

# BROWNELLS GLASBED®

**DANGER: CAUSES BURNS. STRONG SENSITIZER. HARMFUL IF SWALLOWED.** Contains: Epoxy resin, Aliphatic amine blend and Phenol. Do not get on skin or in eyes. Do not swallow. Wear eye protection and rubber gloves when handling. **FIRST AID:** Eyes/Skin: Flush with large amounts of water for at least 15 minutes. Remove contaminated clothing immediately. Inhalation: If symptoms occur, move to fresh air. Ingestion: Do not induce vomiting. Contact physician or Poison Control Center IMMEDIATELY. Seek medical attention for all over-exposures. **WARNING: Release Agent is FLAMMABLE** - Contains: Alcohol, Avoid extreme heat or open flame.

**KEEP OUT OF REACH OF CHILDREN**

**GLASBED NET WEIGHT:** 2 oz./56g

Release Agent **NET CONTENTS:** 1/4 FL. oz./7.4 ml

**KIT CONSISTS OF:** 1 COMBO Pak of **GLASBED** Resin and **GLASBED** Hardener; 1 bottle **GLASBED** Release Agent; 2 **Spreader Sticks**; 1 Cotton-tipped and 1 Rayon-tipped **Applicator**; 2 sheets of 120 grit **Sandpaper** and detailed **Instructions**.

Black Kit **#081-050-100**

Brown Kit **#081-050-101**

**BROWNELLS**  
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200 S. Front St. Montezuma, IA 50171

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## THANKS for selecting GLASBED

You've picked the finest, easiest-to-use bedding compound available and Brownells, Inc. guarantees your satisfaction 100%. This do-it-yourself process improves accuracy and consistency in all your shooting.

We've given you **The Basics** below, but you'll get the greatest benefit from this superior bedding product if you read the detailed instructions that follow. There are some small things you need to do to get the best results from GLASBED and avoid potential problems.

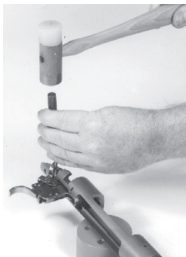
### QUICK INSTRUCTIONS

- (1) Remove the scope and rings. Take the barreled action out of the stock and strip it down to the basic unit.
- (2) Sand and clean the interior of the stock. If necessary, remove stock material to achieve proper clearance.
- (3) Degrease the barreled action, triggerguard and guard screws. Fill all pits, voids and openings with modeling clay. Coat them thoroughly with Release Agent using the swabs included. Cover the edges of the stock where they meet the barrel and action with tape, and coat the tape with Release Agent.
- (4) Clamp the stock in a padded bench vise or gun-cleaning vise with the action recess and barrel channel "up".
- (5) Remove the divider from the Pak of **GLASBED**, leave the Pak sealed, knead and mix the two components together for 4 minutes.
- (6) Cut open one corner of the Pak and squeeze **GLASBED** into the stock's front action ring recess, recoil lug recess and rear tang area. If you wish to bed the barrel channel of a wood stock, squeeze a ridge of **GLASBED** into the barrel channel.
- (7) Spread the **GLASBED** evenly in the action area; leave the ridge down the barrel channel.
- (8) Set the barreled action back into the stock, reinstall triggerguard and its screws.
- (9) Clean off any **GLASBED** that oozes out with a cotton-tipped applicator or small, wooden, or plastic, scraper. Make sure no **GLASBED** oozes up, over and around, the action or barrel. It could trap the metal in the stock.
- (10) Let **GLASBED** harden for 10 hours.
- (11) Remove barreled action from stock and clean off Release Agent, clay and tape from metal, stock, screws and parts.
- (12) Reassemble the barreled action and reinstall it in the stock.
- (13) Set the gun aside for another 2½ days to allow **GLASBED** to reach maximum hardness before firing.

## DETAILED INSTRUCTIONS & TECHNIQUE

### SPECIAL NOTE REGARDING THE FOLLOWING INSTRUCTIONS:

We've written these instructions to help the first-time "accrizer" - and the old-timer - do a professional job. If you have any questions, please call our Technical Support staff at **641-623-5401**. They are available Monday thru Friday, 8:30 am to 4:30 pm, Central Time.



