



# **USER MANUAL**

# **ACS**

**AKILA CHASSIS SYSTEM**

**AKILA d.o.o**  
**2022**



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## 1. INTRODUCTION

Thank you for choosing the AKILA CHASSIS SYSTEM (ACS)

This user manual contains the description of the chassis design, operation instructions and information necessary to safely operate and service the chassis system.

Before using the product, please study the user manual thoroughly. If you have questions, please contact your dealer or AKILA representatives.

## 2. SYMBOLS USED

- ▶ - describes the required action
- ✓ - describes the correct result of the fulfilled action
- ! - describes the safety or precaution instruction



**RULE** describes certain rules to follow.



**ATTENTION** describes situations which can result in a minor injury or material damage to the product.

## 3. FIREARMS HANDLING RULES

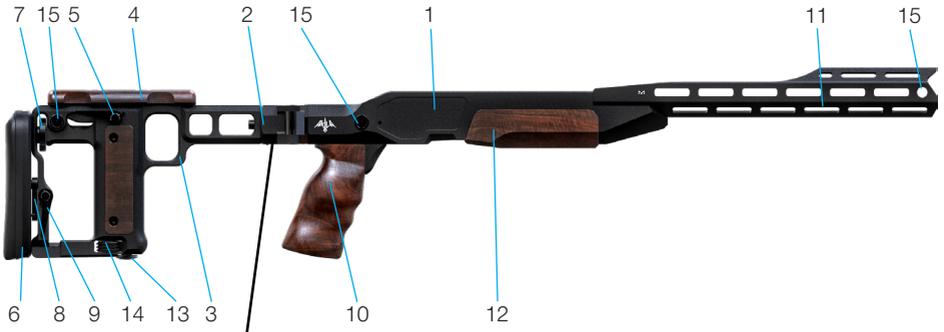
The ACS is not a firearm it is an accessory to your original rifle. You can learn how to properly use your rifle in the user manual provided with your rifle.

## 4. LIABILITY

“AKILA” d.o.o shall not be liable and shall not consider claims related to any damage caused by the following reasons:

- Failure to follow instructions contained in this Instruction Manual;
- Servicing and repairing product outside authorized workshops;
- Use of non-original parts (not manufactured by “AKILA” d.o.o. or original rifle manufacturer);
- Improper handling or care;
- Unauthorized change in the design of parts and components;
- Damage during transportation or mishandling.

## 5. CHASSIS GENERAL VIEW



Pic. 1 General view



## DESIGNATION OF THE STOCK

1. CHASSIS CENTRAL PART
2. FOLDING MECHANISM
3. BUTTSTOCK
4. CHEEKPIECE
5. CHEEKPIECE ADJUSTMENT LEVER (HEIGHT)
6. RECOIL PAD
7. BUTTSTOCK ADJUSTMENT WHEEL (LENGTH)
8. RECOIL PAD ADJUSTMENT LEVER (HEIGHT)
9. BUTTSTOCK ADJUSTMENT LEVER
10. GRIP
11. HANDGUARD
12. FOREGRIP COVER
13. MONOPOD
14. MONOPOD ADJUSTMENT WHEEL
15. QD SLING MOUNT
16. FOLDING MECHANISM BUTTON
17. MAGAZINE CATCH (not for ACSR8mk.2, ACSR80, ACSR82 and ACSR93)
18. MAGAZINE (not for ACSR8mk.2, ACSR80, ACSR82 and ACSR93)

## 6. ACSR8mk2, ACSR80, ACSR82 INSTALLATION

ACSR8mk2  
ACSR80, ACSR82

### 6.1. PARTS DISASSEMBLED FROM THE ORIGINAL RIFLE



Pic. 2 Original rifle parts

#### DESIGNATION OF THE RIFLE PARTS

- |               |                             |
|---------------|-----------------------------|
| I. BARREL     | 1. SAFETY BUTTON            |
| II. BOLT      | 2. BOLT GRIP                |
| III. MAGAZINE | 3. MAGAZINE RELEASE BUTTONS |

### 6.2. TOOLS REQUIRED TO DISASSEMBLE PARTS FROM THE ORIGINAL RIFLE

1. Allen key 5mm Included in to the rifle supply package 



Pic.3 Allen key 5 mm.

### 6.3. ACTION DISASSEMBLY FROM THE ORIGINAL RIFLE

ACSR8mk2  
ACSR80, ACSR82

#### 1

- ▶ Press the magazine buttons 3 in the direction indicated by the arrows.
- ✓ The magazine III can be detached from the rifle.
- ▶ Remove the magazine III from the rifle.



Pic. 4 Detaching the magazine



**ATTENTION** Make sure that the rifle is not loaded, ensure that the chamber is empty. Pressing the magazine release buttons can cause the magazine to fall out. Hold the magazine while detaching.

#### 2

- ▶ Press the safety button 1 to the most forward position (firing position) as indicated by the arrow;
- ▶ Turn the bolt handle 2 backwards (in the direction indicated by the arrow);
- ▶ Move the bolt II to the most backwards position (in the direction indicated by the arrow).



