

Installation Manual

MP-MODSS



"MP-MODSS Stock System"

MODSS Stock Assembly Instructions

PLEASE READ ALL INSTRUCTIONS BEFORE BEGINNING ASSEMBLY

WARNING!!!

Check your barreled action for ammunition! Never work on a loaded weapon!

Never fire a weapon until all fasteners have been lubricated and tightened!

Even though all MODSS stocks are **loosely assembled** as a final QC check by the manufacturer, The **operator** is responsible for removing each fastener, lubricating it, and reinstalling it to final torque.

Assembly of the MP-MODSS stock system is quite simple if the guidelines are followed. We have gone to great lengths to make the assembly manual as easy to follow as possible. If you have any questions please feel free to contact The Billet Arms Company at (509) 720-1570 and we will make every effort to assist you with your installation.

NOTE: We do not recommend the use of thread locking compounds unless you know that you will never reconfigure or disassemble your stock. Thread locking compounds can cause the aluminum threads to be permanently damaged upon removal of the fasteners.

Safety Guidelines!

WARNING! Always verify that your barreled action is unloaded and clear.

WARNING! Always verify proper function of the trigger and safety lever after assembly.

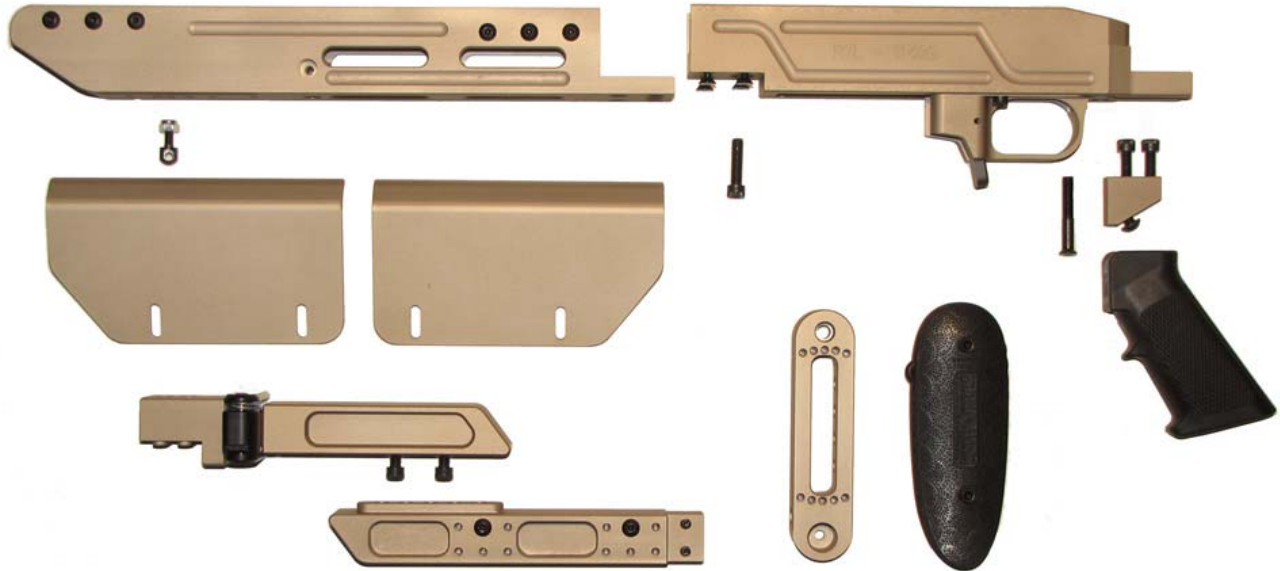
WARNING! Never fire a weapon until the action screws have been tightened to spec.

WARNING! Always apply lubricant to the fasteners during assembly of your stock.

WARNING! Always treat your firearm as if it's loaded!

WORK SAFELY!

MP-MODSS Stock Kit Contents



Standard Folding Model Parts Breakdown

(Fixed Models have 1 piece Upper Rear Section)

Please check your parts inventory against the above parts photo before beginning your installation.

All components are LOOSE ASSEMBLED as a final fit check. Each fastener must be removed, lubricated, and reinstalled to final torque before installing your barreled action. Never install a barreled action or fire a weapon until each and every fastener has been lubricated and checked for final torque.

