# INSTALLATION INSTRUCTIONS
## The MAX Recoil Reducer

Thanks for choosing *Edwards* RECOIL REDUCER®, the world's leader in recoil reduction since 1965. It is recommended that these directions be followed exactly, with no alterations except those discussed below, to achieve maximum satisfaction. Altering this unit by any other means will void the lifetime warranty.

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WOODEN STOCKS

1. Remove recoil pad and measure the depth of the drawbolt hole, and the diameter of the hole.

2. If the hole is less that 7/8 of an inch in diameter, it will need to be drilled or reamed to that diameter, to a depth 1/8 of an inch longer than the unit.

3. Subtract the length of the recoil reducer, plus 1/8 of an inch, from the depth of the drawbolt hole and cut a wooden dowel for the difference. The dowel needs to be at least 13/16$^{th}$ in diameter, but a 7/8s dowel can be used and sanded down to slide into the drawbolt hole.

4. Slide the dowel into the hole first, so that it will be situated between the head of the drawbolt and the front of the recoil reducer.

5. Place the recoil reducer into the hole next, with the threaded hole FACING the recoil pad. If the unit is loose to the point that there is rattling in the hole, remove it and wrap a small amount of electrical tape around the side at both ends. We do not want it to rattle when it is in the hole.

6. Insert the rubber hose washers into the hole between the end of the recoil reducer and the recoil pad. You will have to cut a bit out of the washers so they will fit in the 7/8ths inch hole. If the hole is too deep, just supply some more washers. It may be necessary to sand a taper onto one of the washers so that it has the same pitch as the back of the stock. If possible, allow the washers to protrude from the hole about 1/32$^{nd}$ of an inch or so. They will squeeze down when you add the recoil pad, further insuring a tight fit. Reinstall the recoil pad and you are finished.

7. If no drawbolt hole is present, drill a 7/8" diameter hole 5-1/8" deep and parallel to the comb. Install the reducer with the threaded hole facing the recoil pad, and fit the washers as in step 6 (above).

SYNTHETIC STOCKS

1. Remove the recoil pad or butt plate from the stock. In some cases the pad has been glued as well as screwed and the pad can be separated by inserting a butter knife or flat object between the surfaces and gently prying the pad off.

2. Scrub interior of stock with a detergent solution. Saturate a piece of cloth with isopropyl alcohol and vigorously scrub the inside of the cavity to remove all mold release agent. Allow the solvent to dry. Repeat. NOTE: This is the most important step in the process! Failure to remove all the mold release agent inside the cavity will result in an improper bond with the glue (Step 5) and spray foam (Step 7) and these products will fail to adhere.

3. Roughen the insides of the stock with a rasp to give the surface "tooth" to hold the glue and foam in place.

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4. Coat a 10x32 screw with petroleum jelly, and insert screw into the vent hole on the end of the unit.

5. Epoxy the unit in place at the top of the cavity with the front of the unit "wedged" between the taper of the comb. Ensure that the reducer is set deeper in the hole that the depression of the recoil pad. Allow the epoxy to cure.

6. Wrap masking tape around the gun stock's exterior, making certain all of the composite material is covered. Coat the end of the stock (where the recoil pad/butt plate attaches) and the sides covered with masking tape with petroleum jelly. Do not forget to force the petroleum jelly into the screw holes for the recoil pad/butt plate and if there is a drawbolt present, coat that also.

7. Following the manufacturer's directions on the label, fill the cavity with flexible foam. Use a NEW can! Allow the spray foam to cure, as directed, then remove the 10x32 screw from the vent hole in the MAX.

8. Clean the petroleum jelly from the gunstock, remove masking tape, trim the foam, if necessary, and install pad.

NOTE: For a more permanent installation, or when installing a double unit, we recommend the use of fiberglass in the cavity following the same preparation procedures, but using appropriately sized wooden dowels coated with petroleum jelly to cast the holes in the fiberglass.

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