Pic. 5 Open the bolt



Pic. 6 Move the bolt backwards

3

ACSR8mk2  
ACSR80, ACSR82

▶ Push the bolt stop V down and remove the bolt II from the rifle in the direction indicated by the arrow.

✓ The bolt is removed.



Pic. 7 Remove the bolt

4

▶ Use the 5 mm allen key to completely loosen the stock nuts;

▶ Remove the barrel I from the stock.

✓ The Barrel is removed.



Pic. 8 Remove the barrel

#### 6.4. ACTION INSTALLATION IN THE AKILA CHASSIS SYSTEM

1

▶ Insert the barrel I in the chassis 1;

▶ Use the 5 mm allen key to tighten the stock nuts under the foregrip cover (there are two holes in the foregrip cover). Tightening torque 11 Nm (0,11 kg\*m).

✓ The Barrel is installed and tightened.



Pic. 9 Install the barrel



Pic. 10 Tighten the barrel



## 2

ACSR8mk2  
ACSR80, ACSR82



### RULE

- If your buttstock 3 folds to the right side you need to remove the cheekpiece 4 (see paragraph cheekpiece adjustment 13.1) pic. 58;
- If your buttstock 3 folds to the left side you can just fold the buttstock (see paragraph folding stock 12.) pic. 56.

▶ Insert the bolt II in the direction indicated by the arrow.

✓ The bolt is installed.



Pic. 11 Insert the bolt

(buttstock folding set to the right side)



Pic. 12 Insert the bolt

(buttstock folding set to the left side)

## 3

▶ Insert the magazine III (in the direction indicated by the arrow) until you hear a distinct click.

✓ The magazine is installed;

✓ The rifle is fully assembled.



Pic. 13 Install the trigger

## 7. ACSRX INSTALLATION

ACSRX

### 7.1. PARTS DISASSEMBLED FROM THE ORIGINAL RIFLE



Pic. 14 Original rifle parts.

### DESIGNATION OF THE RIFLE PARTS

- |               |                             |
|---------------|-----------------------------|
| I. BARREL     | 1. SAFETY BUTTON            |
| II. BOLT      | 2. BOLT GRIP                |
| III. MAGAZINE | 3. MAGAZINE RELEASE BUTTONS |

### 7.2. TOOLS REQUIRED TO DISASSEMBLE PARTS FROM THE ORIGINAL RIFLE

1. Allen key 5mm Included in to the rifle supply package 



Pic.15 Allen key 5 mm.

### 7.3. ACTION DISASSEMBLY FROM THE ORIGINAL RIFLE



**⚠ ATTENTION** Make sure that the rifle is not loaded, ensure that the chamber is empty. Pressing the magazine release buttons can cause the magazine fall out. Hold the magazine while detaching.

- Follow the steps in paragraph 6.3. pic. 5-8

### 7.4. ACTION INSTALLATION IN THE AKILA CHASSIS SYSTEM **ACSRx**

#### 1 - 2

- Follow the steps in paragraph 6.4. pic. 9-12

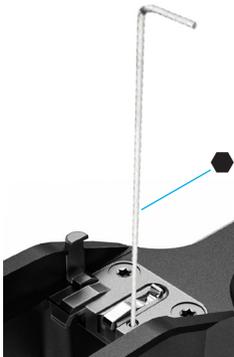
#### 3

- ▶ Insert the magazine **III** (in the direction indicated by the arrow) until you hear a distinct click.
- ✓ The magazine is installed;
- ✓ The rifle is fully assembled.



Pic. 16 Install the magazine.

### 8. ADJUSTMENT OF THE TRIGGER FOR **ACSRx ACSR8MK2 ACSR80 ACSR82**



- ▶ Please use the **1.5 mm** allen key for the weight of pull adjustment;

Trigger type: Two-Stage

Pull Weight:

1st stage: <130g. (0.28lb) to 400g. (0.88lb);

2nd stage: <400g. (0.88lb) to 1200 g. (2.64lb);

- ✓ Trigger is adjusted.

Pic. 17 Adjustment of the trigger.



## 9. ACSR8U INSTALLATION

**ACSR8U**

### 9.1. PARTS DISASSEMBLED FROM THE ORIGINAL RIFLE



Pic. 18 Original rifle parts.

### DESIGNATION OF THE RIFLE PARTS

- |                 |                             |
|-----------------|-----------------------------|
| I. BARREL       | 1. SAFETY BUTTON            |
| II. BOLT        | 2. BOLT GRIP                |
| III. MAGAZINE   | 3. MAGAZINE RELEASE BUTTONS |
| IV. SYSTEM PART |                             |

### 9.2. TOOLS REQUIRED TO DISASSEMBLE PARTS FROM THE ORIGINAL RIFLE

1. Allen key 4mm;
2. Allen key 5mm;
3. Allen key 6mm;
4. Plastic removal.



Pic.19 Allen key 4, 5 and 6 mm.

