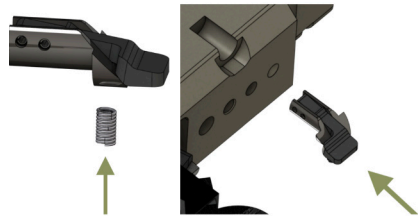




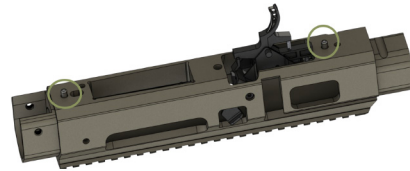
6. Reinstall sear spring in place and apply light pressure while capturing it with the Phillips screwdriver. This may take several tries as it is not the easiest thing to do even without the chassis.
7. Reinstall the sear pin by pushing out the screwdriver from the opposite side making sure to capture the sear spring.
8. Using a small punch or Philip screw driver push the sear pin all the way into the chassis. This will be a tight fit as the chassis is designed to be offset to prevent walk out of the pin while firing.



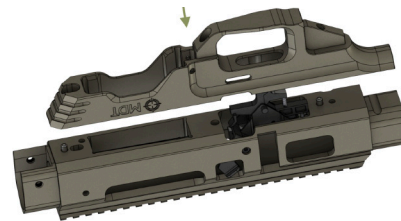
9. Insert the end cap catch assembly into the action housing by sliding the catch assembly into the dovetail style pocket while applying force to the rear of the spring. This will compress the spring and allow it to tuck in between the catch assembly and the upper action housing.



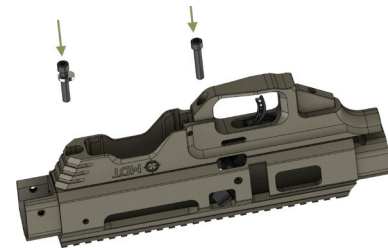
10. Place the two 3/16" (0.188") dowel pins into the action housing. This will align the trigger housing with the action housing.



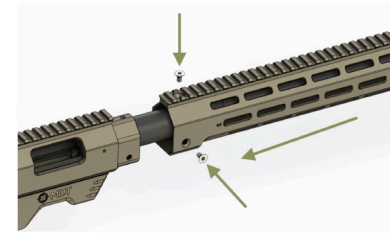
11. Place the trigger housing onto the dowel pins and press down firmly until flush with action housing.



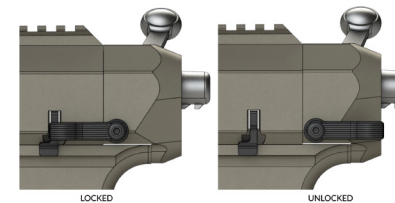
12. Place the two action screws into the trigger housing and screw in until snug. Push barralled action into action housing until recoil lug makes contact with the action housing. Hand tighten the two action screws. The front action screw will have an elongated washer, this is to accommodate the different size hole spacing between early and late savage models.
13. Torque the action screws to 80inch pounds starting with the front screw.



14. Slide fore end on to barrel and action housing and secure with the 3 forend bolts. Torque to maximum of 36 inch pounds so as not to strip the helicoils.



15. Install pistol grip using pistol grip screw. Take care to not cross thread the screw into the chassis. The screw should go in freely and not require excessive force
16. Before installing the end cap reinsert the bolt into the action.
17. Install the end cap assembly onto the action housing by sliding it onto the housing. Ensure that the cam lock is in the unlocked position (arm pointing away from barrel end). Once it is in place, rotate the arm on the end cap assembly into the locked position (arm pointing towards barrel end).



18. You may now install a buffer tube or buttstock into the rear end cap. Follow the manufacturer's instructions for this installation.
19. Install bolt into action. Load an EMPTY magazine and check the fit. Make sure rifle is not loaded.
20. Check function of bolt, trigger and safety, again making sure your firearm is unloaded. Using snap-caps, verify the smooth loading and ejection.
21. Your build is complete and ready for rings, scope and accessories

CAUTION: RE-TIGHTEN ALL SCREWS, FASTENERS AND CASTLE NUTS AFTER INITIAL USE (APPROX. 100 ROUNDS)

TAC21 GEN2 CHASSIS SYSTEM



TAC21 Gen 2 Chassis System For Tikka

Thank you for choosing the MDT TAC21 Gen 2 Rifle Chassis System.

