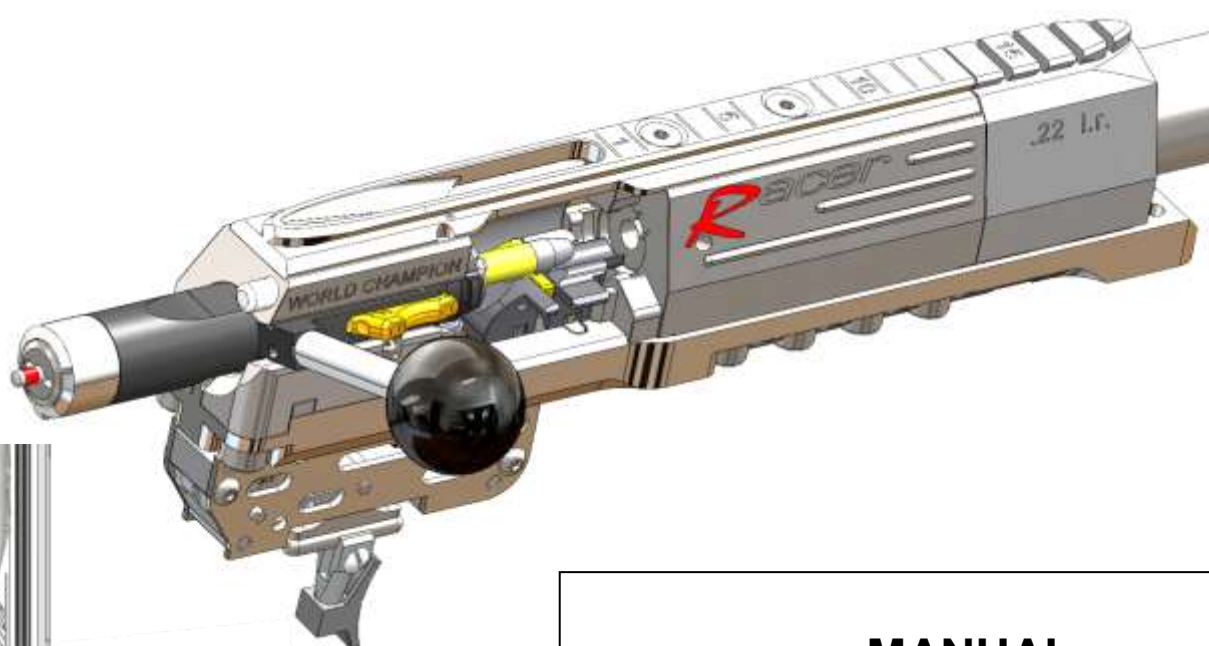


# Racer

## WORLD CHAMPION

SMALL BORE RIFLE .22 l.r.



### MANUAL

**Inserting the Barreled action  
into the Aluminum Stock**



## Overview

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## **Dear Target Shooter**

Congratulations on the acquisition of your new target rifle. Our rifles are used worldwide with great success. We are convinced that your decision was easy. Our products fulfill the highest engineering standards and are manufactured with the latest product technology.

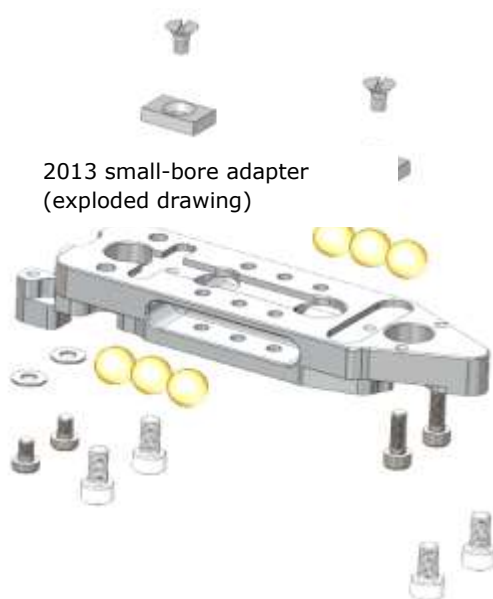
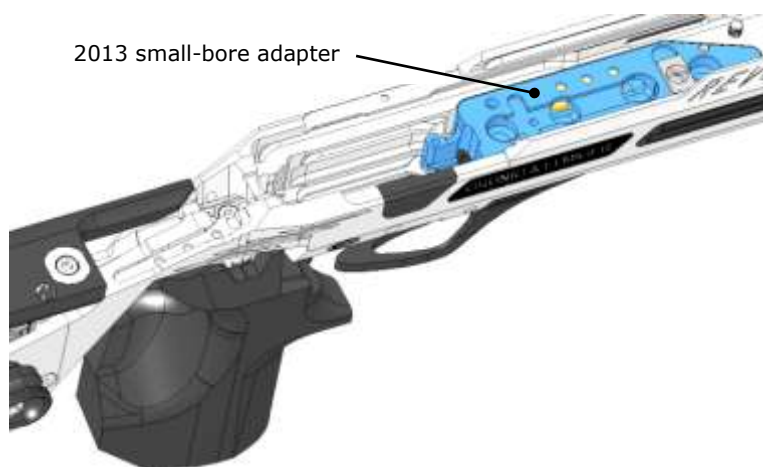
### **Please carefully read the following before using your new rifle:**