### 9.3. ACTION DISASSEMBLY FROM THE ORIGINAL RIFLE

AGSR8U

**! ATTENTION** Make sure that the rifle is not loaded, ensure that the chamber is empty. Pressing the magazine release buttons can cause the magazine fall out. Hold the magazine while detaching.

**1** • Follow the steps in paragraph 6.3. pic. 5-8

**2**

- ▶ Use the  5 mm allen key to completely loosen the foreend fixing screw;
  - ▶ Remove the foreend from the stock;
- ✓ The foreend is removed.



Pic. 20 Loosen the Foreend screw.



Pic. 21 Remove the Foreend.

**3**



There are two versions of the system part. The disassembly process is different for each.

#### FOR THE ULTIMATE MODEL OF THE SYSTEM

- ▶ Use a polymer pry tool to remove the grip cover;
  - ▶ Remove the cover from the stock;
  - ▶ Use the  5 mm allen key to remove the lower fixing screw;
- ✓ The fixing screw is removed.



Pic. 22 Remove the cover.

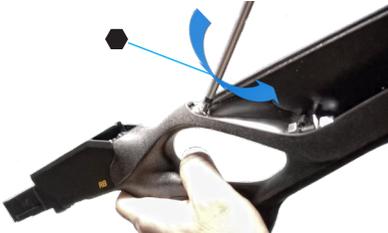


Pic. 23 Remove the lower fixing screw.

**4****ACS R8U**

The second fixing screw is located deep inside the buttstock and to remove it you would have to remove the cheek rest first.

- ▶ Consider having an experienced gunsmith to assist you with this;
- ▶ Use the  5 mm allen key to remove the screw;
- ✓ The buttstock is removed.



Pic. 24 Remove the fixing screw.



Pic. 25 Remove the buttstock.

#### FOR THE STANDARD MODELS WITH WOODEN STOCKS OF THE SYSTEM

- ▶ Use a screw driver to remove the fixing screw of the buttplate and tilt it to the side;
- ▶ Use the  6 mm allen key to remove the lower buttstock fixing screw;
- ✓ The buttstock is removed.



Pic. 26 Remove the screw.

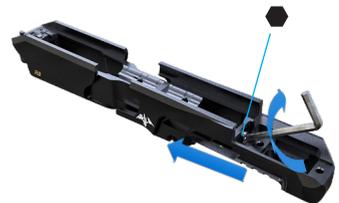


Pic. 27 Remove the buttstock.

#### 9.4. ACTION INSTALLATION IN THE AKILA CHASSIS SYSTEM

**1**

- ▶ Slide the Front connector on to the system receiver;
- ▶ Use the  5 mm allen key to tighten the 2 fixing screws;
- ✓ The Front connector is installed.



Pic. 28 Install the Front connector.

## 2

- ▶ Use the  5 mm allen key to tighten the clamping screw;
- ▶ Use the  4 mm allen key to fix the foregrip cover;
- ✓ The Front connector is tightened;
- ✓ The foregrip cover is installed.



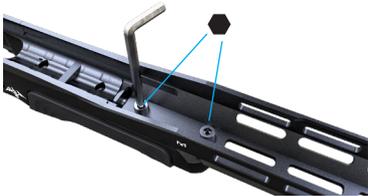
Pic. 29 Tighten the Front connector.



Pic. 30 The foregrip cover is installed.

## 3

- ▶ Use the  5 mm allen key to tighten the Foreend;
- ✓ The Foreend is fixed.



Pic. 31 Fix the Foreend.

## 4

- ▶ Use the  5 mm or  6 mm allen key to fix the Foreend;
- ✓ The Foreend is fixed.

### FOR THE ULTIMATE VERSION OF SYSTEM RECEIVER



Pic. 32 Tighten the Back connector (Ultimate).

### FOR THE STANDARD MODELS WITH WOODEN STOCKS OF THE SYSTEM RECEIVER



Pic. 33 Tighten the Back connector (Standard).

# 5

- ▶ Insert the Threaded bushing and End Plate in to the Back connector;
  - ▶ Follow the steps in paragraph 13.6. pic. 69-70;
  - ▶ Follow the steps in paragraph 15. pic. 82;
- ✓ The chassis is assembled.



Pic. 34 Install the Threaded bushing and the End Plate.

