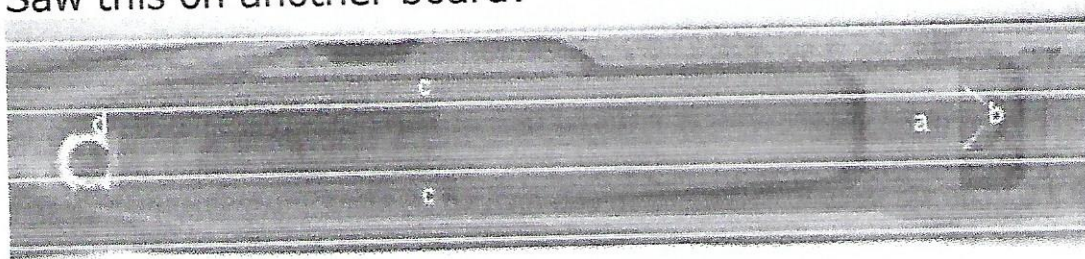


Bedding Mauser

- (1) Bayonet lug to clear barrel by 0.2mm.
- (2) Forward part of stock channel to bear upward against the barrel lightly.
- (3) Tapered part of stock channel forward of rear sight and shoulder on forward part of this tapered section to clear barrel all the way around by 0.5mm
- (4) Rear cylindrical section of stock channel to clear barrel by 0.5mm., except at top edge of channel where it can lightly contact barrel and sight base.
- (5) Recoil lug on bottom of receiver to fit stock uniformly and tightly. Recoil lug must bear firmly against recoil shoulder (recoil crossbolt) on stock.
- (6) 20mm. at bottom rear end of receiver tang to contact stock firmly.
- (7) 25mm. at rear and 20mm. at front of trigger guard to contact stock tightly.
- (8) Front of sight base projection which retains handguard must clear top of stock by 0.3mm."

I would kind of think this would apply to other Mausers also? Maybe?
Saw this on another board:



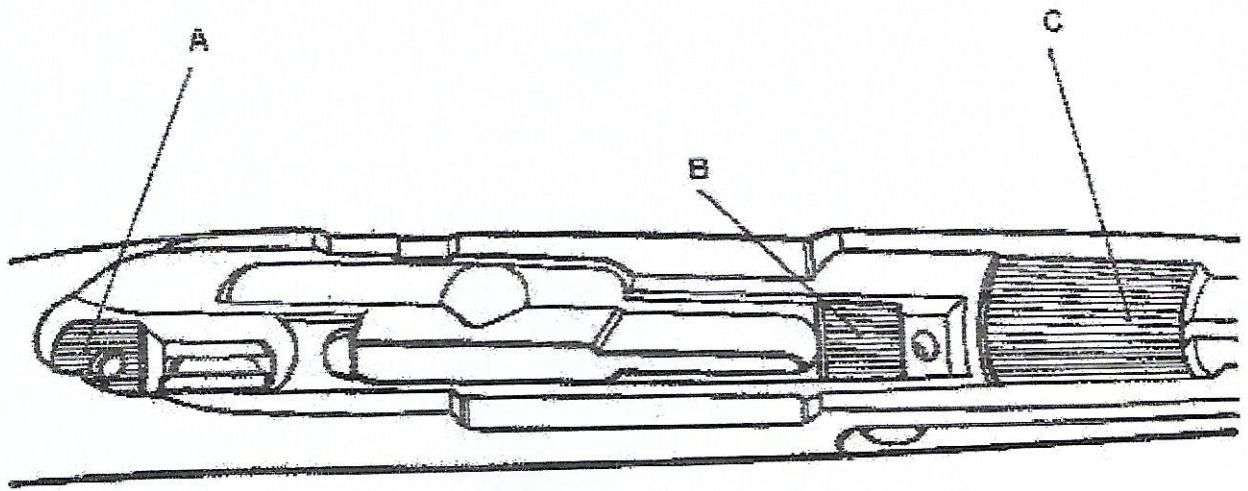
The receiver is bedded primarily at the recoil lug area (a, b) and the tang (d) with some contact desirable but not essential behind the magazine (c). The illustration shows an issue tang shim, which should be legal under CMP Garand/Springfield Match rules. One 03-A3 I received had two of these shims stacked up to tilt the receiver forward and put pressure on the forearm tip.

