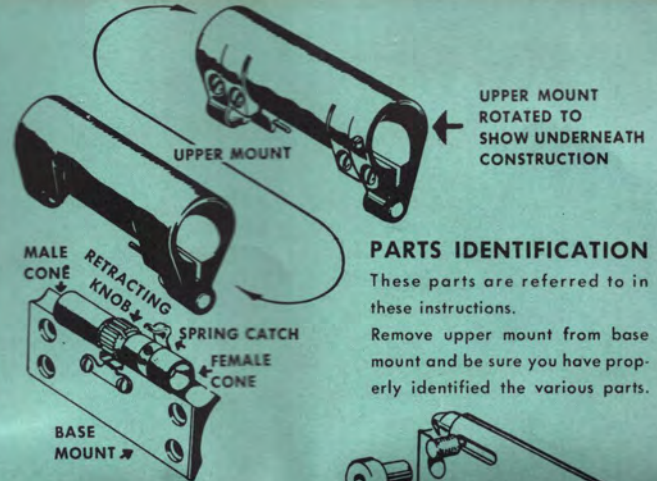


Instructions for Installation of

Pachmayr LO-SWING SCOPE MOUNT

Read instructions completely before undertaking first steps of an installation. Be sure and note special instructions where it is not necessary to inlet base mount into stock, beginning on page 3.



PARTS IDENTIFICATION

These parts are referred to in these instructions.

Remove upper mount from base mount and be sure you have properly identified the various parts.

PRECISION DRILL JIG

A simple precision drill jig is available for installing LO-SWING mounts easily. These jigs are furnished with a hardened drill and tap size bushing, also an 8-40 tap. The jig is sent upon receipt of a \$5.00 deposit, our cost, which is refunded in full upon return of the jig, bushings and tap.

METHOD OF ASSEMBLING SCOPE IN UPPER MOUNT

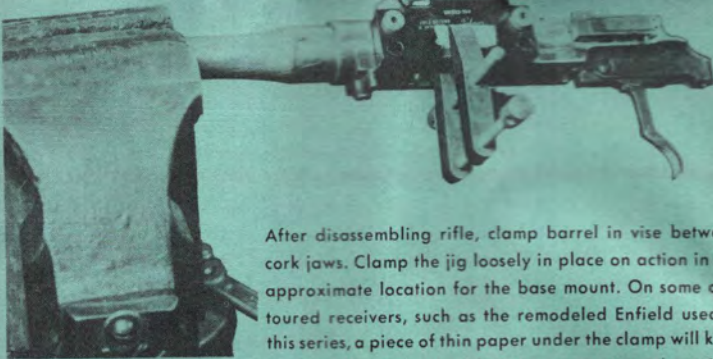
Remove ocular lens and ocular lens locking ring from scope tube. Insert scope tube in upper mount until the adjustment housing is in contact with the forward shoulder of the mount. Be sure you have the mount facing forward with the pivot points as illustrated and adjust reticule so it is in center of field of scope.

Method of Assembling Scopes in Split Upper Mounts

A special divided upper loop accommodates Challenger, Weaver K series or any other scope wherein the placement of adjusting caps interferes with desired installation, to accommodate scopes having 1", 1.020 or 1.040 tube dia., or when the removal of the ocular lens would not be good practice. Four screws hold the upper loop components.

