

SCSA TSP X CHASSIS



SAFETY WARNING: Before commencing any work or modifications on your rifle, make sure your rifle is **UNLOADED**. Before starting with the assembly procedure of this product, **REMOVE** the BOLT and MAGAZINE from the rifle.

ASSEMBLING YOUR SCSA TSP X CHASSIS

Step 1: Remove the action from the current stock/chassis

1. Loosen and remove the action screws holding the action
2. Pull the action away
3. Remove all components of the internal box magazine

Step 2: Install the receiver/action to the chassis inlet

1. Clamp recoil lug after step 3 (fig 1 pg. 2)
2. Invert receiver/action and align TSP X chassis inlet above it
3. Without tightening, insert forward receiver/action screw, confirm alignment again, then insert rear receiver/ action screw
4. Tighten screws to the specified torque values of your rifle, beginning with the **REAR** screw and alternating between it and the front in increments. The rear is tightened first to avoid any tilt of the receiver as it beds into the inlet.

Step 3: Install trigger guard and front adapter

1. Slot trigger guard into the inlet ensuring the trigger guard is homed towards the buttstock. Secure with provided screws.
2. Attach forward adapter with the provided screws.
3. Before moving onto the next step, test the magazine fitment into the chassis. The trigger guard is designed to adjust forward or backwards to cater for the AICS magazine.

Step 4: Install buttstock and forend

1. Secure butt stock to chassis inlet with the provided screw
2. Secure forend to chassis inlet with the provided screws

NOTE - AICS Magazine Compatibility and Tuning

We recommend the Accuracy International AICS Steel Magazines. Due to the manufacturing tolerances in the production of the AICS magazines there may be a need to fine tune the feed lips of the steel models.

HOWA 1500

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WHAT'S IN THE BOX?

- SCSA TSP X Chassis - Buttstock, Chassis Inlet, Forend, Trigger Guard and Forward Magazine Adapter - requires assembly
- Chassis Fasteners
- 3 * Spacers for extra LOP
- 1 * A2 grip with fastener
- Instruction manual - 02-23/08/2019

TOOLS REQUIRED

- 6mm hex key (wrench)
- 5mm hex key (wrench) Metric Threaded Actions
- 3 / 16" hex key (wrench) SAE Threaded Actions
- 4mm hex key (wrench)
- 3mm hex key (wrench)
- 2.5mm hex key (wrench)
- Torque wrench up to 30 N.m (265 in.lb)
- Loctite® 243-Blue medium strength or equivalent

ADJUST TO SUIT YOUR NEEDS

Cheek rest zero return

1. Loosen cheek riser levers, and detach cheek rest assembly
2. Slide O-rings down to their lowest position
3. Shoulder the rifle, carefully pushing down the cheek rest assembly to your desired position
4. Tighten and index cheek riser levers

Cheek rest yaw adjustment

1. Loosen cheek riser levers, and detach cheek rest assembly
2. Loosen screws (Item 4 Fig 3 pg. 3)
3. Adjust yaw up to 7 degrees in either direction
4. Tighten screws to secure adjustment



