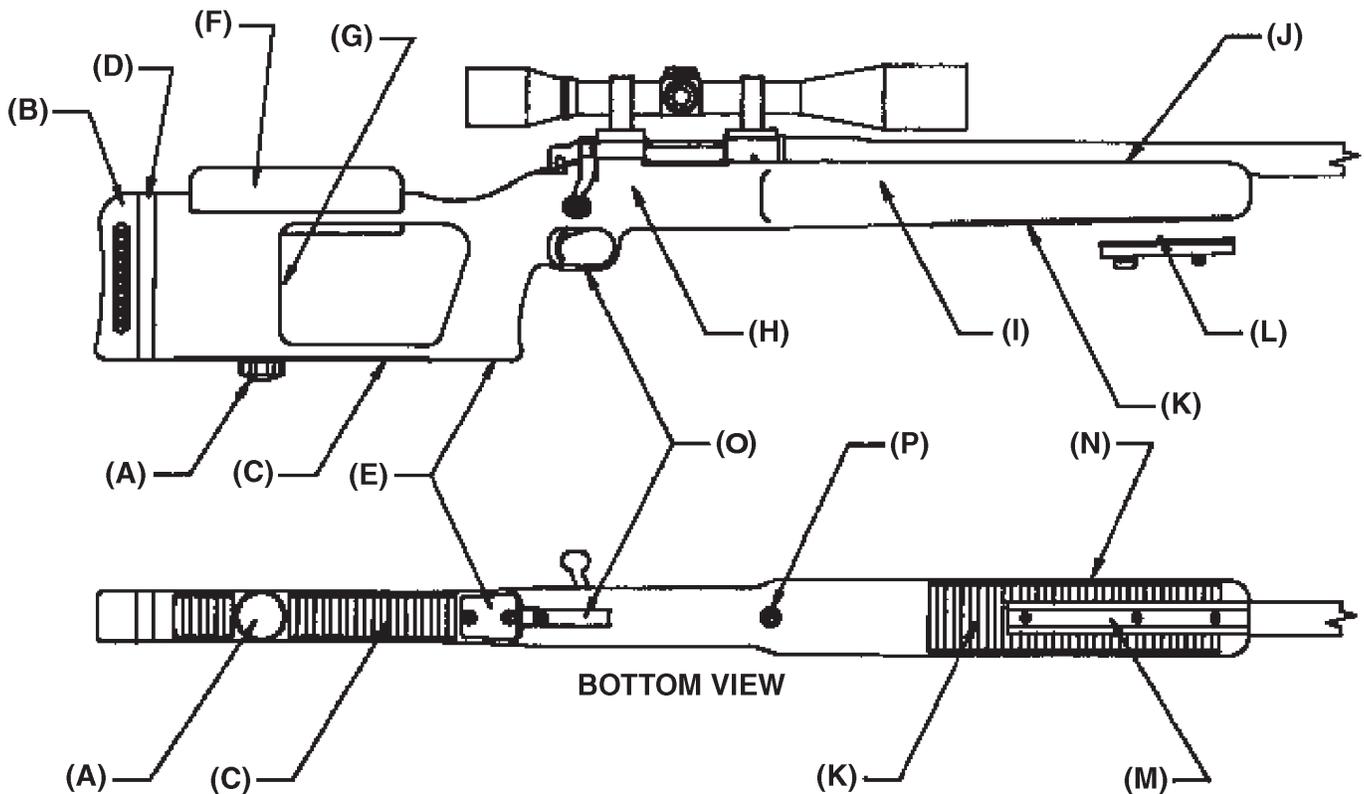


THE ULTIMATE VARMINT STOCK



Remington 700 Short Action	24-01-10
Remington 700 Long Action	24-01-12
Remington 700 Short Left	24-01-14
Remington 700 Long Left	24-01-16
Remington Detachable Magazine Short Action	24-01-18
Savage Short Action	24-06-04
Savage Long Action	24-06-02
Savage Short Action Left	24-06-08
Savage Long Action Left	24-06-06
Winchester 70 Short Action	24-03-04
Winchester 70 Long Action	24-03-02

*** DESIGNED BY MAJ. JOHN PLASTER U.S. ARMY RET., ONE OF THE WORLDS LEADING AUTHORITY & INSTRUCTORS IN LONG RANGE VERY ACCURATE SHOOTING**