Like the MDT TAC21 this chassis has been developed by MDT to provide the ultimate in benchrest accuracy, recoil reduction and follow up shot speed with its inline design.

- Crafted from 6061 aluminum - eliminating warping and distortion.
- The rifle receiver only makes contact with the V-shape bedding area, thereby floating the entire barrel.
- The recoil lug mating surface area ensures the best accuracy and repeatability.
- The built-in mounting rail has 20 MOA (Minutes of Angle) on the action housing and is parallel to the barrel axis on the fore-end.
- Accepts standard AR-style and vertical pistol grips

The MDT TAC21 Gen 2 chassis allows the shooter to add tactical components, leading to better accuracy and functionality:

- New fore-end options with various lengths that all allow the installation of M-Lok accessories
- New barricade grooves to the front of the lower receiver for a firm hold when shooting off of barricades
- New rear end cap cam-lock system to ensure a rock solid connection between your chassis and buttstock

CAUTION: AVOID RESTING OR HITTING THE BARREL AGAINST ANY SURFACE WHILE HANDLING THE ACTION, STOCK, AND CHASSIS.

TOOLS REQUIRED

- 1/8" Allen wrench
- 3/16" Allen wrench
- 5/32" Allen wrench
- Small hammer
- Tweezers
- Inch-lb torque wrench (optional)

NOTE: THESE INSTRUCTION APPLY ONLY FOR STOCK OEM TIKKA SHORT ACTION RIFLES.

REMOVING THE ACTION

1. Ensure that the firearm is unloaded.
2. Remove the magazine (if inserted) and bolt.
3. Using the appropriate Allen wrench for your firearm, release and remove the two screws holding the stock to the action.
4. Remove the barreled action from the stock.
5. If your action has not had a scope on it previously remove the set screws from the scope base mounting holes
6. Place safety lever on 'safe'.

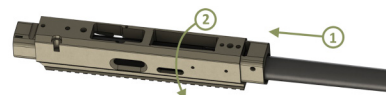
REMOVING THE ACTION

1. Loosen trigger bolt using 5mm allen wrench.
2. Remove trigger, tension clip and 5mm allen bolt.
3. Remove bolt stop by pulling out bolt stop pin. Take care not to lose the small spring.

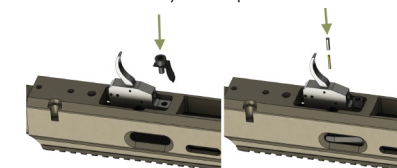


CHASSIS INSTALLATION

1. Slide action into main housing.
2. Rotate action 45 degrees (counter clockwise if looking down barrel). This will enable the safety lever to slip in between the action and main housing
4. Reinstall trigger bolt and tension clip, torque to 25-30 inch/lbs.
5. Reinstall bolt stop and secure with original bolt stop pin.
6. Install 1/8" x 1/2" dowel pin on top of original bolt stop pin. This will ensure that the original bolt stop pin cannot fall out once assembly is complete.



3. Rotate the action back to its original position whilst guiding the trigger mechanism into its intended position.



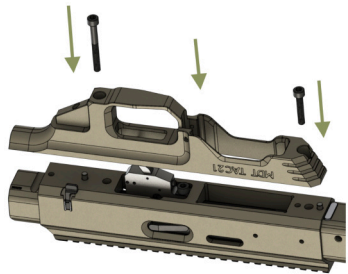
7. Insert the end cap catch assembly into the action housing by sliding the catch assembly into the dovetail style pocket while applying force to the rear of the spring. This will compress the spring and allow it to tuck in between the catch assembly and the upper action housing.