Points to watch for in bedding include making sure there is no metal-to-metal contact between receiver and magazine/triggerguard at the front screw hole and top of the magazine box (forward of "c"). There should be a metal tube in the rear guard screw hole just long enough so there is a very slight crush of the wood when the rear screw is tightened. Shimming with wood or cardboard under the triggerguard works if it doesn't raise the guard/floorplate proud of the stock line, but is not permitted under CMP rules. If the stock is severely oil-soaked and compressed you might either have to remove some metal from the top surfaces of the guard/magazine (bad) or get a new stock (good).

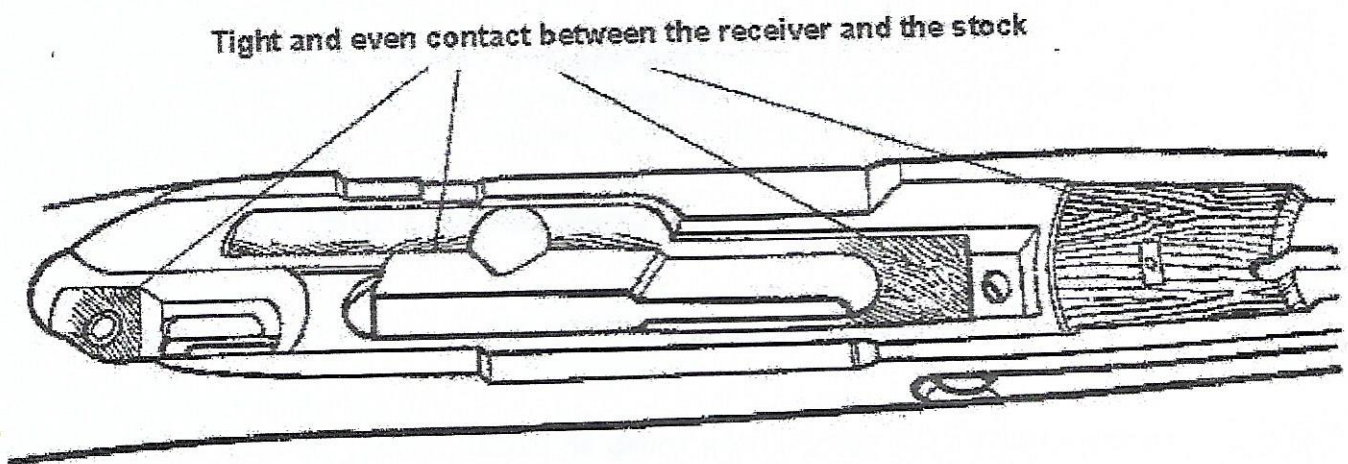
Once you have the right pressure at the forearm tip with bands and handguard removed, install them and check again. Sometimes the handguard will lever the barrel away from the stock and will need to be

handguard will lever the barrel away from the stock and relieve where it engages the rear sight sleeve to correct this. If the front band touches the barrel, scrape wood at the forearm tip until there is at least a few thousandths' clearance. The barrel should touch the stock only in the area of the front band. On occasion you have to remove wood under and around the rear sight sleeve to get the right fit.

