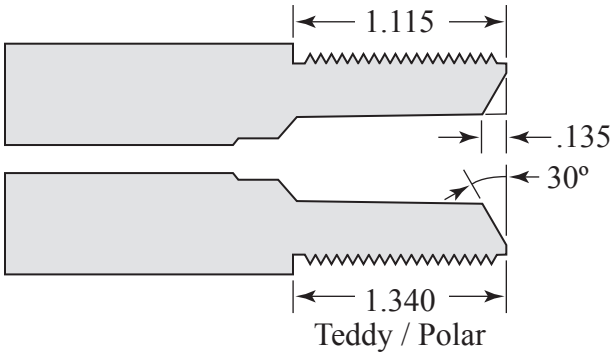
Stolle Actions' Barrel Tenon

Center Fire Actions' Instructions

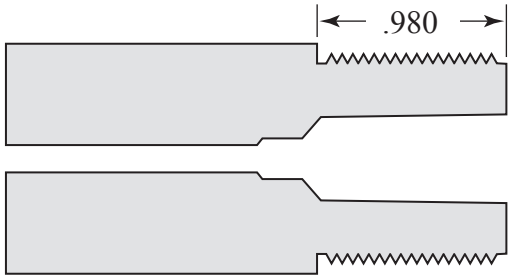
Panda / Kodiak / Grizzly II



When chambering cut tenon 1.0600" in diameter by 1.115" long for a Panda, Short Kodiak or Grizzly II, .980" long for a Long Big Bore Panda, Long Kodiak or Long Grizzly II, .692" long for Cone Bolt Atlas, .557" long for Flat Bolt or Long Atlas, or 1.340" long for a Teddy or Polar. Leave rear end of barrel square for now.

Thread tenon $1\frac{1}{16}$th inches in diameter by 18 threads per inch. If you are using wires to measure the threads the measurement should be 1.0715" plus 0.000" or minus 0.002" using 0.032" wires.

Long Big Bore Panda / Kodiak / Grizzly II

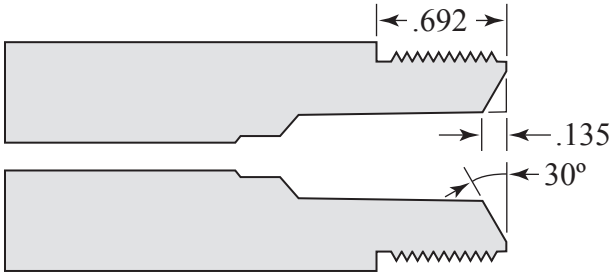


Thread: $1\frac{1}{16}$ - 18

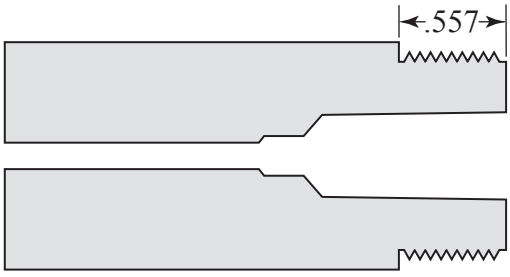
For a coned bolt run the chambering reamer in until head-space gauge is flush with rear end of barrel. For a flat bolt run the chambering reamer in until measurement from base of head-space gauge to shoulder of barrel is 1.115".

For a coned bolt set compound feed of lathe to 30 degrees. Touch tool to be used for cutting cone at chamber edge and set saddle stop. Now back off stop 0.135" and using compound feed only cut cone. This should give approximately 0.007" - 0.010" of space between the bolt and the barrel.

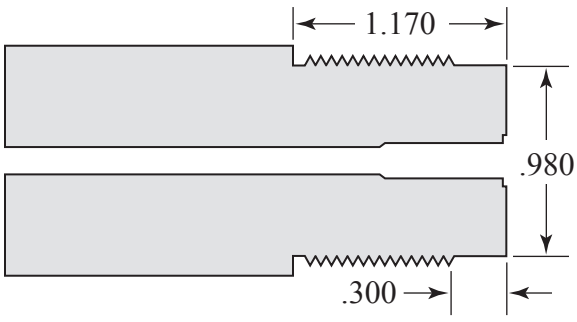
Cone Bolt Atlas



Flat Bolt / Long Atlas



Stolle Swindlehurst 22 Small Bore Instructions



When chambering cut tenon 1.0600" in diameter by 1.170" long, except cut last .300" at .980" diameter.

Thread tenon $1\frac{1}{16}$th inches in diameter by 18 threads per inch. If you are using wires to measure the threads the measurement should be 1.0715" plus 0.000" or minus 0.002" using 0.032" wires.

Caution: Dry-firing of this action without a barrel installed can break the firing pin.