

KELBLYS



A HIGHER LEVEL OF ACCURACY

Switch Barrel Precision Bolt Action Rifle Owner's Manual

*Please read the instructions
and warnings contained in
this manual carefully before
using your new Kelbly rifle.*

***Be sure to note warnings
printed in red.***



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ARCAAS

S E R I E S R I F L E S

by KELBLYS Inc.



ATLAS Hunting



ATLAS CUSTOM Hunting/Varmint



TACTICAL



.338 TACTICAL



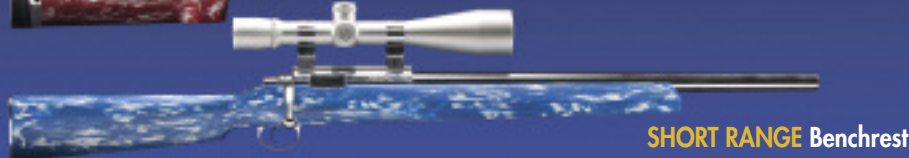
F-CLASS FTR



F-CLASS OPEN



LONG RANGE Benchrest



SHORT RANGE Benchrest

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Introduction to Firearms Safety

Firearm safety is every gun owner's responsibility. Since making our first action in 1981, Kelbly's, Inc. has advocated the safe use, handling, secure storage and proper education that accompany responsible firearms ownership. Both general and specific firearms safety rules and information are packaged with every Kelbly firearm.

Kelbly encourages everyone to securely store all guns under lock and key, and to take special precautions to keep guns out of the unsupervised sight and reach of children.

Today, all firearms are shipped with a cable lock that when used prohibits loading and discharge. If you do not have a cable lock for your Kelbly firearm we will provide one. Just send a request in writing to: Kelbly's, Inc., 7222 Dalton Fox Lake Rd., North Lawrence, OH 44666. Please include 10 (ten) U.S. dollars per lock for shipping and handling. This offer is subject to change without notice.

Kelbly firearms have always been and will continue to be distributed in full compliance with the letter and spirit of all applicable laws pertaining to their sale. All sales are made only to the properly licensed professional firearm dealers and legal individual buyers.

Failure to follow these instructions or failure to obey any safety warnings may result in injury or death to yourself or others, or cause damage to your firearm.

As a gun owner, you accept a set of demanding responsibilities. How seriously you take these responsibilities can literally be the difference between life and death. There's no excuse for careless or abusive handling of any firearm. At all times handle your firearm with genuine respect for its power and potential danger.

For legal purposes, Kelbly rifles are classified as lethal weapons. The failure to read and properly execute the instructions and warnings contained in this manual could result in serious injury, death or damaged property.

Remember that firearm ownership and use is a responsibility that no one should take lightly. Firearm accidents will not occur if the following rules are observed:



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Fundamental Firearm Safety Rules

1. Consider every firearm to be loaded. Never allow the muzzle to be pointed at anything you would not shoot.

Always follow this rule, even when you are certain the gun is unloaded. Be extremely alert and aware of all persons or property within the range of your ammunition.

2. Learn the mechanical and handling characteristics of the firearm you're using.

Always assume that your gun can be fired at any time, even with all safety mechanisms engaged. Like any other mechanical device, a safety can fail; it can be bumped or unintentionally manipulated into the "off" position. Mechanical safeties only supplement safe gun handling and are no excuse for pointing a firearm in an unsafe direction. Safe gun handling does not stop with the guns mechanical safety devices - it only starts there. Always treat all firearms with the respect a loaded, ready to fire gun deserves.

3. Use only the correct ammunition – of the caliber and type intended for your firearm.

The Kelbly action and/or rifle has been made with substantial safety margins over the pressures developed for SAAMI - specified loads. Nevertheless, Kelbly's, Inc. assumes no liability for incidents which occur through the use of nonstandard cartridges which develop pressures in excess of SAAMI and CIP - specified pressure levels.

