

# **SABER® -FOR55T®**

## **Modular Rifle Chassis System (MRCS)**

### **OPERATOR MANUAL**

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### ***Excerpt – Shoulder Stocks***

***Modular By Definition. Performance Engineered By Design***



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The SABER®-FORSST® Modular Rifle Chassis System is designed for bolt action rifles. This manual will instruct users on how to operate the SABER chassis system.

USPTO Utility and Design Patents:  
#7,802,392, #8,656,622, #D630,698, #D626,618, #D629,062,  
#D613,361, #D613,812, #D623,718, #D634,388, #D637,680,  
#D645,532, #D643,085, #D645,533, #D657,841, #D643,086,  
#D676,095, #D646,745, #D705,885. Other patents pending.

## WARNING SUMMARY

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This warning summary contains general safety warnings and hazardous materials warnings that must be understood and applied during operation and maintenance of this equipment upon installation of a barreled rifle action. Failure to observe these precautions could result in serious injury or death to personnel.

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### WARNINGS

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#### WARNING

Keep your fingers outside the rifle's trigger guard. Keep the weapon pointed in a safe direction at all times.

#### WARNING

Before field stripping, make certain the weapon is safe and cleared of live ammunition.

#### WARNING

Do not exchange or switch bolt assemblies from one rifle to another. Doing so may cause injury or death.

#### WARNING

Before beginning the safety check, make certain the weapon is cleared of live ammunition and safe.

## **WARNING**

Never force a cartridge into the chamber. If the bolt does not fully close, release the magazine, clear the weapon, check and clear any obstructions. Do not attempt to fire until normal bolt operation is restored and chamber and barrel obstructions are cleared. Failure to do so could result in serious injury.

## **WARNING**

To avoid injury from negligent discharge, always visually and physically check that the chamber is empty of live ammunition after unloading the weapon.

## **WARNING**

Before starting an inspection, make certain the weapon is in a safe condition and cleared of live ammunition.

## **WARNING**

If your rifle stops firing with a live unfired cartridge in a hot barrel (misfire), remove the cartridge immediately. If this is not possible, wait approximately 15 minutes for the barrel to cool. Keep the muzzle pointed in a safe direction in

case of a cook-off. Keep your face and important body parts away from the ejection port while clearing a hot chamber.

### **WARNING**

Before cleaning the rifle, make certain it is cleared of live ammunition.

### **WARNING**

Do not load or fire corroded, dented or debris covered ammunition. Inspect all cartridges for loose bullets.

### **WARNING**

Oiled or greased cartridges can produce excessive chamber pressures that may damage the weapon or suppressor and may cause serious injury or death.

### **WARNING**

It is vitally important that you double check to make certain the barrel, the bolt, magazines, gages and ammunition being used are marked with the same caliber.

## **WARNING**

Before, during and after any live fire activity, inspect both the muzzle and the suppressor for corrosion, debris, damage, misalignment, or anything clogging the opening of either component. Failure to maintain the barrel and suppressor (if employed) could cause injury or death.

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## **CAUTIONS**

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### **CAUTION**

Do not hang rifles for storage by a sling swivel. The quick detach button can be depressed causing the weapon to fall and damage the rifle.

### **CAUTION**

To avoid a cartridge jam in the magazine during operation, align the cartridges properly and in the correct direction while loading the magazine.

### **CAUTION**

When loading the rifle, close the bolt slowly and steadily to prevent it from slamming the cartridge into the chamber. Slamming can damage the cartridge and possibly cause a malfunction, a slam-fire or inaccurate fire.

## **CAUTION**

Do not leave loaded cartridges in the magazines for extended periods of time. The follower spring can lose tension and cause feeding malfunctions.

## **CAUTION**

Use only an optical lens care kit to clean the day optic. Anything else can scratch the coated lenses and potentially render them unserviceable.

## **CAUTION**

Do not use cotton patches, Q-tips, or cotton products such as T-shirts to clean the day optic lenses. Do not use acetone to clean the lenses.

## **CAUTION**

Do not allow cleaning solvents, lubricating oils, or grease to come into contact with the day optic lenses.

## **CAUTION**

Firing a rifle with oil or moisture in the bore can cause a puff of smoke that could disclose your position.

## **CAUTION**

Avoid damaging the barrel crown. Never clean

the rifle from the muzzle end. Never reverse the direction of the bore brush inside the bore when cleaning.

### **CAUTION**

Never use a sectioned steel cleaning rod in the rifle. A sectioned steel cleaning rod can severely damage the bore, chamber throat, muzzle brake and crown.

