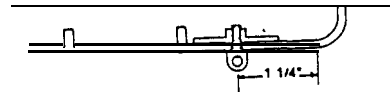


SUGGESTIONS FOR ATTACHMENT OF FLANGED NUT STUDS #2, #2R AND #2A

Manufactured by Harris Engineering, Inc.
Barlow, Kentucky 42024

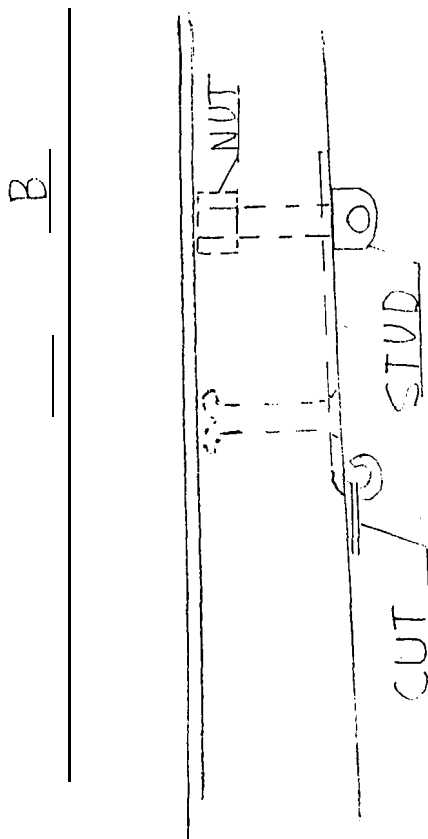


The purpose of the big headed flange nuts is to provide more support for the sling stud on thin walled fore-ends. A bipod exerts more pull on the stud than a carrying sling.
The #2 flat flanged nut measures 1 3/8 x 5/8 in., the shank is 5/16 in. dia., with 10-32 threaded hole. Stud and washer provided.
The #2R is similar except that flange has 3/4 in. radius.
The #2A has round head 5/8 in. dia.
Selection of the right stud for the job at hand is a matter of judgement.
Examine gun with stock removed or take to gunsmith.

- 1) With the gun unloaded and the bolt out, remove barrel and action from stock. Not all injected molded stocks are practical for the application of the #2 adapters. (Fiberglass stocks should be returned to manufacturer or gunsmith for fitting of sling stud.)
- 2) On conventionally shaped stocks, the stud should be placed about 1 1/4" from the start of the stock's fore end radius (about 2 3/4" on Ruger Mod. M-77 RP MK. II. Use #2A on this Ruger).
- 3) Drop the flanged nut in the stock in the desired position and drill through the threaded shank with a 5/32 drill, the flanged nut thus acts as a drill guide. The drilled hole is then enlarged with a 3/16 drill to accept stud. The stud must be perfectly centered or bipod will be canted. Further, any of the flanged nuts may be altered (ground) to better fit the barrel channel.
- 4) After installing stud attach bipod to check proper function.
- 5) If the stud is satisfactorily positioned, remove flanged nut and put epoxy cement under area covered by the flange, screw the stud back in immediately.
- 6) #2R Stud, with its radiused flange can be fitted to some thin wood fore-ends. The fore-end should be at least 3/8" thick at the point of installation. A 5/16 drill is used after the pilot hole is drilled and the shank turned down. The included washer is used under the stud. Inletting under flange may be necessary to clear gas tubes or magazines. Epoxy cement should be used under flange for better contact.

If one is not handy with tools, he should have a competent gunsmith install the stud.
Harris Engineering, Inc., accepts no responsibility for damaged stocks or other liability resulting from the improper installation of the #2, #2R and 2A adapters.

FROM THE DESK OF
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M1A and M14

There are variations in the M1A and M14 stocks. This is one way that a Q.D. stud has been installed. The flange of the rivet was drilled, the rivet removed, and replaced by a fore-end stud. The Harris Bipod requires a Q.D. stud for mounting. See a Gunsmith