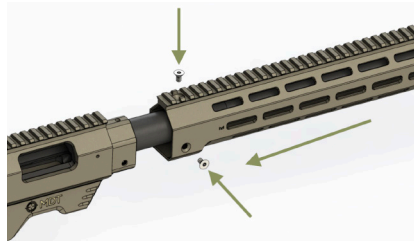
8. Install 3/16 x 1/2 dowel pins into main housing
9. Install lever lock insert on the side of the main housing.
10. Install recoil lug key into slot and ensure that it's seated in the action.



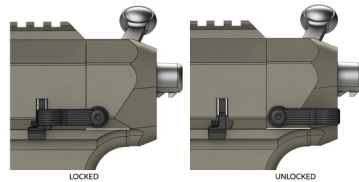
11. Fit trigger housing onto main housing by way of dowel pins. Install M6 bolts as shown. 30mm bolt is installed in the front, 50mm bolt is installed in the rear. Torque to 65 inch/lbs.



12. Slide fore end on to barrel and action housing and secure with the 3 forend bolts. Torque to maximum of 36 inch pounds so as not to strip the helicoils.



13. Install pistol grip using pistol grip screw. Take care to not cross thread the screw into the chassis. The screw should go in freely and not require excessive force
14. Before installing the end cap reinsert the bolt into the action.
15. Install the end cap assembly onto the action housing by sliding it onto the housing. Ensure that the cam lock is in the unlocked position (arm pointing away from barrel end). Once it is in place, rotate the arm on the end cap assembly into the locked position (arm pointing towards barrel end).



16. You may now install a buffer tube or buttstock into the rear end cap. Follow the manufacturer's instructions for this installation.
17. Load an EMPTY magazine and check the fit. Make sure rifle is not loaded.
18. Check function of bolt, trigger and safety, again making sure your firearm is unloaded. Using snap-caps, verify the smooth loading and ejection.
19. Your build is complete and ready for rings, scope and accessories

TAC21 GEN2 CHASSIS SYSTEM



TAC21 Gen 2 Chassis System For Remington 700

Thank you for choosing the MDT TAC21 Gen 2 Rifle Chassis System. Like the MDT TAC21 this chassis has been developed by MDT to provide the ultimate in benchrest accuracy, recoil reduction and follow up shot speed with its inline design.

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CAUTION: AVOID RESTING OR HITTING THE BARREL AGAINST ANY SURFACE WHILE HANDLING THE ACTION, STOCK, AND CHASSIS.

TOOLS REQUIRED

- 1/8" Allen wrench
- 3/16" Allen wrench
- 5/32" Allen wrench
- Small hammer
- Tweezers
- Inch-lb torque wrench (optional)

NOTE: THESE INSTRUCTION APPLY ONLY FOR STOCK OEM REMINGTON 700 ACTIONS.

CAUTION: RE-TIGHTEN ALL SCREWS, FASTENERS AND CASTLE NUTS AFTER INITIAL USE (APPROX. 100 ROUNDS)

REMOVING THE ACTION

1. Ensure that the firearm is unloaded.
2. Remove the magazine (if inserted) and bolt.
3. Using the appropriate Allen wrench for your firearm, release and remove the two screws holding the stock to the action.
4. Set these screws aside as they are no longer needed.
5. Remove the barralled action from the stock.
6. If your action has not had a scope on it previously remove the set screws from the scope base mounting holes.

REMOVING THE TRIGGER

1. Move the trigger to the "safe" position. This will expose the rear pin hole
2. With a 1/8" drift punch and a small hammer, drift out the rear trigger pin (bolt stop pin) away from the safety latch side. Ensure that the bolt stop spring does not fly away.
3. Your trigger will be loose from one end and the sear will no longer be locked.
4. Turn your action over and remove the bolt stop and bolt stop spring from the action. Do not lose these. They will be needed momentarily.
5. With a 1/8" drift punch and small hammer, drift out the front trigger pin in the same direction you drifted the rear pin.