### **CAUTION**

Do not scrub the chamber with an in-and-out motion. Doing so raises burrs and causes spent brass to stick in the chamber.

### **CAUTION**

Do not use Loctite on plastic parts of the SABER® chassis as it can induce fractures in the part.



## **SABER®-FORSST® Modular Rifle Chassis System MRCS**

SABER®-FORSST® modular rifle chassis systems are proudly made in the USA and designed for bolt action rifles from many popular production and custom manufacturers.

SABER® rifle chassis are constructed from aerospace grade alloys, lightweight carbon reinforced composites and high strength carbon fiber. Each chassis is precision engineered to fit a specific bolt action receiver.

SABER® MRCS are ergonomically adjustable and can be easily reconfigured and accessorized for a variety of rifle shooting activities. SABER chassis forends are available in Composite, Alloy and Carbon Fiber Series. All models feature detachable box magazines and have a wide range of easily interchangeable accessories.

The SABER® modular rifle chassis requires NO epoxy bedding compounds to obtain optimal accuracy from a barreled action. The patented design of the SABER chassis is extremely comfortable to shoot, available in left or right operation, enhances accuracy, reduces felt recoil and offers a streamlined exterior. The SABER® chassis has a durable corrosion resistant

coating is user maintainable in the field with simple hand tools.

## **SABER® Shoulder Stocks**

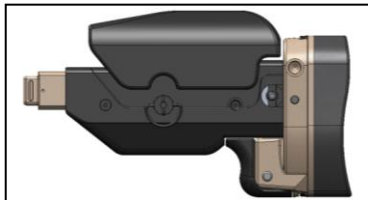
### **Hand Tool Adjustable (HTA)**

The **SABER MOD-0 Modular Rifle Chassis** is equipped with a Hand Tool Adjustable (HTA) fixed shoulder stock. The user can adjust the HTA shoulder stock to fit virtually any body type, and/or accommodate heavy or light clothing. Sporter HTA's are styled slightly differently, yet operate the same.

### **Cheek Piece Height Adjustment**

The adjustable cheek piece is easy to operate and can be loosened or tightened with your thumb and fore finger using the Bail-wire, Thumb Screw or with large screw driver.

- a. Get behind the rifle in a comfortable prone or bench shooting position.
- b. Loosen the Bail-wire Thumb Screw approximately 3 to 4 turns counter-



clockwise on the Cheek Piece until you can move the cheek piece upward and downward.

- c. Move the cheek piece up or down until the desired comb height is achieved.
- d. The shooters head should lie comfortably on the cheek piece, without strain on the neck. The center of the eye will be quartered by the crosshairs of the rifle scope when the proper height is achieved.
- e. Once correct placement of the cheek piece has been achieved, tighten the screw by turning it clockwise until hand-tight. Do not over tighten!
- f. Note: Care must be taken to insure that the locking mechanism is seated in a “notch” not between them. If the screw only tightens ½ to 1 turn then the mechanism is not properly engaged and will loosen during firing. The Bail Ring Screw should turn in 3-4 turns to properly engage the cheek piece pillars.

## Length of Pull Adjustment (LOP) with Spacers

- Using a SABER Field Multi-Tool or 3/16" hex wrench partially unscrew the two screws through the Limbsaver Recoil Pad.
- Insert or remove plastic spacers to obtain the desired length of pull (LOP).
- Use the supplied ¼-28 x 1 1/2" screws for both the ¼" and ½" spacers; the ¼-28 x 3/4" screws for the ¼" spacer only; and the ¼-28 x 1 ¼" for the ½" spacer only.
- Snugly hand tighten the Limbsaver Recoil Pad screws. **Caution: Do not over-tighten.**



## Recoil Pad Vertical Position

- a. Adjusting the Recoil Pad height allows the SABER shoulder stock to be raised or lowered in the shoulder pocket to facilitate a better shooting position or eye relief when used in conjunction with the adjustable cheek piece.
- b. With the HTA Shoulder Stock adjusted to the desired length of pull (LOP), grasp the Recoil Pad.
- c. Using a SABER Field Multi-Tool or 3/16" hex wrench on the loosen the two screws through the Recoil Pad.
- d. Adjust the Recoil Pad up or down to the desired position for shooting.
- e. Snugly hand tighten the Recoil Pad screws.  
**Caution: Do not over-tighten**



## **Tactically Adjustable Shoulder Stock TASS**

The **SABER SuperSport MOD-1 Modular Rifle Chassis** is equipped with a Tactically Adjustable Shoulder Stock (TASS). The user can adjust the



TASS shoulder stock to fit virtually any body type, and/or accommodate heavy or light clothing.