4. Always make sure your barrel is always free from any kind of obstruction such as mud, dirt, snow, grease, heavy oil or any other foreign matter.

Always be alert for signs of ammunition malfunction. If you detect an unexpected sound or light recoil when the cartridge fires, do not load another cartridge into the chamber before checking for obstructions.

5. Always wear appropriate eye and ear protection when shooting.

Unprotected, repeated exposure to gunfire can cause permanent hearing damage. Always wear hearing protection, such as shooting earplugs or ear muffs, to guard against such damage. Wear shooting glasses to protect your eyes from flying particles. Also, wear eye protection when disassembling and cleaning all firearms to prevent the possibility of springs, spring tensioned parts, solvents or other agents from contacting your eyes.

6. When not in use, store unloaded guns and ammunition separately under lock and key.

Store your firearm and ammunition separately and well beyond the reach of children. Take all safeguards to insure that any firearm does not become available to untrained, inexperienced, unsupervised, or unwelcome hands.

7. Never climb a fence, tree, or jump a ditch with a loaded gun.

Never lean or place any loaded firearm on or against a fence, tree, car or other similar object. If this is done the gun may inadvertently fall, causing the gun to fire accidentally.



8. Never pull a gun toward your body by the muzzle.

If this is done, and there is an accidental discharge, you may be injured or fatally wounded.

9. Keep your fingers away from the trigger, while unloading or loading, until you are ready to shoot.

Always be sure of your target and backstop before you shoot. Never use hard flat surface or water as your backstop. Be especially cautious during low light conditions. Know the range of your ammunition. Never fire at water or hard objects as ricochets may occur.

10. If repairs are necessary or indicated, please contact Kelbly's, Inc. for further instructions.

We do not recommend that you alter the trigger, safety or other parts of the firing mechanism on this or any other firearm. Failure to respect this warning may result in injury or death to yourself or others.

11. Never loan your gun to anyone unfamiliar with these basic firearms safety rules.

Supervise and teach firearms safety to all members of your family - especially to children and non-shooters. Closely supervise newcomers to the shooting sports. Encourage enrollment in hunting/shooting safety courses. For younger shooters, The National Rifle Association's Eddie Eagle program is a great starting point.

12. Be defensive and on guard against unsafe gun handling around you and others.

Don't be timid when it comes to gun safety. If you observed other shooters violating any of the safety precautions, politely suggest safer handling practices.

13. Never drink alcoholic beverages or take any type of drugs before or during shooting.

Your vision and judgement will be dangerously impaired, making your gun handling unsafe to you and to others.

14. Don't neglect periodic maintenance. Avoid unauthorized servicing.

Your new firearm is a mechanical device, which will not last forever, and as such, is subject to wear and requires periodic inspection, adjustment, and service. Kelbly firearms should only be serviced by competent gunsmiths or at the factory. Kelbly factory cannot assume any responsibility for injuries suffered or caused by unauthorized servicing, alterations or modifications.

Service Information

A. Top Safety – if present (most target rifles do NOT have a safety lever)

If present, the safety lever is a traditional two-position type commonly found on the Remington 700 and clones, it does allow unloading from the safe position (see Safety-ON (SAFE) Position 1 in photo below).

The safety lever is located to one side of the rear of the bolt. There are 2 positions of the safety lever. Position 1 – The safety lever is pulled completely to the rear, the safety is on. Position 2 – the safety lever is fully forward. The rifle is capable of firing if the trigger is pulled.

Instructions for a top safety:

1. To engage the safety, pull the serrated lever fully to the rear (as pictured in Safety-ON (SAFE) Position 1 photo below).
2. When you are prepared to fire, push the serrated lever fully to the forward position (see Safety-OFF (FIRE) Position 2 photo below). Note: The safety is hand fitted into position before the rifle leaves our facility.
3. To unload the rifle or view the chamber of the rifle, you must open the bolt (see: UNLOADING THE RIFLE).

