



May 9, 2013

201 Old Homestead Hwy.
N. Swanzey, New Hampshire 03431

WTC Barrel Swapping Guidelines

The following guidelines are for swapping barrels fitted to your action by WTC. While they may apply to any barreled action, they are specifically intended for WTC built rifles, its customers and the tools WTC supplies to accomplish the swap. It is essential that you follow these guidelines. Failure to do so could result in one or more of the following; damage to your action, damage to your barrel(s), and personal injury.

A barrel that is threaded and chambered by WTC should only be installed on the action that it was fit to. Unless it was specifically stated by WTC that it may be used on multiple actions, **under no circumstance should it be installed onto an action other than the one it was fitted to.**

1. *Cleanliness* è It is of the utmost importance that you keep your action, barrels, tools, and work area clean. The smallest amount of debris can cause damage to the threads of your barrels and action. It is essential that both your barrel and action threads be 100% clean and free of any foreign matter prior to assembly.
2. *Lubrication* è Lack of lubrication is the detriment to most mechanically mated parts. The same applies to your barreled action. Failure to lubricate the threads of your action and barrel prior to assembly may result in seized and galled threads. Damage such as this may require that the barrel be cut away from the action. Some cases require that the action threads to be re-cut, thus negating the fit of any other barrels that may be fit to the action prior to the damage occurrence.
3. *Swapping* è Regardless of the type of wrench that you use to remove and install your barrel(s) on your action, it is important that only radial torque be applied to the assembly. Torque in a linear direction, i.e. tangential, forward or rearward linear force may result in damage to your action and/or barrels. You need only apply a small amount of force to lock up or break apart the barrel from the action. Using the internal wrench system, you need only wrap the wrench bars with your hand to accomplish this. When using the external wrench system, a small plastic mallet may be used to wrap the wrench bar to accomplish the lock up or break down. Please note that external action wrenches clamped on the action around the thread area if over tightened can collapse the action diameter and lock the thread fit. It should also be noted here that the wrench should only be used for final lock up and initial break



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down of the assembly. You should run the action on and off the barrel by hand at all other stages of removal and assembly. **Under no circumstance should additional tools be used to install or remove barrels from your action. Additional tools, such as breaker bars or wrench extensions can lead to damage to your rifle.** If you believe that you need such items, chances are that the damage is already done.

If at any time, you think that there may be a problem, or if you have questions **STOP!** It is better to obtain the certainty that you are correctly swapping your barrels rather than to incur avoidable damages. Do not hesitate to contact us with any questions.

By signing below, I agree to the above instructions and that I will not hold WTC liable for any damage incurred to my rifle by failing to follow the above guidelines.

Date: _____ Signed: _____