



**Installation Instructions
1022-2-AR Precision Chassis for the
Ruger 10/22
Crazy Ivan Enterprises, LLC
US Patent 10012460
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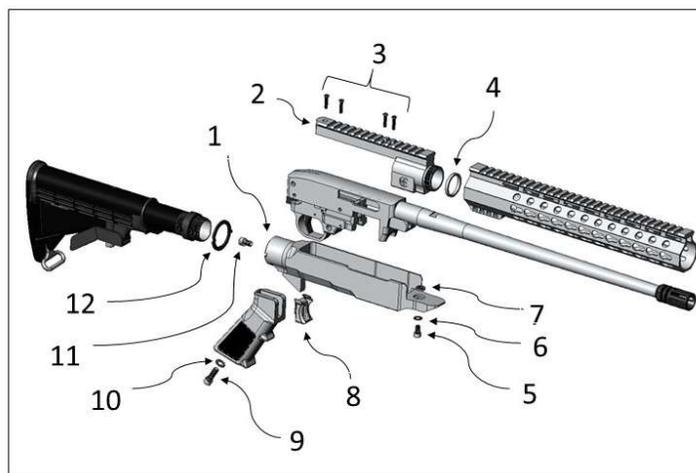
ENSURE THAT YOUR FIREARM IS COMPLETELY UNLOADED BEFORE DOING ANY WORK TO IT!

These instructions have been prepared to assist in the assembly of the Crazy Ivan 1022-2-AR Precision Chassis for the Ruger 10/22. Refer to the installation instructions included with the AR stock, grip, and handguard that you decide to use for details regarding those items.

The Crazy Ivan 1022-2-AR Precision Chassis is design to fit factory 10/22 rifles, carbines, and Charger pistols. It will accommodate barrel profiles up to 0.920" (standard bull barrel diameter). Some aftermarket receivers may not fit without modification. This chassis system is not compatible with Ruger 10/22 takedown models.

Parts included:

1. Lower Chassis
2. Upper Chassis
3. Receiver screws (4) Fillister Hex-Head #6-48 x 9/16"
4. Barrel Spacer
5. Takedown screw (1) Socket Cap #12-24 x 1/2"
6. Takedown screw washer (1) #12
7. Takedown screw nylon retainer (1) #12
8. Grip Spacer
9. Grip Screw (1) Socket Cap 1/4"-28 x 3/4"
10. Grip Screw Washer (1) 1/4"
11. Thrust Screw (1) Socket Cap 1/4"-28 x 3/8"
12. Buffer Tube Alignment Ring



Part Diagram

Assembly Instructions:

STEP 1: Verify that the firearm is completely unloaded!

STEP 2: Remove the barreled action from the existing stock per the manufacturer's instructions.

STEP 3: If the barrel has factory sights, the rear one will need to be removed to accommodate the chassis upper. At this time, you may also want to remove the front sight and replace it with a slip-on flash suppressor - it is much easier now than after the firearm has been reassembled.

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1022-2-AR Precision Chassis for the Ruger 10/22

STEP 4: Attach the free-float handguard of your choice to the chassis upper according to the manufacturer's instructions. The barrel spacer provided is designed to replace the AR barrel collar in the assembly. Some handguards may fit better without the spacer. You may also choose to sand/grind the spacer or add barrel nut washers (often included with the handguard) to achieve a better fit.

STEP 5: Slide the chassis upper over the barrel and secure to the top of the receiver with the four #6-48 screws provided. Use of removable thread locker (e.g. LOCTITE® Blue 242) is recommended. Only use the thread locker sparingly on the screw threads - DO NOT place any thread locker into the screw holes in the receiver, because the thread locker can drip into the bolt or receiver and cause potentially dangerous malfunctions. Alternate tightening the screws until all four are snug, then torque to 12-15 inch/pounds.

STEP 6: Insert the rear of the barreled action/upper chassis assembly into the lower chassis and lower the barreled action/upper chassis assembly into the lower chassis. Note that the trigger safety must be half way between the "on" and "off" positions for it to clear the lower chassis during assembly. Secure the receiver with the provided #12-24 x 1/2" takedown screw and #12 washer. The #12 nylon retainer is provided for convenience and is not required in the assembly. Tighten the takedown screw until snug, but do not fully tighten until the end of STEP 7.

STEP 7: Install the Thrust Screw (socket head screw 1/4"-28 x 3/8") into the hole located inside the buffer tube hole in the lower chassis. Use of removable thread locker (e.g. Loctite Blue 242) is recommended since this screw is a "set and forget" feature. This screw serves the same function as installing a tang on the receiver or bedding the receiver: it provides a custom fit and will remove the small amount of play that might be present at the rear of the receiver. Slowly tighten the screw until it is snug against the rear of the receiver. Note that the Thrust Screw will slightly mark the receiver, but any 10/22 stock covers this part of the receiver. Do not overtighten the screw or it will be difficult to disassemble the firearm. To check this, after tightening the thrust screw, loosen the takedown screw and check disassembly/reassembly before proceeding to STEP 8 (which will block access to the thrust screw). Once a snug fit is achieved and the receiver can still be removed from the lower chassis, tighten the takedown screw again (completely) and proceed to STEP 8.

STEP 8: Install the buffer tube and AR stock of your choice on the chassis lower according to the manufacturer's instructions. The provided buffer tube alignment ring replaces the AR receiver plate in the assembly.

STEP 9: Install the grip spacer at the front of the AR grip.

STEP 10: Install the AR grip of your choice with the provided 1/4"-28 x 3/4" socket cap screw and 1/4" washer. Do not use a standard-length (1") AR grip screw, since it may not seat properly with some grips. Some grips may also need to be trimmed to achieve a proper fit (e.g. beavertail grips).

STEP 11: Your 10/22 is now ready for optics and most other accessories designed for the AR platform!

If you have a question or comment, please contact me via email at Karl@CrazyIvanLLC.com or via US Mail at Crazy Ivan Enterprises, LLC, 1341 Forsyth Lane, Galena, Ohio 43021. Thank you!