

## Flexi-bloc Inletting Instructions

- 1) Determine the exact lengthwise location of the bedding block on the stock and mark a line on the stock at the front and rear of the block.
- 2) Determine the height of the block in the stock by marking the location of the trigger opening on the underside of the stock – use a pencil that can be easily be removed later. To allow proper trigger height, the block must be set at 15 mm from the bottom of the stock, where the trigger is located.
  - a. Example of how to set up the stock height: stock height at trigger position 57mm less the 15mm at bottom = 42mm to bottom of the block from the top of the stock.
- 3) If possible, set up the stock on a vertical milling machine. Zero the X axis on the marked line, and centre zero the Y axis on the stock centre line.
- 4) Drill three 15 mm diameter holes through at :
  - No 1 : 17.8 mm
  - No 2 : 68.6 mm
  - No 3 : 175.0 mmfrom the front block line previously marked.
- 5) Using a 10 mm dia. end cutter, mill the upper part of the recess for the bedding block to a width of 38 mm, a length of 190 mm and a depth of 12 mm Note: + the difference between the 30mm depth and the trigger depth. In the above example of 57mm stock depth, this would be (15mm + 18mm + 12mm) from the stock depth of 57mm gives + 12mm to the dimension. In this case the 12mm + 12mm = 24mm first cutting depth.
- 6) Using the same cutter, mill the bottom recess to same length, a width of 28 mm and a depth of 30 mm + 12mm of the example giving 42mm total depth of cut. This will leave 15mm of stock at the bottom of the cut to obtain the correct trigger height.
- 7) Mark the trigger slot with a pencil then mill the trigger slot in the stock to match the slot in the bedding block.
- 8) Check that the block enters freely in the cut. It is desirable to have the cut made 0.2 to 0.4mm oversize, in width and length to ensure a good glue interface layer.
- 9) Ensure that the three silent blocs are well seated and glue in the bores the three exclusion tubes, using a fast bonding glue (cyanoacrylate or equivalent). Make sure they bear evenly against the external sleeve of the Silent Blocs and the 22mm flange part does not protrude past the outside surface of the block.
- 10) Prepare the block for gluing by degreasing it with acetone or other degreasing solvent.
- 11) Protect the inside vee of the Block with thick packaging tape, Sellotape or equivalent tape to prevent bonding compound to stick on the Vee surface. Place it in strips lengthwise and cut the ends with a sharp blade.
- 12) Close the end of the exclusion tubes with a wad of paper or plastic bung and finally wipe the surface to be glued with acetone to remove any finger prints.

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- 13) Protect carefully with thick tape the bottom and side surface of the stock, leaving the three 14.5mm holes free.
- 14) Apply a coat of adhesive inside the recess and on sides of the block, ensuring it is evenly applied and of just sufficient volume and thickness to fill all the gaps.
- 15) When the block is settled down in the stock, peel out the tapes and wipe away excess adhesive using a cleaning cloth damp with acetone . Wipe out any excess adhesive from the trigger recess and push out the wads or bungs away from the exclusion tubes.
- 16) Allow the glue to cure completely.
- 17) Mark the ejection port recess on the stock and using a 15 -16 mm cutter, remove stock material so that it aligns with the port in the action.
- 18) The bolt handle recess can be cut with a 12 mm cutter by fitting the stock at a 20° angle. Allow 1 mm clearance under the handle for the radius to centre match with the 10 mm diameter of the handle. Or, remove the material with a die grinder or Dremel type machine.
- 19) Cut and file carefully the exclusion tubes flush to the bottom of the stock.

### Notes

-It is possible for the above recess cutting work done using hand tools but be prepared to a lot of work to get it done correctly.

-The Neoprene Flexi-bloc and elastomer strips have an indefinite life and the load and stress placed on them in this application are absolutely minimal in regard to their capacities. Therefore, we know that the trapping of the silent blocs in the stock is not a problem as they would never have to be replaced.

-When finishing the stock, place wads or paper plugs in the exclusion tubes and in the silent bloc sleeves to prevent dust and shavings getting into the cavities .

-The trigger guard and spacer supplied with the bedding block are fitted on the action with the M4 screws provided. The trigger guard can be removed for trigger adjustments while the spacer and trigger remain in place.

-Tension on the action bedding screws when fitting the action is not critical. Torque tension of the screws (with the screw head bearing surface slightly oiled) is best achieved at a torque of 5 to 6 Newton/metre, or up to the flexion of a long 5 mm Allen key. The internal stainless steel bushings controls the right axial tension of the silent blocs and the pressure of the action on the longitudinal strips.

### Care and Maintenance

Simply wipe dry the system if it gets wet, and lightly oil the stainless bushes and screws bearing surfaces in order to ease removal.