## 10. ACSR93 INSTALLATION

ACSR93

### 10.1. PARTS DISASSEMBLED FROM THE ORIGINAL RIFLE



Pic. 35 Original rifle parts

### DESIGNATION OF THE RIFLE PARTS

- |  |                  |
|--|------------------|
| I. BARREL  | 1. SAFETY BUTTON |
| II. BOLT   | 2. BOLT GRIP     |
| III. MAGAZINE                                    |                  |
| IV. TRIGGER (ONLY OFFROAD VERSION IS COMPATIBLE) | <b>OPTIONAL</b>  |

## 10.2. TOOLS REQUIRED TO DISASSEMBLE PARTS FROM THE ORIGINAL RIFLE

1. Torx T20 Key included in the ACSR93 supply package 
2. Allen key 4 or 5mm included in to the rifle supply package 

ACSR93



Pic.36 Torx T20 Key



Pic.37 Allen key 4 or 5 mm.  
(depending on the configuration of the rifle)

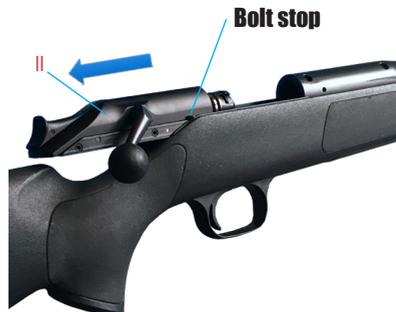
## 10.3. ACTION DISASSEMBLY FROM THE ORIGINAL RIFLE

**1**

- ▶ Press the safety button **1** to the most forward position (firing position) as indicated by the arrow;
  - ▶ Turn the bolt handle **2** backwards (in the direction indicated by the arrow);
  - ▶ Move the bolt **II** to the most backwards position (in the direction indicated by the arrow);
  - ▶ Push the bolt stop down and remove the bolt **II** from the rifle in the direction indicated by the arrow;
- ✓ The bolt is removed.



Pic. 38 Open the bolt



Pic. 39 Move the bolt backwards

2

- ▶ Remove the magazine III from the rifle.



Pic. 40 Detaching the magazine.

4

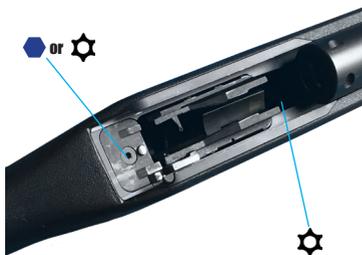
- ▶ Use the  4 or 5 mm allen key to completely loosen the barrel fixing nuts;
- ▶ Remove the barrel I from the stock;
- ✓ The Barrel is removed.



Pic. 41 Remove the barrel.

5 **OPTIONAL**

- ▶ Use the  Torx T20 key or  2.5 mm Allen key to remove the trigger screws;
- ▶ Remove the trigger IV from the original stock;
- ✓ The trigger IV is removed.



Pic. 42 Remove the trigger screws.



Pic. 43 Remove the trigger.

## 10.4. ACTION INSTALLATION IN THE AKILA CHASSIS SYSTEM



### 4

- ▶ Insert the barrel **I** in to the chassis 1;
  - ▶ Use the  5 mm allen key to tighten the barrel fixing nuts under the foregrip cover (there are two holes in the foregrip cover). Tightening torque 11 Nm (0,11 kg\*m).
- ✓ The Barrel is installed and tightened.



Pic. 44 Install the barrel.



Pic. 45 Tighten the barrel.

### 3 OPTIONAL

- ▶ Insert the trigger **IV** in the central part of the chassis 1;
  - ▶ Press the spiral pin to the central part;
  - ▶ Use the  5 mm allen key to tighten the grip. Tightening torque 5 Nm (0,05 kg\*m);
  - ▶ Use the  Torx T20 or  2,5mm key to tighten the trigger screws to fix the trigger **IV** in the chassis. Tightening torque 2-2,5 Nm (0,2-0,25 kg\*m);
- ✓ The trigger **IV** is installed.



Pic. 46 Install the trigger.



Pic. 47 Tighten the triggerguard and grip.



Pic. 48 Tighten the trigger screws.

# 5

- ▶ Insert the bolt II in the direction indicated by the arrow;
- ✓ The bolt is installed.

ACSR93



Pic. 49 Insert the bolt.

## 11. ACST3, ACSR700 AND ACS69 INSTALLATION

OTHER

### 11.1. PARTS DISASSEMBLED FROM THE ORIGINAL RIFLE



Pic. 50 Original rifle parts.

#### DESIGNATION OF THE RIFLE PARTS

- I. BARRELED ACTION
- 1. SUPPLIED SCREWS
- 2. AICS AI STEEL MAGAZINE
- 3. MAGAZINE RELEASE BUTTON



## 11.2. TOOLS REQUIRED TO DISASSEMBLE RIFLE FROM THE ORIGINAL STOCK

1. Allen key 5mm or 3/16" (for rifles with inch screws) 
2. Lotted screwdriver 

OTHER



Pic.51 Allen key 5 mm or 3/16".



Pic.52 Lotted screwdriver.

## 11.3. ACTION DISASSEMBLY FROM THE ORIGINAL RIFLE

1

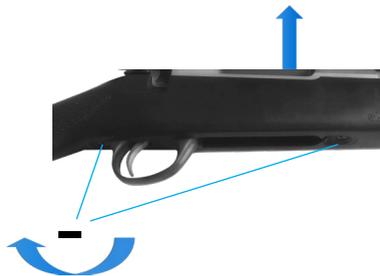
- ▶ Press the magazine button;
- ✓ The magazine can be detached from the rifle;
- ▶ Remove the magazine from the rifle.