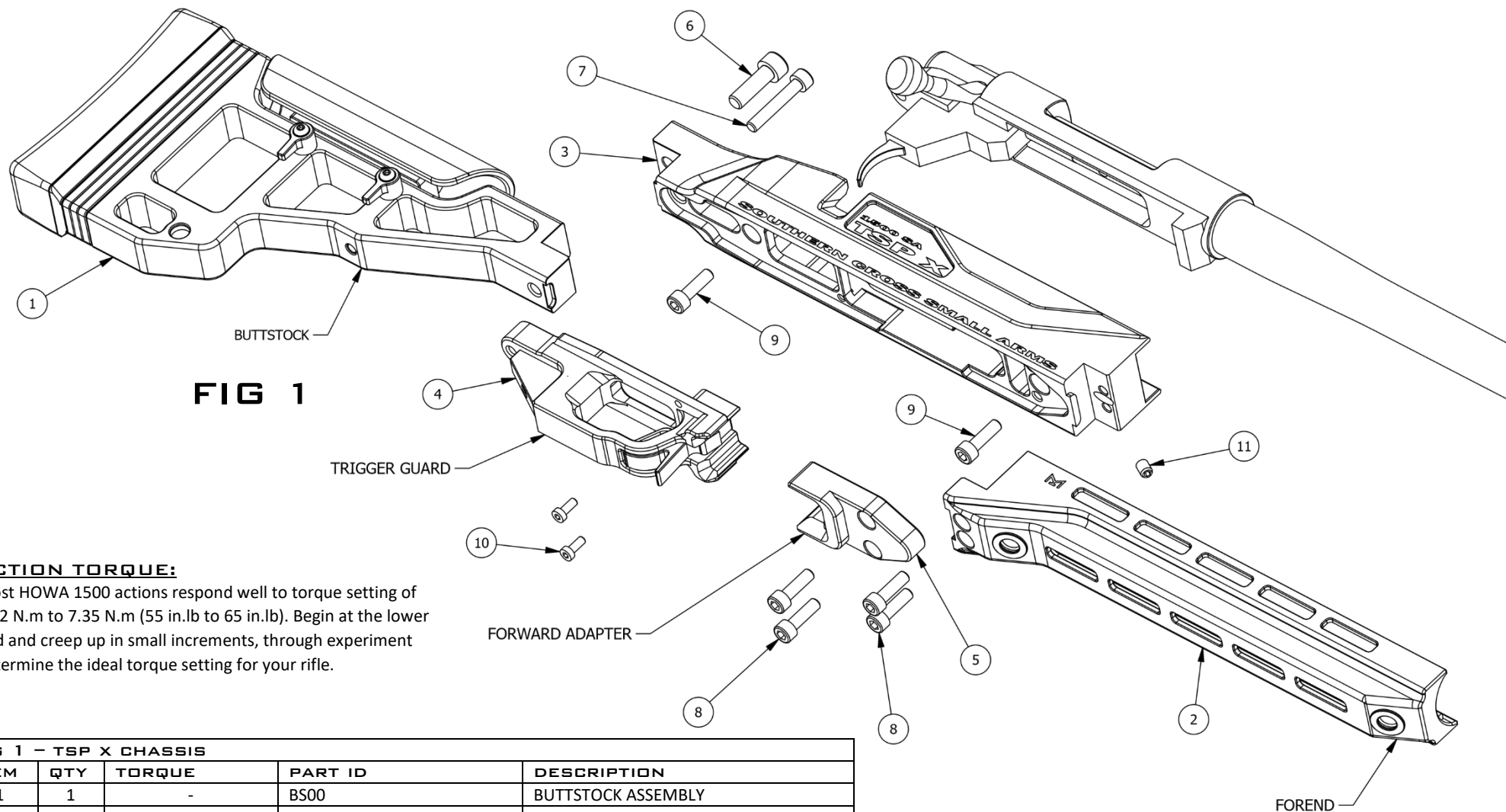


FIG 1

ACTION TORQUE:

Most HOWA 1500 actions respond well to torque setting of 6.22 N.m to 7.35 N.m (55 in.lb to 65 in.lb). Begin at the lower end and creep up in small increments, through experiment determine the ideal torque setting for your rifle.

| FIG 1 - TSP X CHASSIS | | | | |
|-----------------------|-----|--------------------|-------------------------|---------------------------------|
| ITEM | QTY | TORQUE | PART ID | DESCRIPTION |
| 1 | 1 | - | BS00 | BUTTSTOCK ASSEMBLY |
| 2 | 1 | - | FE00 | FOREND ASSEMBLY |
| 3 | 1 | - | IL02 | CHASSIS INLET |
| 4 | 1 | - | TG02 | TRIGGER GUARD SA AICS |
| 5 | 1 | - | FA02 | FORWARD SA AICS ADAPTER |
| 6 | 1 | 22N.m / 194.7in.lb | M8 x 25mm SHCS | BUTTSTOCK SCREW |
| 7 | 1 | 11N.m / 97.35in.lb | M6 x 35mm SHCS | TRIGGER GUARD SCREW |
| 8 | 4 | 16.5N.m / 146in.lb | M6 x 20mm SHCS | FORWARD ADAPTER / FOREND SCREWS |
| 9 | 2 | See Action Torque | M6 X 20mm SHCS | M6 X 20mm SHCS ACTION SCREWS |
| 10 | 2 | 1.7N.m / 15in.lb | M4 x 10mm LOW HEAD SHCS | TRIGGER GUARD SUPPORT SCREWS |
| 11 | 1 | 5N.m / 44.25in.lb | M6 X 16mm SET SCREW | RECOIL LUG CLAMPING SET SCREW |

