

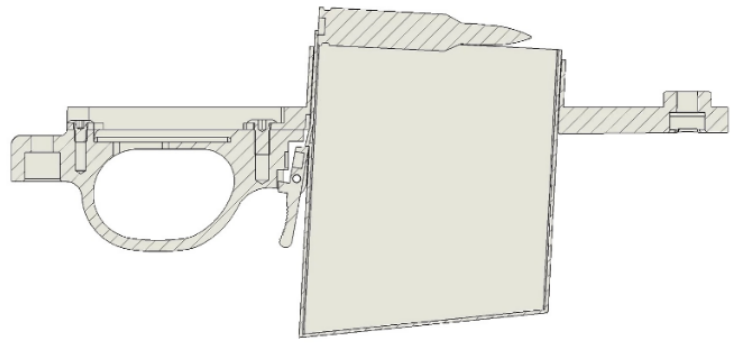
Installation Guide

AICS short action bottom metal ('DBM') for the Lithgow LA102 centrefire rifle

Stock Compatibility

- Fits factory walnut and laminate stocks with minor inletting on each side of magazine well
- Drop-in fit for the Bolly (Precision Defence Industries) carbon fibre rifle stocks
- Will not fit factory synthetic stocks, and not compatible with chassis systems

Some gunsmithing may be required depending on stock compatibility.
A vertical milling machine and 4 flute HSS endmill is the best method for inletting should the stock compatibility specify that inletting is required. Enlarging the inlet on both sides of the magwell is possible also with a dremel type tool or file



Recommended Tools

- Metric hex key set
- Torque wrench (inch/pounds scale)
- Magnetic parts dish
- Padded workbench, nylon bench blocks or gun vice
- Snap caps

Installation Steps

- (1) **Ensure that the rifle is unloaded and that the bolt is removed and put aside**
- (2) Remove barreled-action from stock by unscrewing front and rear action screws
- (3) Take care not to misplace action screws or part #20, put these aside for later reassembly
- (4) Remove assembly consisting of parts #10, #11, #12, and #13. Put aside or store in small ziploc bag (no longer required)
- (5) Leave parts #14 and #17 in place, these are not required but do not interfere with installation of the Lumley Arms AICS unit
- (6) Install the M5x6 locking ring retaining screw provided in place of part #10. This step is essential for safe function of the rifle
- (7) Install the Lumley Arms AICS DBM unit into the stock. Inletting may be required (see stock compatibility above)
- (8) Reassemble barreled-action using part #20 and both action screws
- (9) Action screw torque must be a minimum of 40in/lbs
- (10) Test magazine function extensively including cycling snap caps through action
- (11) Install the supplied shims between the stock and DBM should the bolt bind against the magazine feedlips when testing in step 10

