



Installation Instructions
Original (1022-2-AR) Chassis for the
Ruger 10/22
Crazy Ivan Enterprises, LLC
US Patent 10012460

ENSURE THAT YOUR FIREARM IS COMPLETELY UNLOADED BEFORE DOING ANY WORK TO IT!

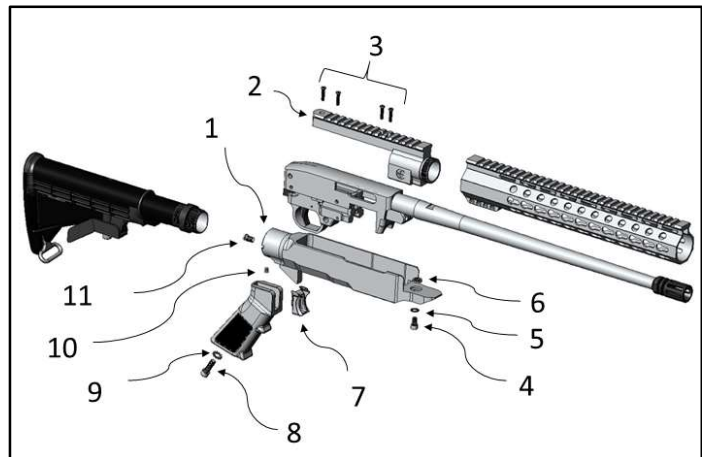
These instructions have been prepared to assist in the assembly of the Crazy Ivan Original Chassis for the Ruger 10/22. The Crazy Ivan Original Chassis is design to fit factory 10/22 rifles, carbines, and Charger pistols. It will accommodate barrel profiles up to 0.920" (standard bull barrel diameter). Some aftermarket receivers may not fit without modification of the chassis (for example Volquartsen). This chassis system is not compatible with Ruger 10/22 takedown models.

TIPS/NOTES:

- To determine what size handguard to use, add 2.5" to the length of the handguard to determine how much barrel will be covered. Example 12" handguard + 2.5" = 14.5", so for 16" barrel, 16-14.5=1.5" of barrel sticking out of handguard.
- When properly assembled, there will be a slight gap between the upper and lower chassis. This is by design, so that the barrel block seats firmly on the lower chassis without interference from the upper chassis.
- Many AR handguards are designed so there is a slight gap between the handguard and the receiver. To close this gap, the end of the upper chassis threads can be sanded/milled.
- Because the handguard does not secure the barrel of the rifle, as is the case for an AR, the torque specifications are optional for the handguard. However, be sure the barrel nut is sufficiently tight to prevent handguard movement, which is potentially dangerous.
- A castle nut is not required because the buffer tube/stock set screw provides a very secure attachment. However, if you choose to install a castle nut the torque specifications are optional because the buffer tube is not part of the rifle operating system as is the case for an AR. However, be sure the stock is sufficiently tight to prevent movement, which is potentially dangerous.

Parts included:

1. Lower chassis
2. Upper chassis
3. Receiver screws (4) socket cap #6-48 x 9/16"
4. Takedown screw (1) socket cap #12-24 x 1/2"
5. Takedown screw washer (1) #12 - flat
6. Takedown screw retainer (1) #12-nylon
7. Grip spacer - nylon
8. Grip screw (1) socket cap 1/4"-28 x 3/4" (shorter than AR!)
9. Grip screw washer (1) 1/4" - lock
10. Buffer tube/stock set screw (1) #10-32 x 3/16- dog tip
11. Adjustment set screw (1) 1/4"-20 x 5/16"



Part Diagram

CRAZY IVAN ENTERPRISES, LLC
1022-2-AR Precision Chassis for the Ruger 10/22

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.

STEP 4: Attach the free-float handguard of your choice to the chassis upper according to the manufacturer's instructions. See additional information under TIPS/NOTES above.

STEP 5: Slide the chassis upper over the barrel and secure to the top of the receiver with the four #6-48 screws provided. If you choose to use removable thread locker (e.g. LOCTITE® Blue 242), 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: Install the takedown screw (#12-24x12") and washer (#12 flat) into the chassis and secure from inside the chassis with the #12 nylon retainer. The nylon retainer will keep the takedown screw and washer attached to the chassis when the receiver is removed for cleaning or service.

STEP 7: 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 halfway 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. Tighten the takedown screw until snug, but do not fully tighten until the end of STEP 8.

STEP 8: Install the Adjustment Screw (Allen set screw 1/4"-20 x 5/16") 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. Do not overtighten the screw or it will be difficult to disassemble the firearm. To check this, after tightening the adjustment screw, loosen the takedown screw and check disassembly/reassembly before proceeding to STEP 9 (which will block access to the adjustment 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 9.

STEP 9: Thread the buffer tube into the lower chassis and secure it with the provided buffer tube/stock set screw (#10-32x3/16" - dog tip). The set screw is sufficient to align and secure the buffer tube/stock - use of the castle nut is optional.

STEP 10: Install the grip spacer at the front of the AR grip.

STEP 11: 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 and might touch the trigger group. Some grips may also need to be trimmed to achieve a proper fit (e.g. beavertail grips).

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!