

Switching the Charging Handle

Use a 9/64" Hex/Allen wrench to unscrew the charging handle bolt. Once the charging handle screw has been unscrewed from the rifle's bolt, the charging handle can be removed and switched to the alternate side of the rifle. Reinsert the screw into the charging handle and firmly tighten.

Installation of barrel into the X-Ring Receiver

Step 1 – Remove action from box. Step 2 – With a 3/16" hex key, remove the two V-block screws and V-block. Remove the action screw from the receiver. Step 3 – Be certain to clear the bore and barrel of any debris or obstructions prior to inserting the barrel into the receiver. Insert the barrel into the X-Ring action with the V-block notch at the bottom of the barrel, and the extractor slot lined up to the extractor on the bolt. * Important Note * If the barrel is difficult to install, lightly sand the shank of the barrel with 200 grit sandpaper until the barrel is able to be fit by hand. Do not sand the inside of the receiver. Do not make any alteration to the receiver in order to fit a barrel. Step 4 – Reinstall V-block and tighten X-ring V-block clamp screws with a 3/16" hex key to 20-24 IN.LB, ensuring the flat part of the V-block is down, and the hump is pressing against the barrel. Step 5 – With the hammer cocked, install the trigger group in receiver and tap the pins back in place. Step 6 – Install the new X-Ring barreled action into the stock, checking for proper fit and function. Replace the action screw and tighten.

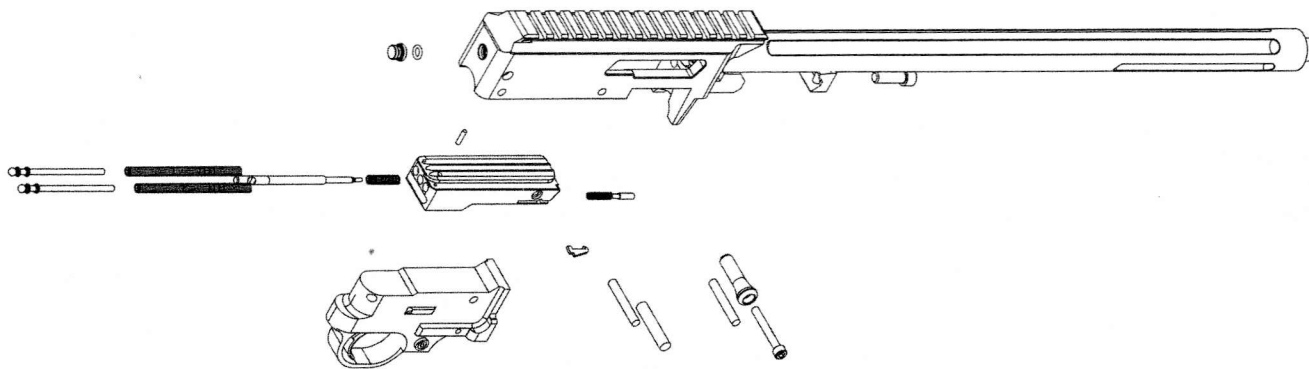
Disassembly

Safety Glasses *As a safety note, the recoil springs will be under considerable tension when removing the bolt from the receiver. Safety glasses are necessary to protect your eyes during this process. *

1. Starting with an unloaded rifle (after following the aforementioned safety rules), turn the rifle upside down exposing the action screw, and remove. Push the trigger group's safety to the middle position, allowing it to clear the stock. Turn the rifle back upright, pivot the barrel slightly upwards, and raise the barreled action out from the stock.
2. Clamp the barreled action in either a padded vice, or hold it down on the V-Block and gently tap out the two receiver pins with a 5/32" punch and remove the trigger group. Be careful to tap the pins out gently.
3. With a 9/64" sized Hex / Allen wrench, unscrew the charging handle from the bolt and remove.
4. Invert the action and gently tap down on the rear of the two recoil spring guide rods, fully seating them into the action. Then tap out the bolt buffer from the side of the action. To remove the stainless steel plug in the rear portion of the receiver, push it from the outside of the receiver to the inside of the receiver.
5. Notice the two small holes on each side of the bolt. These are designed to allow a pair of paperclips or 1/16" sized punches to be inserted once the bolt is pushed back, locking the recoil guide rods in place. This is necessary to remove the bolt. It's easier to use two small paperclips because they will stay in place. To start, push the bolt completely to the rear of the action and hold in place. Slide a straightened end of a paperclip into each hole, approximately 3/4" deep, securing the guide rods in place.
6. Turn the barreled action right side up and carefully tap the top of the receiver. This should allow the rear of the bolt to drop down and out of the receiver. Keep in mind that the bolt needs to pivot slightly from the front to drop out.
7. With the bolt removed, the barreled action and bolt are now ready for cleaning.

CLEANING

1. With the rifle disassembled, start by wiping down the inside of the receiver and breech-face of the barrel with a shop rag. Once the receiver is clean, wipe down the bolt, recoil guide rods, and springs. Then brush off the bolt face, making sure you get under the extractor.



2. At this point you can either use a traditional cleaning rod and patch, or pull-through cleaning system to remove fouling from the chamber and barrel. With all rimfire rifles, it's important to clean any fouling from the chamber.
3. To clean the bolt, cover the rear of the bolt with a shop rag and pointed in a safe direction, carefully remove the paperclips one at a time and gently remove the recoil guide rods and springs. Remember that the springs are under pressure and will shoot out if not restrained.
4. From the bottom of the bolt, tap out the firing pin retaining pin with 3/32" size punch, while holding pressure on the rear of the firing pin. Remove the firing pin and rebound spring. Firing pin is under spring tension.
5. Clean out the holes in the rear of the bolt, and brush off the bolt face.