



AX AICS INSTALLATION AND OPERATION

Please ensure you read and fully understand this text before attempting any installation or maintenance. If you are unsure about any of the operations described below, the rifle should be taken to a competent gunsmith for assembly.

The AX AICS magazine features an added protrusion on the front of the magazine for extra security and ease of loading. This magazine type is not compatible with previous AW style AICS kits.

The Chassis has been designed to suit a Remington 700 barrelled action. **Please consult your Accuracy International dealer if you experience any difficulties during assembly.**



SAFETY

Before handling the rifle or attempting any operation, the individual responsible for the upgrade must ensure the safety of themselves and all others by:

- Standing behind the weapon
- Ensuring it is pointing in a safe direction
- Checking it is unloaded and safe to handle
- Removing the bolt

Note: ensure that the firearm is in a safe overall working condition prior to performing this upgrade

Parts List

- 1 x Chassis (Long or Short Action)
- 1 x Forend
- 1 x Rear grip
- 1 x 5 round detachable box magazine
- 2 x 80mm Accessory Rail with flush cup attachment points
- 1 x 80mm Plain Accessory Rail (rear frame)
- 1 x 140mm Accessory Rail with flush cup mounting points
- 1 x 180mm 20MOA Forend Rail assembly
- 1 x Rail Adaptor (Harris Bipod)
- 2 x Forend retaining screws
- 1 x 2.5mm hex key
- 1 x 4mm hex key (located under cheekpiece)