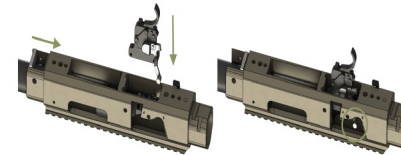


6. Remove the sear and sear spring from the action. Place these to the side, they will be needed momentarily. Make sure you do not lose the sear spring.
7. Remove the trigger from the action
8. Reinstall the sear spring and sear into trigger by using the two small (0.125" diameter x 0.300" long) trigger slave pins included in your kit. Start with the front pin and rotate the sear into the trigger while capturing the spring. Secure the assembly with the second pin. This will hold the trigger together for re-installation.

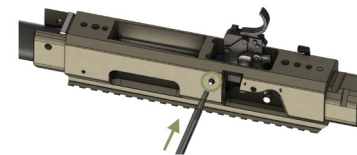


CHASSIS INSTALLATION

1. Place action housing with the rail side down in a vice with soft jaws or on a padded table with soft cloth or old towel.
2. Slide the action without its trigger into the upper housing until the recoil lug of the action makes contact with the chassis housing
3. Slide the action forward approximately 1"
4. Ensure the trigger assembly is still on safe. It must be set to safe to successfully reinstall it into the chassis
5. Drop in the trigger while guiding the safety lever into the cut out safety slot in the TAC21. While doing this slowly push the action back into the housing until it makes contact with the recoil lug.



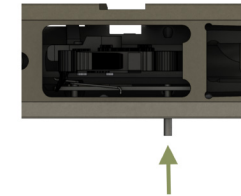
6. With the trigger and action in place, slide in the sear pin (short) on the front hole from the same side as the safety lever. Use a drift punch to push out the trigger slave pin through the action and drift it flush with the bolt stop notch.



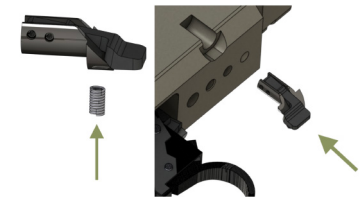
7. Using tweezers place the bolt stop into its proper place with the hook end to the rear and underneath the bolt.
8. Insert bolt stop spring with tweezers with the 90 degree bent side toward the front of the action and resting on top of the bolt stop body



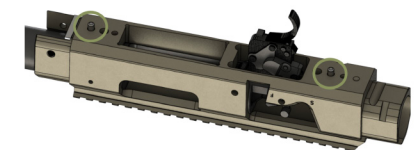
9. Press down with a screwdriver on the bolt stop spring and insert the bolt stop pin (long) through chassis, the bolt stop, spring, and through the action/trigger pushing out the second trigger slave pin. Use a drift punch and drive it flush with bolt stop



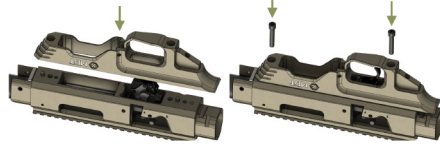
10. To install the end cap catch into the action housing first start by inserting the spring into the rear of the end cap catch assembly.
11. Insert the end cap catch assembly into the action housing by sliding the catch assembly into the dovetail style pocket while applying force to the rear of the spring. This will compress the spring and allow it to tuck in between the catch assembly and the upper action housing.



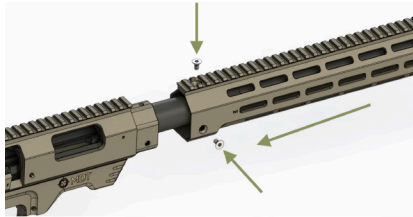
12. Place the two 3/16" (0.188") dowel pins into the action housing. This will align the trigger housing with the action housing.



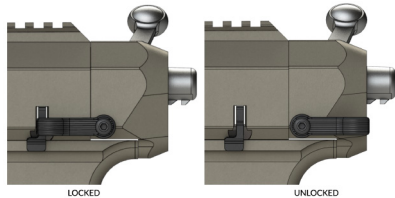
13. Place the trigger housing onto the dowel pins and press down firmly until flush with action housing.
14. Place the two action screws into the trigger housing and screw in until snug. Push barreled action into action housing until recoil lug makes contact with the action housing. Hand tighten the two action screws.
15. Torque the action screws to 60 inch pounds starting with the front screw.



