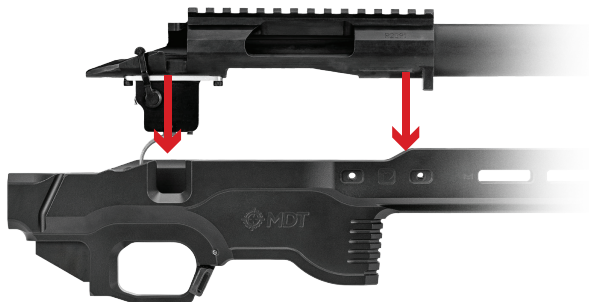


**HAVE QUESTIONS OR
NEED ADDITIONAL SUPPORT?**

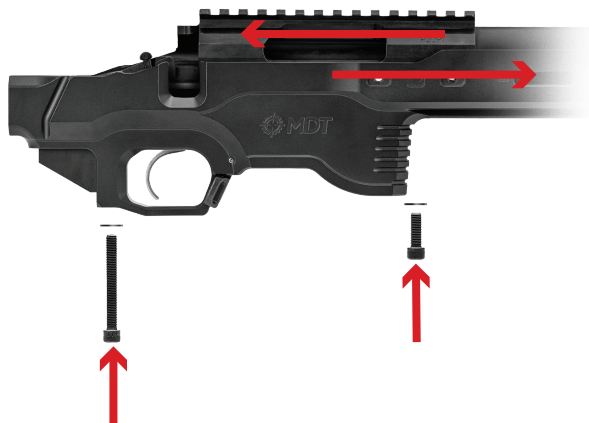
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INSTALLATION

1. Ensure firearm is safe and unloaded then place the barrled action into the the ACC Premier GEN2, ensuring that the recoil lug is firmly seated against the back of the recoil pocket.



2. While applying rearward pressure on the rifle (If you hold your rifle vertical, it will make this step easier) insert the supplied washers and action screws into the chassis, first torquing the front then the rear action screw.



See back of manual for inlet-specific torque specs and tools

ACC PREMIER GEN2

SUPPLIED HARDWARE

- Action Screws & Washers (x2)
- Length of Pull Spacers (x4)
- Magazine Plastic Dowels (x2) *Remington SA inlets only*

MAGAZINE DOWEL INSTALL

Remington 700 SA Inlets

To increase feeding reliability with rimfire magazines, you can insert the included plastic dowels into the magwell.



CHEEK RISER ADJUSTMENT

Loosen the set screws with a **1/8" Hex Wrench** to move the cheek rest up or down. Tighten screws to lock the cheek rest in place.

LENGTH OF PULL ADJUSTMENT

The MDT SRS-X Lite buttstock includes 4 optional 1/4" spacers designed to adjust your length of pull (LOP).

1. Using a **5/32" Hex Wrench**, loosen screws securing the buttpad.
2. Insert a spacer horizontally between the top and bottom screws.
3. Rotate the spacer so that it hooks onto both screws.

Note: Short and long screws are provided. Choose the appropriate size based on the number of spacers being used.

WANT TO LEARN MORE?
CHECK OUT OUR INSTALL VIDEO



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Rifle	Tool	Torque Specs	Inlet Specific Information
CZ457	4mm Hex Wrench	45 inch-pounds	Retain the use of the factory magazines
Howa 1500/Weatherby Vanguard SA	5mm Hex Wrench	60-65 inch-pounds	Will need to use our polymer magazines
Remington 700 SA	3/16" Hex Wrench	60-65 inch-pounds	
Remington 700 LA CIP 3.850"	3/16" Hex Wrench	60-65 inch-pounds	
Ruger 10/22	9/64" Hex Wrench 5/32" Hex Wrench	25-35 inch-pounds	See Inlet Specific Instructions
Ruger American SA	3/16" Hex Wrench	60-65 inch-pounds	See Inlet Specific Instructions
Ruger American Rimfire	5/32" Hex Wrench	30 inch-pounds	Retain the use of the factory magazines
Savage SA	3/16" Hex Wrench	60-65 inch-pounds	Will need to attach supplied oval washer on front action screw, rotating forward or back depending on the action screw spacing you have
Tikka T1x	5mm Hex Wrench	40 inch-pounds	Retain the use of the factory magazines
Tikka T3/T3x SA & LA	5mm Hex Wrench	60-65 inch-pounds	Long Action Inlet will need our 3.560" length magazines

