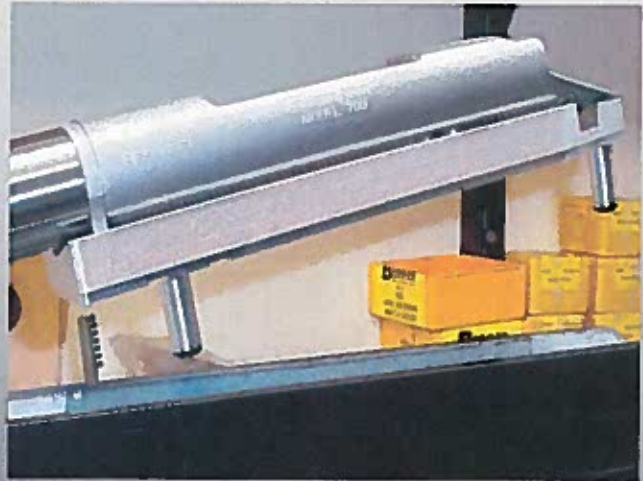


Whidden V-Block Instructions



**PLEASE READ THE FOLLOWING IN ITS ENTIRETY
BEFORE BEGINNING V-BLOCK INSTALLATION.**

Materials List:

Two-part long-cure epoxy

Release Agent

Epoxy Applicators

Cotton Swabs and Vinegar

Stock inletting tools

Drill and 1/2" bit

Masking Tape

Electrician's tape

Whidden V-Block Instructions

Step One:

Put one drop of epoxy onto each pillar and insert it into the base of the V-Block, pushing them securely into their respective counterbored holes.

Step Two:

Drill holes in the stock with the 1/2" bit aligned with the pillars in the V-Block.

Step Three:

Inlet the inside of the stock to fit the V-Block with clearance for only enough epoxy between the V-Block and stock to allow a solid bond.



Whidden V-Block Instructions

Step Four:

To test the fit of the stock and the action assemble the action and V-Block using the action screws. Place the assembly into the stock inlet to check for the proper depth. Adjust the inlet as necessary.



Whidden U-Block Instructions

Step Five:

Once the height of the block in the stock is as desired, wrap masking tape around the barrel to center the barrel in the barrel channel of the stock. The thickness of the wrapped tape layers will hold the barreled action and block level in the stock during the epoxy process.



Step Six:

Remove the trigger and bolt release from the action.

Whidden V-Block Instructions

Step Seven:

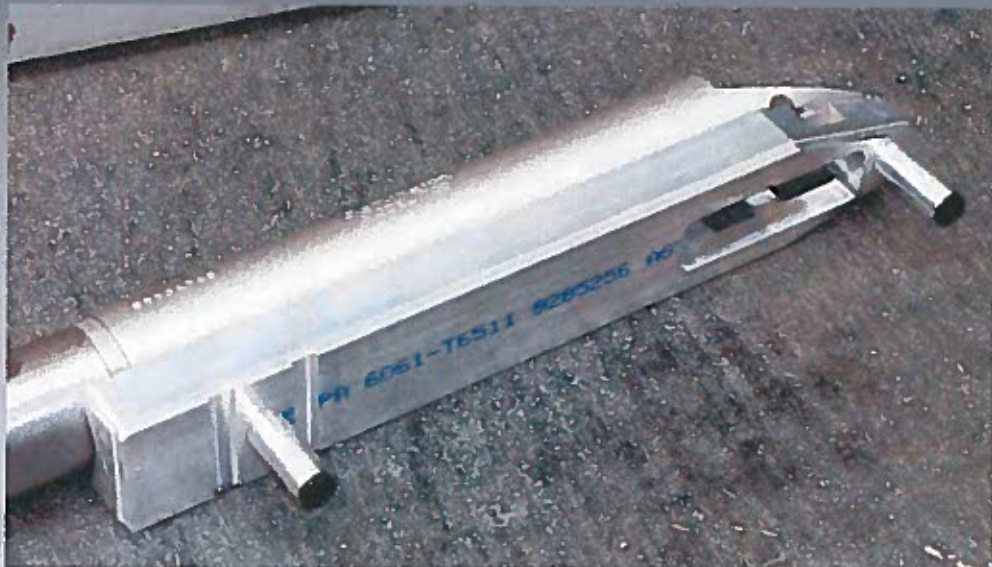
Thoroughly degrease the V-Block to ensure a clean bonding surface for the epoxy.

Step Eight:

Disassemble and coat the action and action screws with a release agent for protection against excess epoxy.

Step Nine:

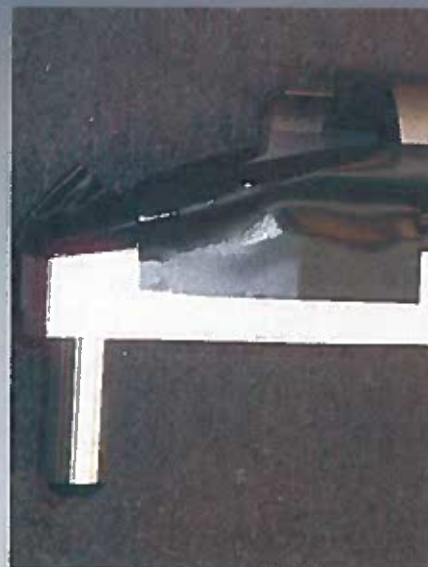
Place action back into the V-Block and screw in action screws to hold parts together as one assembly



Whidden V-Block Instructions

Step Ten:

Use one layer of electrician's tape around the outside of the V-Block where the action and V-Block meet. This prevents any epoxy from getting between the V-Block and action.



