

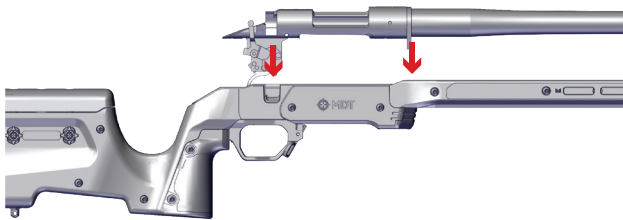


**HAVE QUESTIONS OR
NEED ADDITIONAL SUPPORT?**

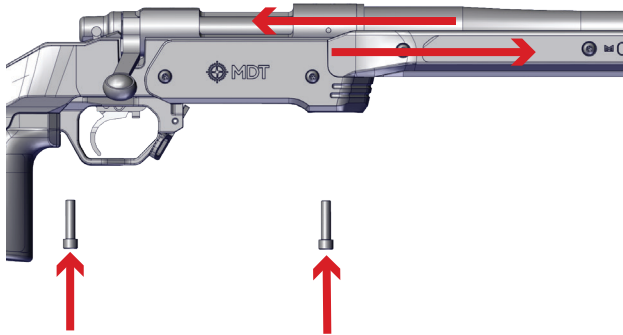
**support@mdttac.com
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INSTALLATION

1. Ensure firearm is safe and unloaded then place the barreled action into the the XRS Chassis, ensuring that the recoil lug is firmly seated against the back of the recoil pocket.



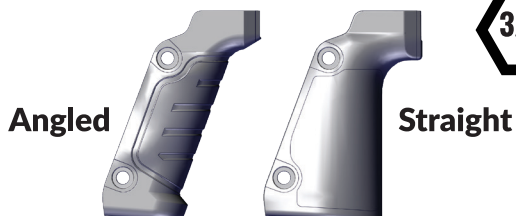
2. While applying rearward pressure on the rifle (If you hold your rifle vertical, it will make this step easier) insert the supplied action screws into the chassis, first torquing the front then the rear action screw.



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

CHANGING OUT THE GRIP

There are 2 different grip styles included to use to your preference. Using a **3/32" Hex Wrench**, remove the screws on each side, slide off & insert on the chassis body and retighten.



XRS CHASSIS SYSTEM

SUPPLIED HARDWARE

- Action Screws
- Length of Pull Spacers (x4)
- Brass tip set screws (x2)
- Vertical & Angled grips
- Sling Swivel Studs

CHEEK PIECE ADJUSTMENT

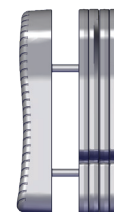
To adjust the cheek piece height, loosen the thumb wheels, adjust the height to the designed location and retighten. For more clamping power, you switch out with the supplied brass tip set screws.

INSTALLING LOP SPACERS

- Loosen the two #10-32 screws holding the buttpad to the stock using a **5/32" Hex Wrench**.
- If removing spacers, loosen the screws at least 5 turns to create enough space for the tabs on the spacer being removed to clear the buttpad and other spacers.
 - Press on the side of the spacer near each slot to rotate the spacer away from the buttpad retention screws.
 - Once the desired number of spacers has been removed, retighten the buttpad retention screws until snug.



- If adding spacers, loosen the screws enough that a space is formed between the buttpad and the nearest spacer to add the desired number of spacers (see the graphic below).
 - Position the spacer slot onto the bottom screw, with the alignment tabs facing forward. There will be a slight click as the screw goes into its required spot.
 - Pivot the spacer about the screw to engage the second screw, and click it into place.
 - Once the desired number of spacers has been added, retighten the buttpad retention screws until snug.



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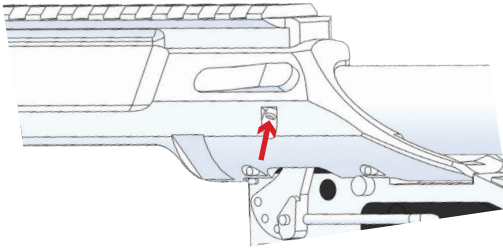
Rifle	Tool	Torque Specs	Inlet Specific Information
CZ455	5mm Hex Wrench	20-45 inch-pounds	Retains the use of the factory magazines
CZ457	4mm Hex Wrench	20-45 inch-pounds	Retains the use of the factory magazines
Howa 1500/Weatherby Vanguard SA/LA	5mm Hex Wrench	60-65 inch-pounds	The Short Action will 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	
Remington Model 783 SA	3/16" Hex Wrench	60-65 inch-pounds	
Ruger American SA/LA	3/16" Hex Wrench	60-65 inch-pounds	See Inlet Specific Instructions
Savage SA/LA CIP 3.850"	3/16" Hex Wrench	60-65 inch-pounds	On the Short Action inlet you need to rotate the oval washer on the front action screw forward or back depending on the action screw spacing you have
Savage Axis SA	3/16" Hex Wrench	60-65 inch-pounds	
Tikka T1x	5mm Hex Wrench	20-45 inch-pounds	Retains the use of the factory magazines
Tikka T3/T3x SA	5mm Hex Wrench	60-65 inch-pounds	

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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 secured.
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.

WANT TO LEARN MORE?
CHECK OUT OUR INSTALL VIDEO

