

How to Epoxy Bed.

If you are installing a new stock, you should first pre-assemble your barreled action into the new stock making sure everything, especially any safety devices function properly.

Preparing the stock.

Pro-Bed 2000 will adhere to most all stock finishes but it is usually best to scrape or sand off all of the stock finish from the section of the inletting to be bedded. The clean up job will be much easier with mold release applied to certain parts of the stock's inletting, such as the sides of the magazine well and to the sides of the trigger inletting. Be very careful not to get any mold release on any part of the stock area that needs to be bedded.

Preparing the barreled action.

When possible remove the trigger assembly and any other parts that could pose a problem and apply mold release to all the metal parts, barrel, action, trigger guard, guard screws and magazine box. Use modeling clay or something similar to fill the trigger assembly pin holes and any other cavities that could fill with epoxy. Epoxy filled crevasses can make it impossible to remove the metal from the cured epoxy without damage to the stock.

The Mold Release Wax.

The mold release packaged with *Pro-Bed 2000* is a buffable wax type. Use a soft cloth or tissue to apply the wax onto your barreled action and any other parts that may come into contact with the bedding epoxy. Make sure that the wax gets into all the corners. After a few minutes buff the surface with a soft cloth to bring it to a shine, similar to waxing a car. Repeat this process 2 to 3 times. After you have removed the barreled action and all other parts from the cured epoxy the wax cleans off easily with most types of petroleum solvents. Paint thinner works particularly well.

Mixing Pro-Bed 2000 Epoxy.

The packet containing the white compound is the curing agent and the packet with the colored (Black or Brown) is the resin. The cured epoxy will be the color of the resin as viewed in the packet window. The combined packets are enough epoxy to completely bed a typical rifle action and trigger guard. After a long period of time the contents of each packet can separate. Before dispensing, it is imperative that you mix the contents of each pack completely by kneading each packet until homogeneous. Dispense the entire contents of each packet onto something such as piece of cardboard and mix thoroughly.

Bedding The Stock.

After mixing the epoxy, apply a thin coat to all of the surfaces to be bedded. This will provide proper wetting out of the stock and help control the flow of the epoxy. Next add liberal amounts of epoxy to all portions of the inletting to be bedded. Be sure to use adequate amounts in the areas where there are large gaps between the metal and stock. Excess epoxy will squeeze out and can be wiped off after assembly. When assembling the components with the epoxy in place be sure that you do not over tighten the guard screws. They should be just snug enough to hold everything in position and no more. Next remove any and all of the epoxy that has oozed up from the inletting and be sure to wipe off any epoxy from the outside of the stock with a moist rag. Finger prints or smudges cannot be removed without damage to the stock finish after the epoxy has cured.

After sixteen or more hours, check the leftover compound. It should be hard. Before removing the barreled action from the stock, check all the edges of the stock where it meets the metal. Any compound that has run over the edge needs to be removed, because it will break off and parts of the stock will break off with it. With the stock firmly in a vise, partially insert the bolt in the rifle and use it as a handle to raise the barreled action out of the stock. Use a rocking motion, pulling up on the barrel then the bolt until it breaks loose. After the barreled action is removed from the stock use a fine file to clean up the edges. On the inside of the stock around the trigger and magazine box any excess resin should pop right off if you previously applied mold release to this area. Clean all of the metal and completely reassemble. Check the trigger and safety to make sure they move freely and function properly. Check for stress by loosening and tightening the trigger guard screws. The barreled action should not move at all. The screws should tighten solidly. You are now ready to go to the range and enjoy the benefits of your efforts.

To see our complete line of stock bedding products and find more information on epoxy bedding along with a ever increasing library of how to videos see the support page at www.probed2000.com