

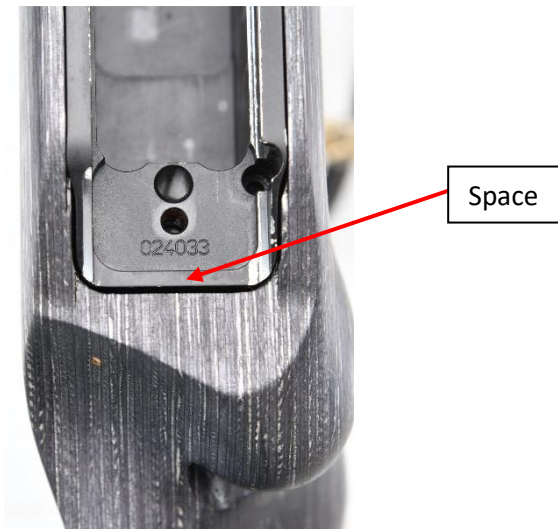
# How to glassbed a GRS laminate stock for Blaser R93

Read the whole instruction before you start working with the stock.

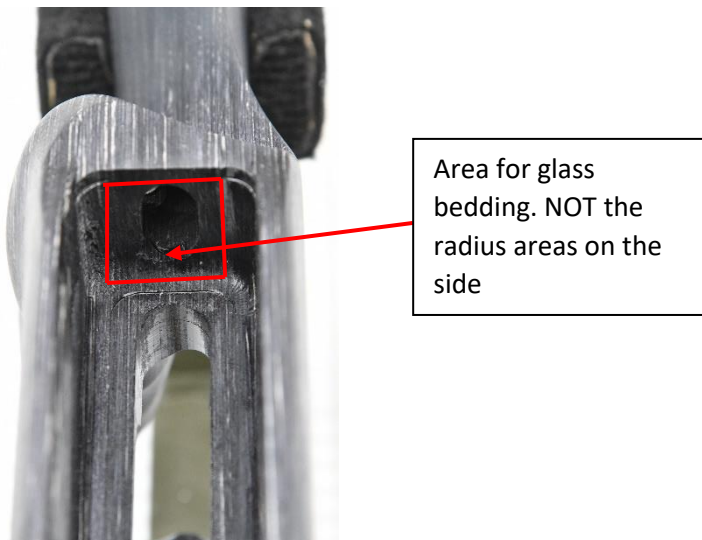
To maintain the warranty of the laminate stock it's a must to glass bed the receiver. It's only the area that receives recoil and the areas that are under the front of the receiver that needs glass bedding.

## Check the fitting

Check how the receiver fits in the stock. There shall be a small space between the receiver and the stock. It's important that this space maintains after glass bedding the receiver.



It's only the area that receive recoil and the areas that are under the front of the receiver that needs glass bedding. All other areas, especially the radius vertical one in the back of the receiver must be free of contact with the stock. Therefore, the glass bedding will be done in two steps. Step one on the back of the receiver and step two under the front of the receiver.



## **Step one**

### **Preparing the receiver**

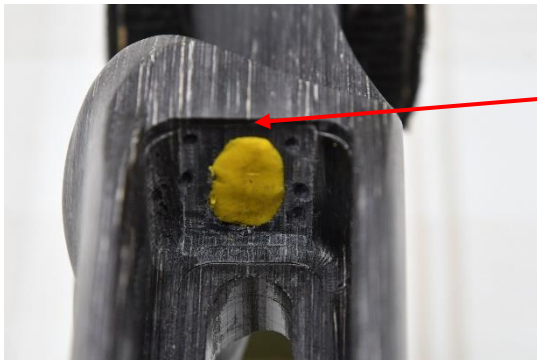
Fill the hole for the rear stockbolt with modelling clay. To maintain the space between the receiver and the stock put two layers of electrical tape on the upper area.



Surface with 2 layers of electrical tape.

### **Preparing the stock**

Mill about 2 – 3 mm of wood where the glass bedding will be placed for the recoil receiving area. Leave as much in the upper edge. Glass bedding shall not be seen only make difference. Drill a few small shallow holes to make the glass bedding mass fasten better to the wood. Put some modelling clay in the hole for the rear stockbolt.



Leave the upper edge while milling.

