

# TAC21 Installation for Savage Short Action

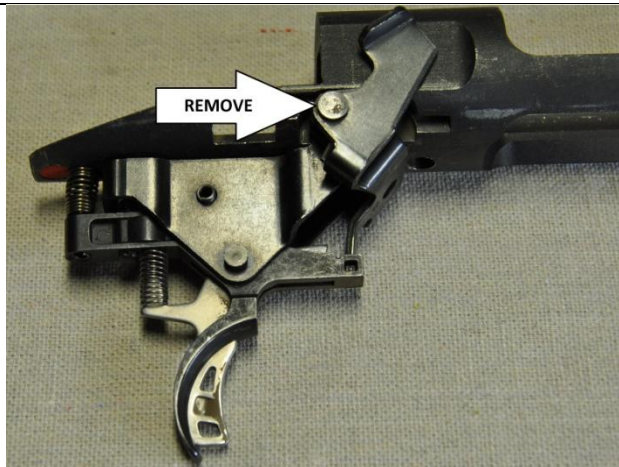
Before starting make sure that your rifle is unloaded and safe. Always point rifle in a safe direction.  
Read all instructions before starting installation.

## Tools required (Not included):

1/8" Allen wrench, 5/32" and 3/16" torque Allen wrench, small hammer, tweezers.

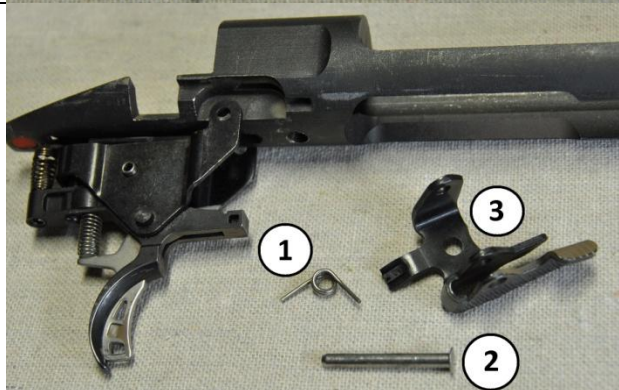
1. Remove bolt from action.
2. Remove barreled action from original stock.

3. With a 1/8" drift punch and a small hammer, drift out the sear pin. You can now remove the bolt stop lever from the action.

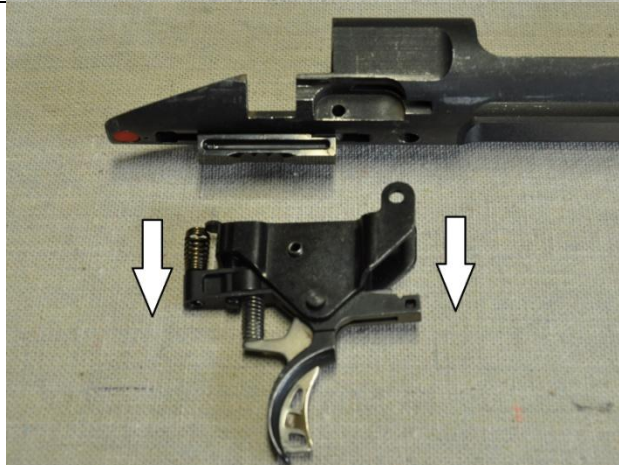


4.

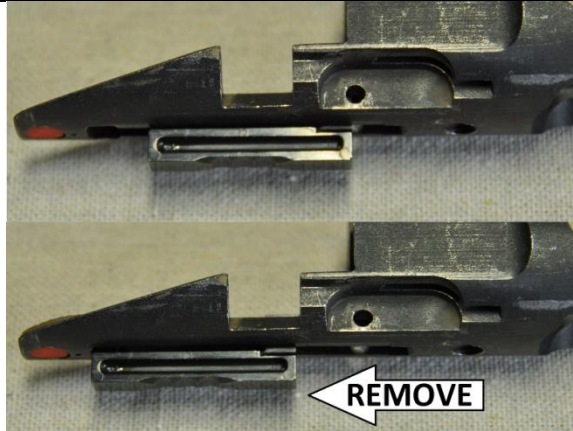
- (1) Sear spring.
- (2) Sear pin.
- (3) Bolt Stop Lever / Sear



