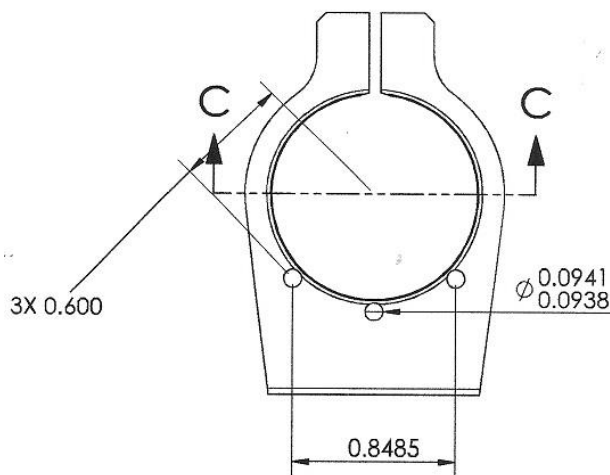


## WTO SwitchLug Installation

The SwitchLug is designed as a direct fit to our Claymore and Caprock Series actions. It is also directly compatible with the Stiller Predator and TAC 30/300 actions, and other custom actions with a maximum barrel tenon thread diameter of 1.0625", and a recoil lug pin hole for 3/32" index pin at a spacing of .600" from action centerline. If you are installing the SwitchLug on an action that meets these specifications, please skip to section B for thread tenon instructions.

- A. **Receiver preparation.** Follow these instructions to fit the SwitchLug to an existing receiver that is not currently capable of accepting a pinned recoil lug:
1. Set up receiver in lathe and indicate true to center axis. True action face perpendicular to receiver centerline axis.
  2. If receiver threads are not true and concentric to centerline, recut threads true to centerline and note required pitch diameter for barrel tenon machining.
  3. Ensure Bolt face is perpendicular to receiver centerline axis, and bolt lug/lug recess is correct.
  4. Drill 3/32" Index pin hole(or holes) in receiver face, see below for hole location.



LEFT AND RIGHT SIDE HOLES AT 45 DEGREES FROM CENTERLINE  
CENTER HOLE AT 90 DEGREES FROM CENTERLINE

NOTE: The SwitchLug will function as designed using only the center index pin. Three index pin holes are provided, and it is gunsmith's discretion whether to use the single index pin or double pin method.

5. Install index pin or pins in receiver face, slip SwitchLug over index pins, and check fit to trued action face.

## **B. Barrel thread tenon instructions.**

1. Turn threaded portion of barrel thread tenon to match your receiver's thread specifications, ensuring the max OD of the thread tenon does not exceed 1.0625". Regardless of thread pitch used, thread fit should have absolute minimum clearance for best repeatability, i.e. your action should screw onto thread tenon with no more than hand tightening force required, but have no discernable looseness. For a common thread such as 1.0625x16TPI Class 2A, the thread tenon pitch should measure no more than .001" undersize of maximum allowed pitch diameter.
2. Turn SwitchLug mating surface. The mating surface should start at the end of the thread portion of the tenon, and extend .350" to the barrel torque shoulder. This is a tapered surface, with the taper opening toward the torque shoulder. Beginning OD of the mating surface must be 1.065" -.003", tapering to a final OD of 1.074" -.003". A relief cut at the torque shoulder/mating surface junction is not necessary as long as your turning tool has a nose radius of .016" or less. Test fit this mating surface by slipping the SwitchLug onto the barrel tenon, with the clamp screw head facing the right side (Large side of taper toward the muzzle). The SwitchLug should slide over the mating surface and seat completely against the barrel torque shoulder.
3. Record the thread pitch diameter of the fitted barrel, and the headspace measurement for future reference. Headspace measurement in this case is defined as the distance from the bolt face to the face of the SwitchLug. If another barrel is to be built in the future, the thread pitch can be turned to the original specification for your action, and the chamber can be reamed so that the distance from the base of the appropriate Go headspace gauge to the barrel torque shoulder is the same as the original measurement. This ensures correct headspace to your specific action, and maximum repeatability of the new barrel.

## **C. Stock interface and bedding.**

1. If your stock does not have a recoil lug pocket large enough to fit the lug, mill out the lug pocket with at least .030" clearance per side to allow room for bedding compound. If you plan to remove barrels with the action in the stock, ensure that your stock's barrel channel has an appropriate amount of clearance to allow for barrel removal with the action in place. Modify as needed, based on your barrel contour.

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2. Assemble your barreled action with barrel hand tight, then torque the SwitchLug clamp screw to 30 in. lbs. Be sure to coat the barreled action with a good quality release agent. Bed the barreled action to the stock in accordance with your normal procedure. Do not place tape on the front side of the lug for a clearance fit, as the lug should be bedded for 100% contact with the lug pocket for best results. We recommend Devcon Epoxy Steel as a bedding material.
3. **IMPORTANT:** Once you have installed the barreled action in the stock and before the bedding compound is cured, release the torque on the SwitchLug clamp screw. Ensure that there is no torque on the lug clamp screw, as the lug needs to be at rest during bedding to allow for expansion when removing barrels.

#### **D. Operation.**

After bedding is completed and final assembly of the rifle has been done, the Switchlug can be operated as designed. To install a barrel:

1. Loosen the SwitchLug clamp screw until the screw can move freely.
2. Apply a very light coat of anti-seize compound or medium weight grease to barrel shank threads. Ensure that the torque shoulder and mating surfaces on the barrel and SwitchLug are clean and free of debris.
3. Screw in the rifle barrel and tighten hand tight against the front face of the SwitchLug.
4. Once the barrel is hand tight, Torque the clamp screw to 30 in. lbs. The rifle can then be zeroed and used for normal operation.