### DISASSEMBLY

Make sure the gun is unloaded and the magazine or clip is empty. Completely disassemble the gun according to the manufacturer's instructions. Remove the bolt from the action and the barreled action from the stock (do not remove barrel from action). Remove the trigger group, magazine box (if present), scope and/or sights and other accessories attached to the action. Barrel-mounted open sights and scope mounts can normally stay in place.

### INLETTING & STOCK PREPARATION

#### Wooden Stocks:

There should be  $\frac{1}{32}$ " to  $\frac{1}{16}$ " clearance between the barreled action and the barrel channel, action recess and behind the recoil lug. Use chisels, scrapers or a miniature grinder to remove wood as required. Be sure to leave a small amount of wood behind the recoil lug and in the tang area to support the receiver in its proper position. The wood should be left rough rather than sanded smooth - not to increase the strength of the **GLASBED**-to-wood bond, but to add strength to the wood itself by

creating more exposed wood surface; thus realizing the full advantages of the **GLASBED**'s strength-giving qualities.

#### Fiberglass or Synthetic Stocks:

Use the sandpaper provided and rough up the interior stock surfaces to help remove any glaze or residual mold release which might prevent **GLASBED** from bonding to the stock material itself.



Put on rubber gloves, provide proper ventilation and degrease the interior stock surfaces with Brownells TCE, Birchwood Casey Gun Scrubber, acetone or similar solvent. Be sure to read the "Solvent Caution" and "Bonding To Plastics" notes under **Tip To Make The Job Easier**.

### All Stocks:

"Mask-off" the stock along the finished edge of the barrel channel and action cut-out area where they meet the barreled action. You can use Brownells Wide Bedding Tape, Scotch, masking or electrical tape. Coat the tape with Release Agent as detailed under the section of these instructions titled, **Metal Preparation - Use of Release Agent**. This will make cleanup easier and make sure any **GLASBED** that squeezes out during the bedding process won't stick to the stock. Test your tape to make sure its glue doesn't react with your stock finish or pull the paint off.



## METAL PREPARATION - USE OF RELEASE AGENT

**GLASBED** is a specially formulated, powerful bedding epoxy. It is also a superb glue for attaching metal to wood or fiberglass. Selective use of **GLASBED** Release Agent lets **GLASBED** bond to the stock but not to the barreled action.

**IMPORTANT:** Fill all milled-out sections, openings, pits, recesses and deep machine marks in the barreled action, recoil lug and triggerguard/floorplate with modeling clay. Smooth with scraper to keep all surfaces flush. Double-check the recoil lug, or any other projection, to make sure that it is not wider at the bottom than the top. This is called a reverse taper and it can mechanically lock the barreled action into the stock once surrounded by **GLASBED**. A mechanical lock can also occur if the barreled action rests so deeply in the stock that the edges of the stock are higher than the largest diameter of the barrel or action body.

Cover the front, sides and bottom of the recoil lug with a single



layer of Brownells Wide Bedding Tape or smooth, electrician's tape. The rear lug surface transfers recoil energy to the stock so it must remain uncovered; just fill any pits with modeling clay. The slight clearance created by the tape will make it easier to remove the barreled action from the stock for cleaning and repair.



Shake vigorously or stir Release Agent before using. Use the large, rayon-tipped Applicator for big areas, like the barreled action, and the small, cotton-tipped Applicator to get into recesses and corners. By pressing the large Applicator against the Release Agent jar's mouth and turning the bottle upside down, you can really saturate the Applicator with Release Agent for smooth, even application. Apply two or more thin coats of Release Agent on all exposed metal surfaces of the barreled action, triggerguard/floorplate, modeling clay and bedding tape that might contact **GLASBED**. Be sure to cover ALL surfaces and recesses. Let dry thoroughly between coats so carrier evaporates completely. Thick coats will "skin over", trapping unevaporated carrier which may damage bluing/metal. Let the Release Agent dry for approximately 5 minutes, or until dry to the touch. Hold the barreled action up toward a light and look across all surfaces. You should see a nearly transparent, continuous, vinyl film covering them. If you see bright reflections or a break in the coating, apply Release Agent to those areas. Apply a **THIN** coat of gun grease or paste wax over the guard screws and any stock pins *after* the Release Agent dries on them. Be certain the coat of Release Agent is **THOROUGHLY DRY** before bedding. When the bedding job is completed, Release Agent can be removed from both gun and bedding with warm water. Release Agent can be thinned with alcohol. Gun and Release Agent must be room temperature (68° F) or higher before beginning the bedding operation.