Optional Parts

- 1 x Action Rail Assembly
- 1 x Harris Bipod Assembly

Tools Required

Torque wrench with a range of 0.8 - 6 Nm [7-53 in-lb] with 3/16" hexagon insert

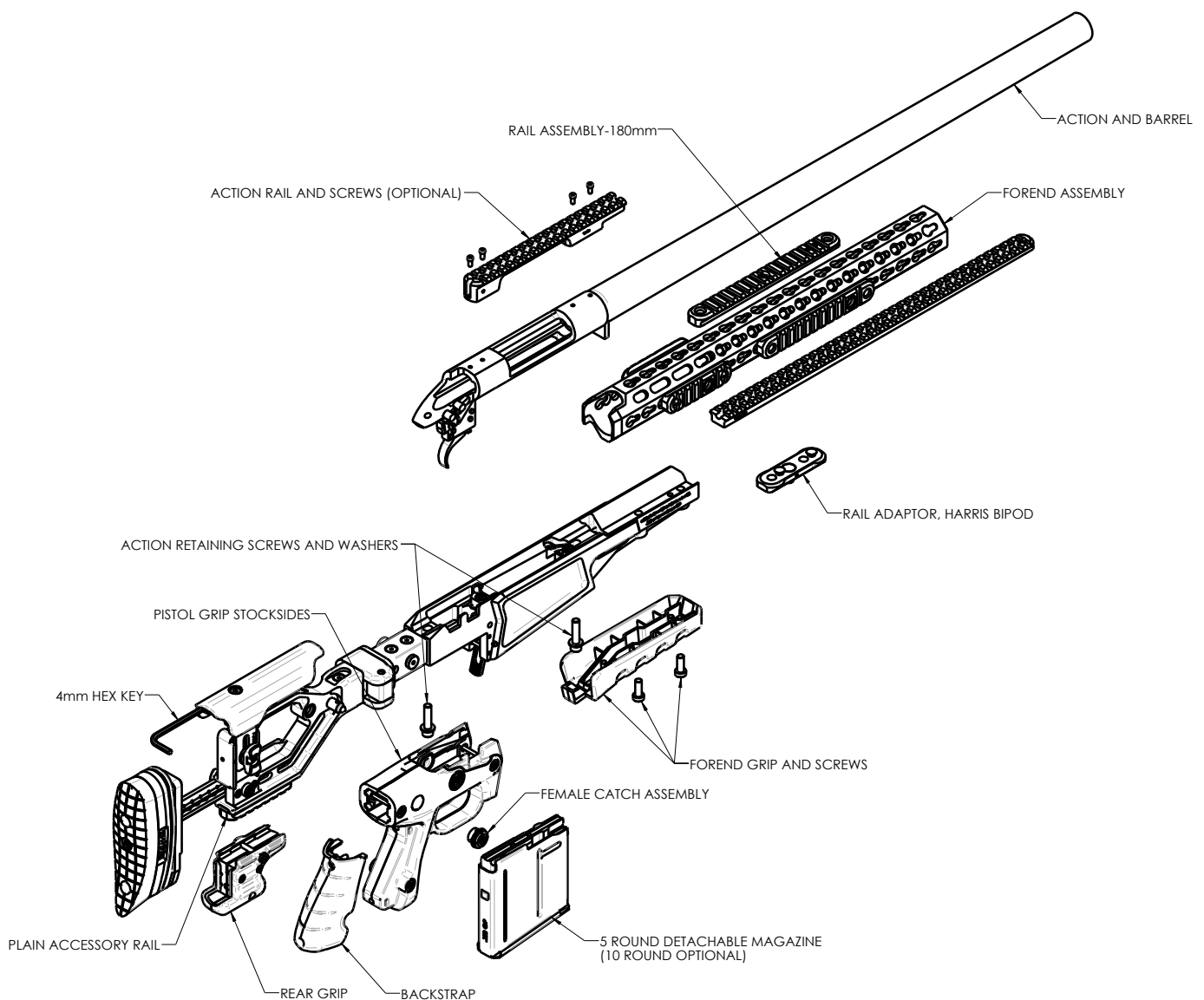
Tools for Optional Parts

Torx 15 key
Torx 15 inserts for torque wrench
Loctite 243 (blue) - For optional Action Rail only

SECTION 1 – ASSEMBLY

Preparation of the Action and Barrel

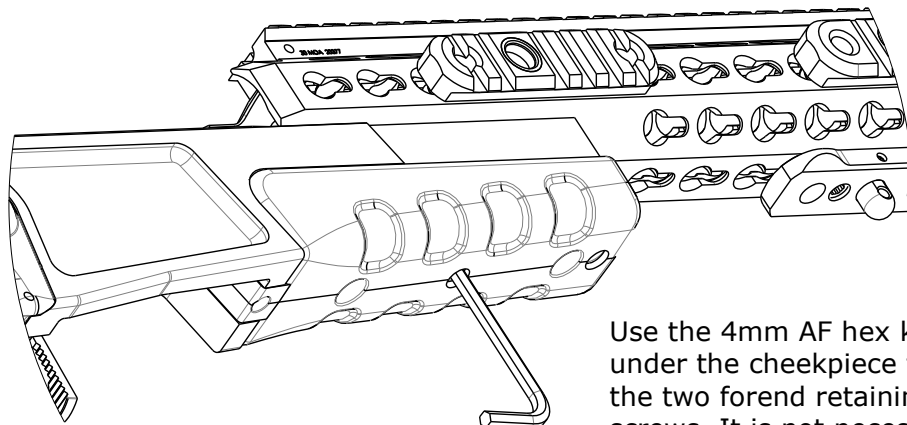
- Ensure that the rifle is unloaded.
- Remove the scope, scope mount and action rail (if required) from the action.
- Remove the Barrel and Action from its existing stock by removing the two $\varnothing 1/4$ " Action screws.
- Ensure that the donor barrelled action is assembled correctly, e.g. the two trigger retaining pins are not protruding beyond the diameter of the action body, the recoil lug is correctly orientated and the barrel is properly fitted.
- If fitting an Action Rail: Align the Action Rail to the Action. Apply Loctite 243 to the threads of the four action rail fixing screws. Use a Torx T15 key to tighten each screw to 1.7Nm [15 in-lb].



