



H-S PRECISION®

INSTRUCTIONS FOR WEATHERBY VANGUARD / HOWA 1500 / RUGER HAWKEYE PRO-SERIES® STOCKS WITH PRO-CENTER® TECHNOLOGY

H-S Precision's Pro-Series® Kevlar/carbon fiber stocks represent a new era in the production of high tech synthetic rifle stocks. Pro-Series® stocks are designed to last a lifetime with little or no maintenance.

Located on each side of your new stock is a flat point set screw. They are used to stabilize and center the barreled action making the need for conventional epoxy bedding unnecessary, but optional. A 3/32" Allen Wrench and Blue Loctite #243 are included.

DIRECTIONS FOR INSTALLATION

1. Before beginning installation of your new Pro-Series® stock, check your gun to make sure it is not loaded and remove the bolt assembly.
2. Remove the set screws from both sides of the stock using a 3/32" Allen Wrench. (See Figure 1)
3. Assemble the barreled action, magazine sleeve and trigger guard into the stock. Loosely install the action screws.
4. Push the barrel towards the right so it is touching the stock. (See Figure 2) Then, finger-tighten the action screws to hold it in-place. The set screw must be able to push the barreled action into correct position in the next step.
5. Apply Blue Loctite #243 to the first 5 to 7 threads on one of the set screws. **DO NOT** use a permanent setting thread locker. Install the set screw on the right side. Slowly turn the screw inward until the barrel becomes centered in the stock. (See Figure 3) It helps to have a good light source pointing directly at the barrel channel to prevent any shadowing.
6. Apply Blue Loctite #243 to the remaining set screw and install it on the left side. Turn it inward until it stops against the receiver. (See Figure 4) Do not over tighten. Small adjustments to both set screws may be necessary for fine tuning.
7. Tighten front and rear action screws to 65 inch/pounds. Hand tighten center action screw (if applicable).
8. Loctite begins to harden in 5 minutes. Allow to fully cure for 24 hours.

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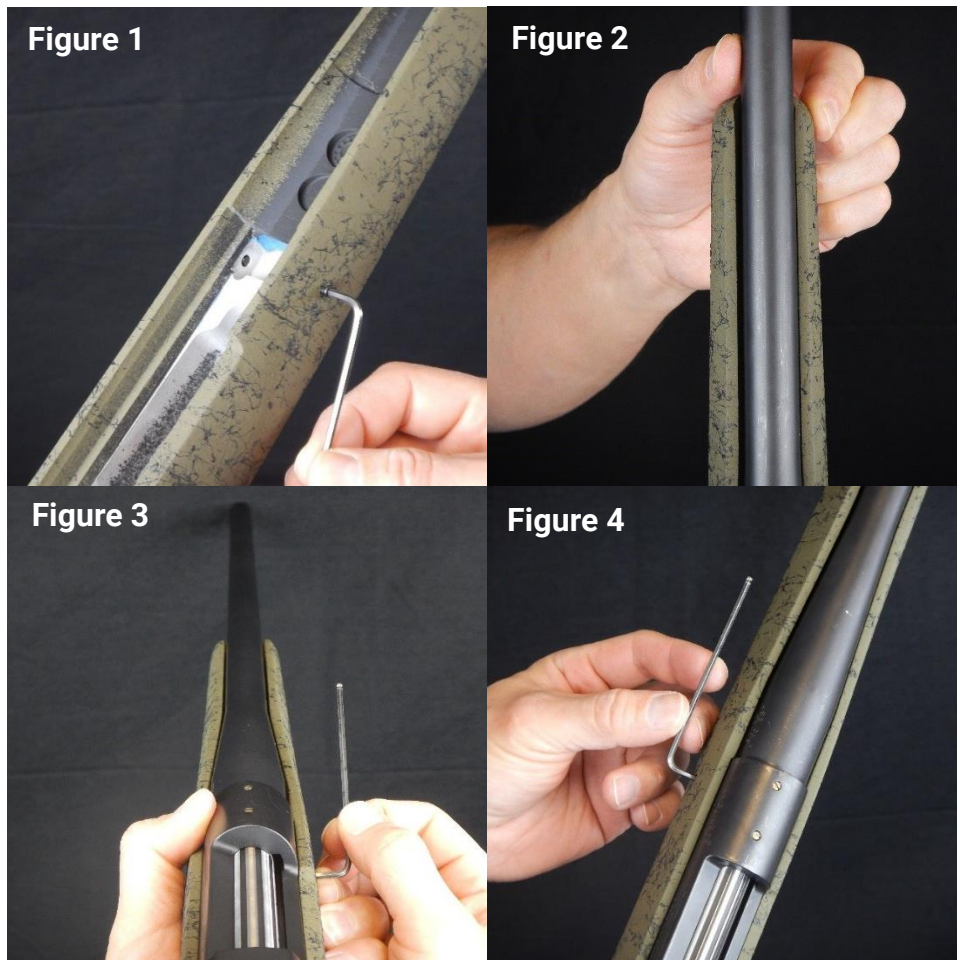
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REMOVAL:

