

## Recoil Pad Installation

1. Please refer to the Pachmayr catalog for proper pad selection. Recoil pad size and design are important to your satisfaction. Please read all instructions before installing and check the back of your pad packaging for size dimensions.
2. Trim butt stock so that it is flat and squared. Check that length of pull is correct with the thickness of the pad chosen, (refer to dimension "E".) You may wish to add spacers for longer pull length. Wrap masking tape around the stock to protect the finish. Note: For fiberglass or synthetic stocks it is necessary to "fill" end of the stock. Remove 1/2" to 1" of the foam filling and fill the mortise with a metal-filled epoxy available from Devcon or Loctite. Trim off the excess material so that it is level with the outside of the stock.
3. Drill out and fill "old" pad or plate screw holes with wood dowel rod. Never use the existing screw hole in the stock to mount a new pad, if you do, the pad may become loose.
4. Always use the Pachmayr screws provided with our pad, never use others. Our pads are designed to be used with the screws provided. Damage to pad base may result from using other screws.
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6. Layout the pad on the buttstock for minimal removal of material from pad dimension "D". Make sure the pad is centered on the stock. Most material removal from the pad will be on the toe. Note: Some pads have an internal insert this is referred to as dimension "F". If you use too large of a pad you may grind into the insert and ruin the pad.
7. Prepare to mount the pad by cutting slits in the pad for screws. To do this you must first find where to make your cut. Push a piece of wood dowel of appropriate size through the screw hole in the pad. When you push the dowel through, it will raise a dimple on the pad face. All that is needed is a cut with a razor knife across the dimple made with the wood dowel. You now have a through hole that is not visible for a clean appearance.
8. Mark the top screw hole location on the stock. Insert a scribe through the cut in the pad, push the scribe into the wood to mark the stock. Measure the second hole position with a dial caliper or equivalent, (refer to dimension "C".)
9. Make sure the pad sits flat on the stock. Some installers grind the pad base, if you do, be careful. If the pad base is ground too much and made too thin there is a severe chance of cracking the base or warping the pad.
10. Drill pilot holes for the screws in the stock carefully. The drill size is 1/8". Do not attempt to mount the pad without drilling pilot holes for the screws. You will run the risk of cracking the stock.
11. Mount the pad tight to the stock with the screws and re-check the pad layout. Your pad should be centered. Note: when inserting the screws through the slits cut in the pad use a light grease (or Armor All®) to keep from tearing the rubber.
12. Grind the pad using 80-100 grit aluminum oxide on a 12" - 15" disc grinder to shape the pad. It is important that you not force the grinding process. Let the wheel remove the material at a reasonable rate. Decelerator pads may require a little more time. Side core pads can be damaged by improper grinding. Always use a grinding disc in good condition. We recommend you use a quality pad grinding fixture. These are available through Brownell's in Montezuma, IA, [www.brownells.com](http://www.brownells.com), or B-Square in Ft. Worth, TX, [www.b-square.com](http://www.b-square.com).
13. Final finish of the pad. We recommend you use the following guidelines: A wood sanding block 1" x 1" with wet/dry paper 180-240/320 grit. Use a few drops of furniture polish with lemon oil for lubricant and polish evenly around the base of the pad. If you attempt to remove too much material you will find that the base will be undersized to the pad. Clean the pad by wiping with Armor All®.