Safety-ON (SAFE) Position 1



Safety-OFF (FIRE) Position 2



CAUTION: The rifle should never be carried loaded with the safety lever in Position 1. The lever may be unintentionally manipulated forward to the fire position without the user knowing it.

WARNING: When the safety lever is in the forward position the rifle can be fired. Do not touch the trigger while moving the safety. Never pull the trigger when the safety is in the “Safe” position. Even when the rifles safety is in the “safe” position, always adhere to Fundamental Firearm Safety Rules on pages 5 - 8.

No safety or mechanical device is a substitute for careless handling of firearms. Even with the safety on, never point the muzzle at anything you do not intend to shoot.



A. Bottom Safety – if present (most target rifles do NOT have a safety lever)

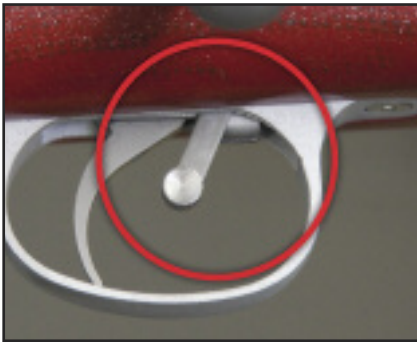
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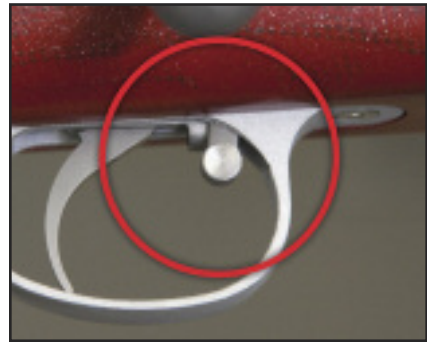
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Safety-ON (SAFE) Position 1



Safety-OFF (FIRE) Position 2



CAUTION: The rifle should never be carried loaded with the safety lever in Position 1. The lever may be unintentionally manipulated forward to the fire position without the user knowing it.

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No safety or mechanical device is a substitute for careless handling of firearms. Even with the safety on, never point the muzzle at anything you do not intend to shoot.

B. Installing the Bolt

Your rifle should arrive completely assembled except for the bolt, which has been removed for safety during transportation and storage. Your bolt should be packed separately in the shipping case.

1. To install the bolt, hold rifle in one hand, with the muzzle pointed in a safe direction.
2. With your other hand, slide the bolt head forward into the receiver.



NOTE: Special care should be taken not to contact the comb of the stock with the bolt as damage may occur.

3. Rotate the bolt handle down to place bolt in the fully closed position.

C. Removal of Bolt

1. With the muzzle pointed in a safe direction, place the safety lever in the Safety-OFF (FIRE) Position. Do not allow your finger to come in contact with the trigger.
2. Lift the bolt handle and gently slide the bolt all the way to the rear. Check the ejection port to confirm that the chamber is empty.



NOTE: Every time you close the bolt handle it automatically cocks the firing pin so the rifle can be fired. If the bolt is closed the rifle will be ready to fire unless you manually apply the safety.

3. Find the bolt stop (see photo), a small rectangular button at the left or right rear section of the receiver.
4. While pushing the bolt stop lever down, pull the bolt fully to the rear and clear of the receiver (see photo).

NOTE: Certain rifle stocks with adjustable cheek pieces may require the removal of the cheek piece to allow for enough clearance for bolt removal and installation. Be careful not to contact the comb of the stock with the bolt, as damage to the stock may occur.



