

Howa M1500/ Weatherby Vanguard Short Action Magazine System

Gunsmith Installation Instructions

The system has been designed to function without modification on most injection molded polymer stocks.

Wood stocks are made to different specifications with trigger guard to action distance and angle varying greatly between manufacturers. In a standard internal magazine bolt action rifle this is of little concern.

However with a detachable magazine fed bolt action rifle the positioning of the trigger guard to the action is critical to function properly.

The following outlines how to adjust the Howa M1500/ Weatherby Vanguard Short Action Magazine System to your particular firearm.

**Do not attempt to install this product on a loaded firearm!
SERIOUS INJURY OR DEATH MAY RESULT!**



Caution

Failure to follow these instructions may result in unreliable operation and may damage the detachable magazine assembly.

Removing the Factory Trigger Guard and Internal Magazine

*****Before Proceeding*****

CHECK TO MAKE SURE THE FIREARM IS UNLOADED NOW!!!

1. Unload the firearm and ensure the chamber is empty.

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2. Remove bolt.
3. Open Floorplate and remove tab spring and follower.
4. Remove screws (2) holding floorplate assembly to stock.
5. Remove Floorplate.
6. Remove internal box magazine (if it didn't come out with floorplate).

Installing the New Detachable Magazine Floorplate

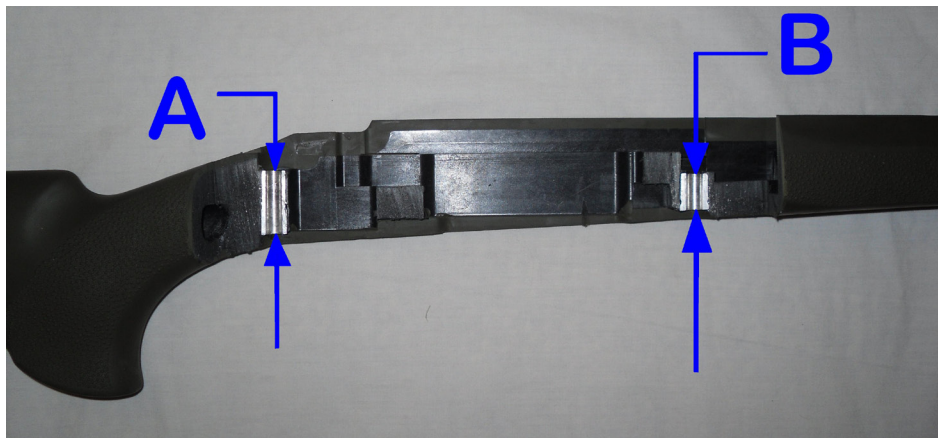
NOTE: The Howa M1500/ Weatherby Vanguard Short Action Mag System is designed to perform reliably when the bedding pillars measure:

A: 1.050" to 1.100" (Figure 1)

B: .625" to .635" (Figure 1)

These are the dimensions found in most injection molded polymer stocks.

Figure 1



1. Measure the front and rear bedding pillars in the stock (see “A” and “B” in Figure 1 above).

2. Use the following to calculate the thickness of shims or depth of machining in the stock. Use steel shims to obtain the correct thickness.

$1.075'' - (\text{Distance measured at point "A"}) = \text{Thickness of shims in Rear pillar.}$

$.630'' - (\text{Distance measured at point "B"}) = \text{Thickness of shims in Front pillar.}$

*Thickness of shims will vary based on type of stock used.

Note: If the measurement in points “A” and “B” are larger than the recommended spec, the stock will have to be relieved to allow proper fit for reliable feeding.

3. Place the shims on the pillars as shown in Figure 2.

Note: The shims should go around the mounting bolts as shown below to ensure they do not move during use.

Figure 2



**Do not attempt to install this product on a loaded firearm!!!
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4. Install an EMPTY magazine in the Conversion Floorplate and place in stock (See Figure 3).

Figure 3



5. Slide Conversion Floorplate toward the rear to ensure the magazine is seated against the action to eliminate or reduce any “play” when installed (See arrows in Figure 4).

Figure 4



6. Using a torque wrench, torque action bolts to 50 to 55 in-lbs.

Caution

DO NOT EXCEED 55 IN-LBS OR DAMAGE TO THE FLOOR PLATE MAY RESULT.

DAMAGE DUE TO OVER-TORQUING MAY RENDER THIS ASSEMBLY UNSAFE.

7. Check the position of the magazine in the action as shown in Figure 5 below.

- Magazine should be flush with the bolt slide area of the action to 1/32" below (See arrow).
- Magazine should be level with the bolt.

Figure 5



Enjoy Your New Detachable Magazine!



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