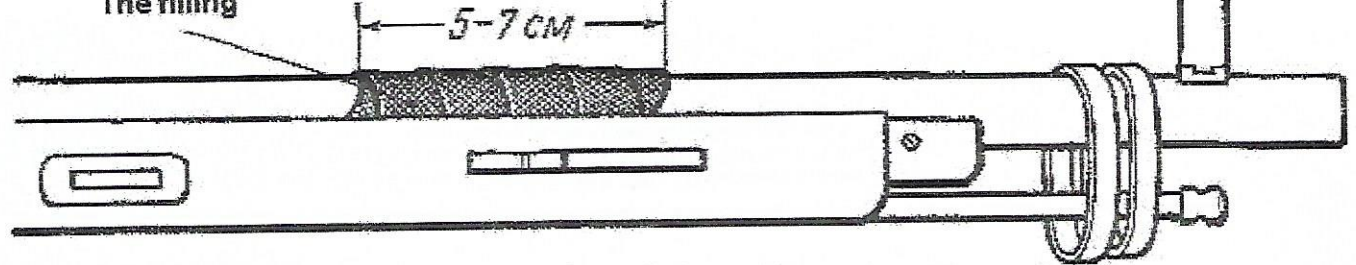
Check this out



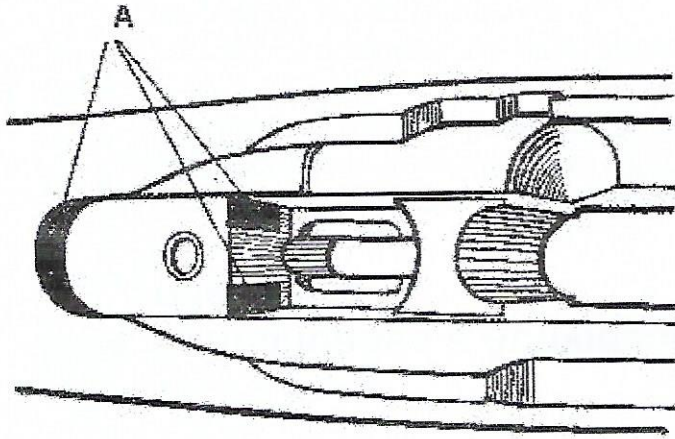
The bedding points



Fitting the receiver



The felt filling wrapped on the barrel (the alternative method)



The points that should not touch the receiver

In the opening post, which was great, there was mention of the action screws.

'Tight' is pretty subjective where accuracy is concerned.

Assuming all else is right and decently made, (bullet and bore compatible..☺) the rifle barrel is sorta like a tuning fork with a hole (the bore).

Each round produces harmonics and vibrations that affect the barrel and how it moves in timing with the bullet's exit to your carefully aligned sight picture. ...and yes, the barrel does move.

Get yourself a good quality torque screwdriver. Measures in inch-pounds.

Insure the action screws and their threaded female counterparts are clean, free from burrs and grit. Lube lightly.

Most centerfire rifles require from 50-70 inch-pounds of torque.

My Swede Mausers seem to shoot best (sub MOA) at about 63 inch-pounds and both screws are identically torqued. Snug them up back and forth by hand and then torque the front screw first.

You can tune the accuracy with a particular load by as little as 1/8 turn on the screws. Once you find the sweet spot, mark the screws' location for that load. jim

Old time stock makers used to bed the action as the Germans did, minimum contact. The reason for this was the expense of training "action bedders" and the significant time it would take to "full contact" bed the action. Glass bedding solved this problem. As mentioned

above, it's necessary to allow for longitudinal "growth" as the barreled

action heats up, especially in combat situations. With glass bedding this may be accomplished by applying layers of wide scotch tape and then removing excess with a razor. I have come to prefer "trough" bedding, that is, creating a trough filled with fiberglass and the barreled action set into it. Not simple to do, requires several applications. Start with mag/trgr grd. and bed it completely (ensure at least 1/8" depth of glass at all points. At least two contact points must be maintained, generally at the front and rear guard screws, to keep the position of the unit in proper alignment. This gets very tricky and must be well thought out before hand. Once in place and partially dried, remove while you still have a chance to correct errors. Next, remove wood at contact points and bed these openings. Now the barreled action (how's your supply of modeling clay or playdough and 2" scotch tape). As with the triggerguard tangs, fill in any lightening cuts with clay with a layer of tape over it to maintain its position. Again, two contact points and allowance for heat growth. This will require more than one session. As you start, this will strike you immediately (How the heck am I going to deal with that! Ah, I'll do the front first, then, the sides). I free-floated the barrel from 1 1/2" in front of receiver to about 2" from the tip, used shim for "up pressure". Does it work? I have a Sears Mod50 30-06, action by FN and barrel by Hi-Standard. I made a classic stock with a high top line on the butt for scope use, trough bedded it, got a 1000yrd shooter to shoot it at 100 yds. First three shots went thru same hole! Really, a first for any hunting rifle I'd ever owned. I ran and got a witness, put up clean target, let "Vassily" shoot again - same result. Witness signed target. Using Optical Columnator, we got .328" group. Now doing earlier stocks over, or was, got bad lungs and got pulled over to the curb by life. Try it sometime on a stray, see what happens.