D. Loading and Firing the Rifle

1. Be sure that the rifle is pointed in a safe direction.
2. Before attempting to load the rifle, visually inspect to be sure that the barrel is dry and clear of any obstructions.
3. Before attempting to load the rifle, be sure that you have the proper caliber ammunition, including the neck diameter (some chambers specify a "tight neck". Check the caliber and neck diameter of rifle on the barrel just in front of where the barrel and receiver meet. If there is no indication of a special neck, your rifle has a standard neck diameter and the cases will not require neck-turning.
4. Place the safety lever into the Safety-OFF (FIRE) Position.
5. Raise the bolt handle and slide the bolt to the most rearward position.
6. If the rifle is a single shot, place one loaded cartridge on the feed ramp, making sure to keep cartridge aligned with the chamber.
7. To load the rifle, gently slide the bolt forward so that the bolt guides the cartridge into the chamber.
8. When the bolt is fully seated, rotate the bolt handle down.

Loading a BDL Magazine

Picture 1- Shows the first step of loading a BDL magazine rifle. "To load a BDL magazine rifle, like the Atlas Hunting Rifle. First select the correct ammo for your rifle, make sure it matches the caliber stamp on the left side of your rifle's barrel. Insert into action between the feed rails (Photo 1). Then press down firmly until the cartridge is down in the magazine. Repeat these steps 1-3 more times depending on the caliber. Smaller calibers like the .223 can hold 4 rounds in the magazine, whereas a .300 Winchester Magnum can only have 2 cartridges in the magazine. Once the magazine is full, cycle the bolt forward to charge the round into the chamber (Photo 2). USE EXTREME CAUTION! Make sure your rifle is pointed downrange at ANY time, Safety is engaged, and your finger is off the trigger until you are ready to fire the round."



Photo 1



Photo 2

Loading a Detachable Magazine

"To load a Detachable Magazine rifle, like the Atlas Custom Hunting Rifle and Tactical Rifles. First select the correct ammo for your rifle, make sure it matches the caliber stamp on the left side of your rifle's barrel. Insert the cartridge into the magazine by placing the case head in front of the feed rails, push cartridge down and slide back until the case head touches the rear of the magazine. The feed rails in the magazine will be located at the back of the magazine, make sure to load the magazine with the case head into the rear of the magazine. Repeat this step 4 more times for a 5 round magazine or 9 more times for a 10 round magazine. Insert the magazine into the bottom of the rifle, make sure the rear of the magazine is inserted toward the rear of the rifle you should hear a click of the magazine lever. Cycle the bolt forward to charge the round into the chamber. **USE EXTREME CAUTION!** Make sure your rifle is pointed downrange at ANY time, Safety is engaged, and your finger is off the trigger until you are ready to fire the round."



THE RIFLE IS NOW LOADED AND READY TO FIRE!

NOTE: If your rifle is a magazine fed repeater and has remaining rounds in the magazine, recycling the bolt backwards and forwards will cycle another loaded round into the chamber in a controlled manner. In other words, each time you recycle the bolt, the rim of the next cartridge case should slide up into the bolt face as the bolt is moved forward and cartridges picked up out of the magazine. The cartridge will then feed into the chamber.



E. Unloading the Rifle

1. Be sure that the rifle is pointed in a safe direction.
2. Place the safety into the SAFE position (for rifles with a safety).
3. Raise the bolt handle and slide the bolt gently to the rear position with your free hand over the ejection port.
4. Remove cartridge with free hand.
5. Once the first cartridge is removed:

Unloading a BDL Magazine

To unload a BDL magazine rifle, open the bolt and pull back on the handle to unload the round in the chamber (Photo 1). This should be done with the safety engaged! Once the cartridge is unloaded from the chamber, press the button inside the trigger guard to release the floorplate (Photo 2). Make sure your hand is under the floorplate to catch the rounds in the magazine."



Photo 1



Photo 2

Unloading a Detachable Magazine

To unload a Detachable magazine rifle, open the bolt and pull back on the handle to unload the round in the chamber. This should be done with the safety engaged! Once the cartridge is unloaded from the chamber, press the magazine lever forward to release the magazine. Make sure you have your hand on the magazine, so that it does not fall to the ground."



Photo 1



Photo 2

Warning: Visually inspect the magazine and chamber to confirm that there are no remaining cartridges in the rifle.