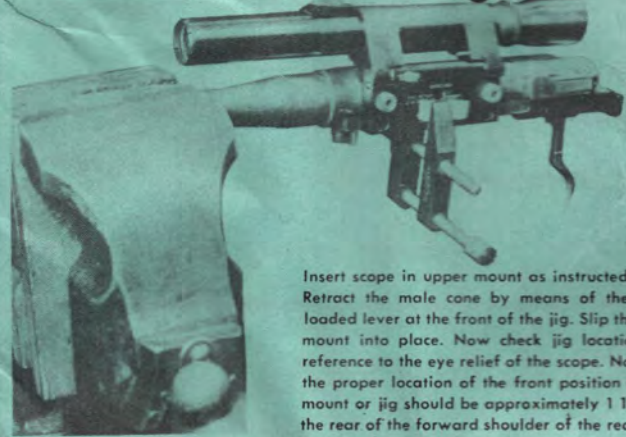
FOLLOW THESE STEPS FOR INSTALLATION

STEP 1. Position Jig on Receiver



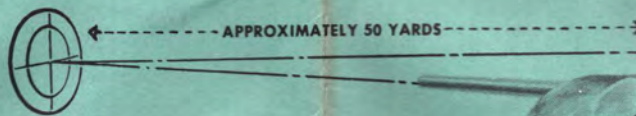
After disassembling rifle, clamp barrel in vise between cork jaws. Clamp the jig loosely in place on action in the approximate location for the base mount. On some contoured receivers, such as the remodeled Enfield used in this series, a piece of thin paper under the clamp will keep jig from slipping out of location on contoured receiver.

STEP 2. Attach Upper Mount to Jig

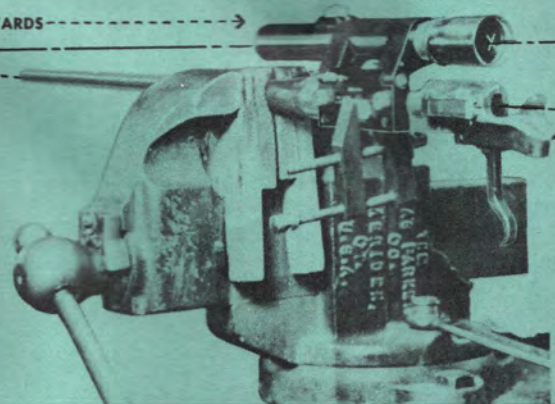


Insert scope in upper mount as instructed above. Retract the male cone by means of the spring loaded lever at the front of the jig. Slip the upper mount into place. Now check jig location with reference to the eye relief of the scope. Normally, the proper location of the front position of base mount or jig should be approximately 1 1/16" to the rear of the forward shoulder of the receiver.

STEP 3. Bore Sight for Exact Jig Location

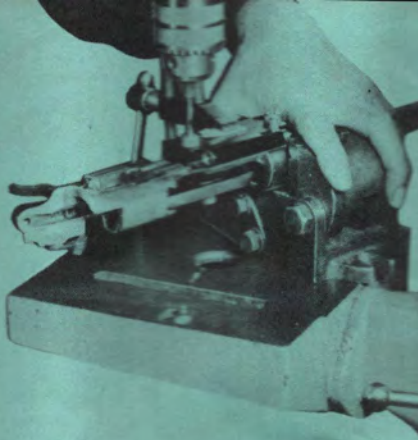


With the upper mount containing the scope in position on the jig, and jig clamped tightly on to the receiver, center the bore on a target approximately 50 yds. distant. If possible, it is best to sit down so that your body is still and only the head is raised and lowered between the scope and the bore for aligning. After lining up the bore by sighting through the barrel, move the mount until the scope and bore are both on the target. Be sure the reticule of the scope is centered in the scope. Tighten clamp holding drill jig without moving jig.



STEP 4. Drill Receiver

Being careful not to move the jig, insert the hardened drill bushing and drill the holes through the receiver with a #28 drill, being careful not to drill into barrel or receiver lugs. If the drill does not cut, spot anneal, being careful not to overheat. Use a drill press vise for holding rifle steady, not vee blocks.



STEP 5. Tap Receiver

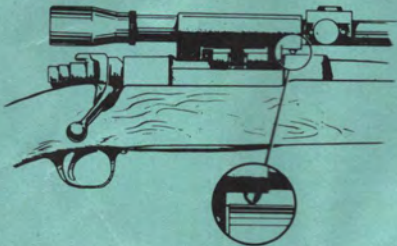
Using the 8-40 tap furnished (which is the exact size for the screws furnished with the mount) tap all four holes. Back off frequently to clear chips and use a light cutting oil. Do not force tap, and we recommend using the tap that is furnished with our mount.



