

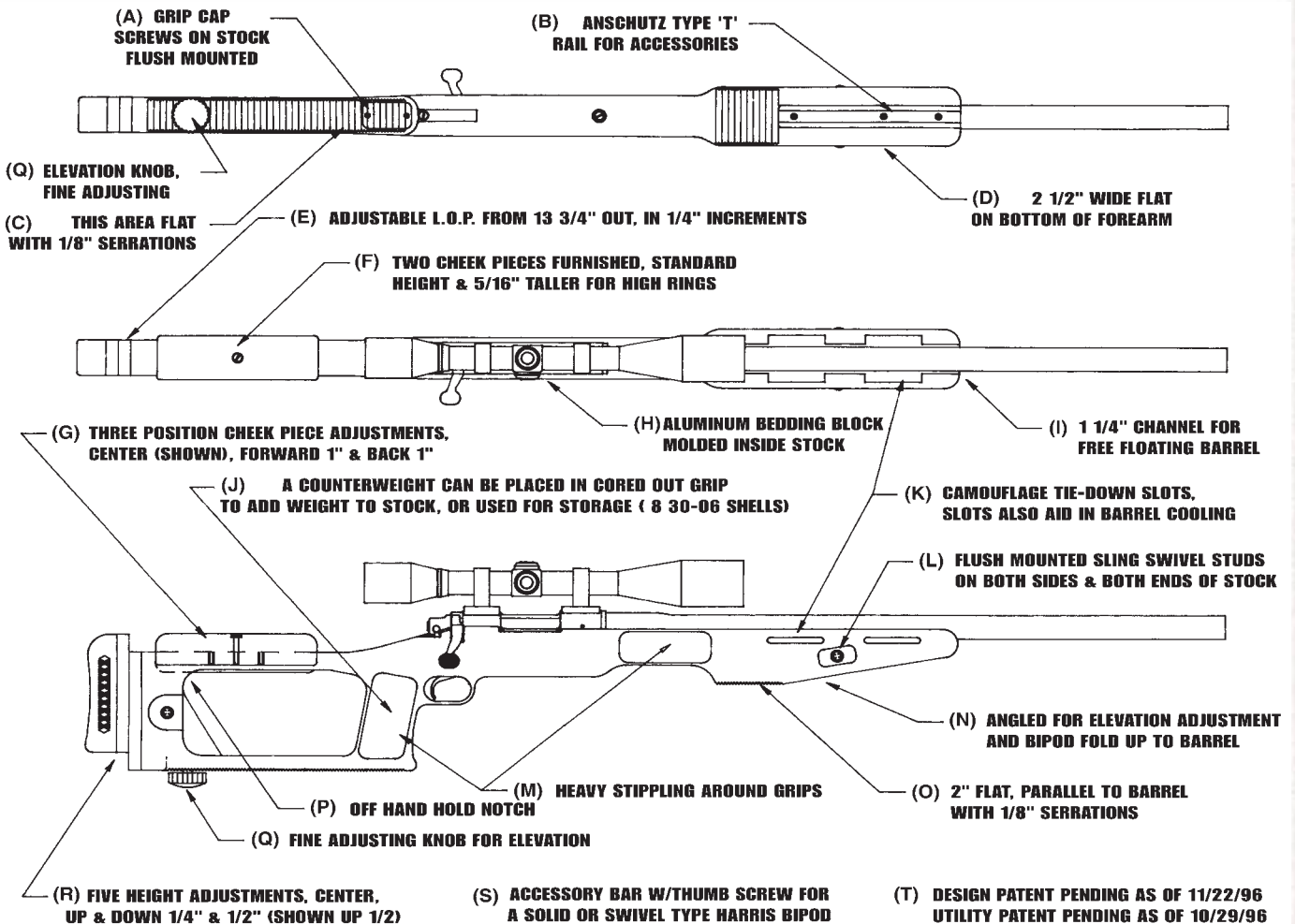
# THE ULTIMATE TARGET AND SNIPER STOCK



**DESIGNED & ENDORSED BY  
JOHN PLASTER**

\* Design Patent Pending  
\* Utility Patent Pending

Remington 700 Short Action	22-01-09
Remington 700 Long Action	22-01-11
Remington 700 Short Left	22-01-13
Remington 700 Long Left	22-01-15
Savage Short Action	22-06-05
Savage Long Action	22-06-01
Savage Short Action Left	22-06-07
Savage Long Action Left	22-06-03
Winchester 70 Short Action	22-03-03
Winchester 70 Long Action	22-03-01



## FEATURES

(A) The grip cap covers a storage area in the stock. For some snipers, the weight of the rifle is not a factor. And in some cases extra weight is wanted. If you need more weight to your stock you may pour the cored out area full of lead shot and screw the cap back on. It is also possible to put basic (pull through) cleaning kit in this area. We also noticed that eight 30-06 rounds will fit in the grip for emergency ammo.

(B) This "T" rail allows many accessories to be placed on your rifle. We furnish a solid steel "T" bar with a detachable sling swivel stud installed. This is for the mounting of a Harris bipod. Many other accessories may be mounted on this bar. The "T" bar has a quick detach thumb screw. Some snipers will want two bipods mounted, short for prone and tall for sitting position. Additional "T" bars are available at a nominal cost. Also any accessory that fits a Anschutz rifle will also fit this "T" rail.

(C) This area is flat to stabilize the rifle when shooting from a rest. It is 1 1/2" wide and heavily serrated. The elevation fine adjusting knob (Q) can be removed, leaving a 3/8 threaded hole and the stock totally flat on bottom.

(D) The forend is 2 3/8" wide to also assist in holding the rifle in a stable shooting position.

(E) The length of pull can be adjusted from 13 1/4" out. The stock comes with one 1/2" adjusting spacer. Additional spacers are available at a nominal cost. They come in 1/4, 1/2 and 3/4 inch in thickness. You will also get a set of longer screws when you order additional spacers. (note: we designed the stock, starting short, to fit the law enforcement snipers that must wear thick body armor.)

