

UNTRADITIONAL SINCE 1983



MADE IN HORNINDAL
NORWAY

GRS Glass bedding Compound - User's manual

It is required and of utmost importance that this entire manual be read and understood before using this product.

If you have any questions, please contact your dealer or GRS Riflestocks AS in Norway. Safety data sheet for the epoxy bedding compound can be downloaded from www.grsriflestocks.com/downloads .

Additional tools and equipment needed for use of this product

- A digital scale to ensure accurate measurements.
- A mixing bowl/tray for thoroughly mixing ingredients.
- Wooden spatula or similar for mixing and applying the bedding mixture.
- Masking tape to prevent excess bedding compound from bonding to stock or metal parts/barrel etc.
- Masking tape to cover up all thread holes and areas where bedding compound isn't needed or wanted.

Preparation before using the epoxy bedding kit

Ensure all surfaces are clean, this includes the barreled action and the stock.

All surfaces, rough edges and corrosion **must be cleaned off and smoothed out** to prevent contamination and avoid compound adhering permanently to the metal surfaces. Cover with MASKING TAPE all surfaces and places that where bedding compound is not needed or wanted.

Applying the release agent

The release agent shall be applied on all metal that will be in contact with the epoxy **at least 20-30 minutes** before pressing it into the bedding compound. It is extremely important to understand that metal with rough surfaces and old metal surfaces often absorbs oil. Therefore, you must apply the release agent at least twice. This makes sure all surfaces will have enough release agent. Leave the oil to float out and to settle for the above-mentioned time frame.

(If the release agent is not applied in a proper manner the epoxy will stick permanently to the surfaces, and it will be extremely hard to remove; this is recognized as a misuse - not a failure of the product - and will not be subject to guarantee or any money back claims.)

Mixing the epoxy compounds

The resin should have a working temperature of **between 20-25°C (68-77°F)**. If used outside of this temperature range, the mix may not work as expected. In general – the higher the temperatures, the faster curing of the compound.



Put the mixing cup or tray on the scale and zero out the scale to 0. Then apply the wanted amount of resin into the cup. ***Please remember the exact weight and apply the exact equal amount of hardener.*** Last, apply the dye to get the color to your preference. (If you do not want a color, the bedding compound works fine without). Please note that the color will darken some after hardening.

Blend the mixture extremely well, and for ***at least 6 minutes***. Then let it stand to settle and start the chemical reaction for 3-4 minutes before application into the gun stock.

(If the compounds are not mixed properly, they will exhibit partial stickiness and flexible areas in the compound. This is recognized as misuse - not failure of the product - and will not be subject of guarantee or any money back claims.)

Bedding the stock

The epoxy compound will not start to harden before 20-25 minutes, so given that all is prepared accordingly to the manual's above-mentioned directions, you will have about 15 minutes to place the barrel and receiver back into the stock.

Remove all excess bedding compound that is pressed out by the metal and leave to cure for 2-3 hours before the finishing touch and removal of all extended compound with a wallpaper knife or similar.

The epoxy shall be allowed to harden for at least 24 hours before removing the barreled action and the finishing touch up of the stock.

Assembly of the gun and further maintenance of the bedding compound

The rifle can be disassembled after a minimum of 24 hours of curing, without any issues. Please note that the epoxy will continue to harden for up to 72hrs. Moisture will evaporate during this time. After 72 hours, the moisture of the compound will be 5-7 %, similar to the wood used in our laminated stocks.

If further removal of bedding compound is required, please use a small sanding tool or other appropriate grinding device for the purpose.

Then – if done correctly and according to the manual – the bedding compound will be rigid and have a surface tension that will exceed 55 shore. This equals a piece of solid, nonflexible, hard epoxy lump.

No further maintenance of the compound should be necessary after bedding.