Front Section

- 1) We recommend that you lay your stock on a protected work surface. Locate the 4 front section mounting screws. Remove and lubricate the screws. Loosely fit the front section to the center section.
- 2) Now, stand the assembly on end to allow the mating surfaces to contact before final tightening. Tighten by hand until the parts don't move easily. There is no need for excessive torque on these fasteners!
- 3) Install the supplied front mount Bi-pod stud in one of the two locations on the bottom of the fore-end and tighten.
- 4) All Hunter and Compact front sections include filler screws for the MIL/TAC package mounting holes. Use of the filler screws will give a clean, finished look to non-tactical stocks. For stocks ordered with the MIL/TAC package or other options please see the Optional Accessories section at the rear of this manual for installation instructions.



Fixed & Folding Rear Sections

A) FIXED REAR SECTIONS

For folding rear sections proceed to step 12

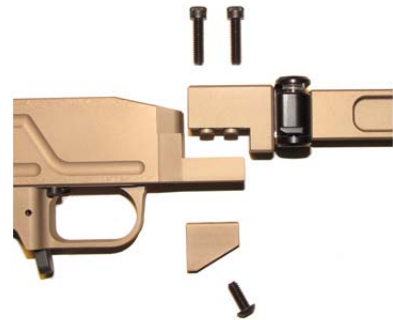
- 5) Locate the 2 rear section to center section mounting screws and the pistol grip mount. Remove and lubricate the fasteners. Install the upper rear section and pistol grip mount using the supplied screws as shown and tighten.
- 6) Locate the pistol grip mounting screw and pistol grip. Lubricate the screw. Install the pistol grip and tighten.
- 7) Locate the 2 lower rear section to upper rear section mounting screws. Remove and lubricate the fasteners. Loosely attach the lower rear section to the upper rear section as shown. Snug but do not tighten at this time. Adjustments will be made to this connection point later in the assembly process for length of pull.



- 8) Locate the 2 recoil pad mount to lower rear section mounting screws. Remove and lubricate the screws. Loosely attach the recoil pad mount to the lower rear section. Snug but do not tighten. Adjustments will be made to this connection point later in the assembly process.
- 9) You will find two cap screws imbedded into the recoil pad. Push the fasteners in to the recoil pad so that the threads are exposed on the other side. Use a 5/32 Allen wrench to attach the recoil pad to the pad mount. Note the radial drill/tap pattern. This allows you to cant the recoil pad, 8.5 and 17 degrees, plus or minus.
- 10) Lubricate the screws and start the upper recoil pad screw but do not tighten. Now rotate the pad until the lower screw aligns with the tapped hole. Start the second screw. Tighten the recoil pad screws just enough to snug the pad to its mounting block.
- 11) Cheek pieces can be installed at this time or just prior to the shooter adjust procedure.

B) FOLDING REAR SECTIONS

- 12) Locate the connector block, 2 connector block to center section mounting screws and pistol grip mount. Remove and lubricate the screws. Install the connector block and pistol grip mount to the center section as shown and tighten.



- 13) Locate the pistol grip mounting screw and pistol grip. Lubricate the screw. Install the pistol grip and tighten.

- 14) Locate the MP-LOKR[®] folding hinge assembly and 4 mounting screws. Remove and lubricate the screws. Re-attach the folding hinge to the connector block as shown and tighten.



- 15) Locate the upper rear sections 4 mounting screws. Remove and lubricate the screws. Reattach the upper rear section to the folding hinge as shown and tighten.

- 16) Locate the 2 lower rear section to upper rear section mounting screws. Remove and lubricate the screws. Loosely attach the lower rear section to the upper rear section as shown. Snug but do not tighten at this time. Adjustments will be made to this connection point later in the assembly process for length of pull.

- 17) With the rear section folded to 90° apply a single drop of lubricating oil to the upper and lower areas of the folding hinge pin. Work the oil in by folding and extending the rear section a few times.



