

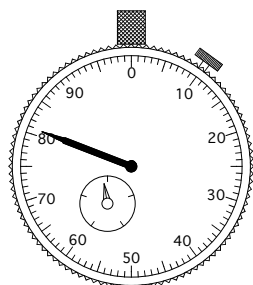


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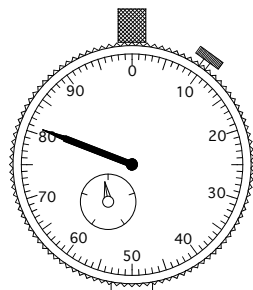
Chambering Gage

United States Patent # 5,170,169
P/N 200-11

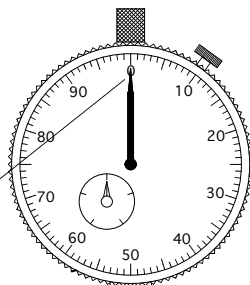
Make certain that the Firearm is unloaded before performing any work.



Do not over tighten set screw (located on back side), or damage to the indicator shaft housing could occur.



Remove original indicator tip and replace it with 1/4" dia. tip.



Zero Chambering Gage on flat surface and adjust indicator bezel accordingly.

Plunger tip should protrude a little, you will zero it in the next step.

Completely strip bolt, and action, insert bolt in action, and close bolt handle. Hold action vertically with the breech face up. Make sure the bolt handle is completely closed. Measure from the receiver face to the bolt face and record the dimension. Subtract .002" from that dimension. This is the crush factor when you tighten the barrel. This should be the final chambering depth from the shoulder of the barrel to the head space GO gage.

Example:

Receiver face to bolt face	.735"
Crush factor	-.002"
Final chamber depth	<u>.733"</u>

Note: For actions with a separate recoil lug, you will have to add the thickness of the lug to your final chamber depth or make the measurement with the lug on the barrel.

Chamber barrel most of the way. Make sure to clean chamber and barrel shoulder of all metal chips. Insert the GO gage and slide chambering gauge over threads until it seats firmly against the shoulder of the barrel, (or the lug) The cutaway view shows the dimension from the barrel shoulder (and Lug) to the headspace gauge to be .827". Now subtract the final chamber depth from the current dimension. This will give you the distance you have left to chamber.

Example:

Current dimension	.827"
Final chamber depth	-.734"
Distance to go	<u>.093"</u>

After chambering to final depth, tighten barrel on action and make sure the GO and NO GO gauges work properly. Once you get comfortable with this gage you will barrel faster and more accurately than ever before.