(F) The stock is furnished with two cheek pieces. The standard height is for low scope rings. The tall cheek piece is for the big lens scopes that require the tall rings.

(G) The position of the cheek piece is adjustable. There are three positions to accommodate all shooters. Also the cheek piece can be turned around for the left hand shooters.

(H) The bedding block is the most important part of the stock. The receiver of the rifle only touches the stock/bedding block in four places, both sides of the "V" in front and in back. The pillar blocks allow a 55/65 inch lbs. torque on the receiver screws which is not possible with wood or most synthetic stocks. The CNC machined bedding block in molded inside the stock, not fiberglassed in after the stock is made.

(I) The barrel channel is large enough to free float a 1 1/4" diameter bull barrel.

(J) See feature (A)

(K) The four slots are for the attaching of camo material. Most sniper experts agree that it adversely effects accuracy to attach camo to a barrel and there are no accommodations on most stocks for camo material. We haven't done any testing but common sense would tell you that the slots would also help dissipate barrel heat.

(L) These side mounted sling swivel studs go through a cored hole in the stock. In "from rest" shooting, the conventional bottom mounted sling studs get in the way and are usually removed. Major Plaster explained to us, during the design phase of this stock, that a sniper crawling on his belly carries his rifle on top of his upper arm and/or across his back while holding the sling in his hand. A side mounted sling is perfect for this application.

(M) The stippling in the grip areas is unusually aggressive and rough to the touch. Major Plaster wanted it that way. Some shooters wear gloves and the rough texture is needed. If you want a smoother grip surface, sand the areas until the desired feel is found. The stock is about 1/4" thick in this area so don't worry about sanding the texture down. Also please notice that the front grip area is narrowed. It is this narrowed size to accommodate a one hand carry of the rifle. Major Plaster complained that most sniper/tactical stocks are very fat in this area and very difficult to carry one handed (suit case style) at the balance point. We fixed the problem.

