INSTRUCTIONS FOR USING THE PYTHON ACTION

1. Fit barrel up per included drawing. The 1.375 headspace dimension is the minimum. The actions headspace is 1.375 ± 0.001. If a recoil lug is used, add the thickness to the tenon length and headspace dimensions. **USE THE ENCLOSED DRAWING FOR CUTTING THE CONE. IT IS ESPECIALLY IMPORTANT ON THE DROP PORT ACTIONS**.

2. The barrel must be at least 1.250 in diameter to use action without barrel adaptor. If a smaller barrel is used, install the adaptor per the drawing that accompanies it. This action should support barrels up to 1.450 diameter 30 inches long if correctly bedded.

3. The threads are the largest size permissible for an ANSI class 2 fit for the 1.1875 – 18 tpi standard.

4. 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.

5. **DO NOT** heat the action up to help loosen a stuck barrel. The insert is put in with four redundant processes. It is interference fit on front and rear, tightened to approximately 150 foot pounds of torque, bonded with Loctite 680 bearing retaining compound. Even though it may seem safe, heating up the action to remove a barrel may destroy the integrity of this joint. Slight heating to remove a glue in from a stock is permissible. Be careful to keep the temperature below 350° F and don't pull up and down on the barrel too hard. The heat treat condition of the aluminum is of more concern then the joint for this process.

6. The extractor will accommodate both PPC and 308/BR bolt faces without changing any parts on the standard actions. Ejector or drop port style actions may be specific for the PPC.

7. **DO NOT** lap the lugs. They are factory lapped before the bolts are coated. By lapping them, you will only remove the coating and increase the potential for the bolt to gall.

8. **ALWAYS** put bolt grease on the lugs. Failure to do so will cause galling.

9. **DO NOT** remove the hard anodize surface from the bottom of the action. Any glue will adhere better to the anodized surface than bare aluminum. I recommend a regular type of 24 hour epoxy gluing the action to a pre-bedded stock using devcon, marine-tex etc.

SAFETY CONCERNS FOR USING THE PYTHON 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 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.