1. Always consider a rifle loaded until you personally checked that it is not. Make sure the action is open when you carry the rifle around so everybody can see that your rifle is unloaded.
2. Make sure the muzzle is always pointed downrange or in a safe direction!
3. Always make sure that you are using the correct ammunition for your rifle.
4. Before shooting always check to see that your barrel is not obstructed.
5. The safety lever must always be pushed all the way in either "safe" or „ready to fire" position (F)! Always keep your rifle on "safe" until you are ready to fire. Make sure there is nothing between the muzzle and the target before you release the safety lever. Always keep the finger off the trigger until you are ready to shoot.
6. Except for cleaning, your rifle should only be disassembled by an authorized gunsmith.
7. The life of your rifle and your barrel depends on proper care. Please carefully follow the instructions in your rifle's manual.
8. Target rifles should only be used by an experienced shooter or under the supervision of such an individual.

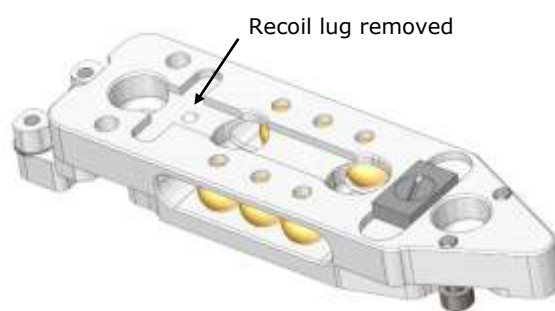
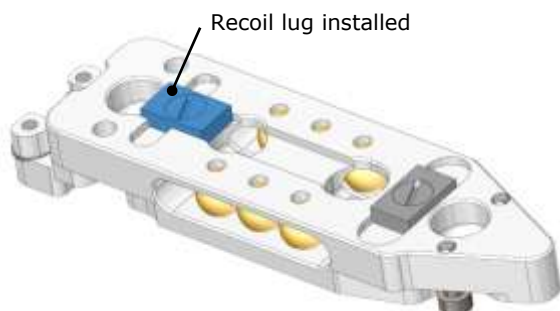
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## Installing the adapter for the small-bore barreled action

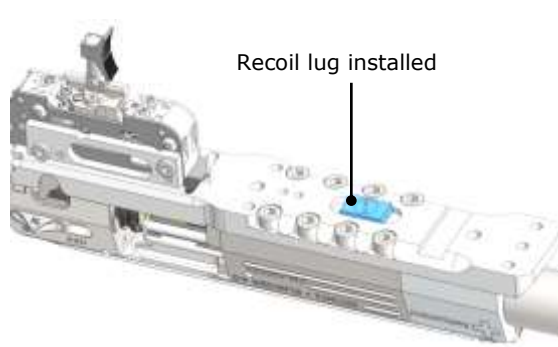
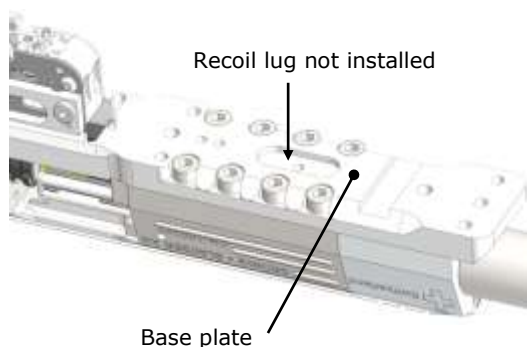
The 2013 **adapter** must be installed before inserting the barreled action into the aluminum stock.