(N) This section of the forearm had a pronounced angle for two reasons. When the bipod is folded up it doesn't leave a 2" gap between it and the barrel. The bipod feet are very near the barrel and will catch fewer limbs and twigs when crawling prone. The second reason for the angle is for quick elevation adjustment of the barrel when the forend is resting on a support. When you push the stock forward the barrel goes up. When you pull the stock back the barrel elevation is lowered. This is so simple that no one seems to have thought of it before or didn't think it was important enough to include on a stock.

(O) This flat surface, parallel to the barrel, is for the shooters that have/use sandbags. We are told that real snipers wait and watch much more than shoot. It is helpful if the rifle doesn't fall over every time you take your hands off the rifle. This area has heavy, 1/8", serrations as on the bottom of the butt area.

(P) This off hand holding notch has been on machine guns since before World War II. The advantage of this feature in a sniper stock is that you can now hold your butt stock on your shoulder with your off hand. This allows the trigger hand to relax and concentrate only on the trigger pull. This off hand hold has been proven to be beneficial over the years. It is a feature that the expensive, labor intensive, hand laid fiberglass stock makers find very difficult to incorporate into their design.

(Q) This is a fine adjusting screw for elevation. The bench rest shooters and prairie dog hunters will really like this feature. Consider this, a one degree turn on this elevation screw will raise or lower the stock only .00017 of an inch. This is truly fine adjusting. This screw has about 2" of engagement and can be removed with ease when not needed. It is very easy to adjust with the thumb and index finger on either side of the stock. We have found, in the prototype stage of design, that the coarse adjustments can be made with the bipod legs and the 'spot-on' adjustment done with the screw.

(R) The rubber recoil pad has five height settings possible. The center setting lines up with the stock and there is two 1/4" positions up and two down. One of these five positions will surely meet your needs.

(S) The bipod "T" bar, mentioned in (B) is made from solid steel and is about 5" long and it will fit the swivel type or solid bipod. There are many different uses and applications for this accessory other than a bipod. If you have a need for a special accessory, your local gunsmith won't have any trouble duplicating the dimensions.

(T) We, Major John Plaster and Choate Machine & Tool, Inc., have a design patent pending as of 11/22/96 and a Utility patent pending as of 10/29/96.

There are some points of interest not mentioned above that we will mention here. The ULTIMATE SNIPER stock has our usual LIFE TIME WARRANTY. The stock is made of DuPont Rynite SST-35. It is one of the most expensive polymers and the most suitable for gun stocks if weight is not a consideration. We mold the stock in dark O.D. green color. Rynite takes paint very well so you can paint your stock with almost any automotive spray can paint. The available duck boat camo paint works very well. The rubber recoil pad is a little on the stiff side because it is much more durable at this durometer than a cushy pad, with a 3/4" compression, can allow a shooter to get a scope eye piece hit in the eyebrow. Hell, you could lose your scopes ZERO on a deal like that.

We predict that this stock will be a benchmark for sniper rifle stocks in the future. We have features that the hand laid fiberglass/kevlar stock makers cannot incorporate into their stocks. What we have done is eliminate most of the expensive hand labor and passed the savings on to you. We are keeping the price down so that most rifle owners can afford a stock. We realized the only way for this stock to sell enough to pay off the expensive tooling cost was to get the price low enough so the average guy can buy one. There aren't enough real snipers, military and police, to support this project if every one of them bought a stock. We think that there will be many deer rifles installed in this stock. Most shooters know what free floating the barrel and a bedding block does for a rifle, it closes the group to about 1/2 it's normal group.

