

5/4/25

Installation procedure using CHS, Concealed Headspace Shim barrel kits. Mechanical inclination, proper tools and knowledge of headspace is required to properly install a barrel kit. The scope of these instructions is not to teach gunsmithing.

This process is used on Rem 700, bolt action clones and CVA Paramount barrel kits. The CHS recoil lug must be used for this installation, it will not work with other recoil lugs.

The lug has a nominal thickness of .250 inches when a .040 shim is inside the bore.

We include these shims: .003", .004", .005", .032" and .040"

final barrel torque = 75 ft/lbs.

Ideal headspace clearance is .003-.005

Fixed module breech (WA04006) plug must be installed and bottomed out on flange prior to setting headspace.

Start by using the .040" shim and hand tighten the barrel into the action. Test shutting the bolt with a module. if the bolt does not close, you must remove the barrel and add another shim then repeat.

If the bolt closed, there is some amount of clear headspace. Add a piece of .004" shim stock between the module and bolt face. If you do not have shim stock, a piece of paper will work. If the bolt closes with the module shimmed, you need to reduce the total shim stack thickness in the recoil lug.

Repeat these steps until your bolt will close with a module, and will not close with a .004" shim or piece of paper between module and bolt face.

It is common that once the shim stack is determined and you torque the barrel, you may now find the bolt will not close. This is normal and generally needs .002"-.003" more overall shim stack thickness. Either add a .003" shim, or swap a .003" for a .005" etc.

When torqued, your bolt should close with a module, and not close with a shim or paper between the module and bolt face.

Barrels are nitrided and then hand lapped for a very consistent bore. After we diamond lap, we clean the bore.

There will still be dark brown/red residue from the nitriding process. It is not beneficial to tire yourself out attempting to scrub the color out of the barrel bore.