### **CAUTION:**

BEFORE PROCEEDING FARTHER, MAKE  
SURE YOUR STOCK IS  
CLEAN AND OIL FREE

## MIXING YOUR GLASBED

**GLASBED** is already packaged with the correct resin-to-hardener mixing ratio. Leave the Pak sealed and folded and pull the outer "clip" off the Pak and center divider rod. Lay the Pak on your workbench and "squeegee" the white resin and the colored hardener together using the outer clip, divider rod or one of the wooden mixing sticks. Begin working the mixture back and forth, stopping occasionally to work any unmixed components out of the corners. After one or two minutes, you can squish the Pak in your hands to further mix the resin and hardener together. Spend 4 minutes mixing the components, varying your techniques

to ensure that everything gets thoroughly mixed. You must get an even, uniform color with no swirls. **Always mix for a minimum of FOUR MINUTES.** Your **GLASBED** is now ready to use.

**Time/Temperature Note:** At 72°-75° F, you have approximately 20 minutes working time before your **GLASBED** becomes too stiff to use and give a suitable bonding between epoxy and stock. At higher room temperatures the stiffening occurs more rapidly, with proportionate decrease in working time. Working time can be lengthened by setting the sealed end of the Pak in a shallow pan of ice water and stirring the water occasionally.

During winter time in cold climates, be sure **GLASBED** is at least 68° F. before mixing and spreading. This same minimum temperature must be maintained during hardening as well. In hot conditions, chill **GLASBED** to approximately 76° F. before mixing to prevent it from setting up too rapidly.

## BEDDING

### Wooden Stocks:

Cut open one corner of the Pak and squeeze **GLASBED** into the stock's front action ring recess, recoil lug recess and rear tang area. Make sure there is good coverage where the rear tang and front receiver ring of the action rest in the stock. Fill the recoil lug recess approximately



half full. If you wish to bed the barrel channel of a wood stock, squeeze a ridge of **GLASBED** into the barrel channel. Use the Spreader Stick to distribute **GLASBED** evenly around the action recess, leaving the ridge down the center of the barrel channel. As an option, you can use your Spreader Stick to “paint” the magazine box and trigger group area with a *thin* coat of **GLASBED** to seal against moisture. If the area has already been coated with a stock finish, this step isn’t necessary. Don’t leave a thick coat or any globs in this area. The excess **GLASBED** could create a mechanical lock, trapping the barreled action in the stock, or it could fill space needed for the magazine box or trigger group.

Firmly press the stripped barreled action into the stock to the required depth and install the triggerguard and/or floorplate unit. Install the guard screws and tighten them as tight as you normally do when installing the barreled action into the stock. After 3 minutes, release pressure on the screws, then turn them in again gently until you feel them start to “draw up” then stop.

### **Synthetic Stocks:**

The barrel channels of some of these stocks are hollow; some aren’t. It’s generally not necessary to have full-length barrel channel-to-barrel contact with a synthetic stock, but it certainly can be done. If you want this contact, follow the directions below for bedding the action area and then squeeze a line of **GLASBED** into the channel, or along the edges of a hollow channel, as detailed under **Bedding - Wood Stocks**.



To bed the action area of a synthetic stock; cut open one corner of the Pak and squeeze **GLASBED** into the stock’s front action ring recess, recoil lug recess and rear tang area. Make sure there is good coverage where the rear tang and front receiver ring of the action rest in the stock. Fill the recoil lug recess approximately half full. Use the Spreader Stick to distribute **GLASBED** evenly. Firmly press the stripped barreled action into the stock to the required depth and install the guard screws and tighten them as tight as you normally do when installing the barreled

action into the stock.

