

Instructions to Install SAKO 85 SS Rail

- 1) Remove Lock Screw and Set rail on action and carefully slide forward
- 2) Place muzzle vertically down on a glove on a bathroom scale.
- 3) Push with 2 thumbs 25KG of added pressure on back of rail - no tapping
- 4) Set rifle on your legs and measure inside the ejection port.
- 5) IF the miss match / stand off = less than 2MM use 24 hour slow cure golf club head epoxy on the dovetails for a permanent installation. For a re-moveable but secure install you may use clear fingernail polish or BRC680 loctite bearing retaining compound.

- 6) IF the miss match / press fit = 2MM to 2.5MM proceed to step #10

- 7) IF the miss match / press fit is greater than 3MM, Place the rail on top of a sheet of 400 grit sandpaper on a FLAT hard surface. (sheet of glass, surface plate, granite or marble counter top, etc)

- 8) Before sanding, please measure the thickness of your base at various points to reference and control the amount of material removed.

- 9) After the hand fit in step 3, there will be witness marks on the insides of the dovetails. You will be able to determine if the front or the rear dovetail has a tighter fit. If the front dovetail is tighter, then sand on the bottom of the front end of the base with light strokes to remove only the bead blasting. This will be about .001" and that will allow the base to fit forward about .030" = 0.75 MM in step 3, 4 &5
When you have arrived at 2MM to 2.5MM of press fit by steps 7, 8&9 you may proceed to the final install in step #10.

- 10) With the rail positioned as in step #3, set a wood dowel about 30CM = 1 foot long, against the rear face of the rail. Use a 1 LB ball peen hammer to tap the wood dowel and drive the base into home position. The recoil stop will provide a tactile feel and an audible indication that the base is home and visually aligned at the inside ends of the ejection port.
NEVER strike the base directly with a block of wood, or even a soft faced hammer. Use ONLY a wood dowel and set that against the back of the base. Please see the video on www.trg42.com/sako

- 11) A loose fit secured with 24 hour slow cure golf club head epoxy provides the most security with zero stress on the rail compared to all known and tested methods.
- 12) Re install Lock screw on bottom side and torque to 20-24 Inch Lbs.

DO NOT CERAKOTE or PAINT as it instantly VOIDS all warranty. Mollycoat, cerakote or **any coating what so ever will cause rail failure!**