| FIG 3 - BUTTSTOCK ASSEMBLY | | | |
|----------------------------|-----|--------------------|--------------------------------------|
| ITEM | QTY | PART ID | DESCRIPTION |
| 1 | 1 | BS00 | BUTTSTOCK FRAME |
| 2 | 1 | TSP X CHEEK PIECE | CHEEK PIECE |
| 3 | 5 | SPACER | 0-25MM ADJUSTMENT, 5MM INCREMENTS |
| 4 | 1 | RECOIL PAD | MOLDED RUBBER RECOIL PAD |
| 5 | 2 | CHEEK RISER LEVER | INDEXABLE CHEEK RISER LOCKING SCREWS |
| 6 | 2 | M5 X 40mm SHCS | RECOIL PAD SCREWS |
| 7 | 2 | CHEEK RISER O-RING | CHEEK REST ZERO RETURN O-RINGS |

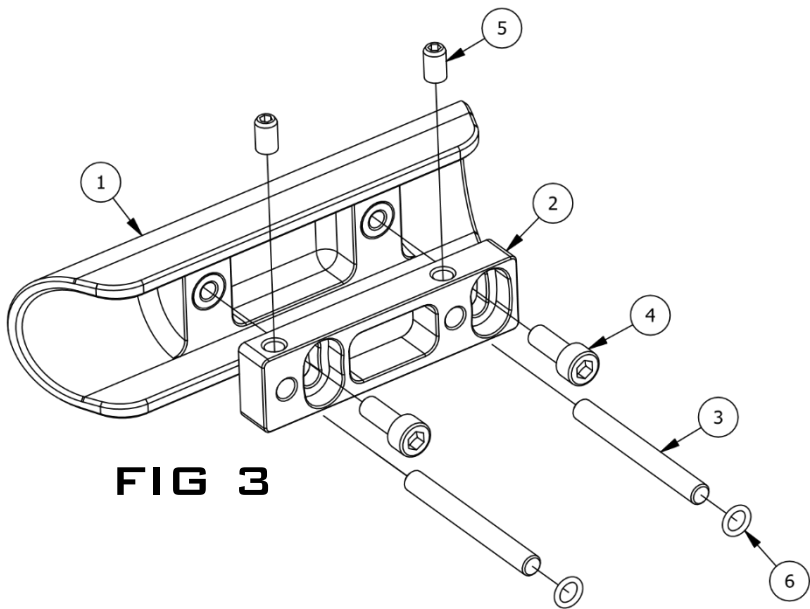


FIG 3

| FIG 4 - CHEEK REST ASSEMBLY | | | |
|-----------------------------|-----|---------------------|--------------------------------|
| ITEM | QTY | PART ID | DESCRIPTION |
| 1 | 1 | TSP X CHEEK PIECE | PLASTIC MOLDED CHEEK REST |
| 2 | 1 | TSP X CHEEK BASE | CHEEK REST MOUNTING BRACKET |
| 3 | 2 | CHEEK RISER RODS | RISER RODS |
| 4 | 2 | M6 x 12mm SHCS | CHEEK REST SCREWS |
| 5 | 2 | M6 x 8mm SET SCREWS | RISER ROD SET SCREWS |
| 6 | 2 | CHEEK RISER O-RINGS | CHEEK REST ZERO RETURN O-RINGS |