**ATTENTION** Make sure that the rifle is not loaded, ensure that the chamber is empty. Pressing the magazine release button can cause the magazine fall out. Hold the magazine while detaching.

2

- ▶ Use the  slotted screwdriver to completely remove the stock screws;
- ▶ Remove the bolt action from the stock.
- ✓ The bolt action is removed.



Pic. 53 Remove the bolt action.

## 11.4. ACTION INSTALLATION IN THE AKILA CHASSIS SYSTEM

OTHER

1

- ▶ Insert the bolt action in the chassis;
  - ▶ Use the  $\blacklozenge$  5 mm allen key or 3/16" (for rifles with inch screws) to tighten the stock screws  
Tightening torque 11 Nm (0,11 kg\*m).
- ✓ The bolt action is installed and tightened.



Pic. 54 Install the action.

## 12. FOLDING STOCK

### 12.1 FOLDING

1

- ▶ Press the buttstock catch button 16 and simultaneously pull the buttstock 3 (in the direction indicated by the arrow).

✓ The butt stock is released.



Pic. 55 Press the button, fold the buttstock.

2

- ▶ Turn the buttstock 3 in the direction indicated by the arrow until it gets fixed with the catch.

✓ The butt stock is folded.



Pic. 56 The butt stock is folded.

## 12.2 UNFOLDING

▶ Press the buttstock catch button 16 and simultaneously pull the buttstock 3 (in the direction indicated by the arrow).

✓ The buttstock is released.



Pic.57 Unfold the buttstock.

## 13 BUTTSTOCK ADJUSTMENT

### 13.1 CHEEKPIECE ADJUSTMENT

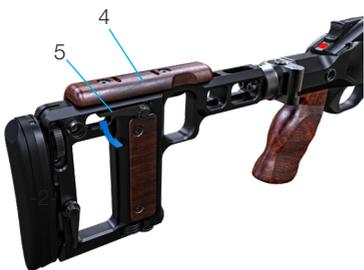
#### 13.1.1 CHEEKPIECE HEIGHT ADJUSTMENT

▶ Turn the lever 5 counter-clockwise and unlock the cheekpiece 4;

▶ Pull the cheekpiece 4 up or down to the desired position;

▶ Lock the position of the cheekpiece 4 by tightening the lever 5 clockwise.

✓ The cheek piece is adjusted.



Pic. 58 Cheekpiece before adjustment (HEIGHT).



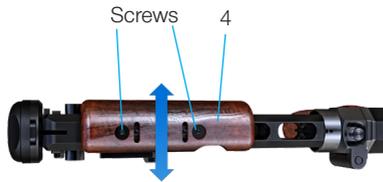
Pic. 59 Cheekpiece after adjustment (HEIGHT).

### 13.1.2 CHEEKPIECE LATERAL ADJUSTMENT

- ▶ Fix the cheekpiece 4 as in paragraph 13.1.1;
- ▶ Using the  4 mm allen key loosen the screws that fix the cheekpiece 4;
- ▶ Adjust the cheekpiece 4 to the left or to the right;
- ▶ Using the  4 mm allen key tighten the screws to fix the cheekpiece 4.

Tightening torque 6-6,5 Nm (0,6-0,65 kg\*m)

- ✓ The cheekpiece is adjusted.



Pic. 60 Cheekpiece after adjustment (SIDEWAYS).

### 13.2 BUTTSTOCK LENGTH ADJUSTMENT

- ▶ Turn the lever 9 counter-clockwise to loosen the recoil pad 6 length adjustment;
- ▶ Turning the wheel 7 changes the position of the recoil pad 6 adjusting the buttstock length;
  - One wheel 7 turn adjusts the recoil pad 6 position by 1,25mm;
  - Recoil pad 6 adjustment travel is 40 mm.
- ▶ To lock the recoil pad position turn the tightening lever 9 clockwise.

- ✓ The recoil pad is adjusted.



Pic. 61 Recoil pad 6 adjusted (length).

### 13.3 RECOIL PAD HEIGHT ADJUSTMENT

- ▶ Turn the fixing lever 8 counter-clockwise to release the recoil pad 6 height adjustment;
  - ▶ Pull up or down the recoil pad 6 to the desired position;
  - ▶ Lock the recoil pad 6 position by tightening the lever 8 clockwise.
- ✓ The recoil pad is adjusted.



Pic. 62 Recoil pad height adjustment .

### 13.4 MONOPOD ADJUSTMENT

- ▶ Press the adjustment wheel 14 in the direction indicated by the arrow for quick adjustment;
  - ▶ Turn the wheel 14 for fine adjustment.
- ✓ The monopod 13 is adjusted.



Pic. 63 Monopod adjustment.

### 13.5 REMOVING THE BUTTSTOCK

In order to change the folding side or to install a different AR15 style buttstock.