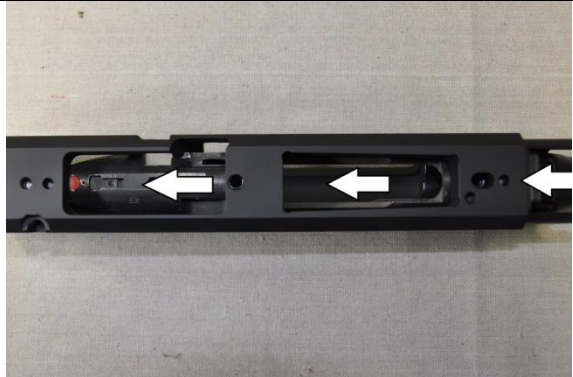
5. Remove the trigger assembly.



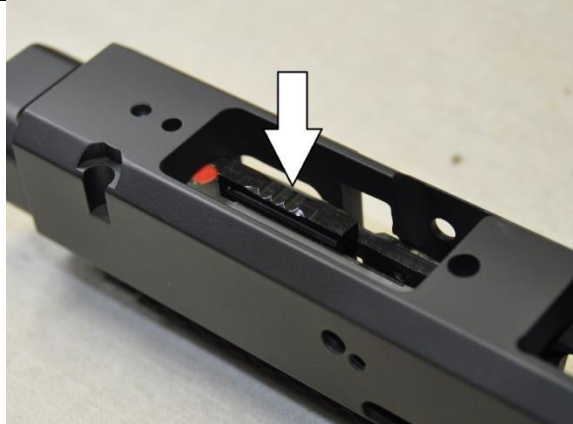
**6.** Slide the safety bar all the way to the rear of the action and remove it. You do not need to remove the upper safety tab.



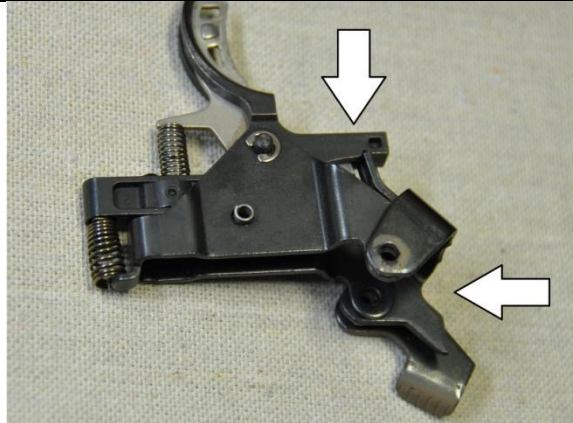
**7.** Slide the barreled action in until the recoil lug is flush with the main housing.



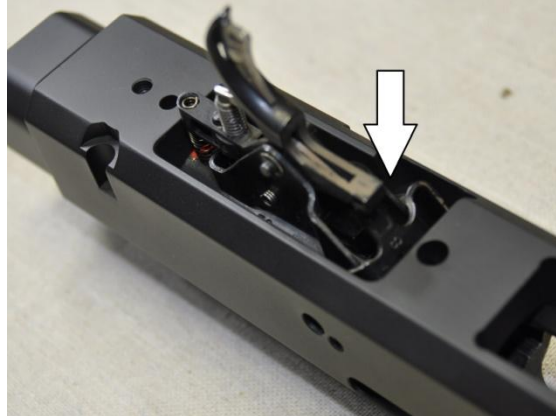
**8.** Reinstall the safety bar and slide it forward, make sure that it's connected to the upper safety tab.



