

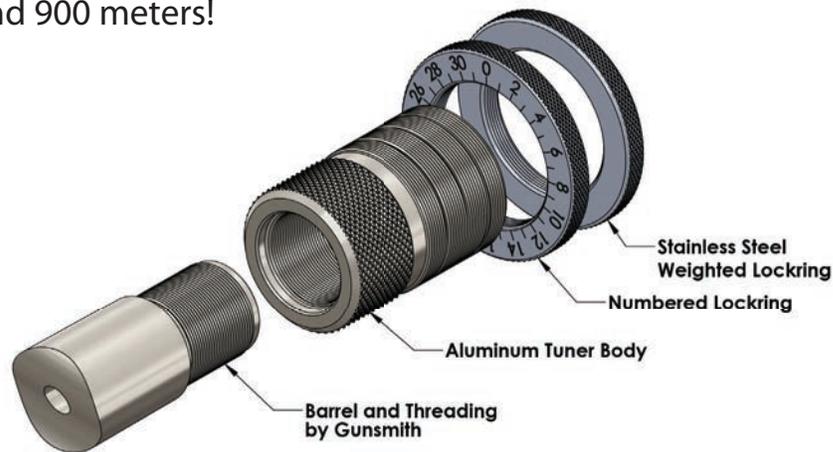


The Bald Eagle® "Shadetree" Barrel Tuner Model BE1226

Congratulations! You have just purchased one of the simplest and most incredible Tuners on the market today for precision Long Range Shooting accuracy.

This Tuner is used by some of the top Bench Rest and F-Class Shooters in the World. As of the date of this writing this tuner was used on one of the rifles that currently holds the US 4 man Team National Record for 800, 900 and 1,000 yards in F-Class. The F-Class X Ring is only 5" and hitting that ring at 1,000 yards requires the most finely tuned rifle.

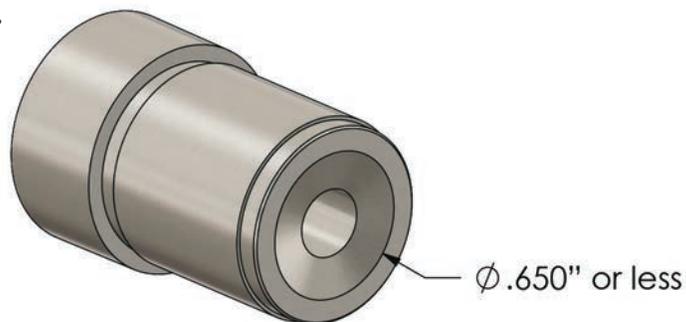
This tuner was also used to win the last three (2014, 2015, 2016) Canadian F-Class National Matches at 700, 800 and 900 meters!



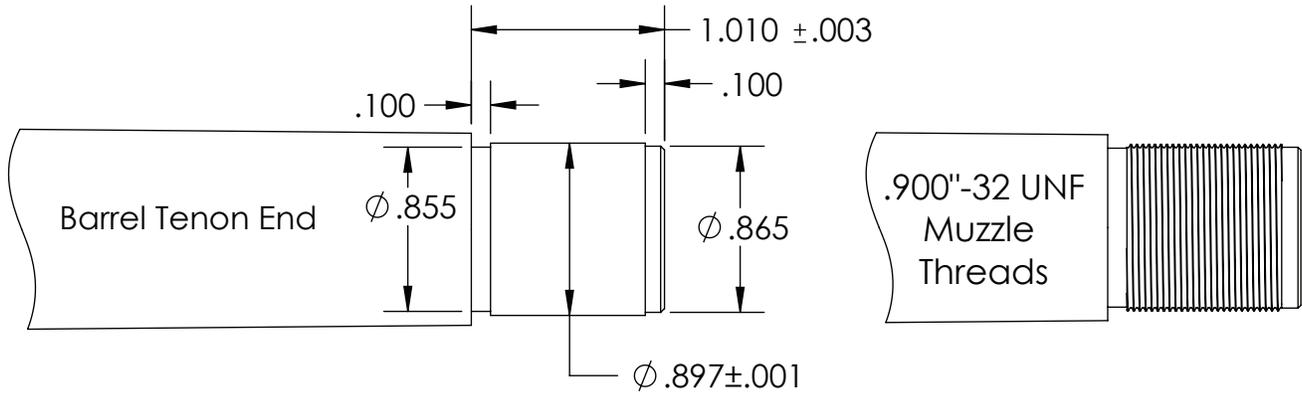
Gunsmithing Instructions

1. Center the barrel in the lathe so that the bore has less than .001" total runout.
2. Machine the face of the muzzle flat as this is the face that will contact the tuner when installed. Add a crown of your choice, but make sure that the diameter of the crowned portion does not exceed $\varnothing .650$ ".

Muzzle Crown Detail



3. Machine the tenon blank as per the sketch below. Cut the threads carefully until the tuner screws on nicely. For those able to measure pitch diameter the spec. is $.8785" \pm .001"$.



4. Deburr any remaining sharp edges and clean the threads thoroughly. Thread the tuner onto the barrel hand tight and use a feeler gauge to make sure there is a gap of at least $.020"$ between the tuner and the shoulder of the threaded tenon. **The key to the success of this tuner is having it bottom out on the crown of the barrel.**



See Page 3 for Assembly and Tuning



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Assembly and Tuning

- A. Clean the excess grease and oil from the barrel threads and screw the tuner body tightly onto the barrel. Loctite® maybe used as well (just on the barrel threads).
- B. Make sure the external threads on the tuner body are clean and screw the numbered locking onto the body so that the numbers will be visible to the shooter. Screw the unnumbered locking onto the body behind it so that it is flush with the end of the tuner and tighten the two rings together so that the number "0" is at 12 O'clock.



- C. Generally, changes can be visibly seen on the target by turning the locking rings towards the shooter every 2 to 4 numbers. For best results, turn the numbers only towards the shooter (counterclockwise when in the trigger position). Start with three shot groups at "0".
- D. If results are unsatisfactory, unlock the rings and rotate the numbered ring CCW (from the shooter's perspective), to the number "2". Lock the rings together and shoot another three round group.
- E. Continue moving the rings in 2 mark intervals until the desired group is obtained. Confirm your best setting by shooting several five shot groups.
- F. Be sure to tighten the rings securely against one another. The tuner can only function as designed when everything is tight enough and the tuner vibrates with the barrel.