### **Glass bedding**

The glass bedding shall be done according to the instructions from the manufacturer. It's important to use glass bedding that will neither shrink nor expand during its hardening, for example Brownells Accra gel or EpoBed from EpoTex. Do not forget the release agent or you will have something similar to a few layers of hard car wax.

Apply a small amount of glass bedding on the areas that shall be glass bedded. It's better to do this moment twice rather than put too much amount at once which will make the stock crack. The receiver is put into the stock gently by hand, no force will be necessary. Secure the receiver with some rubber band or tiny rope.

### **Clean up the glass bedding and receiver**

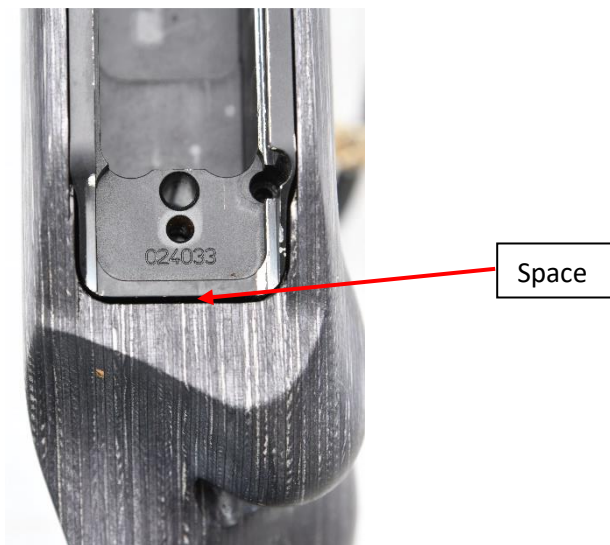
When the glass bedding has hardened according to the instruction from the manufacturer it shall be cleaned up. Remove all glass bedding from the areas that shall not be in contact with the stock. Remove the modelling clay from the hole, for the rear stockbolt, in the stock.



Clean the receiver from release agent, electric tape and modelling clay.

### **Check how the receiver fits**

Mount the adaptor for the stockbolt into the receiver. Place the receiver into the stock and tighten the stockbolt. When the stockbolt is tightened there shall still be a small space between the receiver and the stock.



## **Step two**

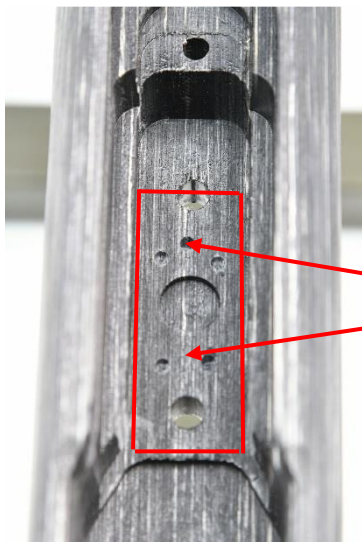
### **Preparing the receiver**

Put modelling clay in the holes for the barrelnuts and the screw for the recoil lug. Make it level to the receiver.



### **Preparing the stock**

Drill some small shallow holes to make the glass bedding fasten better.



Areas for glass bedding.  
NOT the areas on the  
side.

## **Glass bedding**

The glass bedding shall be done according to the instructions from the manufacturer. It's important to use glass bedding that will neither shrink nor expand during its hardening, for example Brownells Accra gel or EpoBed from EpoTex. Do not forget the release agent or you will have something similar to a few layers of hard car wax.

Apply a small amount of glass bedding on the areas between, in front of and behind the holes for the barrelkey. The surface shall be smooth so you only need to add a thin layer of glass bedding. The sides of the receiver shall not be glass bedded. It's better to do this moment twice rather than put too much amount and crack the stock. Place the receiver into the stock and gently tighten the stockbolt in the rear and then in the front.

## **Clean up the glass bedding and receiver**

When the glass bedding has hardened according to the instruction from the manufacturer it shall be cleaned up. Remove all glass bedding from the areas that shall not be in contact with the stock. Drill the holes in the stock, clean from bedding, for the barrelkey.



Clean the receiver from release agent and modelling clay.

## **Assembling**

Apply some thread lock, such as Loctite 243, to all threads. Assemble the adaptor for the stockbolt to the receiver, place the receiver into the stock and tighten the rear stockbolt. Then mount and tighten the front stockbolt.

**FINISHED!!**