



PRODUCT

INSTALLATION GUIDE

Vepr Strikeforce Elite Stock with Scorpion Recoil System

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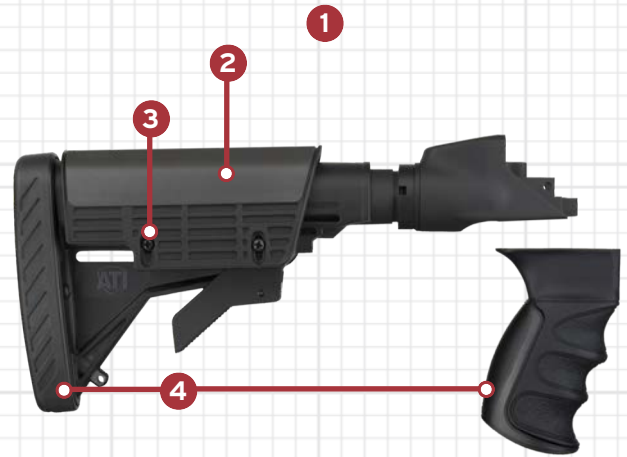
Contents Included

Six Position Adjustable Stock

**3M Industrial Grade Self Adhesive Soft Touch
Cheekrest**

Removable and Adjustable Cheekrest

Scorpion Recoil System







Installed on Firearm








VEPR Strikeforce Elite Stock with Scorpion Recoil System

Hardware Included

- | | |
|---|--|
|  [1] M6 x 1 x 25mm Socket Head Cap Bolt |  [2] 8 x48-2 x 1/2" Torx Pan Head Screw |
| [2] 6 x 48/2 x 1/2" Plastite Screws | [2] 8-32 x 1/4" Set Screw |
| [1] M4 x 0.7mm x 12mm Torx Head Screw |  [1] M6 Lock Washer |
| [4] 6 x 48/2 x 3/8" Flat head Phillips Screw |  [4] 6-32 Hex Nut |
| [4] 6-32 x 3/8" Machine Screws | |

Tools Needed

-  Phillips Head Screwdriver
-  Torx Set
-  Wrench Set



Warning: When handling a firearm, always follow the proper handling procedures at all times. Failure to follow these procedures could result in serious damage, injury, or death. ATI is not responsible for damage to property, injury, or death resulting from improper installation, misuse or modification of products. If you are not comfortable completing any of the following steps, or do not have the proper tools enlist the help of your local gunsmith. ATI is not responsible for components that are damaged due to improper installation.

A

Stock Removal

!

Point the rifle in a safe direction and place the safety in the "on" position. Next remove the magazine, pull back, and carefully inspect the chamber to be sure the rifle is unloaded.

1

Begin by depressing the receiver cover latch button as seen in Figure 1A and removing the receiver cover as seen in Figure 1B.



1A



1B



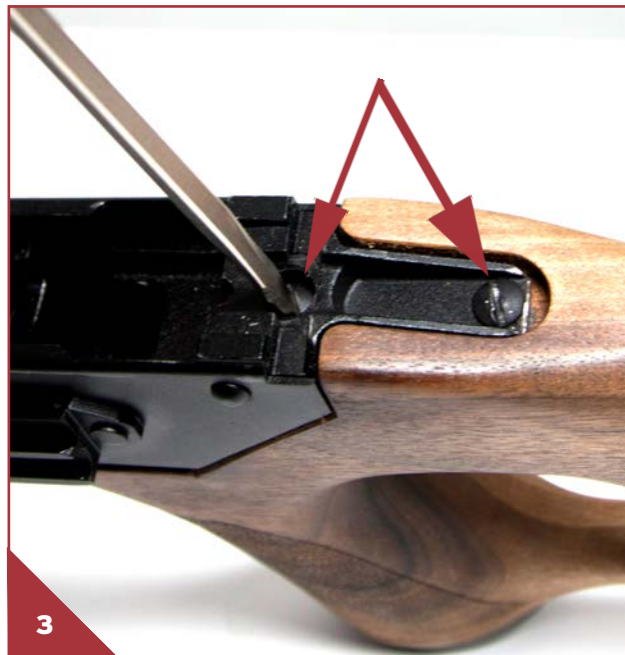
VEPR Strikeforce Elite Stock with Scorpion Recoil System

A Stock Removal -Continued

- 2 Next, depress the recoil spring and remove it from the receiver as seen in Figure 2.



- 3 Remove the two wood screws from the receiver tang with a flat head screwdriver as seen in Figure 3.



- 4 Next, remove the screw from the thumbhole stock cap with a flat head screwdriver as seen in Figure 4A and remove the cap as seen in Figure 4B.