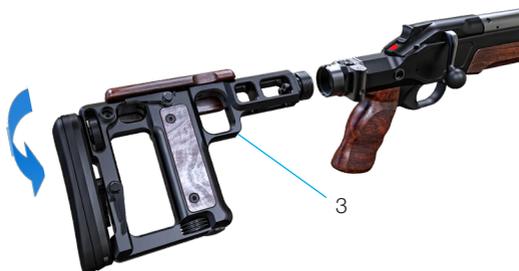
- ▶ Use the  4 mm allen key to loosen the screws by 4-5 mm;
  - ▶ Pull the buttstock 3 back in the direction indicated by the arrow;
  - ▶ Rotate the buttstock 3 counterclockwise until it is removed.
- ✓ The buttstock is removed.



Pic. 64 Unscrew the screws.



Pic. 65 Unlock buttstock.



Pic. 66 Remove the buttstock.

- ▶ To install the buttstock repeat the above steps in reverse order. Tightening torque for the fixing screws is 6-6,5 Nm (0,6-0,65 kg\*m).

✓ The buttstock is installed.

### 13.6 CHANGING THE BUTTSTOCK FOLDING DIRECTION

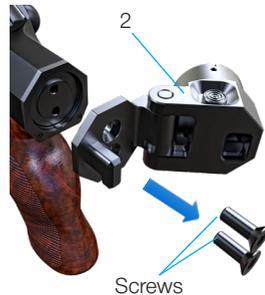
You may choose the folding side of your AKILA buttstock as well as install other AR15 style buttstocks. The folding unit has to be installed with the release button down to enable the left side buttstock fold. Aftermarket AR15 buttstocks may have to be folded to the opposite side of the bolt grip, ACSR93 must fold to the opposite side of the bolt grip. AKILA buttstock can be configured to fold other side covering the bolt grip on the left or right handed versions.

**1**

- ▶ Remove the buttstock (see paragraph 13.5);
  - ▶ Press the folding catch button 16 and simultaneously pull the Foldingstock 2 (in the direction indicated by the arrow);
  - ▶ Use the Torx key  T25 tool to unscrew the fixing screws that fix the folding unit 2 until both are completely removed.
- ✓ The folding unit 2 is removed.



Pic. 67 Unfold.



Pic. 68 Remove the folding unit.

**2**

- ▶ Rotate the folding unit 2 by 180 degrees;
  - ▶ Use the Torx key  T25 to install and tighten the screws fixing the folding unit 2.
- Tightening torque 6-6,5 Nm (0,6-0,65 kg\*m);
- ▶ Close the folding unit 2 until it locks (in the direction indicated by the arrow).
- ✓ The folding direction is changed.



Pic. 69 Folding unit 2 is installed.



Pic. 70 Unfold the folding unit.

### 13.7 INSTALLING AN AFTERMARKET BUTTSTOCK

The AKILA Chassis System is compatible with most AR15 pattern buttstocks with 1 3/16-16 UN thread. Please read the user manual supplied with the buttstock you have purchased.

- ▶ Use the  1.5 mm allen key to loosen the screw counter-clockwise until it is removed (Pic. 60);
  - ▶ Thread the buffertube with the buttstock into the chassis until it stops (Pic. 61). Now, unscrew it back to the point where the buttstock is in a straight position to the chassis. The hole of the M3 screw should be aligned with the groove on the buffer tube (Pic. 62);
  - ▶ Use the  1.5 mm allen key to tighten the screw to fix the buttstock and tighten the castle nut with a special tool. Pic. 63. Using tightening torque 1-1,2 Nm (0,1-0,12 kg\*m).
- ✓ The buttstock is installed.



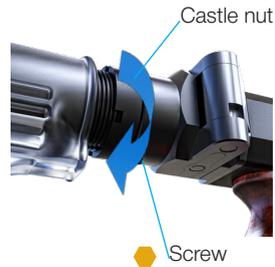
Pic. 71 Remove the screw.



Pic. 72 Install the buttstock.



Pic. 73 The groove on the buffer tube



Pic. 74 The buttstock is fixed.

## 14 ACCESSORIES

Forend 11 has octagonal cross section with M-LOK™ interface for accessories or rails mounting.



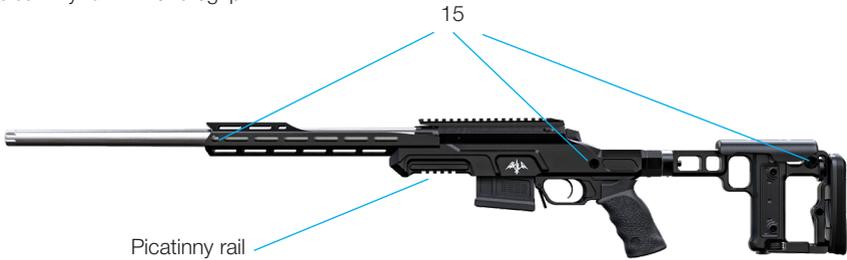
Pic. 75 M-LOK™ Forend.

As well as Arca Forend 11 has octagonal cross section with M-LOK™ slots. The 6 o'clock side features a full length ARCA Swiss rail. ARCA Forend is supplied with a take down AKILA Forend Upper for top mounted accessories.