1. Remove the Left set screw only.
2. Remove the action screws and barreled action from the stock.

REASSEMBLY:

3. Reinstall the barreled action and finger-tighten the action screws.
4. Apply Loctite Blue #243 to the left set screw and reinstall. Tighten the left set screw the same amount as you did in the initial installation to center the barrel in the stock.
5. Tighten front and rear action screws to 65 inch/pounds. Hand tighten center action screw (if applicable).



Our Pro-Center® technology is a major advancement in firearm stocks. This technology allows anyone to center the barrel in the stock, regardless of dimensional variances in the barreled action. If you are unable to center the barrel in the stock, the tolerances of your barreled action may be out of specification. Please contact your barreled action manufacturer before making any modifications.



LIMITED WARRANTY

H-S Precision is a complete gun manufacturer producing high-quality firearms and related products providing services for the shooting sports industry since 1978. From the complete action (including the floor metal and trigger), the barrel, bases and stocks – we are proud to produce innovative products using world-class techniques, proprietary technology and state-of-the-art equipment. We set our quality, accuracy, and service standards higher than our competition to ensure our customers receive the highest quality products available anywhere.

Because of the confidence we have in our products and production processes, H-S Precision does not provide a written warranty. However, we stand behind our reputation for customer satisfaction. We will consider requests for service or repair of H-S Precision firearms without charge on a case-by-case basis. A determination will be made taking into consideration such things as the age and condition of the firearm, and the circumstances surrounding its malfunction or other problem.

H-S Precision will not be responsible for damage resulting from ordinary wear and tear, alterations by unauthorized persons, accidents, misuse, use of incorrect or other than factory loaded ammunition, or failure to provide reasonable and normal maintenance.

Should any H-S Precision product require service or repair under this policy, please contact our offices to receive a Return Authorization Number.

Shipment must be delivered prepaid to H-S Precision (1301 Turbine Drive, Rapid City, SD 57703). The product must be accompanied by a proof of purchase and a letter explaining the problem. It should also be insured by the owner at the time of shipment, as H-S Precision is not responsible for damage or shipments lost in transit. H-S Precision will pay all charges to return the product to the owner if it is accepted for service or repair without charge under the provisions of this service policy.

H-S Precision reserves the right to repair or replace any product at our sole discretion.

H-S PRECISION IS NOT LIABLE FOR ANY CONSEQUENTIAL, INCIDENTAL, OR CONTINGENT DAMAGES. ALL SHIPMENTS MUST DISPLAY THE RETURN AUTHORIZATION ON THE OUTSIDE OF THE SHIPPING CONTAINER.

REFUND POLICY

Refunds will be given only if the stock is returned in its original condition within 30 days of shipment. Alterations made to the stock will void any right to a refund. No refunds will be made for special order stocks. Refunds are limited to price paid for the stock and do not include shipment charges. Stocks must be returned to H-S Precision (prepaid) for inspection before any refund can be given.