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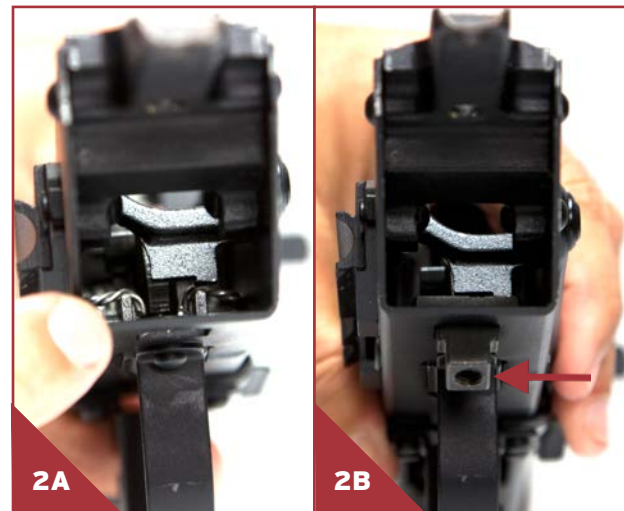
B

Stock Installation

- 1 Remove the pistol grip screw with a flat head screwdriver as seen in Figure 1A and slide the thumbhole stock off of the receiver as seen in Figure 1B.



- 2 Next, Remove the existing T-nut as seen in Figure 2A and install the ATI T-nut through the rear of the receiver with the T-nut facing the rear as seen in Figure 2B.



- 3 Insert the M6 x 1 x 25mm Socket Cap Screw into the grip housing as seen in Figure 3A and fasten it into the T-nut w/ a 6mm Allen wrench as seen in Figure 3B.





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B Stock Installation -Continued

- 4 Slide the ATI Scorpion Grip into the grip housing as seen in Figure 4A and fasten with (2) 6 x 48/2 x 1/2 plastite screws using a phillips head screwdriver as seen in Figure 4B.



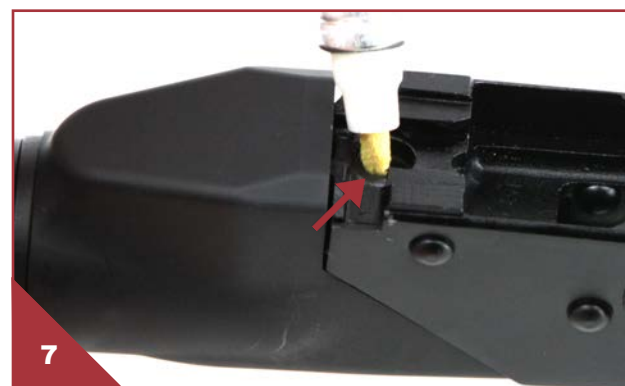
- 5 Remove the VEPR Elite Mount from the buffer tube by using a AR-15 wrench as seen in Figure 5A. Once the lock nut is loose and threaded back about 1/2", slide back the locking ring so the tab is no longer engaged into the elite mount. You can now unscrew the mount from the buffer tube as seen in Figure 5B.



- 6 Place the new ATI Elite Mount and buffer tube into the receiver of the VEPR as seen in Figure 6.



- 7 Next, use a paint pen to mark a circle onto the mount by placing the pen through the existing hole in the receiver as seen in Figure 7. Make sure the mount is held tight and flush to the receiver when making your mark..





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B Stock Installation -Continued

- 8 Once you have the mount marked, clamp the housing securely in position on the drill press as seen in Figure 8.



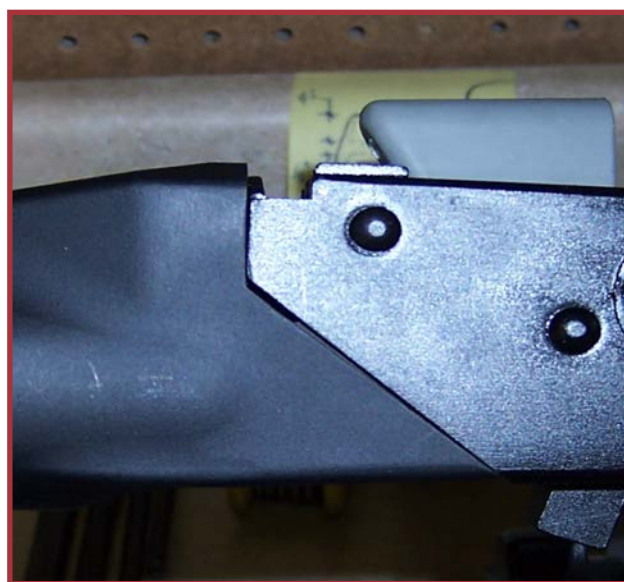
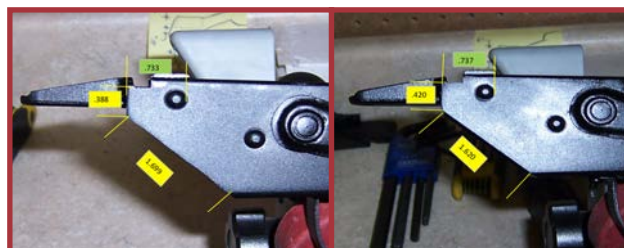
NOTE: ATI has included a drill bit and tap to help mitigate any variances between the VEPR receiver and the ATI receiver mount. By allowing the end user to fit the mount to their specific receiver before drilling and tapping the mounting hole, it insures the most desirable fit.