F. Disassembly of the Bolt

NOTE: Kelbly's Inc, recommends that only the firing pin assembly be disassembled from the bolt. Further disassembly of the bolt is not recommended. If for any reason you cannot re-assemble the bolt, do not use force. Send the parts to Kelbly's Inc.

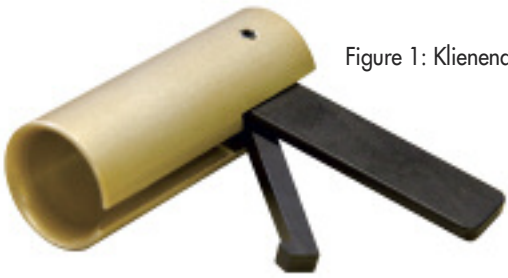


Figure 1: Klienendorst Bolt Disassembly Tool.



NOTE: Kelbly's Inc, recommends that you purchase a Kleinendorst Bolt Disassembly Tool for a Remington model 700, the tools are available from several retail outlets over the internet, and Kelbly's, Inc. sells them as well.

1. Remove the bolt from the action (see instructions – Part C).
2. The tool fits over the bolt shroud and has a steel hook which engages the cocking piece.
3. The cocking piece is pulled backward by rotating the lever.
4. After locking the lever in place, the bolt shroud and firing pin can be easily unscrewed from the bolt.
5. You now have the firing pin assembly ready for inspection, cleaning and maintenance.

Reassembly of the Bolt:

1. To reinstall the bolt shroud and firing pin, screw them back into place.
2. Release the tension on firing pin by rotating the lever back to its original position.
3. With the Kleinendorst tool still in place, rotate the bolt shroud and firing pin until it “fits” into its notch.

G. Removing Barreled Action from Stock

When taking the barreled action out of the stock, the following procedure should be carefully followed to avoid damage to your precision rifle. Some actions may not be removable because of being glued in place.

1. Place the safety in “Safety-ON (SAFE) Position 1”.
2. If there is a detachable magazine, remove it and remove the bolt assembly (see Section C).
3. Remove any takedown screws from the trigger guard and any screws holding the action in place.



G. Removing Barreled Action from Stock (continued)

4. Carefully lift the barreled action from the stock taking particular care to protect the stock around the receiver tang area and recoil lug.
5. To re-install carefully slip the rear of the action until bottomed out then push the front (barrel) down until seated snugly into the stock.

To re-install, make sure the bedding area that encompasses the action is free of dirt and debris. Hold the barreled action straight and square with the bedding, and carefully press the action into the stock. If the barrel action has a recoil-lug, make sure it slides into the bedding area without binding. Simultaneously push the barrel and rear of the action down into the bedding until seated snugly into the stock.

NOTE: The trigger guard must first be removed in order to take the barreled action out of the stock. If for some reason the trigger guard gets stuck in the stock, the best way to remove it is to pull lightly on each end of it, fore and aft, with your fingers.

After reinstalling the barreled action in the stock, be sure to tighten the front (action) screw first, then the rear screw.

H. Trigger

Kelbly rifles are available with different trigger options, Kelbly's, Inc. recommends you see the manufacturer of your trigger for instructions regarding adjustment and maintenance of your trigger. As a general rule, we do not recommend disassembly or adjustment except by a qualified gunsmith or by our factory personnel.

I. Action - Cleaning & Care

Kelbly's, Inc. recommends periodically cleaning the action with a good quality gun cleaning solvent such as Shooters Choice Extreme Clean or other quality gun solvent. Follow Manufacturer's directions then re-oil (very lightly) with Shooters Choice FP-10 or other high quality gun oil. The cocking cam surfaces on the bolt should be kept (lightly) lubricated with EP-2 specification grease.

NOTE: Use oil in moderation, remember more is NOT better. A light coating is all that is needed.