Whidden U-Block Instructions

Step Eleven:

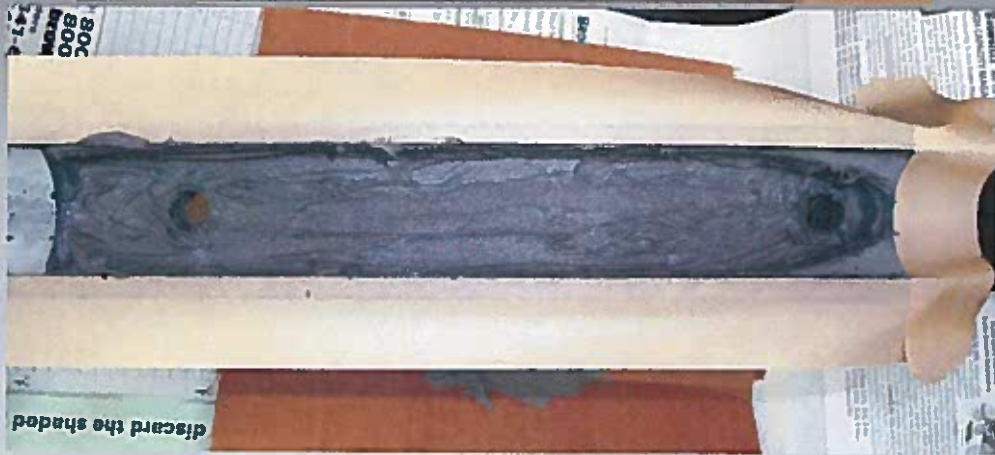
Mask the top of the stock inlet with masking tape to ease cleanup of the epoxy.



Whidden V-Block Instructions

Step Twelve:

Mix epoxy and apply it to the V-Block and stock inlet.



Whidden V-Block Instructions

Step Thirteen:

Place the action and attached, taped, and epoxied V-Block into the epoxied stock inlet.



Whidden V-Block Instructions

Step Fourteen:

Clean epoxy from the heads of the action screws as well as any other epoxy leakage, paying very close attention to the trigger and magazine areas. Cotton swabs dipped in vinegar are very effective for this part of the process.

Step Fifteen:

Let the epoxy cure overnight.

Step Sixteen:

Remove the action screws and the action.

Step Seventeen:

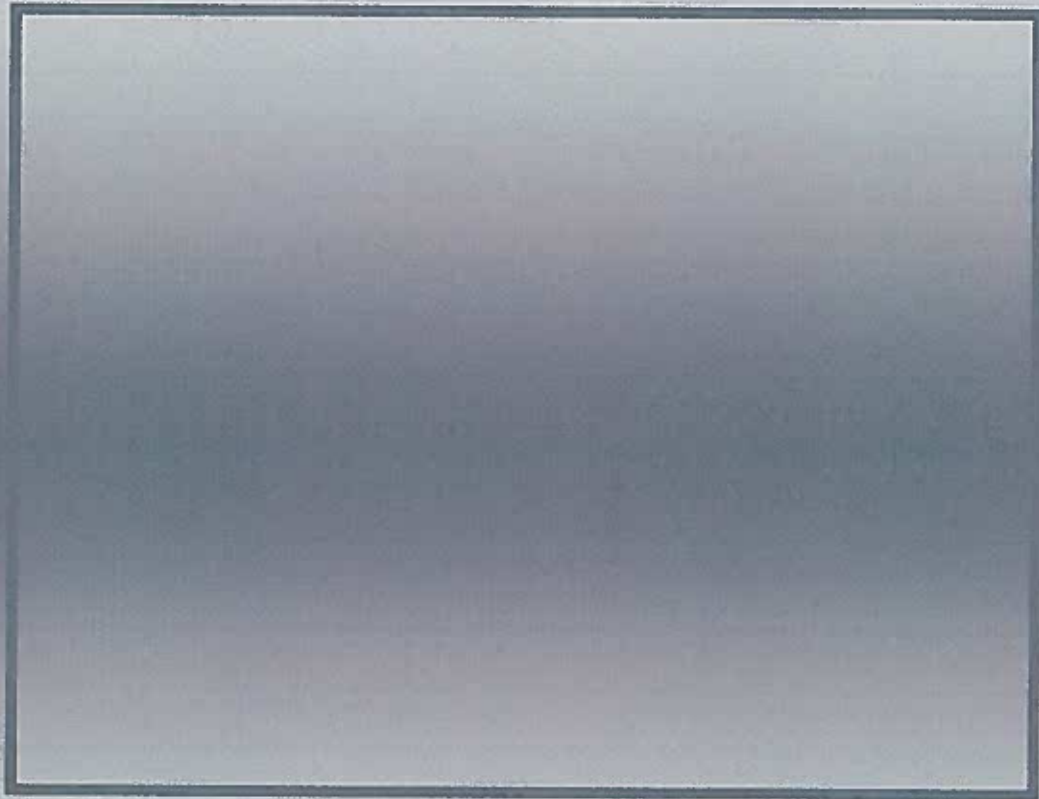
Trim any V-Block pillar protrusions flush with the base of the stock.

Step Eighteen:

Any voids remaining between the V-Block and the stock can be filled with epoxy.

Whidden U-Block Instructions

Please use the box below to record your firearm model, stock manufacturer, epoxy used, and date installed for your records.



Whidden Gunworks

PO Box 969

Nashville, GA 31639

(229) 686-1911

Whidden U-Block Instructions

Notes:

Whidden Gunworks

PO Box 969

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