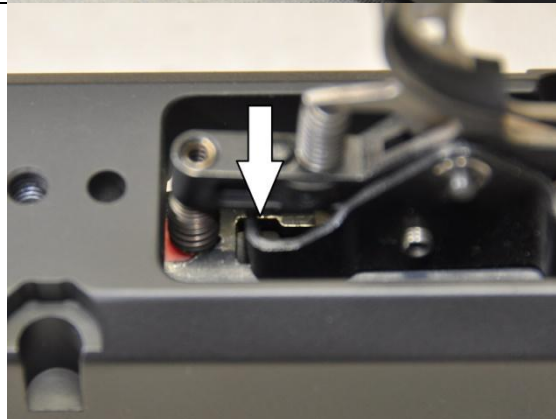
**9.** Connect the trigger housing and bolt stop lever before inserting them into the action housing. This will make the insertion easier to accomplish.



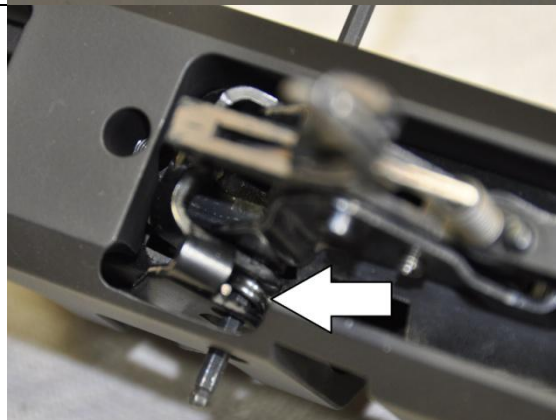
**10.** Insert the trigger housing & bolt stop lever into the main housing.



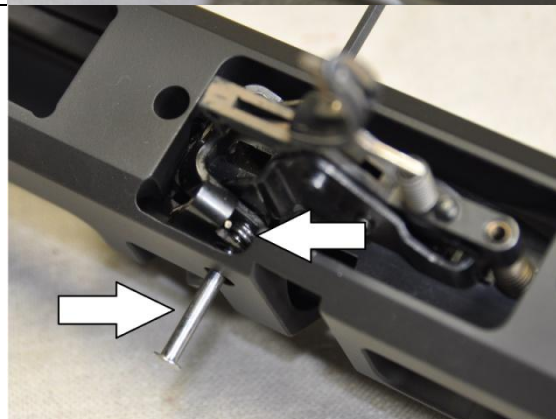
**11.** Make sure the rear of the trigger is hooked into the action and that the trigger spring is sitting flat.



