

Two point Glass bedding

1. JB Weld 8281 Professional (let sit 15 to 20 minutes to thicken before use)
2. Devcon Plastic Steel Putty (A) 10110
3. Marine tex gray

- Plumber's putty
- Good Quality Electrical tape
- KIWI natural shoe polish or furniture wax
- Clean Wax (parch) (parts) Brush
- Blue masking tap both large and small widths
- acid brushes
- Using gloves is a good idea
- paper towel
- old rags
- tongue depressor

Remove – scope, trigger, anything you can

Have correct bits for tool ready at hand.

Have all gun parts easily accessible

Process should be finished 10 to 15 minutes after mixing epoxy

Leave

Using gloves is a good idea

Don't add height around screw holes

Leave tank screw a loose fit so screw moves in hole

Insert glass bedding in front screw, the threads are in the stock.

Ream out rear tank screw hole

Step One

- Protect and prepare barrel and action.
- Using wax all over the barrel and action using a thin film. Fill screw holes with putty, get into the recoil lug recesses, screws may connect inside the action.
- Bed in front of the recoil lug a small distance
- Wax screws with a heavy amount of wax remembering the screw heads and in all threads, pack it in.
- Trigger guard needs wax everywhere
- Putty-on the screw holes, scrap off excess, make it smooth, into any recesses, pay attention to where you want the glass to go, plug tang screws
- After the putty is used, reapply the wax over all the barrel and receiver
- If the barrel is not free floated, free float after glass bedding. Use the stocks front pillar to center the barrel if the pillar is not moving the barrel.

- If the front pillar is moving the barrel, gently sand down the pillar use tape to center.
- If the barrel is free floated, wrap blue tape around barrel about 1.5 inches from the front of the stock to center the barrel in the stock.
- Start with ten rounds of tape, remove 1 layer at a time until you get a sharp fit, don't expand the stock, this centers the barrel
- Make sure the barrel is centered and secure.
- Recheck and wax a third time making sure any scope screws holes are filled with putty.

Step Two:

- Apply butty from 3/8' in front of the recoil lug back to the magazine edge
- Apply putty to tang making sure not to interfere with where the tang meets the wood at the top. Putty the screw holes
- Clean area to be epoxied with mineral spirits and alcohol to remove wax
- Rough up the area to get the epoxy with a dremmel tool using a 1/8' diameter round bit using the highest speed
- Tape up the stock with the wide blue tape making sure the trigger guard fits
- Cradle the wood stock in a vice using wood panels and a thick rag
- Using the dremmel tool, remove about 1/16' wood in front of the lug, rough up area behind the lug, around the raised area around the score, don't touch the back of the lug surface, don't use the dremmel from the magazine edge to the hole
- Dremmel around the rear screw
- Don't remove any wood from the bolstered area

Step Three

- Mix epoxy
- Make sure all parts and tools are handy
- measure by weight can be helpful
- Mix thoroughly and completely
- Use artist knife to apply compound
- Don't put compound under recoil lug
- Compound should be a little high, same height above as you dremmel deep
- Putty is covering only area that was dremmel
- Amount should be even on both sides
- Lower barrel into stock, don't drag,
- pull barrel back to set recoil lug
- attach trigger guard with screws
- Snug screws first
- tighten screws until they bottom out
- re-tighten screws after 30 seconds
- tape action tightly with electrical tape round and round the action
- Back out two screws 1/2 turn and re-tighten back to same place, just bottoms out
- check barrel

- use the cup that the putty was mixed in to check hardness
- after 3 ½ to 4 hours and the cup is semi hard where a finger nail will make an indentation
- look for any seepage
- run artist knife around and viable areas where putty might have oozed out.
- Look under blue tape that is accessible
- make sure action screws can be turned out and back in.

Step four – separate stock and barrel/action

- If you have trouble separating the wood from the steel, place in the freezer for 3 to 4 hours then separate.
- Remove the electrical tape and the blue tape
- remove screws
- Try to use the epoxy to pillar bed the front screw, not the rear screw
- Hold the stock and hit the barrel on a soft “pillow”
- Use acetone to remove putty and wax but use it outdoors
- Use less epoxy on the rear area compared to the front area
- If needed, re-drill rear hole to original size.

Notes

- Don't let epoxy into blind holes, use putty or studs
- Marine - Tex gray
- JB weld 8281 Professional, let sit for 15-20 minutes before applying