

# INSTRUCTIONS FOR USING THE SPF PREDATOR/TAC ACTIONS

1. Fit barrel up per included drawing. **USE THE ENCLOSED DRAWING FOR CUTTING THE COUNTERBORE AND CREATING THE THREADS AND CHAMBER.**
2. The threads are the largest size permissible for an **ANSI class 2 fit for the 1.0625 – 16 tpi** or **1.125 – 16 tpi** standard on the 338 lapua actions. If a currently chambered barrel that fits another action does not fit, it is out of ANSI standard tolerance.
3. **ALWAYS, use anti-seize when installing a barrel, oil is NOT good enough.** If it feels like it is galling during installation or removal, stop, put in Kroil and very easily work it back and forth to try and save it. If it does not work, stop, cut off the barrel and have your gunsmith or us machine out the stub. This is standard on all stainless steel actions.
4. **DO NOT heat the action** up to help loosen a stuck barrel. If it is galled into the action, heating it will only make it worse.
5. **DO NOT lap the lugs.** They are factory lapped before the bolts are coated with the **Armoloy process.** By lapping them, you will only remove the coating and increase the potential for the bolt to gall.
6. **ALWAYS put bolt grease** on the lugs during use. Failure to do so will cause galling of the bolt lugs to the lug faces inside the action.
7. **Any Remington Model 700** pattern trigger and stock will fit this action. The magazine cutout for the short actions is extended 0.130 on the Predators, but not the TACS. **Wyatt Outdoors or HS Precision** boxes will fit. Standard off the feed lip style boxes are recommend for all actions. If you don't use the extended boxes in the Predator, glue in the little half moon aluminum piece behind the box to fill in the space. The scope bases required are 2 front bases for a Model 700. Standard one-piece bases will not fit. SPF has recoil lugs available that use the pin in the front of the actions to retain it in place. SPF also has scope bases and is working on bottom metal and other accessories.

## SAFETY CONCERNS FOR USING THE PREDATOR ACTION

1. **Do not overload** any ammunition past SAAMI or industry standard specifications. Stiller's Precision Firearms, LLC cannot be responsible for any loss caused by this type of incident.
2. Always keep your **head clear of the port and from behind the bolt** when discharging the weapon for the first time after changing barrels, etc.
3. Always make sure barrel is **clear before discharging.**
4. Always make sure the ammunition is correctly **headspaced and the necks are correctly sized** for the chamber in use.
5. If anything seems out of the ordinary, **STOP and investigate before discharging.**
6. **IF THERE ARE ANY PROBLEMS, QUESTIONS OR CONCERNS PLEASE CONTACT STILLER'S PRECISION FIREARMS, LLC FOR ASSISTANCE.**