Parts identification diagram

Preparation of the Chassis

- Remove the Magazine from the AX AICS kit.
- Using a 4mm Hexagon Key, loosen the two screws holding the Forend in place. The screws will remain captive inside the forend grip.
- Remove the forend.



Use the 4mm AF hex key under the cheekpiece to undo the two forend retaining screws. It is not necessary to remove the forend grip

Assembly of the Chassis and Barrelled action

- Carefully insert the barrelled action into the chassis. Partially engage the two Action retaining screws' threads into the action.
- Pull the action back until the recoil lug rests up against the chassis, then use a 3/16" (4.5mm AF) hexagon key to carefully tighten the action screws. Starting with the front screw lightly tighten both screws until the action is sitting in the 'V' of the chassis and is centred. Rotate the action until the trigger is correctly orientated.
- Using a torque wrench fitted with a 3/16" hexagon insert, tighten the action screws (starting with the forward screw), to the specified torque of 6 Nm [53 in-lb].
- Slide the Forend over the barrel, and locate.
- Refit the Forend and tighten the retaining screws to 5Nm [44 in-lb], using a 4mm hexagon key.



SAFETY

ENSURE THAT THE BOLT, TRIGGER AND THE SAFETY MECHANISM OPERATE CORRECTLY BEFORE USING THE RIFLE.

The rifle is now assembled and ready for optics to be mounted.



CAUTION

It is recommended that the user fires a five shot group, then re-tightens the action screws to the specified torque of 6 Nm [53 in-lb] to account for any 'settling in' before shooting a second five shot group and zeroing the optics to the rifle.

It is recommended that the torque of the two action screws is periodically checked.

