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Glass bedding instruction

seit 1953

WILL APEL

Jagdausrüster Büchsenmacher

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Preamble

- GRS recommends to glass bed all laminated GRS Riflestocks for maximum accuracy.

- If you are shooting magnum calibers glass bedding is always required so the action does not have any play during recoil.

- For some inlets like Schultz & Larsen, Rössler Titan 6, Blaser R93 Offroad / Professional, Blaser R8 Professional, glass bedding is always required as well!

- Instead of bedding the Hülsenkopf as a standard only, you can optionally bed the complete system as well or work in additional pillars.

- It is very important to avoid any tension inside the system, as this will always lead to precision problems.

- With some inlets (for example Heym SR30) the bedding has some importance on the safety (Hülsenlauf) as well and for some inlets you must generally use the original parts (for example Mauser M12, Rössler Titan 6) as otherwise dysfunctions may occur.

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Material / Tools

- Bedding material + blend in material
- Parting agent + paintbrush
- Putty (for example Plasticine), gun grease
- Medical gloves, tissues, Q-Tips etc.

- **Bench vice and availability of standard gunsmith tools preconditioned!**

- ALWAYS CHECK ON THE ACCIDENT PREVENTION REGULATIONS OF ALL CHEMICALS AND TOOLS IN USE FOR THE GLASS BEDDING!

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Assembly of parts:

- Before preparing the metal parts and wooden parts please first of all mount the GRS Riflestock to the rifle for once.

- You will then find out soon, if there will be tension when mounting the rifle using the recommended torque and whether the barrel is in correct position.

- All existing weapon parts (for example HEYM SR30, Rössler Titan, Mauser M12 etc.) need to be mounted to the GRS Riflestock as well to check if they are fitting properly.

Preparation of laminated wood:

- All oiled GRS Laminated Riflestocks will have to be cleaned on the parts that will have bedding material put on. So all oil / surface protetcion needs to be removed from these parts first.

- If you do the glass bedding without grinding/sanding/engraving the surface of the relevant laminated wood inside, the glass bedding will lose it‘s footing and might quarry out again.

- It might be necessary to remove the recoil lug as well and grind/sand the wood underneath as well.

Preparation of laminated wood:

- After the surface of the relevant laminated wood parts have been grinded/sanded/engraved just blast the rifllestock with compressed air to clean the inside afterwards.

- After this is done you can start!

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Preparation of metal parts:

- It might be necessary to remove burs from metal parts (for example on all M98/K98).

- Clean the metal parts with metal/brake cleaning solvent. This is absolutely necessary for a good footing of the parting agent!

- Fill all Drill holes, gaps etc. with putty. This is very important so that the compound won‘t build up a mechanical blockade inside the riflestock and you can remove the metal parts again afterwards.

- Put on the parting agent on all parts that will be covered with the compound material (screws, magazine well etc.).

- To be on the save side, put some gun grease into the thread for the action screws as well.

Glass bedding:

- Mix the bedding compound according to the manual.
- Color the compund if necessary.

- Put on the bedding material (in this example – Tikka T3 – the area beneath the recoil lug will be covered as well).

