

CDiPrecision Gunworks

1852 University Parkway
Sarasota, FL 34243
941-961-3185

FN - SPR / FN - PBR / TSR - XP /Winchester Model 70 S/A

Installation Instructions & Troubleshooting

Please follow these installation instructions and check the troubleshooting section for custom fitting CDi bottom metal to your rifle.

Please do not hesitate to contact us at anytime with any questions about our products or to set up custom installation services with us. CDi offers stock inletting and complete install services, call for details.

CDi recommends the use of only genuine Accuracy International Magazines with our bottom metal. We stock these AICS magazines in 5 and 10 round capacity for .308, and in 10 round capacity for .223. WSM rounds (RSAUM) or equal will also work in this system in a Modded AI .308 magazine. MagPul AICS and MDT mags work well in this as well.

We can be reached at 941-961-3185 or email: cdi@cdignition.com

Installation

Step 1 - Factory FN-SPR / FN-PBR / FN-TSR rifles with the factory detachable box magazine, require no stock inletting. On these rifles the only adjustment to your stock needed for CDi bottom metal to fit is cut clearance around the front and rear screw to fit the corresponding bosses on our bottom metal. They are .100" deep.

On all other rifles and any hinged floorplate FN rifles, inlet the stock to fit the CDi bottom metal. See attached bottom metal drawing for dimensions and template to help with pattern. Stock shapes and lines can vary; the area of the bottom metal where the magazine goes is the area that should be flush to the bottom of the stock. The ends of the bottom metal may or may not sit completely flush depending on the stock's shape.

Step 2 - Minor cutting to the action is required for the magazines to fit properly into the action's magazine well. For customers that will cut their actions themselves please refer to the attached picture that shows where the action needs to be cut. The front radius must be trimmed out so the magazine will fit into the action properly. Cut .200 deep from the top of the magazine well, at the front of the Magazine well. Go slow and test fit things till it fits. If you cut too deep, it will still work but the magazine will push into the bolt and could drag on the feed lips. This could be a problem if you like to support the rifle with your hand directly on the magazine while shooting.

Step 3 - Assemble the stock and bottom metal to the barreled action with your original front and rear action screws. Some trimming of these screws may be necessary for a custom fit to your rifle. The rear screw is blind; ensure that the screws do not bottom out in blind tapped holes. Torque the front and rear action screws to 65 inch pounds once the stock is assembled to the action. Replacement screws can be purchased at Brownell's they are 1/4-32 thread and are not available commercially. Brownells PN 122-505-670MB. These screws will need a little trimming so pay attention to the length.

Step 4 - Install the AICS magazine into the bottom metal and adjust the length of the magazine release lever if necessary. Any factory FN-SPR rifles with the factory DBM (detachable box magazine), will not need the magazine release lever adjusted. All other models may require an adjustment to the length of this lever. The magazine should click into place snugly and must sit at the correct height to the barrel for proper round loading and operation. To shorten the magazine release lever use a 3/32" pin punch to remove the roll pin that holds the lever and free the lever. Shorten the lever with a file or a grinding wheel the same amount needed to lower the magazine for proper round loading in your rifle. Maintain the angle of the lever when shortening it. Reassemble the magazine release lever and check fit. CDi does not recommend any modifications to Accuracy International magazines. **AI Magazines should never be machined, cut or ground for any reason. Adjusting the feed lips for non-standard rounds is ok.**

Step 5 - **Only for Winchester Model 70 (Not required for FN rifles).**

Disassemble trigger and remove the bolt stop lever. Grind about a 1/8" off the end of the lever to allow the bolt to move rearward more so that the bolt can pick up rounds from the magazine. Reassemble trigger and test for function.

Troubleshooting

Issue: After installation of bottom metal and magazine the bolt will not close or operate properly, the bolt is hitting the action screw.

Solution: The front and rear action screws need to be shortened for a custom fit to your rifle.

Issue: After installation of bottom metal the magazine does not latch or does not snap into place properly.

Solution: The magazine release lever needs to be shortened to obtain proper magazine height in your rifle.

Issue: Poor extraction or ejection of loaded rounds, when testing function after completed installation.

Solution: These rifles are designed to extract and eject fired empty cases therefore anemic extraction and ejection of unfired rounds is normal. Use an empty case to test extraction and ejection. In addition, using snap caps for testing is also unreliable.

Issue: Unreliable magazine function or operation when employing aftermarket copies of Accuracy International Magazines(C Products, etc.)

Solution: CDi recommends the use of only genuine Accuracy International Magazines with our bottom metal. The use of aftermarket copies is unreliable due to lower manufacturing standards. If you install and adjust the bottom metal for an aftermarket copied magazine, then a genuine Accuracy International magazine may not function properly.

Issue: When running WSM rounds (RSAUM) in a .308 AICS magazine the rounds are not sitting high enough to enable the bolt to pick up the rounds.

Solution: Adjust the magazine feed lips out slightly to accommodate the WSM rounds.

We can be reached at 941-961-3185 or email: cdi@cdignition.com
We hope you enjoy your rifle with our bottom metal and magazines. If you have any questions about our product or the installation process please contact us for assistance. We are here to help and happy to do it. Thank you for your business!

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AICS Magazine Proper Round seating in Magazine

SIZE	DWG. NO.	REV.
A		1
SCALE: 1/2	WEIGHT:	SHEET 1 OF 1

SHEET 1 OF 1

REV. 1

HT:SCALE:1:2WEIG

NSIZE DG. O. W**A**