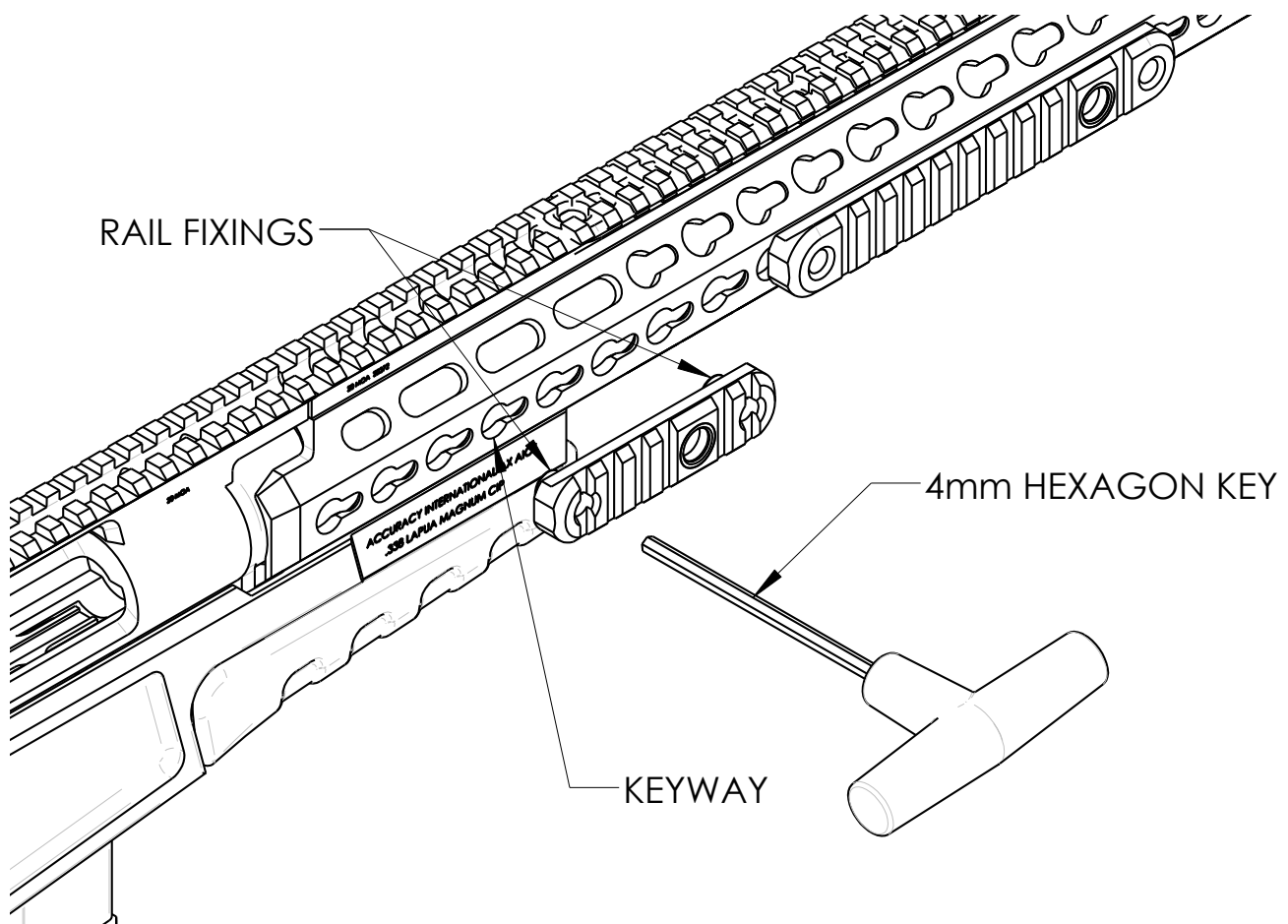
SECTION 2 – USER ADJUSTABLE AND CONFIGURABLE FEATURES

Rail Adjustment

The AX series of rifles and chassis systems are fitted with a modular system of STANAG/MIL STD accessory Rails. The rails can be removed and repositioned anywhere on the Forend or under the rear stock of the rifle.

To remove a rail:

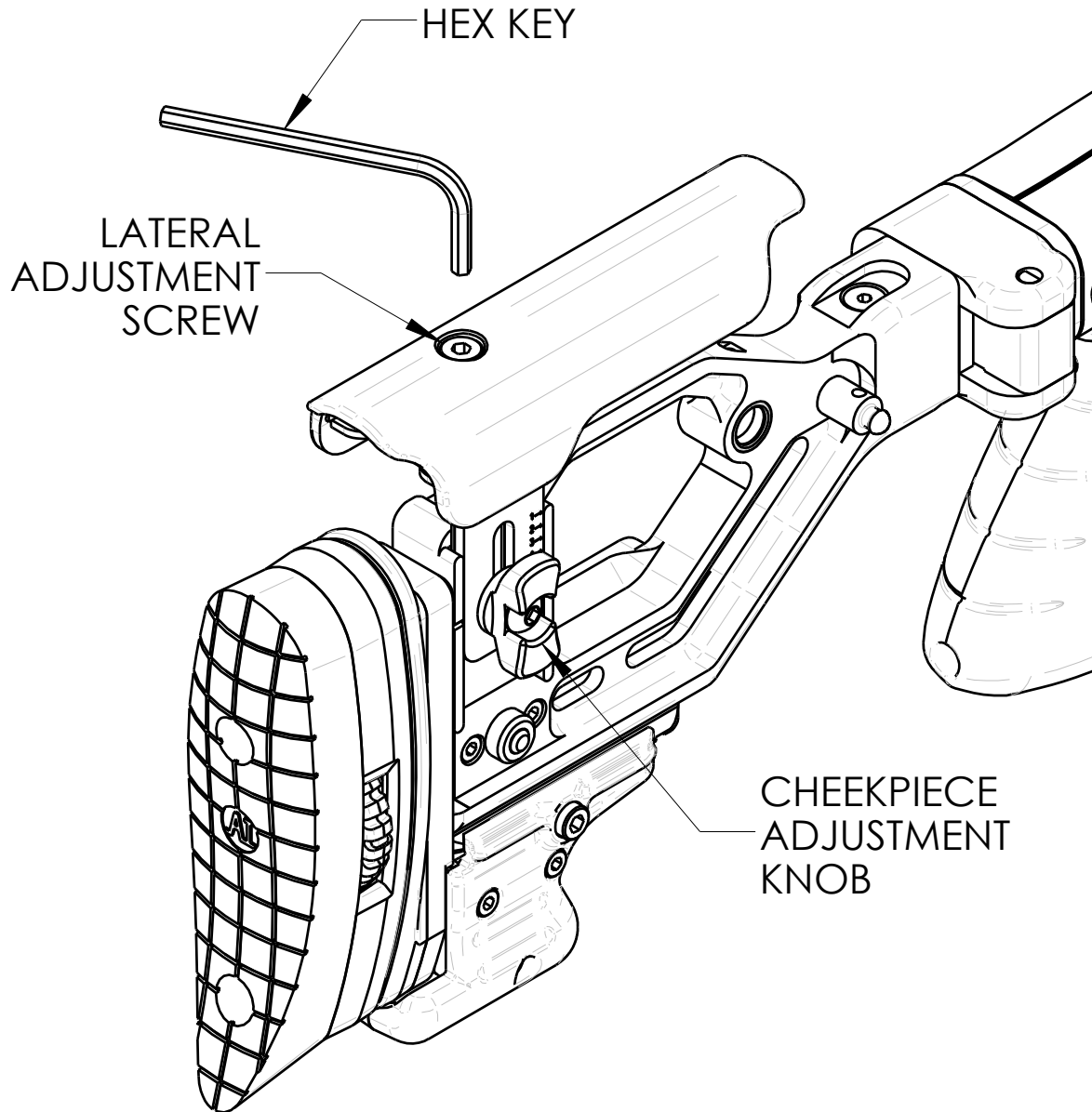
- Remove any accessories fitted to the rail.
- Use the 4mm Hexagon key stored under the cheekpiece to loosen the securing fixings (turn anti-clockwise).
- Slide the rail to the rear until it stops then lift out of the keyway.