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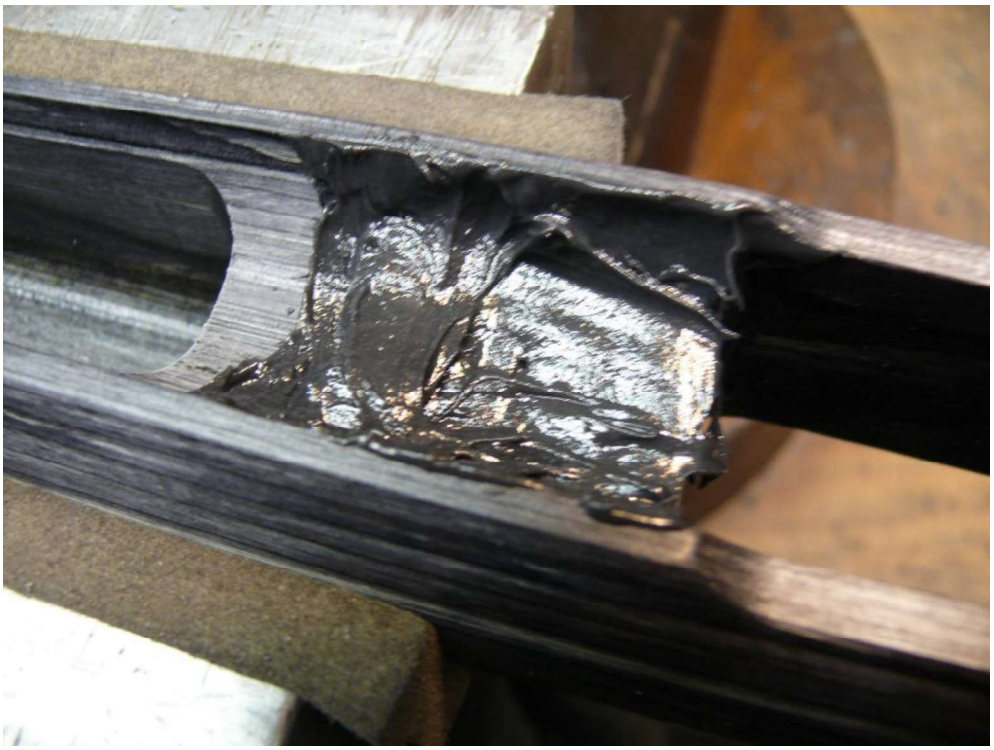
- Always use <u>enough</u> compound in order to avoid having uncovered parts and to prevent generating any air bubbles.



- Put in the metal parts / action inlet and torque the action screws like you did when pre-assembling the rifle to the GRS Rifletsock in the beginning.

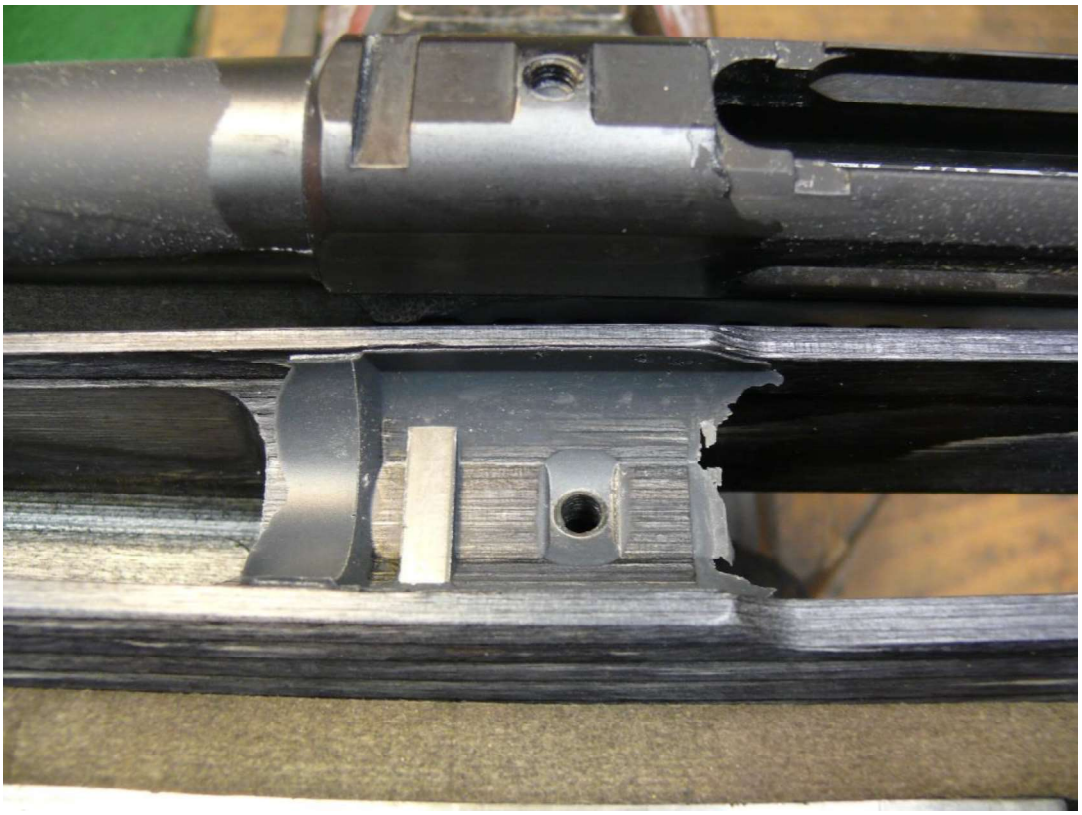
- It‘s a proof of having used the right amount of bedding material when excessive compound will be extruded while assembling the metal parts / action inlet.