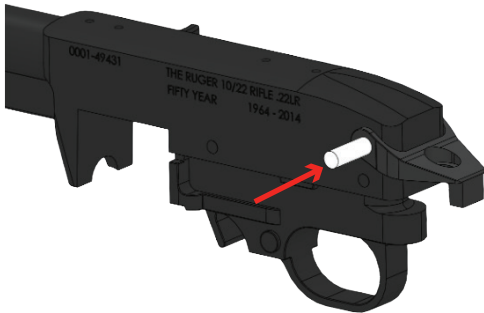


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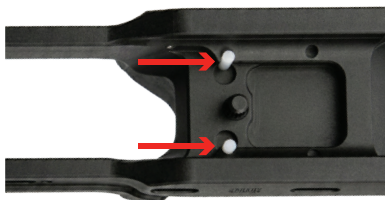
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RUGER 10/22 & CLONE ACTION INSTALLATION

1. Ensure firearm is safe and unloaded.
2. Remove your barreled action from the factory stock.
3. Remove the rear buffer pin. You will need a pin punch and a mallet. Some receivers are a tight fit. Be careful not to lose any other pins, they sometimes drop free.
4. Place the supplied "Pin-Puller" over the receiver, and insert the supplied buffer pin through the Pin-Puller and receiver. The pin should pass through both ears of the Pin-Puller. You will likely need a pin punch and mallet to install the pin.



5. Before placing the action in the chassis check that the plastic dowel pins are in place. If they are missing or worn, insert new dowel pins provided.



6. Remove the plastic hex nut on the action screw in the chassis and place aside, they are no longer needed.

7. Set the safety to the **CENTER** position, then carefully slide the receiver backwards into the stock. You will need to point the barrel slightly upwards, in order to slide the lip under this feature of the stock.



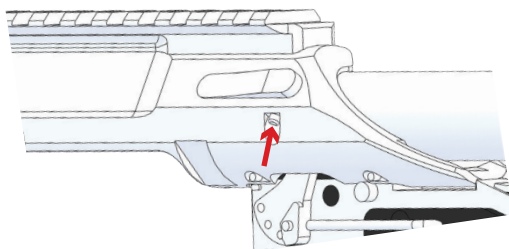
8. Insert a the supplied front action screw (#12-24) with the supplied washer, but do not fully tighten. Carefully hold the chassis and action pointing barrel-up, to ensure good contact between chassis and the rear face of the receiver. Then, tighten the Pin-Puller screw using a **5/32" hex wrench** to **25-35 in-lb**. If you have a scope installed on the action, you may need to remove it.
9. Lastly, torque the front action screw to **25-35 in-lb** using a **9/64" hex wrench**.

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RUGER AMERICAN BOLT STOP PIN INSTALL

You will need to replace the bolt stop pin in your action before installing your rifle in the chassis, using the supplied 20mm Pin (The longest out of the 3)



MAG LATCH INSTALLATION

Ruger American SA Inlets

1. Rifle Installation will be the same as stated on the first page of the manual.
2. The magazine latch however will have to be installed once the rear action screw has been torqued.
3. Position spring within the back side of the magazine latch, ensuring that the looped end of the spring is facing forward.
4. Insert the dowel pin into the side of the magazine latch & spring until it sits flush with the magazine latch.
5. Take the magazine latch & spring and position it in the bottom metal metal ensuring that the assembly pin lines up with the magazine latch pin hole.
6. Using a **1/8" pin punch**, start pushing out the dowel pin in exchange for the pin punch, making sure to not pull out the pin punch once the dowel pin has been removed.
7. Using a small hammer, start inserting the magazine latch pin into the magazine latch pin hole, chasing out the **1/8" pin punch** until it is completely pushed out.
8. Once the magazine latch pin has been installed, make sure that it is evenly seated side to side.