To refit a rail:

- Ensure the fixings have been loosened (turn Anti-clockwise).
- Offer the rail up to the desired position and insert the securing fixings into the large slot of the keyway and push forward until stop.
- Use a 4mm Hex key to tighten the securing fixings to a recommended torque of 3Nm [26 in-lb].
- The position of the Accuracy International Harris Bipod rail adaptor can be adjusted in the same way.

Cheekpiece Adjustment



Cheekpiece vertical adjustment:

- Loosen the cheek piece adjustment knob.
- Adjust the height of the cheek piece to the desired position.
- Tighten the cheek piece adjustment knob.
- The 4mm hex key can be used to aid loosening and tightening if required, be careful not to over tighten the cheek piece adjustment knob.

Cheekpiece lateral adjustment:

- Use the 4mm hex key to loosen the lateral adjustment screw.
- Adjust the cheek piece to the left or right as appropriate.
- Tighten the lateral adjustment screw using the 4mm hex key.

Folding the Chassis

NOTE: The AX AICS has been designed to fold over the bolt handle of a standard Remington 700, with additional clearance to cater for some larger aftermarket bolt knobs. Take care when folding the rifle for the first time to ensure the bolt handle will fit in the rear frame recess.

Ensure the rifle is unloaded and is safe to handle.