- 18) Locate the 2 recoil pad mount to lower rear section mounting screws. Lubricate the screws. Loosely attach the recoil pad mount to the lower rear section. Snug but do not tighten at this time. Adjustments will be made to this connection point later in the assembly process for recoil pad height.
- 19) You will find two cap screws imbedded into the recoil pad. Push the fasteners in to the recoil pad so that the threads are exposed on the other side. Use a 5/32 Allen wrench to attach the recoil pad to the pad mount. Note the radial drill/tap pattern. This allows you to cant the recoil pad, 8.5 and 17 degrees, plus or minus.
- 20) Lubricate the screws and start the upper recoil pad screw but do not tighten. Now rotate the pad until the lower screw aligns with the tapped hole. Start the second screw. Tighten the recoil pad screws just enough to snug the pad to its mounting block.
- 21) Cheek pieces can be installed at this time or just prior to the shooter adjust procedure.

Installing Your Barreled Action

- 22) First remove, lubricate, reinstall and tighten MODSS trigger guard screws.
- 23) Make sure that your rifle is unloaded!
- 24) Remove your barreled action from the factory stock.
- 25) Locate the supplied action screws. Lubricate the screws.
- 26) Install your barreled action in the MODSS but do not tighten the action screws at this time.
- 27) Stand the entire assembly on the recoil pad. Allow the recoil lug on your barreled action to settle/rest against the internal lug mating surface of the MODSS stock.
- 28) Holding the rifle in this position torque the action screws to specification*.

*We have found 50 inch pounds of torque to be a good starting point for your action screws. You may wish to try 5 inch pound increments up and down to fine tune your action.

Never fire a rifle without first torquing the action screws!!!

Shooter Adjustment Procedure

- 29) Set the Length of Pull first. Remove the 2 ea. 1/4 x 20 socket headed cap screws at the upper rear member to lower rear member connection point. Slide the 2 parts and loosely reinstall the screws. Test for fit and repeat until you reach the best fit for you. Then, insure that you have adequate clearance for your hand on the pistol grip.
- 30) Tighten the connector screws.
- 31) Use a 5/32 Allen wrench to remove, replace or adjust the recoil pad. Note the radial drill/tap pattern. This allows you to cant the recoil pad, 8.5 and 17 degrees, plus or minus.
- 32) Adjust the recoil pad Height by placing the 2 cap screws in the appropriate holes for the best fit to you.
- 33) Install the cheek rest halves if you have not already done so. Adjust the Cheek Rest for the best location for you. There are numerous mounting holes to allow for fore and aft adjustment along with slotted holes to allow for height adjustments. Shown with optional Thumb Screw Kit.
- 34) Insure that when you complete the Rear Section adjustments, the bolt still has enough travel to function properly.

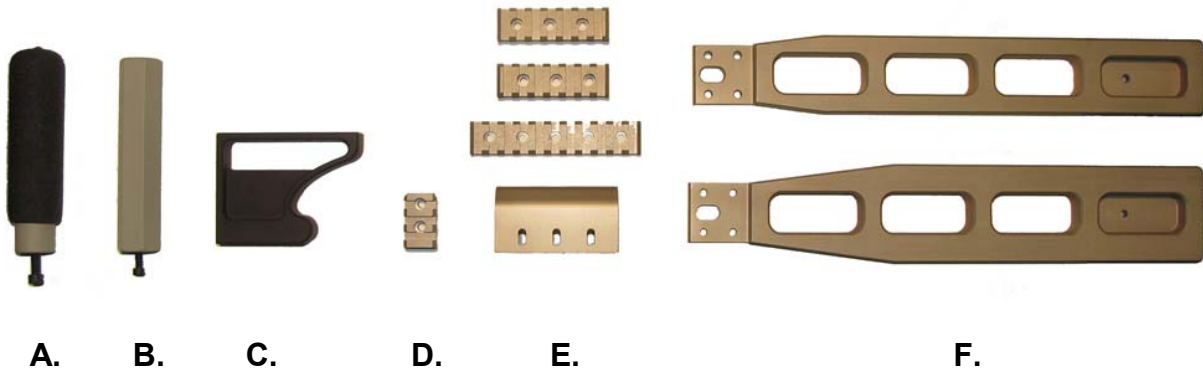


Finishing Up

- 35) Verify all fastener torque one last time.
- 36) Verify action screw torque.
- 37) Verify safety function by testing the safety in a **dry fire** mode repeatedly. Verify that the weapon is unloaded. Set the safety to “ON” and test the trigger action.