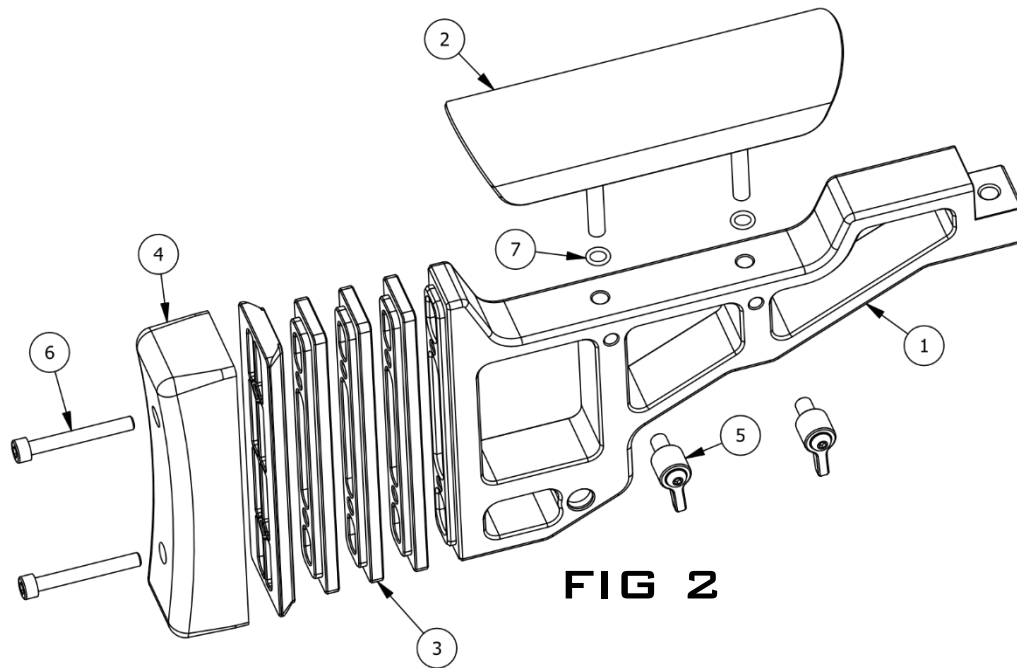


FIG 2

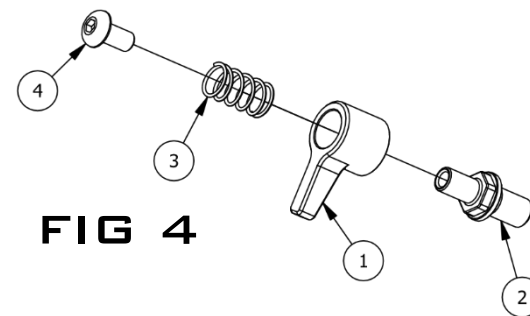


FIG 4

| FIG 5 - CHEEK RISER LEVER | | | |
|---------------------------|-----|--------------------------|------------------------|
| ITEM | QTY | PART ID | DESCRIPTION |
| 1 | 1 | CHEEK RISER LEVER | RISER LEVER |
| 2 | 1 | INDEXABLE BOLT M6 x 12mm | RISER LEVER BOLT |
| 3 | 1 | CHEEK LEVER SPRING | RISER LEVER SPRING |
| 4 | 1 | DOMED HEAD M4 x 8mm | DOMED HEAD LEVER SCREW |

| FIG 6 - FOREND ASSEMBLY | | | |
|-------------------------|-----|---------|------------------|
| ITEM | QTY | PART ID | DESCRIPTION |
| 1 | 1 | FE00 | TSP X FOREND |
| 2 | 1 | QD CUP | QUICK DETACH CUP |