J. Barrel – Cleaning

Before cleaning, always visually inspect the chamber and magazine to assure that no cartridges are in the rifle.

Kelbly's, Inc. recommends:

- The use of a stock boot (cover) when cleaning the barrel.
- The use of a bore guide, such as a Lucas bore guide, sized appropriately for the action and caliber of the rifle.
- The use of a ONE piece cleaning rod (such as a Bore Tech rod, which we sell).
- The ONE piece cleaning rod should have a ball-bearing handle, so it rotates with the rifling as it is pushed and pulled through the bore (such as a Bore Tech rod, which we sell).
- The use of a Bore Tech bore jag.
- The use of cotton/flannel patches.
- Recommended solvents include: Shooter's Choice.

NOTE: Some gun bore solvents are extremely aggressive to metal & wood finishes. Kelbly's, Inc. accepts no responsibility for damaged metal and wood finishes due to misuse of solvents. Remove all solvents from the bore after use by running a dry patch through the bore.

1. Remove bolt assembly (see Section C).
2. Insert the appropriate bore guide for the action and caliber of the rifle.
3. Use correct cleaning rod and patch jag attachment.
4. Run a solvent-wet patch into the bore guide and through the bore, repeat as many times as necessary to soak the bore and loosen carbon fouling – until the patch appears to be removing no more carbon fouling.
5. Change to correct caliber bronze bristle brush.
6. Push the brush completely through the bore until it exits the muzzle. Slow the stroke speed down when exiting the muzzle, and pull the brush gently into the muzzle on the back stroke. Swipe the brush through the barrel for several in-and-out strokes to loosen built-up carbon fouling.
7. Repeat steps 4-6 until the fresh patches come out relatively clean.

SPECIAL NOTE: Always make sure the muzzle-end of the barrel is lower than the action to allow excess solvent to run out the muzzle, rather than back into the action.

8. Push several dry patches through the bore to remove remaining solvent residue, and wipe the muzzle clean of dripping solvent.
9. Wipe exterior metal surfaces with a lightly oiled cloth.
10. If storing for any period of time, lightly oil the inside of the barrel. Remember to always remove any oil from inside the barrel before firing.

K. Care and Cleaning

When storing any firearm, always thoroughly clean and lubricate. Exterior metal surfaces should get a light coat of oil or good quality rust preventative such as Shooters Choice Rust Prevent or equivalent.

Before firing any firearm, be sure to remove all excess lubrication, making sure the chamber and bore of the firearm are clean and free of any oil.

Handling leaves invisible prints of moisture that can cause rust to metal parts. Always wipe receiver and barrel with an oiled cloth after handling. Rust represents neglect.

Abrupt temperature changes cause condensation and moisture; therefore, special care to interior metal parts is needed to prevent rusting. Do not store the rifle overnight in the trunk of a car, even if it is inside a soft gun case. Humid, cool conditions can cause condensation and rust in a short period of time. Long term storage should be done in a dehumidified gun vault or safe.

Insure that a light coating of oil is maintained on the bolt and receiver thus insuring smooth fluid functioning of these two major parts.

Warning: after cleaning the bore, always check to see that no part of the cleaning rod or part of a patch remains inside the barrel as an obstruction.

The synthetic stock on your gun requires very little care. Wipe the stock of your Kelbly rifle with a good quality clean cloth. Using this method will preserve the beauty and durability of your rifle.

Owners of Models with Kelbly Fiberglass/Graphite (carbon fiber) Synthetic Stocks, Wood Stocks and Painted Stocks.

Your synthetic stock should give you years of trouble free performance if you follow a few simple rules.

1. Do not use degreasers, lacquer thinners or aggressive cleaners on your stock. The finish on your stock will not be covered under warranty if damage caused by solvents or aggressive cleaners is evident.
2. To avoid bore solvents from dripping and settling into your stock, drape a towel over the butt-stock, or use a stock boot.



Figure 2: Stock Boot.