### **Length of Pull (LOP) Adjustment with Spacers**

- Using a SABER Field Multi-Tool or 3/16" hex wrench partially unscrew the two screws through the Limbsaver Recoil Pad.
- Insert or remove plastic spacers to obtain the desired length of pull (LOP).
- Use the supplied ¼-28 x 1 1/2" screws for both the ¼" and ½" spacers; the ¼-28 x 3/4" screws for the ¼" spacer only; and the ¼-28 x 1 ¼" for the ½" spacer only.
- Snugly hand tighten the Limbsaver Recoil Pad screws. **Caution: Do not over-tighten.**

## Recoil Pad Position

- a. Adjusting the TASS recoil pad position allows it to be raised or lowered in the shoulder pocket to gain a more secure rifle position and or correct eye relief when used in conjunction with the adjustable Cheek Piece.
- b. Grasp the recoil pad with one hand.
- c. With the other hand depress and hold the Recoil Pad locking button. The Recoil Pad can now be freely adjusted up and down to aid in placing the Recoil Pad properly in the shoulder pocket for firing. Adjust the Recoil Pad to the desired position.
- d. Release the Recoil Pad locking button. A “click” indicates the Recoil Pad is now locked into place.



## Cheek Piece Height Adjustment

- a. Get behind the rifle in a proper prone or bench shooting position.



- b. Loosen the tension screw approximately 3-4 turns counter-clockwise on the Cheek Piece until you can move the cheek piece upward and downward.
- c. Move the cheek piece up or down until the desired comb height is achieved.
- d. The shooters head should lie comfortably on the cheek piece, without strain on the neck. The center of the eye will be quartered by the crosshairs of the rifle scope when the proper height is achieved.
- e. Once correct placement of the cheek piece has been achieved, tighten the screw by turning it clockwise until hand-tight. Do not over tighten!



- f. Note: Care must be taken to insure that the locking mechanism is seated in a “notch” not between them. If the screw only tightens ½ to 1 turn then the mechanism is not properly engaged and will loosen during firing. The Bail Ring Screw should turn in 3-4 turns to properly engage the cheek piece pillars.

### **Push Button Adjustable Hybrid (PBA-H) Shoulder Stock**

The **SABER MOD-1 Modular Rifle Chassis** is equipped with a Push Button Adjustable Hybrid (PBA-H) folding Shoulder Stock. The user can adjust the PBA-H Shoulder Stock to fit virtually any body type, and/or accommodate heavy or light clothing using no tools.



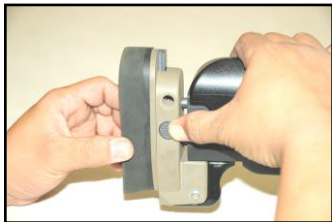
## Length of Pull (LOP) Adjustment

- Place the SABER Chassis in front of you on a flat surface.
- Grasp the PBA-H Shoulder Stock in your right hand.
- Grasp the recoil pad with one hand and with the other depress and hold the LOP locking button. Pull the Recoil Pad out to the desired length.
- Release the LOP locking button. An audible click indicates the Length of Pull adjustment is now locked in place. Insure that the locking bar is seated in a notch before firing.



## Recoil Pad Position

- Adjusting the Recoil Pad position allows the rifle to be raised or lowered in the shoulder

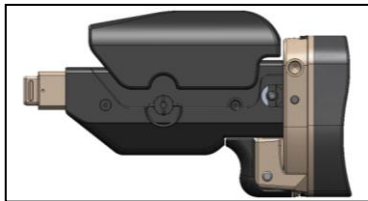


pocket to gain a better position or correct eye relief when used in conjunction with the adjustable Cheek Piece.

- b. Grasp the recoil pad with one hand.
- c. With the other hand depress and hold the Recoil Pad locking button. The Recoil Pad can now be freely adjusted up and down to aid in placing the Recoil Pad properly in the shoulder pocket for firing. Adjust the Recoil Pad to the desired position.
- d. Release the Recoil Pad locking button. A “click” indicates the Recoil Pad is now locked into place.

## **Cheek Piece Height Adjustment**

- a. Get behind the rifle in a proper prone or bench shooting position.
- b. Loosen the tension screw approximately 3-4 turns counter-clockwise on the Cheek Piece until you can move the cheek piece upward and downward.