16. Slide fore end on to barrel and action housing and secure with the 3 forend bolts. Torque to maximum of 36 inch pounds so as not to strip the helicoils.



17. Install pistol grip using pistol grip screw. Take care to not cross thread the screw into the chassis. The screw should go in freely and not require excessive force
18. Before installing the end cap reinsert the bolt into the action
19. Install the end cap assembly onto the action housing by sliding it onto the housing. Ensure that the cam lock is in the unlocked position (arm pointing away from barrel end). Once it is in place, rotate the arm on the end cap assembly into the locked position (arm pointing towards barrel end).



20. You may now install a buffer tube or buttstock into the rear end cap. Follow the manufacturer's instructions for this installation.
21. Install bolt into action. Load an EMPTY magazine and check the fit. Make sure rifle is not loaded.
22. Check function of bolt, trigger and safety, again making sure your firearm is unloaded. Using snap-caps, verify the smooth loading and ejection.
23. Your build is complete and ready for rings, scope and accessories

CAUTION: RE-TIGHTEN ALL SCREWS, FASTENERS AND CASTLE NUTS AFTER INITIAL USE (APPROX. 100 ROUNDS)

MAINTENANCE INFORMATION

NOTICE: THIS MANUAL COMPLEMENTS YOUR RIFLE MANUFACTURER'S MANUAL. FOLLOW ITS LUBRICATION AND MAINTENANCE INSTRUCTIONS.

When should I clean and lubricate my new MDT chassis?

- Before and after long-term storage;
- Soon after being subject to adverse conditions such as rain, snow, mud, sleet, or saltwater;
- Soon after operating in rough conditions such as lying on the ground outdoors or dropped in mud.

How should I clean and lubricate my MDT chassis?

- Use a damp (not wet) clean cloth to remove dirt and other stains from the surfaces.
- Use a dry clean cloth to dry and finish the cleaning;
- Do not apply oil on the chassis surfaces;
- After cleaning, place a drop of gun oil in the sling swivel stud, magazine lock pin, action screw, and pistol grip screw.

NOTE: AFTER USE UNDER EXTREME CONDITIONS, IT MAY BE NECESSARY TO DISASSEMBLE THE CHASSIS FOR PROPER CLEANING.

Is the MDT chassis corrosion-proof?

- Yes, the MDT chassis coating provides superior corrosion protection using Cerakote®.
- However, only proper care can keep your firearm and chassis system in good operating condition, and maintain its appearance.
- If after extensive use the protective coating on plated parts shows signs of reduced corrosion protection, recoat or replace the parts to ensure the integrity of the chassis.

WARRANTY

What warranty does MDT provide?

- MDT offers a 100% satisfaction guarantee on all products. If you receive any of MDT product, but you are not completely satisfied, return it to MDT's central office within 30 days for a 100% refund.
- All our products come with lifetime support against defects.
- Performing modifications/alterations to the product voids all warranties, expressed or implied.

How do I claim warranty on a MDT product?

- If you experience a problem with your MDT Rifle Chassis system, call us or initiate a service ticket through the MDT website.
- Warranty claims must show the product model, a contact email, a phone number, and a description of the problem.

How MDT process warranty claims?

- Upon receiving the item, MDT decides whether to accept the warranty claim, and whether to repair or replace the parts, at its discretion.
- MDT accepts no responsibility for loss or damage in transit.
- MDT pays for shipping and insurance charges for the return to the owner, ONLY after accepting the warranty claim.
- If non-warranty parts or services are required, MDT provides an estimate for approval prior to performing any service.

What are the warranty limitations?