L. Dry Firing

Cycling the action - lifting the bolt, cycling it back and forth, rotating it closed, aiming and pulling the trigger of an unloaded gun is known as dry firing. Dry firing can be useful to learn the feel of your new Kelbly rifle. Be certain the rifle is unloaded and pointed in a safe direction when dry firing. Your new Kelbly rifle can be dry fired without damage to the firing pin or other action components although we suggest the use of a snap cap for dry firing.

M. Maintenance

This rifle should be checked periodically by competent gunsmiths to ensure proper function and replacement of any worn or damaged part. This is best performed at the factory by Kelbly trained gunsmiths.

N. Lead Warning

Discharging firearms in poorly ventilated areas, cleaning firearms, or handling ammunition may result in exposure to lead and other chemicals known to cause birth defects, reproductive harm, cancer, and other serious conditions. Have adequate ventilation at all times. Wash your hands thoroughly after exposure.

O. Scope Mounts and Bases

Most Kelbly actions come with an integral scope base – either dovetail or Picatinny. The Atlas action is drilled and tapped for Kelbly one or two piece scope base(s). We recommend that you order Kelbly scope rings to go with your Kelbly rifle. They are machined in perfectly matching pairs, do not need lapping if installed on a Kelbly base, and available directly from Kelbly's, Inc. The Kelbly scope mount bases are available in 0 MOA and 20 MOA (for long range shooting disciplines) in dovetail or Picatinny configurations.

Before ordering scope rings, it is very important to first decide on the scope you want to install on your rifle. This will influence the height of the rings for your rifle. The rings must be tall enough to meet two criteria:

1. The bolt handle must not collide with the ocular (eye bell) of the scope &
2. The front objective must clear the rifle barrel and/or a rear sight.

Most styles of rings come in three different heights. Medium height rings should be adequate for most standard size scopes. Low and high rings are available for special applications.

P. Barrel Changing/Installation Instructions



Before installing a new barrel, apply EP-2 (NCGI Grade 2) or equivalent bearing grease on the barrel threads and shoulder tenon or receiver face. Do not use metallic based "anti-seize" compounds. Using a Kelbly's Inc., barrel vise and action wrench, first insert the barrel into the barrel vise and tighten the nuts on the barrel vise.



Then, using the action wrench, turn the action with a minimum of 100 ft./lbs. of torque. If you do not own a torque wrench, use a T-handle rear entry action wrench and install the barrel with the same amount of torque as one would use on a typical lug nut for an automobile wheel.

Headspace will be within specification when the barrel is installed tightly to the receiver. No witness mark is necessary. Please note that the caliber stamp may not align on the left side of the action after the barrel is installed in the receiver. If you have any further questions about installing your barrel, please contact us via telephone or e-mail.



Q. Kelbly Service Policy

Kelbly's Mfg., Inc. does not recommend and is not responsible for any alteration or modification to the rifle not made by Kelbly personnel, nor the replacement of worn or damaged parts (e.g. barrels) with those not manufactured by Kelbly's, Inc. We reserve the right to refuse to service manufactured or recommended firearms that have been altered, added to or substantially modified.

Every rifle is carefully inspected and tested for function before shipment to insure that is leaving the factory in perfect condition and conforms to our specifications and standards. Should damage occur en route, or if there are any questions regarding its performance, please call, Fax, Email or write and fully describe the problem encountered.

R. Warranty

This limited warranty has been drafted to comply with the Magnuson-Moss Warranty Federal Trade Commission Improvement Act which is effective for goods manufactured on or after December 31, 1995.

Kelbly's, Inc. firearms are warranted to be free from defects in material and workmanship for one year after the date of original purchase. The manufacturer agrees to correct by repair or replacement (with the same or comparable quality model) your firearm, without charge, if returned prepaid with a copy of the bill of sale.