MP-MODSS stocks are designed for use with factory triggers. **You are responsible** for the use of aftermarket triggers. We cannot and will not take responsibility for other manufacturers tolerances or quality.

Optional Accessories



Not Shown: G. Standard Sling Stud Kit H. Cheek Rest Thumb Screw Kit

A. ROUND CHEEK BAR

- 1) To add or remove the optional Round Cheek Bar*, loosen the bottom recoil pad screw 2 turns, then loosen the upper recoil pad screw until the threads are disengaged with the mount, pivot the recoil pad to the side. This gives you access to the Round Cheek Bar screw hole.

*Note: Depending on your length of pull setting with the Round Cheek Bar in place you may have to fold the rear section (folders) or remove the recoil pad mount (fixed models) to remove the bolt for cleaning.



- 2) Install the Round Cheek Bar as shown and tighten. Reattach the recoil pad

B. BAG BAR

- 1) To add or remove the optional Bag Bar, loosen the top recoil pad screw 2 turns, then loosen the lower recoil pad screw until the threads are disengaged with the mount, pivot the recoil pad to the side. This gives you access to the bag bar screw hole.

*Note: With the Bag Bar in place you will have to install the sling swivel on either side of the recoil pad mount.



- 2) Install the bag bar as shown and tighten. Reattach the recoil pad.

C. RIDGID REAR HAND HOLD

- 1) Locate the Rigid Rear Hand Hold and fasteners. Lubricate the fasteners and install as shown.



D. REAR MONO-RAIL

- 1) Locate the Rear Mono-Rail and fasteners.

A) To add or remove the optional Rear Mono-Rail, loosen the top recoil pad screw 2 turns, then loosen the lower recoil pad screw until the threads are disengaged with the mount, pivot the recoil pad to the side. This gives you access to the Rear Mono-Rail screw hole.

Use one long screw and the supplied nut for the pass thru connection and one standard screw (lubricated) for the threaded connection as shown.

B) For installation with the Rigid Rear Hand Hold use the two short fasteners, lubricate and install on the bottom of the Hand Hold.



E. MIL/TAC FRONT COVER & PICATINNY RAIL KIT

- 1) Remove the 3 forward filler screws from the front section.
- 2) Locate the front cover mounting screws. Lubricate the screws and install the front cover.

NOTE: The mounting hole pattern can also be used for a forward Picatinny rail installation if desired by the operator.

- 3) Locate the PR-4 Low Pic Rail and mounting screws. Lubricate the screws and install the Low Pic rail on top of the front cover in the desired position. Install the remaining Pic rails in the desired operator position.



F. 2" or 2-1/2" FLAT VARMINT FRONT

- 1) To add or remove the optional Varmint front simply remove the four screws that attach the front section to the center section. Remove the front section. Lubricate the fasteners and loosely install the chosen Varmint front.
- 2) Now, stand the assembly on end to allow the mating surfaces to contact before final tightening. We recommend no more than 20 inch pounds of torque be applied to the fasteners.
- 3) Tighten by hand as shown until the parts don't move easily. There is no need for excessive torque on these fasteners!

G. STANDARD SLING STUD KIT

- 1) To add the Standard Sling Stud Kit locate a flush cup mounting point. Note that the flush cup holes are also tapped for stud installation. Lubricate the stud and insert thru the supplied spacer. Thread into the bottom of the flush cup hole as shown and tighten.

H. THUMB SCREW KIT

- 1) To install the optional Thumb Screw Kit first remove the stock cheek rest screws. Lubricate the thumb screw threads and reinstall. (Shown with optional Bag Bar)



Additional accessories for your MP-MODSS can be found by visiting our website. Please feel free to contact us should you have any questions or comments.

WWW.BILLETARMS.COM

BILLET ARMS COMPANY

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The Warranty is Limited to one (1) year from the date of sale and limited solely to the parts contained within the product's kit. Warranty does not cover anodizing or custom finishes. All products that are in question of Warranty must be returned shipping prepaid to the SELLER and must be accompanied by a dated proof of purchase receipt. All Warranty claims are subject to approval by The Billet Arms Company.

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