- After mounting the rifle, please remove the excessive bedding material immediately as this will save you a lot of work and time afterwards.

- Using Q-Tipps and some slightly oiled cloth will be very helpful for doing this job.

- After this is done, the bedding material needs some good time to harden. To be on the save side, check on the manual of the bedding compound and let it harden over night!

Postprocessing:



- Dissamble the action inlets from the riflestock, and remove all metal parts (please make sure that with Blaser R93 and Blaser R8 the action inlet is not tilt/twisted as the riflestock might crack otherwise!)

- Clean all metal parts with metal/brake cleaning solvent and slightly oil them afterwards.

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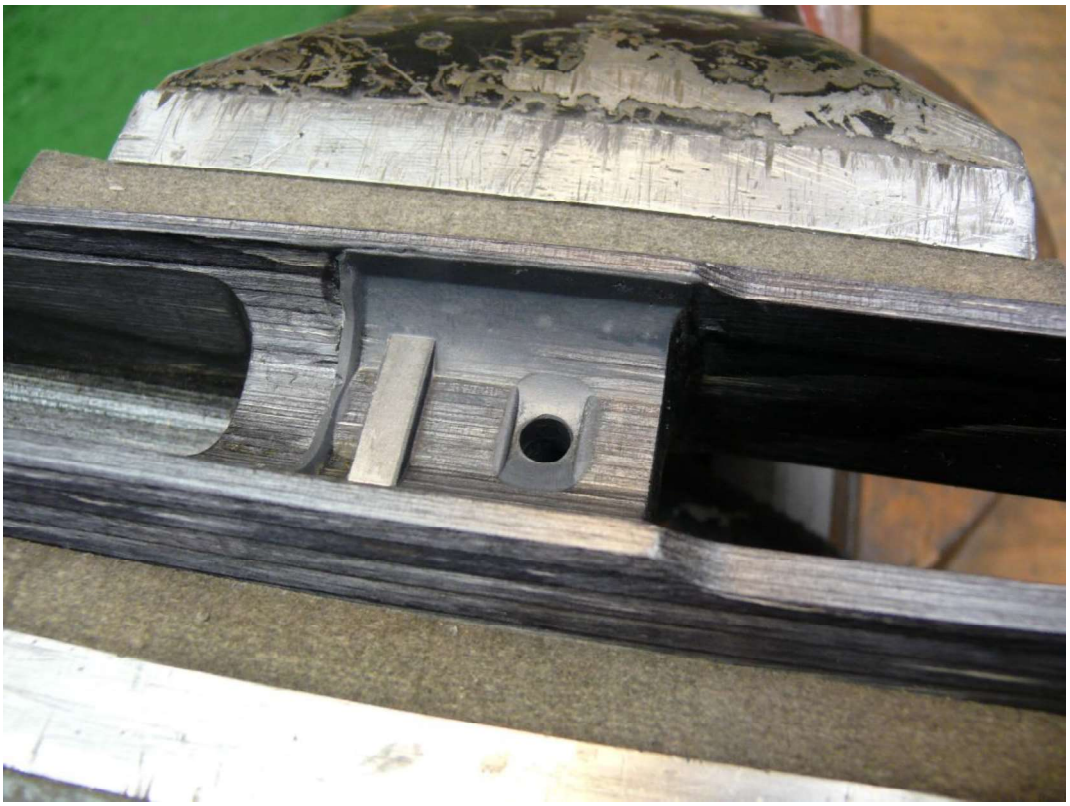

- Remove all excessive compound and clean the riflestock thoroughly. Especially all areas needs to be observed that should not contact or could crack easily and which will be sitting in the mechanism.

- All drill holes for the action screws need to be opened again (drill to original size, so that they will fit properly!).

- Chamfer the coumpound if necessary in order to avoid any damage on the bedding when mounting rifle again.

Final Assembly

- Mount the rifle and torque all action screws according to the recommended torque of the rifle manufacturer / GRS Riflestocks AS.

- Make a functional test and check for the bolt to run smoothly, for the magazine to hold properly in the magazine well etc.)