- c. Move the cheek piece up or down until the desired comb height is achieved.
- d. The shooters head should lie comfortably on the cheek piece, without strain on the neck. The center of the eye will be quartered by the crosshairs of the rifle scope when the proper height is achieved.
- e. Once correct placement of the cheek piece has been achieved, tighten the screw by turning it clockwise until hand-tight. Do not over tighten!
- f. Note: Care must be taken to insure that the locking mechanism is seated in a “notch” not between them. If the screw only tightens  $\frac{1}{2}$  to 1 turn then the mechanism is not properly engaged and will loosen during firing. The Bail Ring Screw should turn in 3-4 turns to properly engage the cheek piece pillars.

## 1. Butt Hook and Monopod Installation

- a. Using the SABER Field Multi-Tool or 1/8" hex wrench, remove the retention screw shown.



- b. Push the axle out the opposite side.

- c. Replace the Monopod or Butt Hook (user preference) and replace the axle in the hole.

- d. Place a small drop of **blue Loctite #242** on the screw and screw it into the axle, tightening until hand tight. **Caution:** Do not apply blue Loctite to plastic parts.

## 2. Field Monopod

- a. If the Monopod is being employed, it has the capability of being used in the horizontal



position 180° (parallel to the ground), or at a

45° forward-down angle or at the 90° angle in the to support the shooting platform.

- b. These positions are achieved by grasping the grooved barrel of the Monopod and pulling down



against the spring tension, moving the Monopod into the desired position, and then releasing the barrel of the monopod. The Monopod will retract to the rear when properly locked. Ensure the Monopod is firmly locked into position before firing.

- c. Adjusting the vertical height of the Monopod is as easy as grasping the grooved barrel and turning it clockwise or counter clockwise to raise or lower the muzzle and crosshairs of the scope.

## SABER Rifle Chassis Hinges & Joints

### Operating the Fixed Hinge Joint

HTA, PBA-H and TASS Shoulder Stocks can be attached to all SABER modular rifle chassis with a Fixed Hinge Joint. The Fixed Hinge Joint allows users to have a rigid non-folding shoulder stock, yet can completely remove the SABER shoulder stock from the chassis for storage and transportation if required.

- a. The HTA Fixed Shoulder Stock is easily removed from the Center Chassis Section for bolt removal (long action) visual and physical safety inspection and cleaning the barreled action.



Using a SABER Field Multi-Tool or 3/16" hex wrench loosen the anti-vibration fastener approximately four turns.



b. Push inward on the mechanism.

c. Use care as the HTA Shoulder Stock will separate from the Center Chassis Section allowing the bolt to be removed



providing access to the inside of the receiver and bore.

## Reattaching the Fixed Hinge Joint

a. To reattach the HTA Fixed Shoulder Stock to the Center Chassis Section, grasp the Center Chassis Section with the barreled





action in your right hand.

- b. Grasp the HTA Fixed Shoulder Stock in your left hand.



- c. Insert the “hook” section of the Fixed Joint into the corresponding female slot of the joint mounted on the Center Chassis Section. Rotate the shoulder stock counter clockwise until the sections meet.
- d. Lay the SABER chassis on a flat surface with the Fixed Stock Joint facing upward. Using a SABER Field Multi-Tool or 3/16” hex wrench, tighten the anti-vibration fastener hand tight.  
***Caution: Do not over-tighten.***
- e. Check to insure that there is no movement in the joint.

## Operating the Foldable Locking Hinge

HTA, PBA-H and TASS Shoulder Stocks can be attached to all SABER modular rifle chassis with a Foldable Locking Hinge. The Foldable Locking Hinge allows users to unlock and fold the SABER shoulder stock against side of the chassis for storage and transportation.

- a. With the PBA-H Shoulder Stock in the extended position, grasp it in your right hand and the SABER chassis in your left hand.

- b. Push the locking button with your thumb which unlocks the hinge mechanism.



- c. Rotate the Shoulder Stock clockwise until it folds against the side of the rifle.

## Extending the Foldable Locking Hinge

- a. With the PBA-H Shoulder Stock folded, grasp it in your right hand and the SABER chassis in your left hand.



- b. Rotate the Shoulder Stock counter clockwise into the joint until it locks into the extended position.
- c. The user will hear a “click” indicating that the locking button has engaged.

### Double Locking Alloy Hinge

HTA, PBA-H and TASS Shoulder Stocks can be attached to all SABER modular rifle chassis with a Double Locking Alloy Hinge. The Double Locking Alloy Hinge allows users to lock the SABER shoulder stock open and closed for storage and transportation.

## Folding the Double Locking Alloy Hinge

- a. With the TASS shoulder stock in the extended position, grasp it in your right hand and the SABER chassis in your left hand.
- b. Push the locking button with your thumb which unlocks the hinge mechanism.
- c. Rotate the Shoulder Stock clockwise until it folds and locks against the side of the rifle.



