

H-S Precision, Inc.
Generation II Detachable Magazines
 Rev AW, 9/6/22

Setting Feed Gap:

1. Place bending tool (H-S Precision #AP-260) over rail with beveled side towards inside of magazine. *Fig. 1*
2. Angle bender along rail diagonally as shown to widen or reduce front gap. Bend both rails the same amount. *Fig. 2*
3. Angle bender along rail diagonally as shown to widen or reduce rear gap. Bend both rails the same amount. *Fig. 3*
4. Check straightness by placing straight edge of bending tool against each rail. *Fig. 4*
5. Check front and rear gaps with a Veneer caliper for best results. The scale on the bending tool can be used but will only give approximate results.



Fig. 1

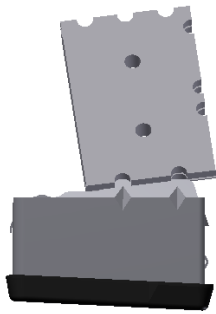


Fig. 2

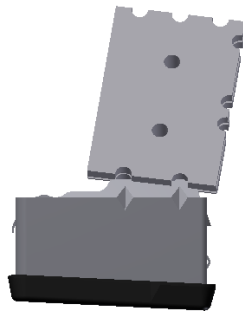


Fig. 3

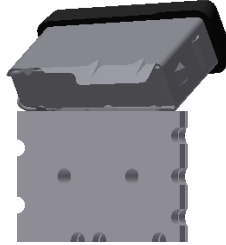
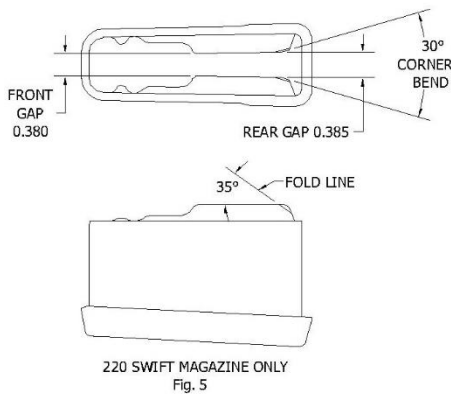


Fig. 4

* Feed Gap specifications below are a close starting point. Small adjustments may be necessary for best performance. If large adjustments have been made and it's still feeding improperly, check the clearance between the bolt and the top of the magazine feed rails. There should be roughly 1/32" to 1/16" clearance while pushing UP on the magazine. Excessive clearance will cause feeding malfunction.

Short Action Cartridge	S/A Magazine #			L/A Mag #	Front Gap	Rear Gap
	Low Cap	Med. Cap	High Cap			
Remington: 17, 222, 223 204 Ruger	7369		7527		.325	.312
350 Legend	7369		7527		.325	.312
6.5 Grendel, 6mm ARC	7369		7527		.380	.380
22 Nosler	7556		7554		.360	.370
224 Valkyrie	7556		7554		.360	.370
300 AAC Blackout	7369				.325	.312
22-250 Rem	7368				.380	.380
220 Swift	7371				See Fig. 5	
6mm Rem	7372	7384		7377	.400	.420
257 Roberts						
284 Win	7373	7375	7393	7390	.435	.425
Short Action Ultra Mag SAUM: 6.5mm, 7mm, 300	7372	7375	7376	7377 (std. COAL) 7381 (>2.826 COAL)	.485 .460	.490 .460
Winchester Short Mag WSM: 7mm, 270, 300, 325	7372	7375	7376	7377 (std. COAL) 7381 (>2.826 COAL)	.485 .460	.490 .460
Ruger Compact Mag RCM: 300, 338	7372	7384	7393	7390	.450	.480
35 Rem	7372			7390	.395	.410
Remington Mag: 6.5mm, 350	7372	7384	7393	7390	.460	.445
Creedmoor: 6mm, 6.5mm, 22 Remington: 7mm-08, 260 Winchester: 243, 308, 358 338 Federal 6 GT 6.5 Lapua 6 XC	7372	7384	7376	7377 (std. COAL) 7381 (>2.826 COAL)	.410 .395	.420 .410