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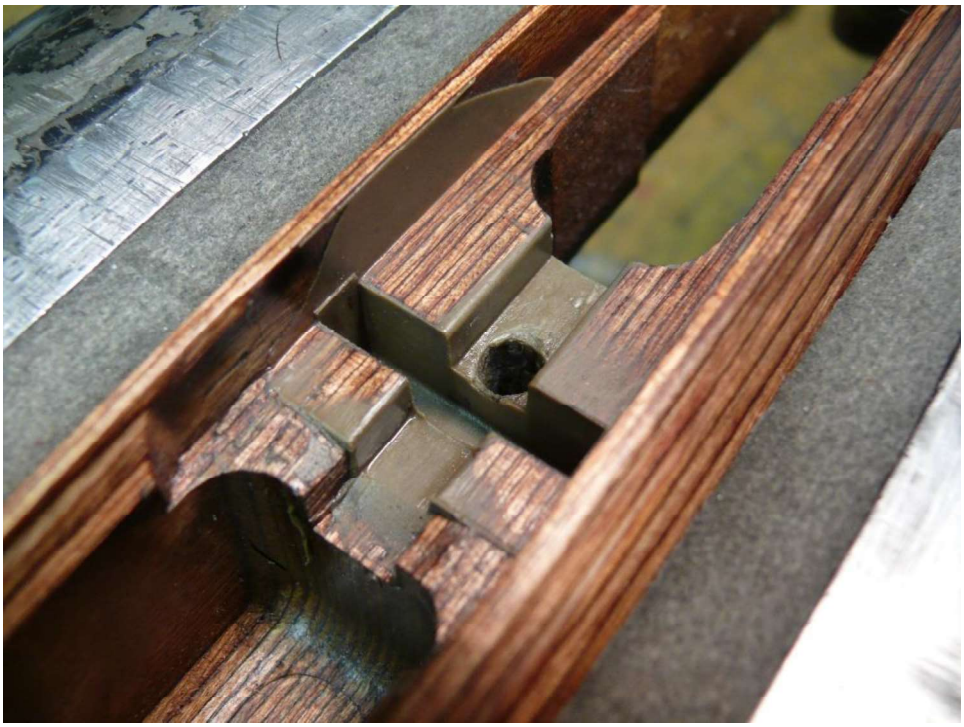
Good luck!

Giann Wehrs
Will & Apel

Version 1

Exemplifications:

SAKO



Heym SR 30

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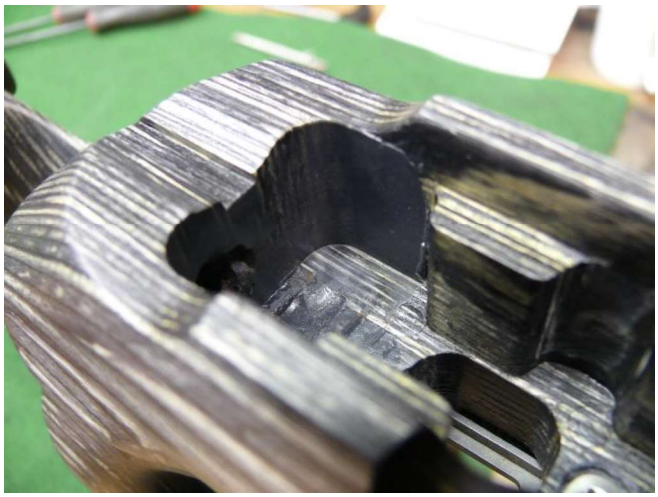
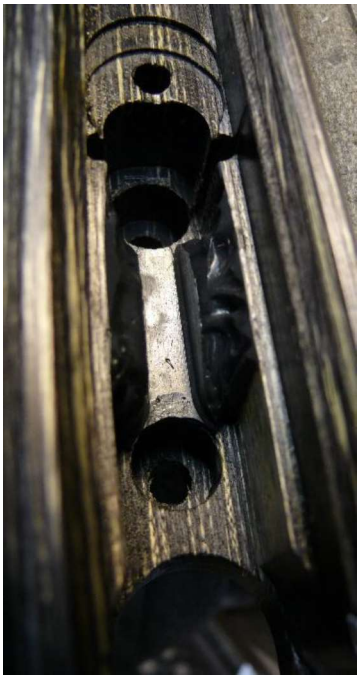
Mauser M03





Mauser M12

T3 CTR

Ruger

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Examples of bad workmanship / faulty glass beddings that caused cracking of GRS Rifletstocks