FEATURES

- (A) This is the elevation adjusting knob. If you are on a hard surface you can use it without the block. If you are in the field we suggest you can carry a 2" x 4" x 6" wood block. You can make your coarse adjustment with your bipod and one of the block heights will put you in your adjusting range of the screw. The screw removes completely one degree rotation for seventeen millionths of an inch. You can get really fine on your elevation adjustment.
- (B) This is a 1 inch thick rubber recoil pad. If you are shooting a big caliber rifle you will appreciate this 'cushy' pad.
- (C) This area has coarse 1/8" serrations. These are to assist in holding the rifle in place while shooting from sand bags. This area is also flat bottom. The rifle sits upright, it doesn't have to be held constantly.
- (D) This is a 1/2" spacer that can be removed for a shorter length of pull. Your stock will come with 1/4", 1/2" and 3/4" spacers and the screw set to give you many combinations of length of pull you need. The spacer blocks are interlocking (nesting) so alignment is assured.
- (E) The grip cap is held in place by two screws. Inside the grip is a void to save plastic. This can be used to insert a counter weight if you need more stock weight, or you can put emergency ammo in the grip. It will hold 8 rds. of 30-06 ammo or what ever.
- (F) This stock comes with two cheek pieces. You get a regular height and 5/16" taller. The taller cheek piece is for the people who use the big objective lens scopes and then have to use the tall rings. You have the option of three locations, center, forward and back. You also have the option of reversing the cheek pieces if you are left handed. The cheek pieces are thick so you can shave, grind or sand them into a custom height or contour.
- (G) This is the off-hand notch. We learned this trick from the German MG-42 machine gun. We also designed and built the new NAVY/MARINE M-240 machine gun stock with this same feature. When you use a bipod or shoot from a sand bag you can use both hands to hold the butt of the rifle in place and steady on your shoulder.
- (H) Molded inside the stock is a bedding block that is C.N.C. machined from a solid billet of aluminum. The receiver screws are also supported by solid aluminum pillars that are part of the bedding block/forearm insert. The rest of this machined part is the 'U' channel (I) that is molded into the forearm barrel channel. This adds rigidity and stability to the forearm area that had never been accomplished before in a molded stock. The bedding block, support pillars and barrel 'U' channel (I) are all one piece. Anyone that has any experience in machining or stock making will tell you that this is the very best way to make a rifle stock.
- (I) Like (H), this is the forearm 'U' channel that is molded into the stock for rigidity. It is welded to the bedding block.
- (J) The barrel channel is 1 1/4" wide. This will assure that any production rifle barrel will be free floating. This clearance ensures that your receiver only touches your stock in five places, both sides of the front and back 'V' bedding block and the recoil lug area. If you have a custom rifle barrel that is larger than 1 1/4" you can simply inlet it as you would a wooden stock.
- (K) This area has coarse 1/8" serrations to retard the rifle from sliding or slipping on sand bags.
- (L) This feature is a quick detach bipod adaptor. We have a patent on this design. It fits a Anschutz type rail imbedded in the bottom of the forearm. You can now install or detach your bipod in seconds. Simply turn the thumbscrew and slide it in or out. Some Law Enforcement officers and varmint hunters will really appreciate this feature. You have the option of using a bipod to shoot from a sand bag, you can have a short leg bipod for prone shooting and a long bipod for shooting in tall grass from a sitting position. All these options can be done in a few seconds. The bipod adaptors are designed for the very well engineered Harris bipods. Extra adaptors are available, contact us at 1-800-972-6390.
- (M) This is the bipod adaptor rail. The rail is flush with the bottom of the forearm and held in place with three #10 machine screws. An endless variety of accessories can be put into this port from the bipod, to night light, to you name it.
- (N) The forearm is 2 7/16" wide. This helps the rifle stability while shooting from sand bags or a solid horizontal rest.
- (O) The trigger guard is molded in place as part of the stock. It is larger than usual to allow the shooter to wear gloves when necessary.
- (P) We furnish you with a new set of receiver screws. They are grade 8 Tool and Die quality hex socket machine screws. They should be torqued to 55 to 65 inch pounds (NOT FOOT POUNDS) of torque. Without the aluminum bedding pillars this would not be possible. Try this in a wood or plastic stock and you will split it wide open. This high torque assures that your rifle and new Choate stock are bolted together until you want them apart.

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.*