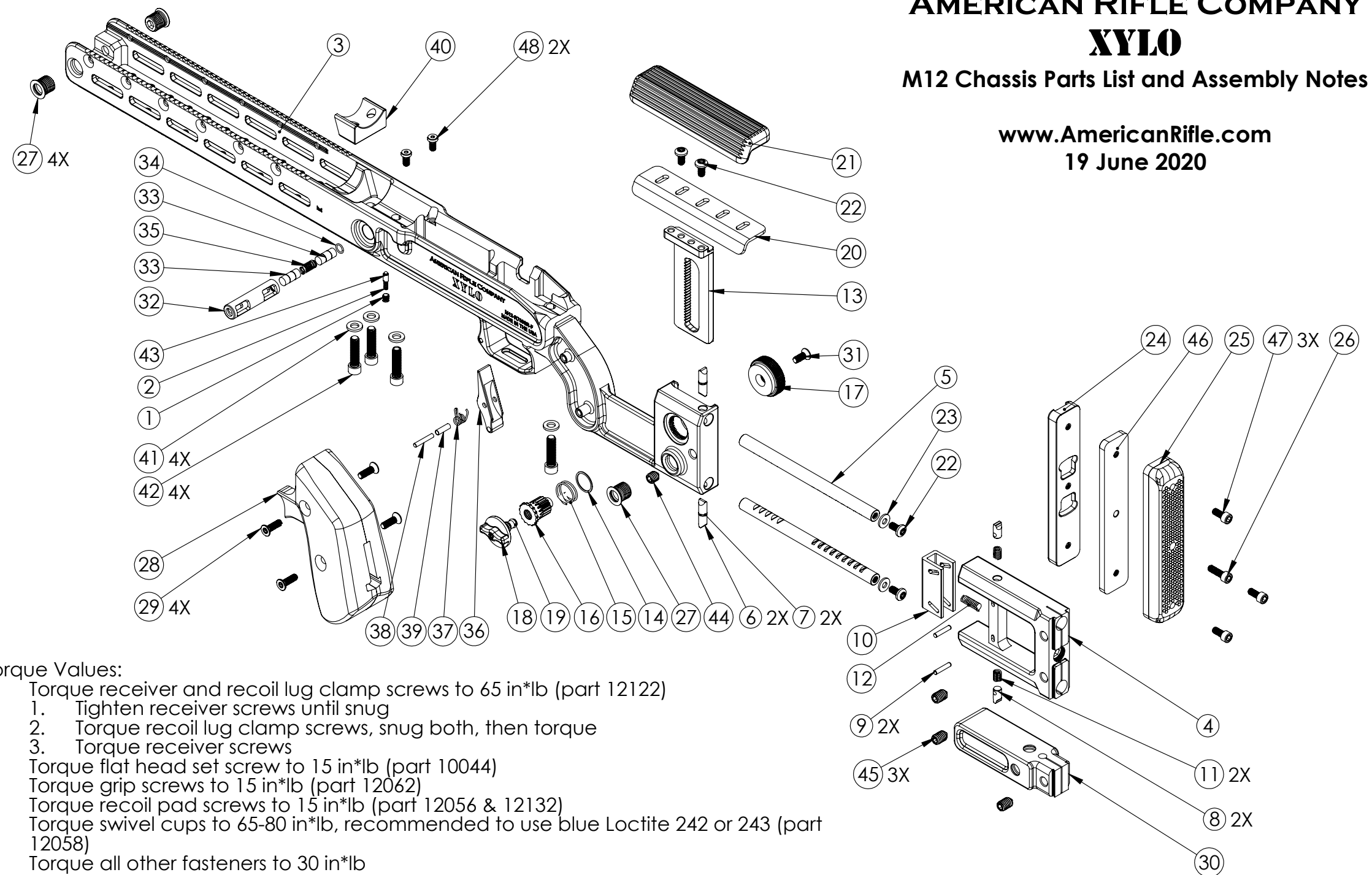


# AMERICAN RIFLE COMPANY XYLO

## M12 Chassis Parts List and Assembly Notes

www.AmericanRifle.com  
19 June 2020

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	10044 rB	flat headed set screw	1
2	10080	M12 level tube detent spring	1
3	12002 rF	M12 chassis short right	1
4	12004	M12 butt slider	1
5	12006	M12 LOP slide pin	2
6	12010	M12 LOP locking pin	2
7	12012	M12 LOP locking pin drag O-ring	2
8	12014	M12 QA LOP pin	2
9	12016	M12 QA LOP cross pin	2
10	12018	M12 QA LOP yoke	1
11	12020	M12 QA LOP pin spring	2
12	12022	M12 QA LOP yoke spring	1
13	12024	M12 cheek piece elevator	1
14	12026	M12 pinion washer	1
15	12028	M12 pinion spring	1
16	12030	M12 pinion	1
17	12032	M12 cheek elevator dial	1
18	12036	M12 cheek elevator lock	1
19	12038	M12 cheek elevator lock o-ring	1
20	12040	M12 cheek piece	1
21	12042	M12 cheek piece cover	1
22	12044	M12 cheek piece screw 10-32x0375 BSHCS	4
23	12050	M12 LOP slide pin stop washer	2
24	12052	M12 butt plate	1
25	12054	M12 recoil pad	1
26	12056	M12 recoil pad screw 10-32x0625	1
27	12058	M12 swivel cup	4
28	12060 rC	M12 grip type 1	1
29	12062	M12 grip screw 10-32x0625 T25	4
30	12064	M12 rear bag rider	1
31	12066	M12 elevator knob screw FSHCS 10-32x0500 T25	1
32	12072	M12 level vial tube	1
33	12074	M12 spirit level vial	2
34	12076	M12 level tube O-ring.SLDPRT	1
35	12078	M12 level spring	1
36	12086	M12 magazine latch	1
37	12088 rA	M12 magazine latch spring	1
38	12090	M12 magazine latch pin	1
39	12092	M12 magazine latch bushing	1
40	12094	M12 recoil lug clamp	1
41	12096	M12 washer 6mm	4
42	12122	M12 receiver screw SHCS 0250-28x1000	4
43	12124 rB	M12 detent pin	1
44	12126	M12 set screw 03125-18x0375	1
45	12128	M12 set screw 03125-18x0500	3