Kelbly's, Inc. assumes no responsibility for product malfunction or for physical injury or property damage resulting in whole or in part from criminal or negligent use of the product, improper or careless handling, unauthorized modifications, use of defective, improper, hand-loaded ammunition, customer abuse or neglect of the product, or other influences beyond Kelbly's, Inc.s control. This warranty does not apply to normal wear of any parts, including metal, wood, fiberglass, plastic, rubber and other materials, surface finish or if unauthorized repair and/or alteration has been performed.

This warranty does not cover repairs related to unreasonable use, corrosion, failure to provide proper maintenance, damaged or shopworn display guns, gun barrels damaged by an obstructed bore or guns damaged in return shipment due to improper packing and handling. Kelbly's, Inc. reserves the right to inspect any product before making any adjustment covered by this warranty.

Under no circumstances shall Kelbly's, Inc. be liable for incidental or consequential damages with respect to economic loss or injury or property damage whether the result of breach of express or implied warranty. This warranty gives only the original purchaser specific legal rights. Other rights may also be available which may vary from state to state. The terms of this warranty cannot be changed except in writing by an officer of Kelbly's, Inc.

S. Instructions for Ordering Parts

Please provide model name, serial number and part name. Supply caliber of gun. You can identify parts from a list, or exploded view. Some parts are made to close dimensions, and may require slight adjustment or fitting to insure proper function of the firearm.

Please note that some parts are marked restricted (such as actions) – these parts can only be ordered and mailed to gunsmiths with FFL's on record.

T. Instructions for Factory Service

Return firearms to Kelbly's, Inc. for factory service only upon authorization by Kelbly customer service personnel. Please package your firearm carefully. We recommend that you ship firearm(s) in their original shipping container with proper cushioning material to prevent movement of gun and/or parts. Hard gun cases are recommended for return shipping. Clearly mark shipping and return address on the outside of the package as well as on an enclosed letter.

Securely attached complete letter to outside of each package returned to the factory. Include also inside the package a copy of the same letter. The contents of the letter must include: your name, complete mailing address, your telephone number, serial number of firearm and a complete description of the problem.

Please do not return gun accessories such as sling straps, quick release swivels, mounts or any other special equipment to the factory with the gun shipment. Identify complete condition of firearm and contents, including any missing or damaged parts.

To avoid delays please do not include part orders with repair instructions. Unless otherwise specified return shipments will be made by FedEx. Before packaging firearms for return to the factory, all ammunition must be removed.

Please send parts orders and repairs directly to:

Kelbly's, Inc.
7222 Dalton Fox Lake Road
North Lawrence, Ohio 44666
Phone (330) 683-4674
Fax (330) 682-7349



Notes:

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Notes:



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Kelbly Custom Actions & Rifles

Dear Kelbly Action/Rifle owner -

Congratulations on your purchase of a new Kelbly rifle. We can confidently state that this rifle is one of the finest custom bolt action rifles in the world.

Breaking world accuracy records since the 1970s, Kelbly rifles integrate many time-tested design features with modern manufacturing technology. Made exclusively at our North Lawrence, Ohio facility for competitive and sporting purposes, this rifle features unparalleled precision, attention to detail and hand craftsmanship not seen in other custom firearms.

Right from the very start of the manufacturing process, our objective has been to produce a precision rifle of reliable quality which will provide a lifetime of satisfaction for the owner and be a worthwhile investment.

Those who will settle only for the very best have no other choice. No other complete rifle manufacturer, regardless of price, can compete with the precision, design, accuracy and dependability of Kelbly rifles.

To assure satisfaction with your new Kelbly rifle we urge you to carefully read these instructions prior to operation or initial firing. Should you have any questions please feel free to contact our customer service representatives at our facility in North Lawrence, Ohio.

Firearms safety is a responsibility we all share. Kelbly's, Inc. urges everyone to use appropriate care and precautions with their firearms. For additional safety information and training, please contact the National Rifle Association, the National Shooting Sports Foundation, and/or your local state rifle and pistol association.

Kelbly's Rifle Range, Inc.
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