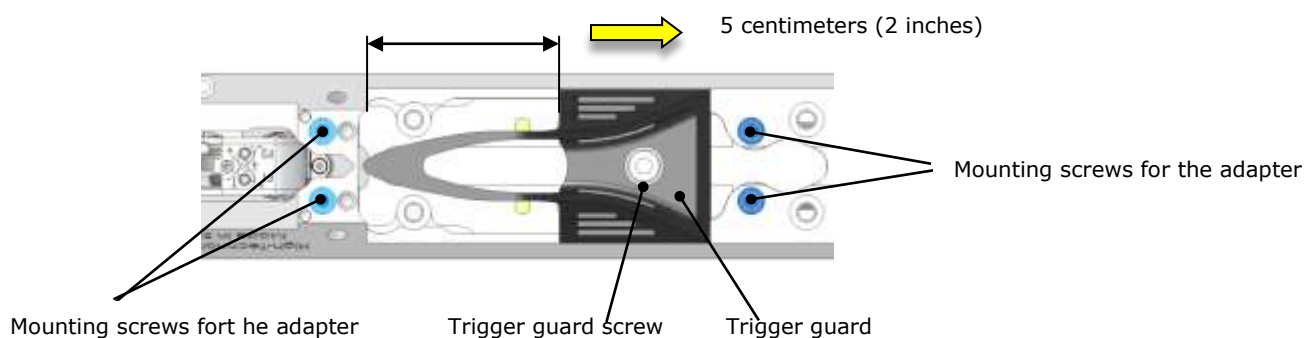
Make sure that the rear recoil lug is removed.



The rear recoil lug will be installed on the base plate of the small-bore barreled action.

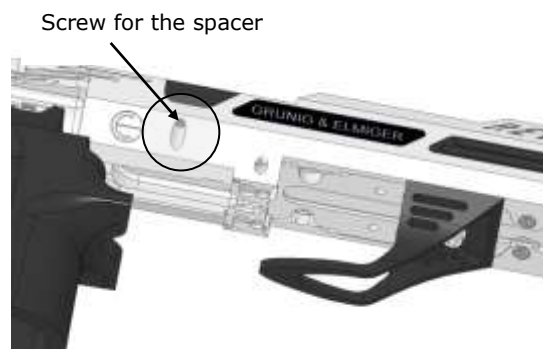
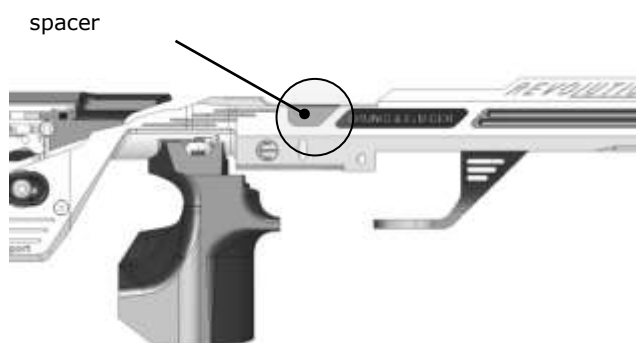


To install the adapter you have to loosen the trigger guard screw and then move the trigger guard about 5 centimeters (2 inches) forward. You can now reach all the adapter mounting screws and install the adapter.

