

Photographic Instructions

Step-by-Step Photo Details Inside!



Removal and Installation of 10/22 Trigger Assembly



Removal and Installation of 10/22 Bolt Assembly



Installation of 17 HM2 Heavy Bolt Handle Assembly

The EABCO 17 HM2 Heavy Bolt Handle Assembly is absolutely necessary for safe and proper function when shooting 17 Mach 2 ammunition in a 10/22 that has been converted to 17 Mach 2 with the installation of an EABCO 17HM2 Target Barrel. This larger bolt handle is properly balanced and precision machined to properly time your 10/22 action for 17 Mach 2 ammunition. Do not attempt to fire 17 Mach 2 ammunition in any 10/22 rifle that has been converted to 17 Mach 2 from 22 long rifle without this bolt kit.



17 HM2 - 10/22 Bolt Handle

Manufactured Exclusively by
E. Arthur Brown Company, Inc.
 4353 State Highway 27 East
 Alexandria, MN 56308 USA

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Ph. 320-762-8847, www.eabco.com

17 HM2 Conversion System



Heavy Bolt Handle Assembly
 For the Ruger 10/22 (Barrels Sold Separately)

NEW! HORNADY 17 MACH 2					
RANGE	Muzzle	50	100	150	200
VELOCITY (fps)	2100	1799	1530	1304	1134
ENERGY (ft/lb)	166	122	88	64	49
TRAJECTORY (inches)	-1.3	0.7	0.0	-4.4	-14.0
DEFLECTION (inches)	0.0	1.0	4.4	10.5	19.7



STANDARD HIGH VELOCITY 22 LONG RIFLE					
RANGE	Muzzle	50	100	150	200
VELOCITY (fps)*	1255	1113	1017	-	-
ENERGY (ft/lb)*	140	110	92	-	-
TRAJECTORY (inches)	-1.3	2.9	0.0	-	-
DEFLECTION (inches)	0.0	1.6	5.5	-	-

*Source: Remington 2004 brochure

Detailed Instruction Notes

Congratulations and Thank You for your purchase of this 17 HM2 Heavy Bolt Assembly for your Ruger 10/22. Please follow the directions below to achieve the best results with your installation and use. Take your time and enjoy the job and your workmanship will shine!

The EABCO 17 HM2 Heavy Bolt Handle Assembly is absolutely necessary for safe and proper function when shooting 17 Mach 2 ammunition in a 10/22 that has been converted to 17 Mach 2 with the installation of an EABCO 17HM2 Target Barrel. This larger bolt handle is properly balanced and precision machined to properly time your 10/22 action for 17 Mach 2 ammunition. This product is available from E. Arthur Brown Company, Inc... not Ruger.

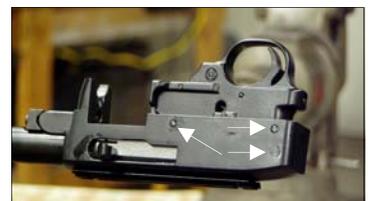


Do not attempt to fire 17 Mach 2 ammunition in any 10/22 rifle that has been converted to 17 Mach 2 from 22 long rifle without this bolt kit.



To install this EABCO 17HM2 Heavy Bolt Handle Assembly, simply follow these instructions:

1. Unload the rifle and remove the clip.
2. Leave the rifle in the cocked position.
3. Remove the barrel band, if present, and unscrew the receiver screw located directly in front of the clip on the bottom of the stock.
4. Locate the safety in the center position and rock the barrel and receiver out of the stock by lifting the muzzle of the barrel up and out of the stock.
5. Lay the stock aside so that it will not be damaged.
6. Notice that the exposed receiver has 3 pins in it. Carefully push them out of the receiver completely.
7. At this point the entire trigger guard will easily come out of the rifle. Remove it. Leave this assembly in the cocked position, as it will be easier to re-install it later on.
8. Now the only parts left in the receiver are the bolt assembly and the bolt handle assembly. Pull the bolt to the complete rearward position and hold it in that position with your hand on the bolt handle. Lightly lift the front of the bolt. It will rock up and out. Simultaneously the bolt handle assembly will be released from the bolt and will move forward with slight spring pressure. Ease it forward with your hand still on the bolt handle and remove it from the ejector port of the rifle.
9. To re-assemble with the 17 HM2 Heavy Bolt Assembly simply reverse the above directions by first installing the Bolt Handle Assembly in the receiver through the ejector port.



Step-by-Step Photo Instructions Continued on Back...

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10. Pull the 17 HM2 Heavy Bolt Handle Assembly completely to the rear of the receiver. (The spring must be fully compressed) This is easily accomplished by pulling it back with an index finger placed on the front center of the assembly, close to the spring in the receiver and pulling it back internally. It will be stiff if you try to pull it back by using the outer part of the bolt handle. Once it is all of the way back hold it there by grabbing the end of the handle on the outside of the receiver.



11. Once the bolt handle is all of the way back drop the rear of the bolt into the rear most part of the receiver and apply slight pressure down on the front of the bolt.

12. While applying slight downward pressure to the front of the bolt slowly and carefully allow the bolt kit handle to move forward a small amount. As



the kit handle moves forward it will interface with corresponding slot in the bolt and the bolt will drop down to its normal position. When this happens allow the entire bolt to move forward with it's own spring tension until it stops. NOTE: do not let the bolt slam forward without a barrel on the rifle, as it will mark the ejector port of the receiver.



13. Install the largest of the three pins through the receiver.

14. Position the trigger guard assembly so it lines up with the corresponding two smaller pinholes and install the pins. Do not force them these are slip fit pins and are not designed to be tight. Be sure that the ejector is lying in the slot in the



trigger guard and all of the way down.

15. Apply a few drops of oil to the inside of the action and operate it by hand a few times. It should operate freely and close freely under it's own power.

Installing a 17 HM2 Target Barrel (Sold Separately)

Note: These Instructions are for a heavy, .920 Diameter target barrel which requires a wider barrel channel in the rifle stock. Installation into a target stock is shown here for illustration purposes.



1. To remove the original barrel, locate the V-Block barrel retainer at the bottom of the barrel where it meets the receiver. Unscrew the two Allen screws.

2. Remove the V-Block retainer and the receiver should slide off of the barrel with a slight twisting motion.

3. Now slide the receiver onto your new barrel making sure the dovetail groove on the bottom of the barrel is positioned at the bottom of the receiver at the V-Block attachment point. See the photo just to the left.



4. While holding the bolt slightly rearward (so that it won't be pressing against the barrel), tighten the V-Block retainer screws as shown below. Your new barrel is now installed!

Installing a Target Stock and Scope Mount...



5. Position the safety halfway between on and off, then slip the stock onto the barreled 10/22 Action.

6. Tighten the stock screw.

7. Clean the scope mounting holes and screws with acetone, then install the scope base with blue Loctite® on the screws



Enjoy shooting your new 17 Mach 2 conversion and the satisfaction of a job well done.



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ph. 320-762-8847 * www.eabco.com * sales@eabco.com