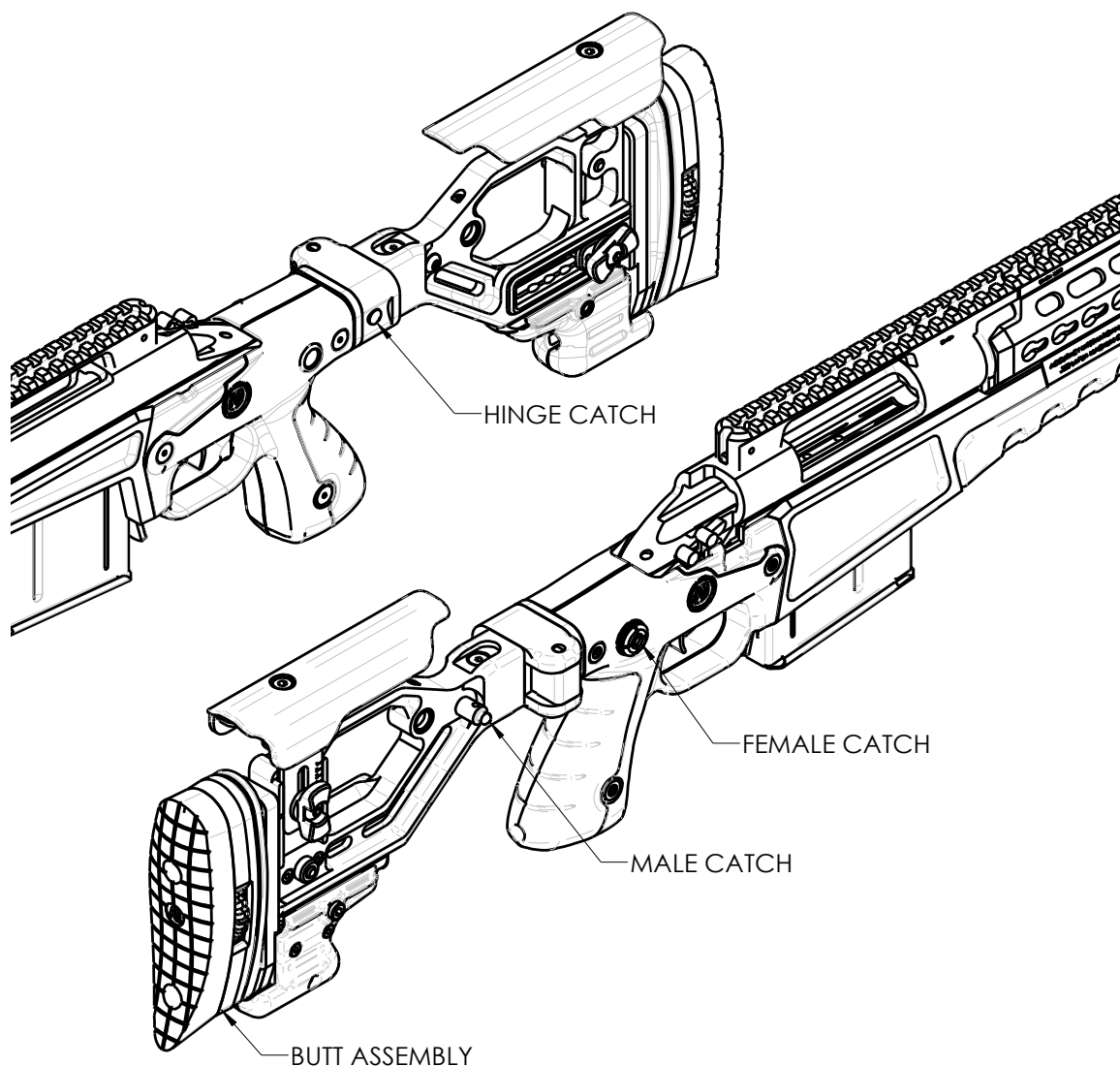
Close the Bolt.

To fold the chassis:

