

# INSTALLATION INSTRUCTIONS

## Synthetic Stock 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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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 similar flat object between the surfaces and gently prying the pad off. Do not use force or the composite material of the stock may be nicked.
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 mold release agent inside the cavity will result in an improper bond with the spray foam (Step 11) and the foam will fail to adhere.)
3. Roughen the insides of the stock with a file or rasp to give the smooth surface "tooth" to hold the foam in place.
4. Observe the cavity in the stock. If there is a drawbolt in the bottom, or if you are installing a double recoil reducer system, cut a piece of 7/8" rigid plastic tubing, or wooden dowel long enough to cover the head of the drawbolt and allow it to protrude from the rear of the stock.
5. Measure the depth of the cavity at the top of the stock (comb) and record this depth.
6. Since the cavity in the composite stock tapers to a smaller diameter as it approaches the receiver, it is necessary to taper the sides of a 1" piece of wooden dowel so it will fit snugly in the front of the cavity, at the top (comb) of the stock. The reducer must be seated against a firm base, or the unit will come apart. The firm base in this application will be the rear end of this 1" piece of wooden dowel.
7. Transfer the depth measurement from Step 5 to the length of 1" wooden dowel, then subtract the length of the recoil reducer PLUS 1/8" (i.e. 3 5/8" for a 3 1/2" unit). Mark this measurement on the wooden dowel. **Do not cut the dowel at this time.** Ideally, there should be a minimum of 3/4" of wooden dowel to fit into the front of the cavity.
8. Wrap masking tape around the gun stock's exterior, making certain all of the composite material is covered.
9. Coat the end of the stock (where the recoil pad/butt plate attach) 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.

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10. Coat the uncut 1" and 7/8" wooden dowel/rigid tubing with petroleum jelly and insert them into position in the cavity. Don't forget to coat the front end of the wooden dowels/tubing! The smaller diameter dowel should be parallel to the 1" dowel, but remember, it must be positioned to allow access to the draw bolt.
11. Following the manufacturer's directions on the label, fill the cavity with flexible foam. We recommend using Great Stuff™ Manufactured by Dow Chemical as it cures the best and provides firm bedding. (NOTE: Use a NEW can!)
12. Allow the spray foam to cure, as directed.
13. Remove the two wooden dowels/rigid tubing. There should be a 7/8" diameter hole to the drawbolt, and a 1" hole at least 3/4" longer than the length of the reducer to be installed.
14. Clean the petroleum jelly from the wooden dowels, gun stock, etc. and remove masking tape.
15. Cut the tapered 1" wooden dowel to the mark made in Step 7 (above).
16. Insert the wooden dowel into 1" hole and seat with several **light** taps with a hammer.
17. Follow the installation instructions for the adjustable Edwards RECOIL REDUCER® included with the unit.
18. If installing the non-adjustable unit in the 7/8" hole, follow the directions provided with the nonadjustable Edwards Recoil Reducer.
19. If the recoil pad furnished with the stock has nubs to keep the stock from collapsing, they may need to be cut off to allow the pad to re-seat against the stock. The foam and reducers you have installed should keep the stock from collapsing inward.

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