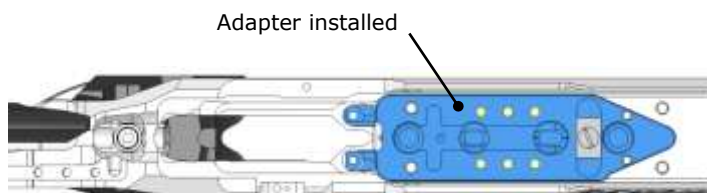
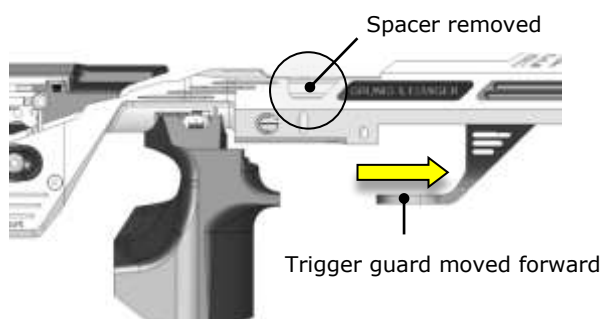


### Removing the spacer

The spacer of the aluminum stock must be removed. Loosen the screw for the spacer.

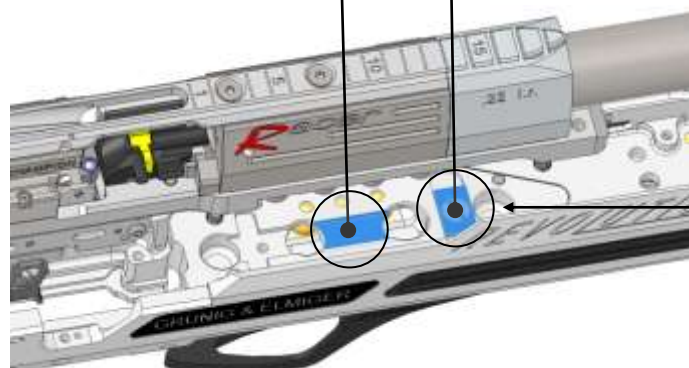
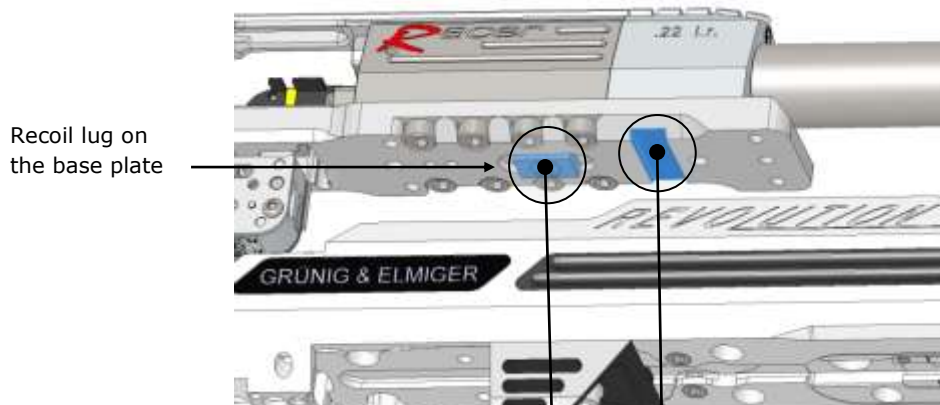


The barreled action is now ready to be installed.