Long Action Cartridge	L/A Magazine #		Front Gap	Rear Gap
	Low Cap	High Cap		
7x57 Mauser, 6.5x55, 6.5x55 Swedish	7377 (< 3.061 COAL) 7381 (> 3.061 COAL)		.415 .395	.425 .410
6.5 PRC	7390 (< 3.061 COAL) 7379 (> 3.061 COAL)		.450 .440	.480 .450
240 Wby Mag	7377		.395	.410
6.5x284 Norma	7390 (< 3.061 COAL) 7380 (> 3.061 COAL) (> 3.061 COAL) 7367		.450 .440 .395	.430 .450 .410
300 H&H Mag	7380		.420	.460
300 Win Mag	7379	7382	.440	.450
7mm STW	7379	7367	.440	.450
8mm Rem Mag				
338 Lapua	7381	7382	.475	.440
Norma Mag: 300, 338	7381	7396	.475	.440
Remington Mag: 7mm Winchester Mag: 264, 338 Norma Mag: 308, 358	7379	7367	.440	.450
Weatherby Mag: 7mm, 257, 270, 300, 340	7379	7367	.440	.450
Remington: 25-06, 280, 280 Ackley Improved 30-06 Springfield 35 Whelen 270 Winchester	7381	7396	.395	.410
Nolser: 26, 27, 28, 30, 33	7379	7367	.460	.460
375 H & H Mag	7379		.420	.460
		7396	.395	.410
7mm LRM, 7mm PRC, 300 PRC, 375 Ruger	7381	7396	.440	.450
Remington Ultra Mag RUM: 7mm, 338, 300, 375	7379	7367	.460	.460
Weatherby Mag: 30-378, 378	7381		.490	.490
416 Rigby	7381		.490	.500
416 Rem Mag, 458 Lott	7379		.440	.450
458 Win Mag	7379	7367	.440	.450

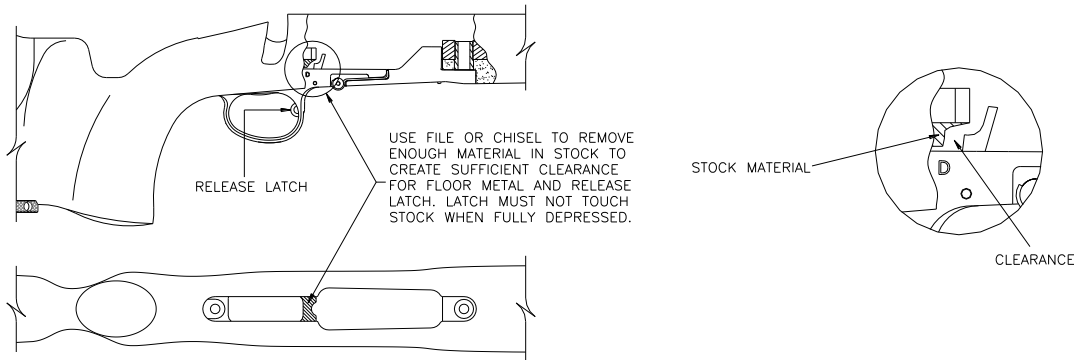


Installation instructions:

Gen 2 Floor Plate

Step 1.

Prepare clearance, if release latch interferes with stock during operation.



Step 2.

Assemble action and floor metal into stock but **do not tighten**. There may be some room for the floor metal to slide up or down in the stock. It should be placed in the "UP" position. The tip area of the floor metal is shown in the following pictures.

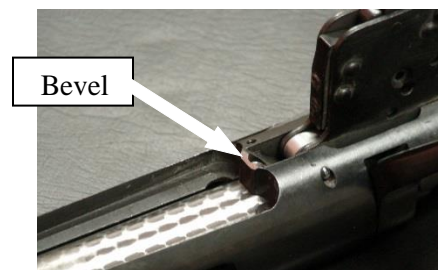
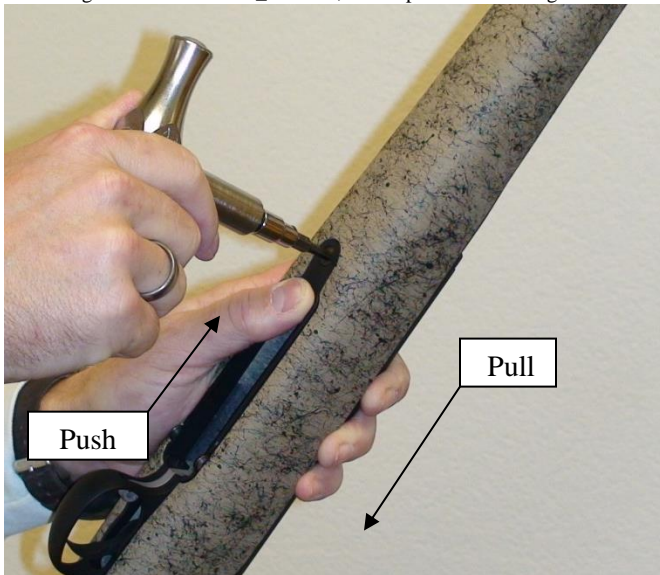


Fig 1. Down – (Incorrect)

Fig 2. Up – (Correct)

Step 3.

Position rifle so muzzle is pointing upward. Pull the action downward to seat the recoil lug onto the bedding block while at the same time pushing upward on the floor plate to diminish the gap between the tip of the floor metal and stock. This will generate proper clearance and positioning between the magazine and receiver. Tighten the front guard screw to 65 in_lbs. first, then repeat for the rear guard screw.



Troubleshooting: If the rear of the magazine interferes with the receiver after following steps 1 thru 3, it may be necessary to slightly bevel the rear edge in the receiver's feed port as shown. It is recommended to apply cold blue to the exposed bare metal afterward.