STEP 6. Attach Mount and Adjust Spring Catch



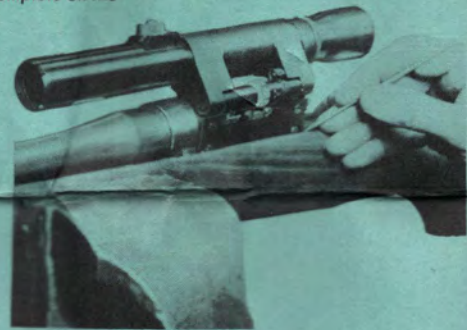
After all holes are tapped, remove jig and attach base mount to receiver. Check screw length first and if necessary, grind screws so that none extend through the walls of the receiver. Adjust spring catch so that stop pin on the bottom forward section of the upper mount (see drawing at left) is in contact with the receiver and the scope is at the lowest possible shooting position. This stop pin may be ground shorter if necessary to bring scope to lowest possible position. (Take care that bolt will clear scope and function properly).



through the walls of the receiver. Adjust spring catch so that stop pin on the bottom forward section of the upper mount (see drawing at left) is in contact with the receiver and the scope is at the lowest possible shooting position.

STEP 7. Scribe Stock for Inletting

With the installation now complete on the receiver, set the barrel in place and lightly scribe the stock for inletting. It is best to scribe the lines slightly under size so base can be carefully inletted.



STEP 8. Inlet Stock



Remove wood carefully with well-sharpened chisels. After the inlet section begins to approach a fit, blacken or chalk the base mount and repeatedly spot and inlet until you have a good fit. By holding the barrel tight at the fore-end position and attempting to rock the tang, you can tell when the inletting is complete so the receiver will seat properly.

Preceding Instructions on Pages 1 and 2 apply to the following:

- Springfield
- Enfield
- Mauser — Carbine, Rifle, Magnum
- Newton
- Winchester
 - Model 70
 - Model 54
 - Model 52
 - Model 43
 - Model 75
- Remington
 - Model 721
 - Model 722
 - Model 30
 - Model 30S
- Remington
 - Model 720
 - Model 510
- Savage
 - Model 20
 - Model 40
 - Model 45
- Stevens 325C
- Mannlicher-Schoenauer
- Mannlicher-Haenel
- Krag
- Brno
 - Model B21
 - Model B22
- Brno Hornet

Special INSTRUCTIONS

LEVER ACTION TOP EJECTION GUNS

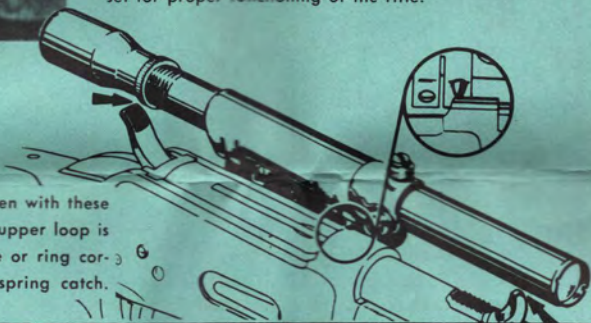
These instructions apply to:

- Winchester Model 64
- Winchester Model 65
- Winchester Model 71
- Winchester Model 86
- Winchester Model 92
- Winchester Model 94
- Winchester Model 95



1. To permit the ejection of empty cases through the top of the receiver, we recommend the scope be mounted off-set to the left as shown. Locate and use jig as previously instructed excepting (1) to determine scope location use iron sights or a prismatic bore sighting device and (2) eject an empty case, to be sure scope is far enough off-set for proper functioning of the rifle.