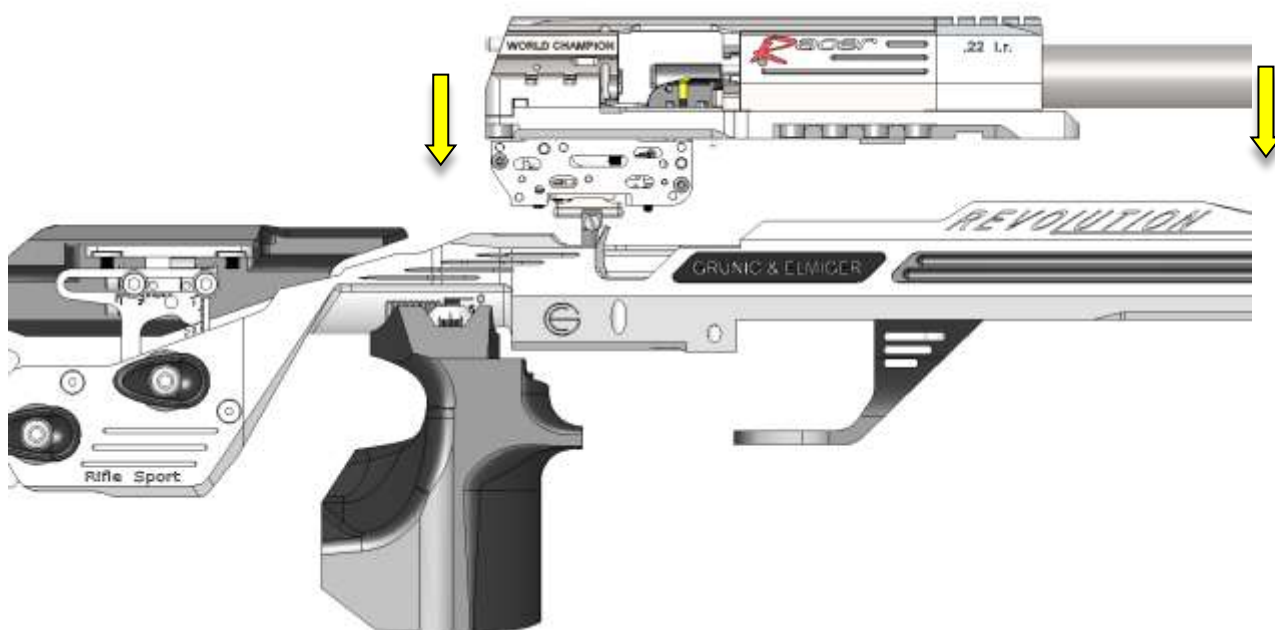


### Inserting the small-bore barreled action into the aluminum stock

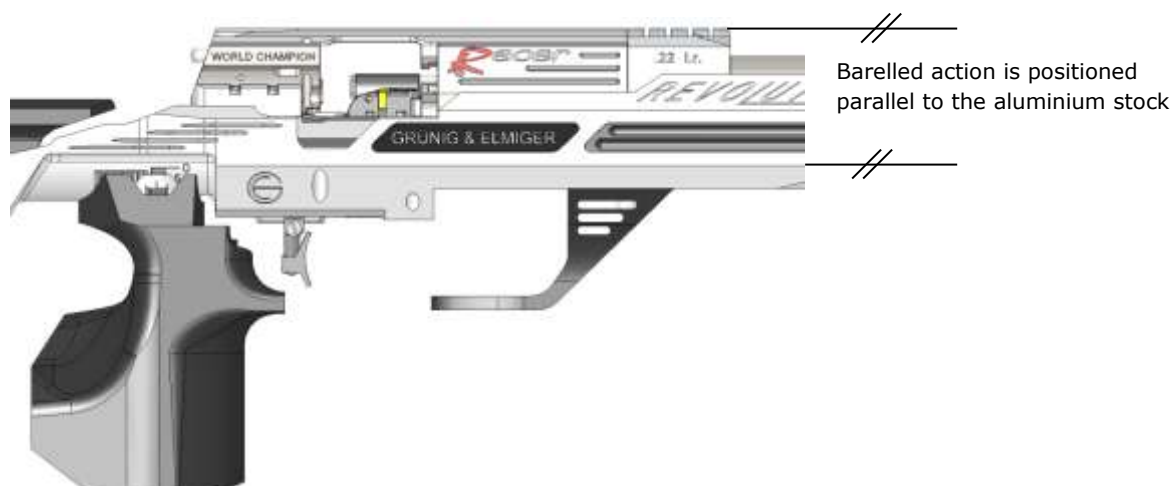
The barreled action (including the base plate) must be positioned precisely into the 2013 adapter slots.



Carefully join the system and aluminum stock!



The barreled action is now positioned correctly in the aluminum stock. Check if the barreled action is parallel to the aluminum stock (see picture below).



Squeeze the barreled action and the aluminum stock together with your hand (as illustrated below) and then hold it upright. You can now insert the action screws and turn them only as far as you feel little resistance. Do not yet tighten the action screws. By its own weight, the base plate will align itself correctly with the 2012-adaptor. Continue to hold the aluminum stock upright.



Now tighten the action screws in a cross sequence with a torque wrench set to 6 Nm. Loosen the trigger guard screw, place the trigger back to its initial position and tighten it again. Insert the bolt.

Tighten **4** action screws  
in a cross  
sequence

Slide the trigger guard  
back to its  
initial position.