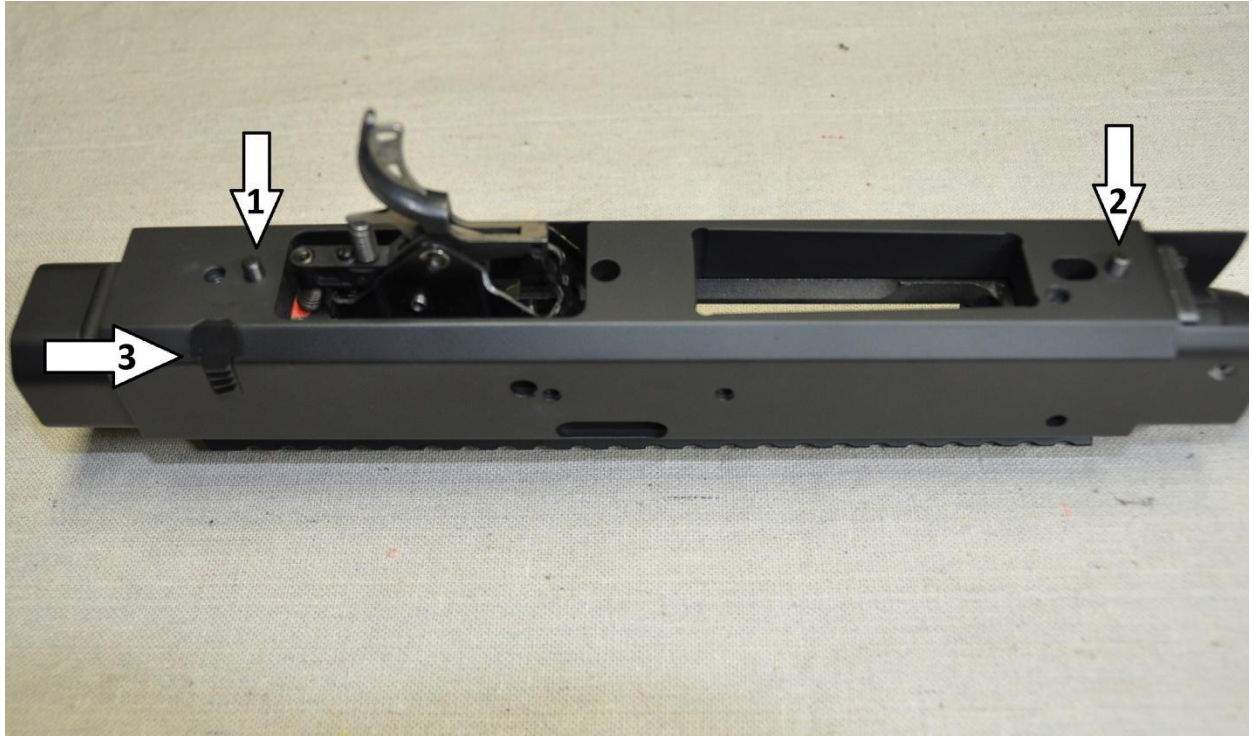
**12.** Using a small screwdriver or allen wrench, align the holes between the main housing, the action and the trigger assembly. Place the sear spring with tweezers and apply gentle pressure, capture the spring and keep it in place as shown.



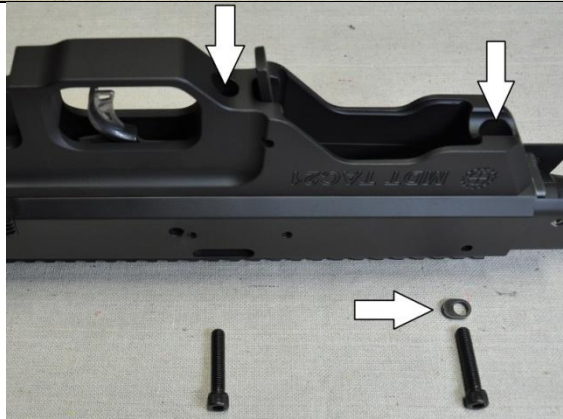
**13.** Reinstall the sear pin by using it to push out the tool used in the previous step. Make sure to capture the sear pin in the process.



- 14.** (1) Install 3/16 x 1/2 dowel pins into main housing as shown.  
(2) Install 3/16 x 1/2 dowel pins into main housing as shown.  
(3) Install lever lock insert on the side of the main housing.



- 15.** Fit trigger housing onto main housing by way of dowel pins. First, install the rear screw, then check the position of the front screw and insert the offset washer accordingly. Install the front screw. Torque to 65 inch/lbs.



- 16.** Fit fore-end to main housing. Install the 3 10-32 countersunk screws to secure fore-end to main housing. Torque to 15 inch/lbs.

Note: The screw holes are slightly off-set on purpose. This results in a tighter fit between the components.



17. Install pistol grip using provided 1/4-28 bolt.
18. Reinsert bolt. Ensure the firearm is not loaded.
19. Attach buffer tube to end cap and install desired butt-stock.



20. Attach end-cap to main housing and lock in place using end-cap lever.



21. Conduct function test. Check that bolt moves freely and safety is functioning properly.



22. Congratulations, you have successfully assembled the TAC21 Chassis for the Savage Short Action!

Enjoy!