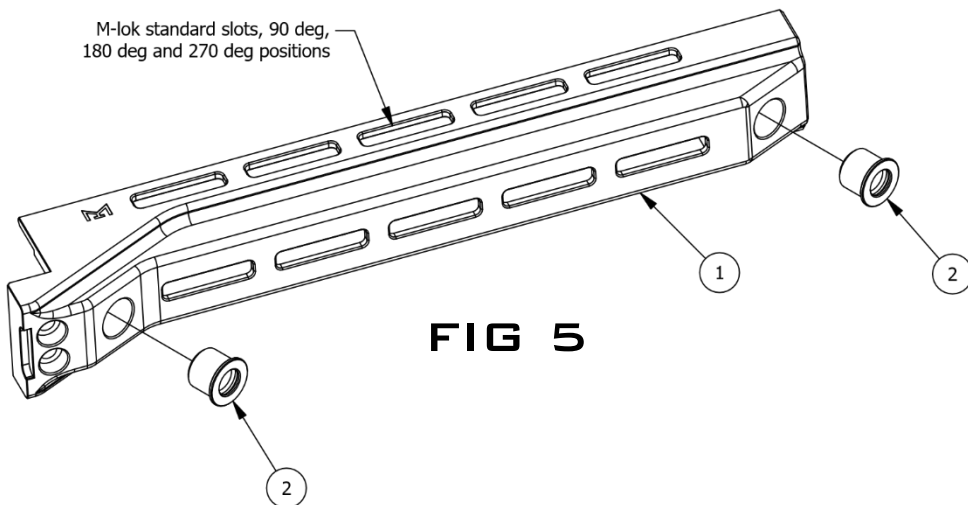


FIG 5

| FIG 7 - TRIGGER GUARD ASSEMBLY | | | |
|--------------------------------|-----|---------------------|-------------------------------|
| ITEM | QTY | PART ID | DESCRIPTION |
| 1 | 1 | TG02 | TRIGGER GUARD |
| 2 | 1 | AICS SA MAG RELEASE | SHORT ACTION MAGAZINE RELEASE |
| 3 | 1 | MAG RELEASE PIN | MAGAZINE RELEASE THREADED PIN |
| 4 | 1 | MAG RELEASE SPRING | MAGAZINE RELEASE SPRING |

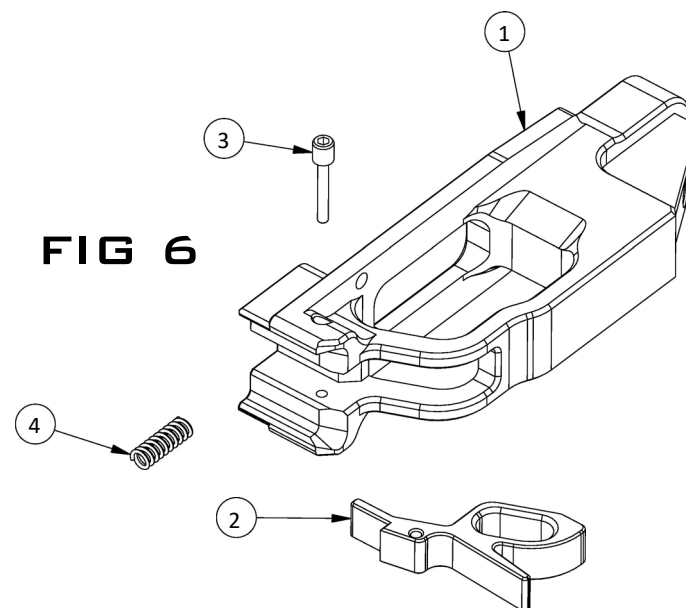


FIG 6

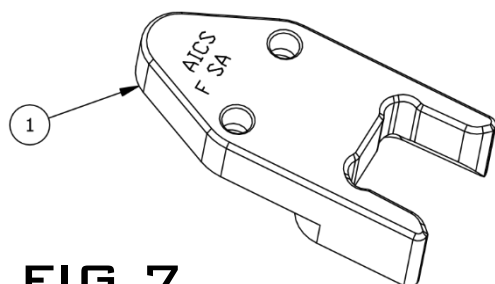
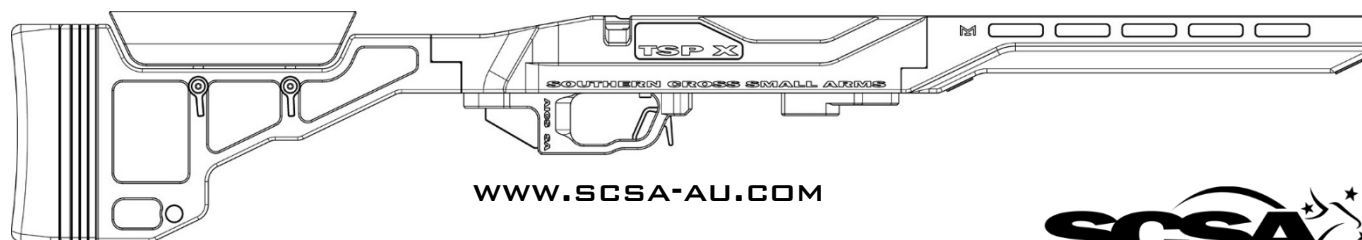


FIG 7

| FIG 8 - FRONT ADAPTER | | | |
|-----------------------|-----|---------|--------------------|
| ITEM | QTY | PART ID | DESCRIPTION |
| 1 | 1 | FA02 | FRONT AICS ADAPTER |



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