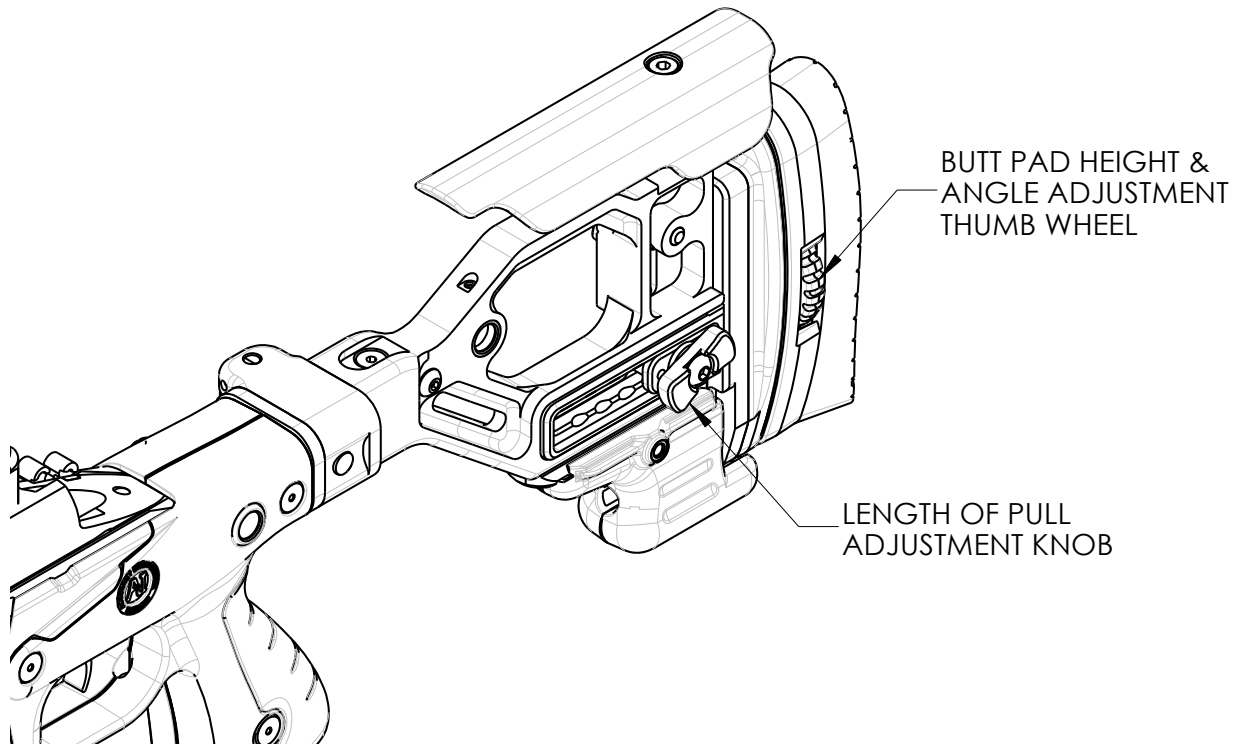
- Depress and hold the Hinge catch.
- Fold the Butt assembly through 180 degrees to the right until the Female Catch engages with the Male Catch fitted on the Butt Assembly.

To unfold the chassis:

- Firmly pull the Butt assembly from the front chassis and rotate through 180 degrees to the left to engage the hinge catch.
- Ensure the butt assembly is securely locked in position.



Adjusting Length of Pull & Butt pad Height / Angle



To adjust the length of pull:

- Loosen the length of pull adjustment knob and unscrew until it stops.
- Pull the butt pad rearwards until the desired length is achieved. A sprung detent is fitted to indicate when each possible increment is reached.
- Tighten the length of pull adjustment knob.
- The 4mm hex key can be used to tighten or loosen the knob if required.

To adjust the position of the butt pad:

- To raise, lower or rotate the Butt pad, loosen the adjustment Thumb Wheel.
- Once the desired position has been achieved, retighten the Thumb Wheel.

Accessories

The AX AICS kit can be easily upgraded by the user. A number of different upgrade modules and spare parts are available direct from Accuracy International or your local Accuracy International dealership.

Accuracy International of North America Inc.

Fredericksburg, VA, USA.
Tel + 1 540 368 3108
Fax + 1 540 368 3109
Email: aina@accuracyinternational.us

Accuracy International (UK) Ltd.

Portsmouth. UK.
Tel + 44 (0) 23 92 67 1225
Fax + 44 (0) 23 92 69 1852
Email: ai@accuracyinternational.org

www.accuracyinternational.com