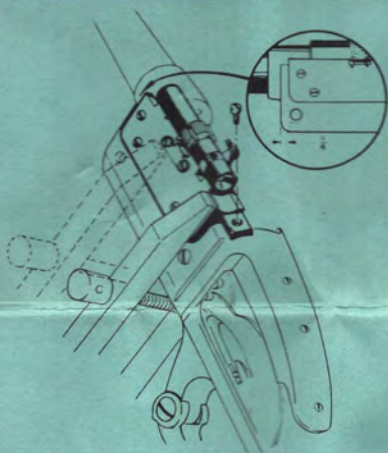
2. Particular care should be taken with these guns to see that stop pin on upper loop is positioned on receiver bridge or ring correctly, and then secured by spring catch.



Special INSTRUCTIONS

FOR SAVAGE MODEL 99 and REMINGTON MODEL 760

No jig is furnished for these guns

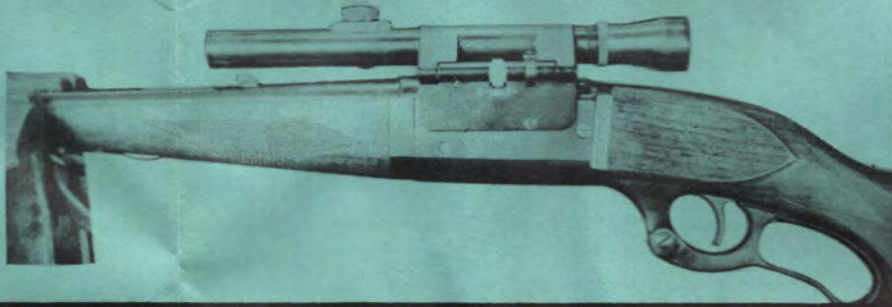


1. Using the base mount, with upper mount containing scope in place, locate so scope is over the center of the receiver. Remove upper mount after clamping base securely in location shown above. Center punch, drill and tap rear hole. Screw base to receiver at this single point.



2. Move clamp to other end of base and re-assemble upper mount to base. Line up scope and bore of rifle by raising or lowering rear of telescope until both bore and scope bear on the target (see step 3). Remove upper mount from base, scribe, and spot drill and tap remaining holes.

3. Grind screws proper length, insert and tighten firmly. Line up cross wire or post in scope and tighten clamp screws in upper mount. Illustration below shows finished installation.



Special INSTRUCTIONS

SIDE EJECTION GUNS HAVING FLAT SIDE RECEIVERS

Apply to:

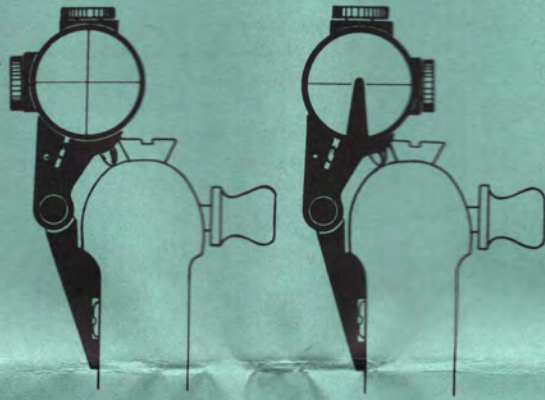
- Winchester
 - Model 61
 - Model 63
 - Model 12
- Remington
 - Model 121
 - Model 14
 - Model 141
 - Model 24
 - Model 241
- Marlin
 - Model 36
 - Model 39
- Garand
 - Model M1
- Browning
 - Model 12



Remove all working parts from action. Assemble scope in mount. Place mount and scope on left side of action, far enough forward to permit stop pin to rest on receiver. Raise or lower mount to bring scope directly over bore. Scribe, center punch, drill (#28) and tap forward hole. Secure mount with one screw and bore sight scope. Clamp securely, remove upper mount, spot, drill and tap other holes. Install base securely and adjust spring catch. (For easy installation, we recommend use of our drill jig).