46	12130	M12 recoil pad interface plate	1
47	12132	M12 recoil pad screw 10-32x0438	3
48	12142	M12 magazine stop screw	2



### Torque Values:

- Torque receiver and recoil lug clamp screws to 65 in\*lb (part 12122)
  - Tighten receiver screws until snug
  - Torque recoil lug clamp screws, snug both, then torque
  - Torque receiver screws
- Torque flat head set screw to 15 in\*lb (part 10044)
- Torque grip screws to 15 in\*lb (part 12062)
- Torque recoil pad screws to 15 in\*lb (part 12056 & 12132)
- Torque swivel cups to 65-80 in\*lb, recommended to use blue Loctite 242 or 243 (part 12058)
- Torque all other fasteners to 30 in\*lb

### Adjustment notes:

- T25 Torx can be used in 5/32 inch hex adjustment screws. This single tool can be used for all adjustments.
- Cheek Elevator: loosen part 12036, then pull out on part 12032 and rotate to adjust vertically. Part 12036 is optional and can be removed if you prefer.
- Recoil pad rotation: Loosen the center screw in part 12130 to rotate the pad. If no rotation is needed, part 12130 can optionally be removed and the recoil pad attached directly to part 12052. Use the extra screw supplied in place of the original longer center screw.
- Recoil pad vertical adjustment: Loosen set screws, part 12128, and center screw in recoil pad, part 12130. The center screw in part 12130 is designed to preload parts 12052 and 12130 for locking rotation and must be slightly loosened for vertical adjustment.
- Part 12142 is optional. If magazine is not prevented from over insertion by the receiver, the screws can be installed. Gently snug screws, receiver will retain screws. Trimming of magazine may be necessary for proper fit with screws installed.