Pictured are (2) different VEPR receivers of the same caliber. There are variations in certain locations which can prevent a precise fit between the receiver and the receiver mount.

Due to variations in the manufacturing of the VEPR receiver and the varying locations of the receiver mounting hole, a small gap may still be present between the mount and the receiver.

We apologize for any inconvenience, however ATI is not responsible for any fit issues on a receiver with fluctuating dimensions.

If you have any questions, please contact us at 800.925.2522.





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B Stock Installation -Continued

- 9 Next, double check positioning for squareness. Using a level, check to ensure the mount is fixed in a level position as seen in Figure 9.

NOTE: If you are not comfortable with using a drill press to complete these steps, enlist the help of your local gunsmith. ATI is not responsible for components that are damaged due to improper drilling and tapping methods.



- 10 With the mount still clamped, use the supplied 3.3mm drill bit and drill slowly (to a 1/2" depth) so as not to burr the inside of the hole as seen in Figure 10. (It is recommended to use cutting oil during the drilling process.)





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B Stock Installation -Continued

- 11 Next, with the mount still clamped, use the supplied M4 X 0.7mm tap (and cutting oil), to tap the mount as seen in Figure 11.

NOTE: To ensure you do not ruin the mount when backing the tap out of the mount, it is necessary to use a drill press with a clutch.



- 12 Without unclamping, clean the tapped hole area and securely screw in the supplied M4 x 0.7mm x 12mm screw to ensure the threads were cut correctly as seen in Figure 12.

- ! Remove the mount and clean it, removing any burr(s) from the tapped holes.





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B Stock Installation -Continued

- 13 Locate the buffer tube and castle nut. Thread the castle nut onto the buffer tube, make sure the teeth of the castle nut are facing towards the rear of the buffer tube as seen in Figure 13.



- 14 Locate the locking channel on the buffer tube. Install the new lock ring by sliding it onto the buffer tube with the lock side facing outward. Push the lock ring to the rear of the buffer tube against the castle nut as seen in Figure 14.



- 15 Install the Elite Mount by screwing it onto the buffer tube. Now carefully align the Elite Mount slot with the locking ring as seen in Figure 15.



- 16 Once the Elite Mount has been screwed down and aligned correctly with the locking ring, insert the locking ring into the slot on the Elite Mount as seen in Figure 16 (Shown with arrow). Now, tighten the castle nut until it is snug against the lock ring and Elite Mount using a AR-15 wrench.



- 17 Slide the VEPR Elite Stock and Mount into the rear of receiver as seen in Figure 17A and install the M4 x 0.7mm x 12mm screw with a T20 Torx Driver as seen in Figure 17B.



- 18 You can now reinstall the receiver spring and receiver cover completing the installation of your ATI stock as seen in Figure 18.





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C

Cheekrest Installation

- 1 Place the 6-32 Nuts into the nut pockets on the inside of the cheekrest rails as seen in Figure 1.



- 2 Attach the right cheekrest rail onto the right side of the buttstock using the #6 x 48/2 3/8" flat head screws provided as seen in Figure 2. Repeat the same process on the left side of the buttstock.

NOTE: Make sure that the nuts inside the rail do not fall out while installing the rail onto the buttstock.



- 3 Slide the cheekrest onto the cheekrest rails and slide toward the rear of the stock as seen in Figure 3.





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C Cheekrest Installation -Continued

- Line up the slots in the cheekrest with the holes in the cheekrest rails. Use the 6-32 x 3/8" pan head screws provided to attach the cheekrest to the rails by securing the screws into the 6-32 nuts that were installed in the cheekrest rails in step # 2 as seen in Figure 4.



D Cheekrest Pad Installation

- Begin by using the supplied alcohol swab to clean the cheekrest area on both sides of the stock as seen in Figure 1.



- Wait 30 minutes until the alcohol is dried. Remove the backing from the adhesive side of the pad as seen in Figure 2.





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D

Cheekrest Pad Installation -Continued

- 3 Place the adhesive pad on the top of the cheekrest, aligning the center of the pad with the cheekrest parting line as seen in Figure 3.



- 4 Use your thumb to remove any air bubbles in the pad and to firmly press and secure the adhesive pad onto the cheekrest as seen in Figure 4.