- This warranty is exclusive and is in lieu of any and all other warranties, expressed or implied. No implied warranties of merchantability or fitness for a particular purpose are given and any and all liability for breach of any implied warranty or warranty created by law is disclaimed.
- Under no circumstances shall MDT be liable for incidental or consequential damages with respect to economic loss, injury, death or property damage, whether as a result of breach of this warranty, negligence or otherwise.

Jurisdictional Exceptions:

- Some jurisdictions do not allow limitations on how long an implied warranty lasts, so the above limitation may not apply to you.
- Some jurisdictions do not allow the exclusion or limitation of incidental or consequential damages, so the above limitation or exclusion may not apply to you completely or in part.
- This warranty gives you specific legal rights. You may also have other rights that vary from jurisdiction to jurisdiction.

SAFETY GUIDELINES

1. ALWAYS KEEP THE MUZZLE POINTED IN A SAFE DIRECTION.

UNLOAD ALL FIREARMS WHEN NOT IN USE. ALWAYS VERIFY. Never allow your firearm to point at anything you do not intend to shoot. Always handle any firearm as if it were loaded and ready to shoot. Load your firearm only when you are in the field or on the target range and ready to fire. Unload as soon as you finish shooting. Verify that the firearm is unloaded before storing.

2. DO NOT RELY ON ANY MECHANICAL SAFETY.

Safety devices are not a substitute for safe handling procedures. Treat every firearm as if it can fire at any time, regardless of the safety position. Do not touch the trigger until you are ready to fire.

3. UNDERSTAND THE TARGET AND WHAT IS BEYOND THE TARGET.

Do not fire unless you know exactly where your shot is going, and what is beyond the expected point of impact. Never fire at a sound, a movement, or a patch of color. If you cannot see clearly what is beyond the target, DO NOT SHOOT.

4. NEVER SHOOT AT WATER OR AT A HARD SURFACE.

Shooting at water, rocks, or other hard surface may result in bullet fragmentation with unpredictable flight paths.

5. USE PROPER AMMUNITION.

The use of wrong ammunition, mixed ammunition, or improperly reloaded ammunition may result in serious injuries or death, and catastrophic damage to your firearm. Check each round before loading. If in doubt, DO NOT SHOOT.

6. IF THE FIREARM FAILS TO FIRE, DO NOT MOVE.

If the ammunition does not fire when you pull the trigger, stop and keep the muzzle pointed in a safe direction. Wait 15 seconds before opening the chamber. Look away from the chamber while opening it and removing the round. In semi-automatic firearms, remove the magazine before manually cycling the round. Properly discard the round immediately. DO NOT try to fire it again.

7. ALWAYS WEAR EYE AND EAR PROTECTION WHEN SHOOTING.

Wear protective shooting glasses to guard against any combustion discharges, cartridges ejection, or debris resulting from firing your firearm or firearms around you. Also, wear eye protection when you are disassembling or cleaning a firearm to guard against tensioned parts and cleaning solvents. Always use ear protection.

8. VERIFY THAT ACTION AND BARREL ARE CLEAR BEFORE SHOOTING.

Before loading your gun, inspect the action and barrel to ensure there are no obstructions such as snow, mud, excess lubricant, cleaning patches, or any other foreign material.

9. LEARN THE PARTICULAR CHARACTERISTICS OF EACH FIREARM.

Not all firearms are alike. Become very familiar with the firearm before shooting. Learn safe handling procedures for loading, unloading, carrying, shooting and storing each firearm before firing the first round.

10. SHOOT SOBER!

NEVER handle any firearm while under the influence of alcohol, drugs, or any medication that may impair your senses in any form.

DISCLAIMER

MDT SHALL NOT BE RESPONSIBLE IN ANY MANNER WHATSOEVER FOR INJURY, DEATH, OR DAMAGE TO PROPERTY AS A RESULT OF THE INTENTIONAL OR ACCIDENTAL MISUSE OF THIS PRODUCT, OR FROM ITS PROPER FUNCTION WHEN THE PRODUCT IS USED FOR PURPOSES FOR WHICH IT WAS NOT DESIGNED.