Special INSTRUCTIONS

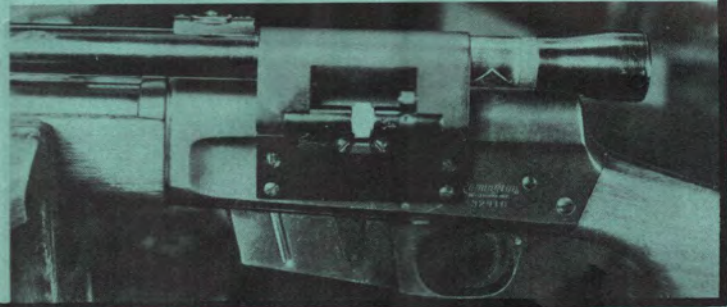
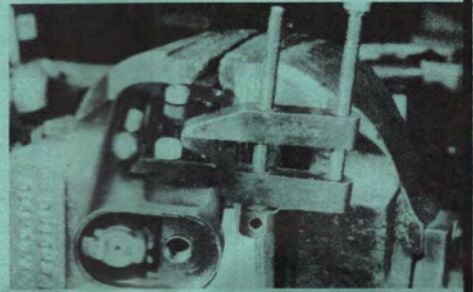
REMINGTON MODELS 8 and 81



1. The base mount is shaped to fit receiver as shown above. A scope having a post reticule must be positioned forward far enough so that empty case, when ejecting, will clear windage adjusting screw. Cross hair reticule permits mounting closer to eye, since scope may be rotated $\frac{1}{4}$ turn, as shown, so shells will clear scope when ejected.

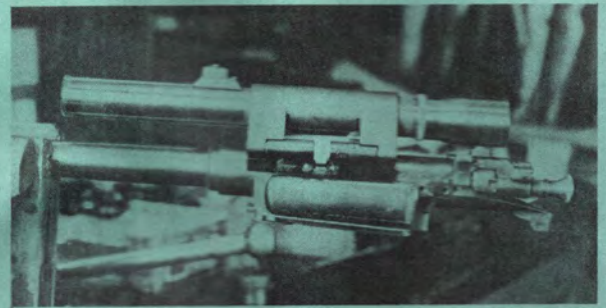
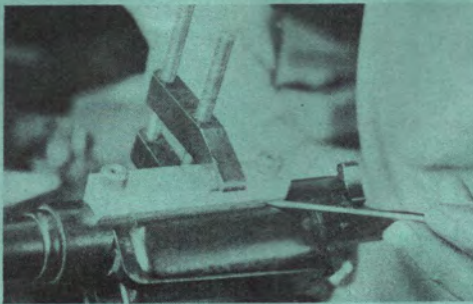
2. With working parts removed from action, place radius of jig or base mount snugly against mating surface on receiver and proceed as previously described for other models.

3. To bore sight, clamp barrel securely in vise with cork jaws. Remove action from barrel and sight through bore. Without moving barrel, replace action and adjust scope to target. A prismatic bore-sighting device may better be used (see step 3). This will allow you to leave barrel and action together for an easier installation.



Special INSTRUCTIONS

KRAG



On the Krag, care should be taken so that shell will properly eject. Centerline of scope will have to be offset to left, approximately $\frac{3}{8}$ inch, approximate location, so bottom of base mount is about $\frac{1}{32}$ inch from top of magazine plate. Above illustration (left) shows drill jig in approximate position. Be sure stop pin rests on receiver bridge. Adjust spring catch so scope is held securely.

The complete Krag installation is shown above.

NOTE:

The following guns should be sent to Pachmayr Gun Works for proper installation: *Mannlicher, Mannlicher-Schoenauer, Mannlicher-Haenel.*

PACHMAYR GUN WORKS, Incorporated

1220 South Grand Avenue



Los Angeles 15, California