We like either of two methods to clean up any excess **GLASBED**

that squeezes out onto the stock. First, and best, you can immediately wipe or scrape the excess away with the clean end of the cotton-tipped applicator or a small scraper made of wood or plastic. Second, you can wait until **GLASBED** takes a firm set - around 9 hours after application. The surplus **GLASBED** can be cut with a knife. Be careful, don't scratch the bluing or stock finish. **GLASBED** adhering to cutting instruments and hands can be removed *while still tacky* by rubbing with a vinegar-saturated cloth (don't get vinegar on blued steel).



Under normal conditions, you can remove the gun from the stock in 10 hours. To separate the barreled action from the stock: remove the action screws, remove the triggerguard/floorplate, secure the stock, right side up in a padded vise; place a wood dowel in the bolt opening and slowly, firmly lift the dowel and the barrel to remove the barreled action from the stock. This may not be that easy, especially on wood stocks where the entire action recess and barrel are now fitted more tightly than possible with any other method. If they won't separate, give the barreled action a few taps with a soft rubber mallet and try again. Proceed with a firm, slow lifting once the stock and barreled action begin to separate. If you still can't get the barreled action out, give our Tech Support staff a call.



### **REASSEMBLY:**

Clean off the Release Agent from the barreled action and stock. Remove all bedding tape and modeling clay. Follow the gun manufacturer's instructions and reassemble the trigger group, magazine box (if applicable) and other parts onto the barreled action. Lightly oil the metal parts. Check the bedding in the magazine and trigger area and remove any excess with files and sandpaper to get proper clearances. Re-install the barreled action into the stock.

You have now given your gun the finest of accurizing jobs. It

can be fired in three days, but waiting a week will be much, much better.

### TIPS TO MAKE THE JOB EASIER



**Storage** - Store in a cool place (68°-72° F). Shelf life of unmixed **GLASBED** components is Fifteen to Twenty years.

**Vinegar** - Great for cleaning up sticky **GLASBED**, but don't use on blued steel. It is an acid and can dull or remove bluing.

**Solvent Caution** - Some solvents may react with some synthetic stocks or wood stock finishes. If a synthetic stock has exposed foam filling, be very careful when using solvents for degreasing. The solvent could actually "melt" the foam. Solvents can also remove the paint used on some synthetic stocks or the finish from a wood-

en stock. We suggest you test any solvent on a part of the stock that won't show in normal use.

**Bonding To Plastics** - **GLASBED** "sticks" easily to stocks made from laid up fiberglass, Kevlar™ and graphite cloths which are bonded with epoxy resin. Brown Precision and H. S. Precision brand stocks are examples of this type. **GLASBED** may have problems sticking to some injection-molded, plastic stocks, especially if they contain a high percentage of polypropylene. Six Enterprises, Ramline, Butler Creek, Choate and some factory Remington stocks are made by this process.

Don't worry! You can **GLASBED** these stocks! The trick is to create mechanical locks by making undercuts in the bedding areas. This is the same thing an engraver does when putting gold inlays into a gun, or a dentist does when putting in fillings. Create some undercut grooves in the bedding recesses with a chisel or miniature grinder and drill several small holes at random angles into the bedding surface. Keep the holes small:  $\frac{1}{16}$ " to  $\frac{1}{8}$ " diameter is plenty, and there's no need to go deeper than  $\frac{1}{8}$ " to  $\frac{1}{4}$ ". Be careful when putting holes or grooves into the stock - you don't want them to go through to the exterior. After grooving/drilling, sand and degrease as explained earlier. **GLASBED** will flow into these cuts and holes and mechanically lock itself in place after setup. Give our Tech Staff a call if you have questions.

Another method that will increase epoxy bedding adhesion with

injection-molded stocks is to heat the area to be bedded with a propane torch, just prior to applying **GLASBED**. A low flame is all that's needed. Simply warm the area until it becomes slightly softened. Do not overdo this and melt the plastic, and stay away from any small edges that will show on the outside surface of the stock. You may observe the flame turning blue and hear a small, popping sound while you are playing the flame against the surface of the bedding area. This is caused by oil being driven out of the synthetic material and burning off. After heating, and while the bedding area is still warm, immediately apply the **GLASBED**.

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