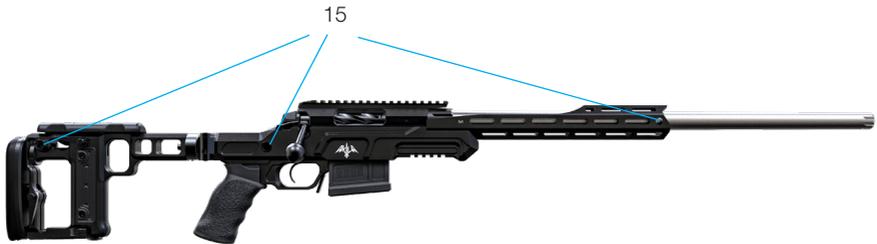


Pic. 76 ARCA Swiss rail Forend.

The stock has 6 QD sling mount (15) points for comfortable sling attachment when the buttstock is folded or unfolded. ACST3, ACSRem700 and ACSSG69 have an integrated Picatinny rail in the foregrip.



Pic. 77 QD-sling mount left side.



Pic. 78 QD-sling mount right side.

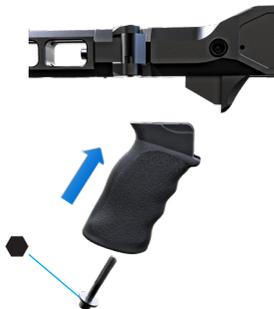
## 15 INTERCHANGEABLE FURNITURE ACCENTS

### 1

- ▶ Use the  5 mm allen key to remove the grip fixing screw;
  - ▶ Mount new grip and use the  5 mm allen key to tighten the fixing screw. Tightening torque 2-2,5 Nm (0,2-0,25 kg\*m);
- ✓ New grip is installed.



Pic. 79 The grip is removed.



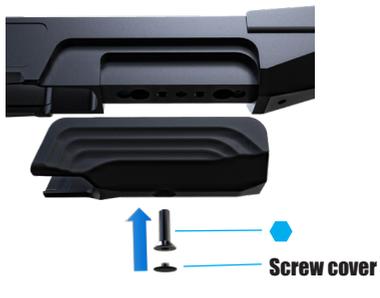
Pic. 80 The grip is installed.

### 2

- ▶ Remove the fixing screw cover;
  - ▶ Use the  4 mm allen key to remove the foregrip cover fixing screw;
- ✓ The foregrip cover is removed.



Pic. 81 The foregrip cover is removed.



Pic. 82 The foregrip cover is installed.

### 3

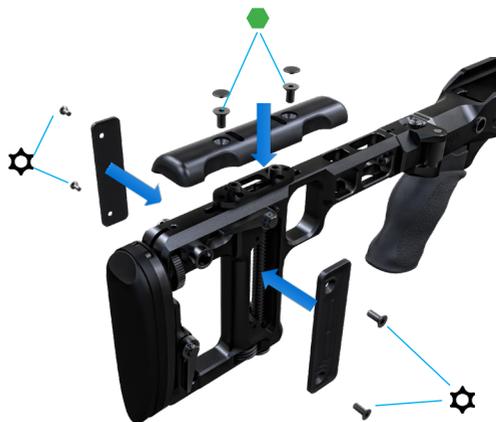
Remove the cheekpiece fixing screws covers;

- ▶ Use the  3 mm allen key to remove the cheekpiece fixing screws;
  - ▶ Use the  Torx T20 tool to unscrew the buttstock panels fixing screws.
- ✓ The cheekpiece and buttstock panels are removed.



Pic. 83 The cheekpiece and buttstock panels are removed.

 **ATTENTION** Due to different storage and use conditions (i.e. humidity, temperature, etc.), wooden parts may slightly change the dimensions, causing difficulties to remove or install the covers.



Pic. 84 The cheekpiece and buttstock panels are changed.

## 16. STOCK CARE AND CLEANING

The AKILA Chassis System (ACS) has special anti-corrosion coating, anyway it is necessary to monitor the condition of the stock. Corrosion may occur if the chassis is not cleaned after use. Especially if it has deep scratches or any other damage of the coated surface.

The chassis should be regularly maintained at least once a year or more often after heavy use or in severe conditions. Moreover, regular maintenance is recommended if the rifle is stored for a long period. If it is necessary to replace any parts, use only original factory spare parts.

When loosening or tightening screws, make sure that the screwdriver or wrench is of an appropriate size and shape. Improper or low quality tools may damage the screw heads and overall chassis appearance. Use only high quality gun oil that cleans, lubricates and preserves (CLP).

Routine cleaning procedure must be done as follows:

1. In case the stock has been used in wet conditions dry it using compressed air or let it dry in a warm / dry place without any protective cover or drag bag;
2. The wood parts should be treated with special gun wood oil or varnished. It is important to maintain the wooden parts dry after using the chassis and regularly treat with oil. It is recommended to wipe the wood parts with special gun wood oil. Parts made of plastic do not require special care.
3. Wipe the stock clean from dust, mud etc. and lubricate all metal surfaces with a lubricated rag so that a light film of lubricant remains on the stock.