## Extending the Double Locking Alloy Hinge

- d. With the TASS shoulder stock folded and locked, grasp it in your right hand and the SABER chassis in your left hand.



- e. Rotate the TASS shoulder stock counter clockwise into the joint until it locks into the extended position.
- f. The user will hear a “click” indicating that the locking button has engaged.

### **Detachable Shoulder Stock Break-Down Joint**

HTA, PBA-H and TASS Shoulder Stocks can be attached to all SABER modular rifle chassis with a Detachable Break-Down Joint. The Detachable Joint allows users to completely remove the SABER shoulder stock from the chassis for storage and transportation.

### **Detaching a Break-Down Joint**

- a. With the SABER Shoulder Stock attached, grasp the Shoulder Stock in your right hand and the SABER rifle chassis in your left hand.



- b. Push the Detachable Joint locking button with your right thumb and rotate the SABER Shoulder Stock clockwise until it detaches.

## Re-Attaching a Detachable Break-Down Joint

- a. With the SABER Shoulder Stock detached, grasp the shoulder stock in your right hand and the rifle chassis in your left hand.



- b. Insert the Break-Down Joint hook into the left side female slot of the joint. Rotate the shoulder stock counter clockwise into the joint until it locks.
- c. The user will hear a click indicating that the locking button has engaged

## Limited Warranty

This warranty is granted by Ashbury International Group, Inc. / Ashbury Precision Ordnance Mfg. the Manufacturer, as to the **SABER®-FORSST® Modular Rifle Chassis**; is effective from the date of purchase; and applies only to the original owner of this rifle. This warranty supersedes any and all other warranties.

The **SABER®-FORSST® Modular Rifle Chassis** is warranted to be free from defects in material and workmanship for a period of one (1) year. Any such defects of which Ashbury International Group, Inc. / Ashbury Precision Ordnance Mfg. receives written notice within one year from the date of purchase by the original owner, will be remedied by Ashbury International Group, Inc. without charge within a reasonable time after such notification and delivery of the rifle as provided below. Warranty claims must be in writing and must accompany the rifle, which must be delivered to Ashbury International Group, Inc. / Ashbury Precision Ordnance Mfg. Customer Service Department at the address set out below, or at such other address as may be directed by Ashbury, at owner's expense. Warranty claims must state the model and serial number of the firearm concerned and the description of the difficulty experienced. It is recommended that shipments be insured by the owner, since Ashbury International Group, Inc. will accept no responsibility for loss or damage in transit. Transportation and insurance charges necessary to return the firearm to the owner at the original location to which the firearm was shipped when purchased, or to such other location of the owner closer to the repair facility of

Ashbury International Group, Inc. / Ashbury Precision Ordnance Mfg. as may be designated by the owner, will be paid by Ashbury International Group, Inc. if the claim is covered by the warranty. If the claim is not covered by the warranty the rifle will be returned to owner only after arrangements for payment satisfactory to Ashbury International Group, Inc. for the repair, transportation, and insurance charges are made by the owner. The warranty period for warranty repairs shall be six months from the date of the repair, and shall be limited to the extent of such repairs.

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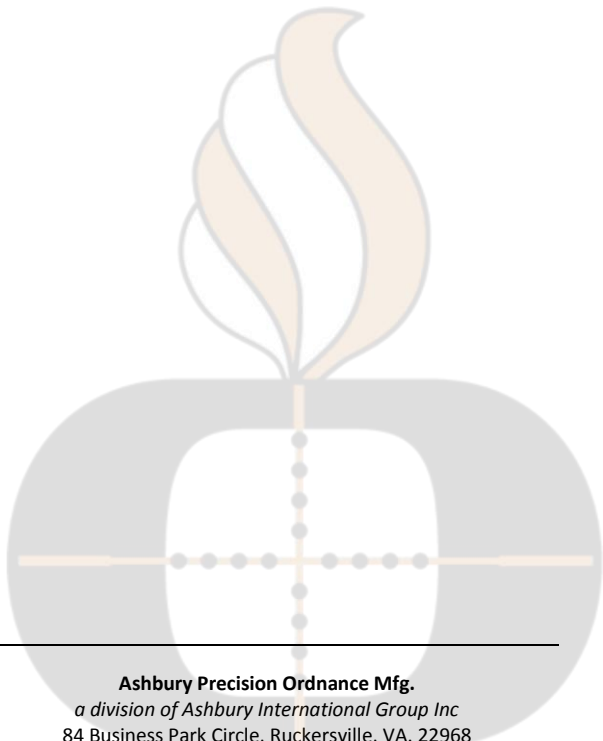
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