We showed this stock for the first time at the 1997 SHOT show. We have never had a product that generated so much interest and excitement. Every dealer and distributor that saw it wanted to stock it. Major John Plaster did an outstanding job on this stock design and he gets full and total credit for it. We would like to mention his book THE ULTIMATE SNIPER. It is everything you ever wanted to know about sniper rifles and sniping. He has also produced two Videos on sniping that go into great visual detail on sniping and the equipment. His latest book is about this three tours in Viet Nam with the Special Forces. The book title is S.O.G. You can purchase these books and videos from Delta Group. Their order number is 1-800-852-4445. For information concerning stocks call us at 1-800-972-6390.



## ADDITIONAL INFORMATION

Our Ultimate Sniper and Ultimate Varmint Stocks have our usual lifetime warranty. They are made out of 20% fiberglass filled polymer. If you break your stock, send it back, we want to see it. Plus you will get a new one, free.

Major John Plaster, the stock designer, has done his usual fantastic job in design. His work has made him a legend in his own lifetime. We hope you will agree with us and realize that this stock is a run-away good deal. As far as we know we are the only company that offers a inject molded varmint stock. The only alternative to our stock is wood or the very expensive hand laid fiberglass stocks that are foam filled. What we have done is invest in very expensive, complicated and high tech tooling that eliminates all of the expensive hand labor. We pass the saving on to you. It's simply 21st. Century technology saving you money. We will attempt to answer some of the most asked questions in advance. Some are brand specific and may not apply to your rifle.

### **Q. "How much does the stocks weigh?"**

A. The Varmint weighs about 4 pounds and the Sniper weighs 6 pounds. Additional weight can be added in the grip area, inside the butt and the barrel channel. Epoxy and lead shot make a good weight and you can dig it out if you change your mind.

### **Q. "What is the difference between the Remington ADL & the BDL rifles?"**

A. The BDL, their deluxe rifle, has a hinged floor plate assembly. This allows you to remove ammunition through the bottom of your rifle. The ADL has a trigger guard only with out the hinged floor plate. The magazine well on the ADL is blind bottom & does not open to the bottom side of the rifle. All of the rifle manufacturers make a less expensive model with a blind bottom magazine well. Our stock also has a blind bottom magazine well. This way we can make a stock for both models without doubling our inventory. If you can't live without a hinged floor plate your local gunsmith will be glad to custom fit one to your stock just like installing it in a wooden stock. But don't ask us, we don't do custom work.

### **Q. "How do you install the shell follower & spring in the new stock?"**

A. Place it in the new stocks molded-in magazine well and set the rifle on top. Make sure it moves freely before you tighten and torque the screws down.

### **Q. "Will we ever make this stock for the Mauser or Ruger Mod. 77?"**

A. We are planning to make one for the Mauser 98 and Yugo 48 as well as the Ruger 77 rifles. We hope to release these models in middle to late 2006.

*Here are some dimensions that might help you identify your receiver length. These are the distances between the two receiver screws.*

Remington	short action	6.500	/	long action	7.350
Winchester	short action	7.031	/	long action	7.570
Savage	short action	4.275	/	long action	5.062

### **Q. "Do you make or plan to make; a stock for the Savage series 'J' rifle made between 1978 & 1985 that has a bolt spread of 4.500; the pre-64 Winchesters / the Winchesters left hand rifles / the Winchester, Savage & Remington long action detachable magazine rifles?"**

A. No, sorry, the demand is not great enough to justify the tooling expense or to add more models to our inventory. Example, some nice gentleman wanted a varmint stock for his WWI French Label. We have had two inquiries about a stock for the Lee Enfield that have the two piece stock. Give us a break guys. There are some things that just can't happen.

### **Q. "Can I put my BDL or ADL rifle in to one of the Detachable magazine stocks so I can use detachable magazines?"**

A. No, the feed lips on the BDL and ADL rifles are cut into the bottom of the action and the feed lips on the detachable mag. rifles are in the magazine itself.

*\*All stocks comes with 2 screws. The short bolt is attached on the front of the action and the longer bolt is used in the back of the action, close to the grip. Always tighten the front bolt first.*