**RULE** After cleaning and lubrication of the stock it is necessary to degrease the contact surface of the central part of the chassis 1 and the barrel | (Pic. 73)



Pic. 85 Marked area must be degreased

## 17. TECHNICAL CHARACTERISTICS

	ACSR8mk.2	ACSR93	ACST3	ACSRem700	ACSSG69
CHASSIS LENGTH	847mm (33,3") / 594mm (23,4")	846mm (33,3") / 593mm (23,4")	864mm (34") / 614mm (24,2")	861mm (33,9") / 619mm (24,4")	863mm (34") / 607mm (23,9")
TOTAL RIFLE LENGTH WITH 22" BARREL	1024mm (40,3") / 771mm (30,3")	1024mm (40,3") / 771mm (30,3")	1080mm (42,5") / 830mm (32,7")	1079mm (42,5") / 837mm (33")	1079mm (42,5") / 823mm (32,4")
WEIGHT (WITHOUT MAGAZINE)	2112g (4,7Lbs)	2118g (4,7Lbs)	2183g (4,8Lbs)	2102g (4,6Lbs)	2094g (4,6Lbs)
STOCK LENGTH ADJUSTMENT		40 mm (1,6")			
CHEEK PIECE HEIGHT ADJUSTMENT		30 mm (1,2")			
RECOIL PAD HEIGHT ADJUSTMENT		±31 mm (±1,2")			
MONOPOD LENGTH ADJUSTMENT		104mm (4,1")			
FOLDING MECHANISM		Folded to the left or to the right rifle side; AR-15 compatible pattern			
BUTTSTOCK		With adjustments and integrated monopod; AR-15 compatible pattern			
ACCESSORIES INTERFACE		The octagonal handguard features the M-LOK®, ARCA Swiss rain interface			
SURFACE TREATMENT		By default black hard anodizing; Cerakote® upon request for extra charge			

## 18. STORAGE

Store the AKILA Chassis System dry in a cabinet with reduced humidity (30-40%), away from heating devices and avoiding high temperature changes. The air must be free from acid, alkaline and other aggressive substances.

## 19. SUPPLY SET

- Chassis ACSR8, ACSRX, ACSR8U, ACSR80, ACSR82, ACSR93, ACST3, ACSR700, ACSSG69, ACS1500;
- User manual;
- Screw M6x25 (for ACST3, ACS1500 and ACSSG69);
- Screw 1/4-28 X 1" (for ACSREM700).

## 20. ADDITIONAL INFORMATION

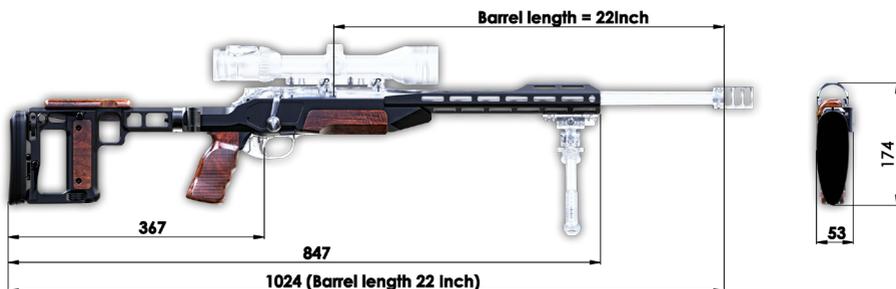
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## 21. LIMITED FACTORY WARRANTY

AKILA d.o.o warrants the workmanship and all parts of this product against material or workmanship defects for a period of 3 year from the date of original purchase for use. This warranty shall be effective only if the registration card is fully completed and mailed to AKILA d.o.o. for registration, and applies only to the original purchaser.

This warranty is null and void if the unit and or its components therein have been damaged or tampered with by improper handling, use or unauthorized repair. In all cases of damage during shipment for repair, a claim must be filed with the shipping carrier by the purchaser, and not with AKILA d.o.o. In all events the manufacturers agree to repair or replace the defective parts, but never to exceed the purchase price as paid. As this is a limited warranty, AKILA d.o.o.'s liability for consequential and incidental damages is expressly disclaimed and shall not exceed the purchase price paid.



Pic. 86 ACSR8mk.2 Chassis length with rifle



Pic. 87 ACSR8mk.2 Chassis length folded with rifle



Pic. 88 ACSR93 Chassis length with rifle



Pic. 89 ACSR93 Chassis length folded with rifle



Pic. 90 ACST3 Chassis length with rifle



Pic. 91 ACST3 Chassis length folded with rifle



Pic. 92 ACSRem700 Chassis length with rifle



Pic. 93 ACSRem700 Chassis length folded with rifle



Pic. 94 ACSSG69 Chassis length with rifle



Pic. 95 ACSSG69 Chassis length folded with rifle





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