

WEAVER QWIK-POINT INSTRUCTIONS

PROCEDURE FOR MOUNTING BASE AND S-1 QWIK-POINT SIGHT ON AUTOMATIC AND PUMP SHOTGUN RECEIVERS.

Gunsmith's Information

1. Base is mounted on left side as far back on receiver as possible without running into radius at back of receiver.
2. Use a vernier protractor or combination square with blade (Figure A(1) that can be set at 45° angle. The right side of the shotgun receiver is used as a reference surface. Set base (Figure A(2) on receiver radius with two tapped holes toward bottom. Base should be located under 45° blade so that blade will contact base on the top of base. Slide square down side of receiver until blade touches base top and "square up" base on receiver at 45° angle.
3. Using scribe, transfer holes from base to receiver.
4. Use center punch to pick up center of above scribed holes.
5. Drill 6 screw holes in the receiver with #32 drill (.116" dia.). Drill all way through. We recommend the removal of all parts from inside the receiver before drilling and tapping.
6. Tap holes with #6-48 tap.
7. Shotgun receivers are manufactured with many different inside configurations, variations in the width of receivers, and various radii on the top corners of the receivers. We furnish 12 screws (6 each of two different lengths) to allow the installer to custom fit the screws to the receiver for maximum thread engagement. Clean tapped holes. Place base on receiver and install screws. Make sure that the screws selected are the best length. In some receivers a combination of long and short screws might be preferable. If screws project into the receiver, remove one screw at a time and grind off the end until each screw is the precise length needed.
8. After proper fitting of screws, attach base to receiver using a drop of Loctite stud lock #73-21 on each screw. Do not get Loctite into receiver.
9. Allow to dry overnight.
10. Attach sight with cone screws. Use a screwdriver with large handle and a ¼ to ⅝" blade. **Tighten both screws as tight as possible.**

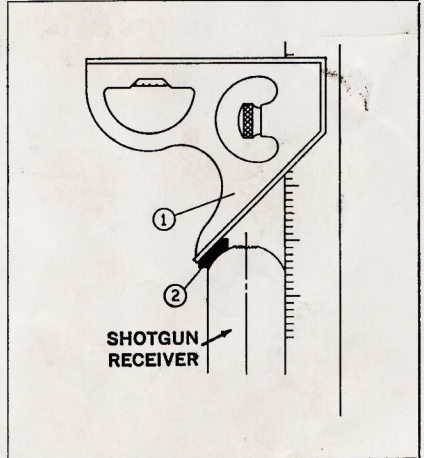


FIGURE A

SIGHTING-IN THE S-1 QWIK-POINT FOR SHOTGUNS

1—How to align Qwik-Point by using factory installed iron sight.

Place the shotgun in a vise or some fixed position with the iron sights precisely lined up on a target about 20 yards distant. Remove the turret caps and make any adjustments necessary in windage and elevation to line up the Qwik-Point dot with the target. Replace the turret caps.

2—Test firing. Target should be placed against a soft dirt bank or other safe position.

Test fire the S-1 Qwik-Point at one of the following distances. It is easier to determine the center of a shotgun pattern at short range.

On Full Choke guns	test fire at 20 yards
On Modified Choke	15 yards
On Improved Cylinder	10 yards

Use a bench rest or other steady position. Align the Qwik-Point dot with the target and fire. Make any adjustments necessary in windage and elevation to bring the center of pattern onto the target.

Each click of the windage and elevation screws will change the center of your pattern as shown below:

	20 yards	40 yards
S-1 Qwik-Point per click	⅛"	¼"

PROCEDURE FOR MOUNTING THE R-1 QWIK-POINT ON RIFLES.

Most rifles are drilled and tapped for Weaver Detachable Top Mount bases. The R-1 Qwik-Point is shipped complete to fit on these bases.

1. Remove the factory installed screws and attach Top Mount bases to the rifle. The correct base numbers for most rifles are shown in our W. R. Weaver Company catalog. If you have a rifle that is not listed, write to us for correct base numbers.
2. Due to the difference in spacing of bases on some rifles, the R-1 Qwik-Point has two optional positions for the crossbolt that fits into the groove in the rear base. The optional position is covered by the mount clamp on one side and by a friction-fit push-out plug on the other side. If it is necessary to use the optional position, remove the thumb nut, remove the friction-fit plug, change the crossbolt to the optional position, reverse the mount clamp, replace the thumb nut, and insert the friction-fit plug in the remaining hole.
3. Install the R-1 Qwik-Point on the rifle. Loosen the thumb nut enough to allow the mount clamp to fit over the rear base. Position the crossbolt in the groove in the base. Snap the Mount spring over the front base. Push the R-1 forward and tighten the thumb nut with a screw driver.

R22 Qwik-Point for .22 Rifles.

The R22 is shipped complete with Tip-Off Mount to install on .22 rifles with $\frac{7}{8}$ " grooved receivers.

SIGHTING-IN THE R-1 AND R22 QWIK-POINT FOR RIFLES.

1—Bore sighting (a collimator can be used in lieu of bore sighting). Place the rifle in a vise or other fixed position with the bore precisely lined up on a target about 20 yards distant. On bolt actions this can be done by removing the bolt and looking down the bore. On lever actions, pump and automatic rifles use a small piece of mirror held at an angle in the breech. Remove the turret caps and make any adjustments necessary in windage and elevation to align the Qwik-Point dot with the target. Replace the turret caps.

2—Test firing. Test fire the R-1 and R22 Qwik-Point at 20 yards. Target should be placed against a soft dirt bank or other safe position to prevent a ricochet. Use a bench rest, prone or other steady position to fire a three shot group. Make any adjustments in windage and elevation to bring the group to the aiming point. Fire another group. The center of the group should be on the aiming point. If not, repeat the process of adjustments. Each click of the windage and elevation screws will change the point of impact as shown below:

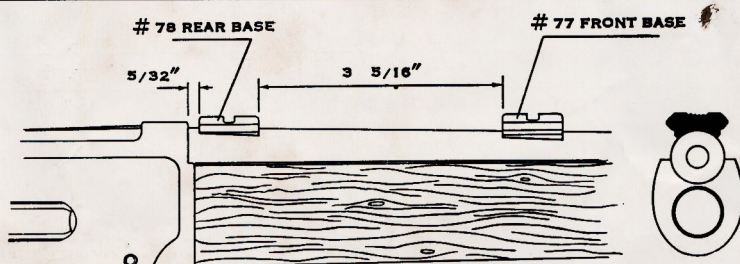
	20 yards	40 yards	80 yards
R-1 and R22 Qwik-Point per click	$\frac{1}{8}$ "	$\frac{1}{4}$ "	$\frac{1}{2}$ "

Center fire rifles that are sighted-in at 20 yards will shoot from $\frac{1}{2}$ " to $1\frac{1}{4}$ " high at 40 yards and from $1\frac{1}{2}$ " to 3" high at 80 yards due to differences in caliber and ammunition.

DRILLING AND TAPPING THE MODEL 94 WINCHESTER RIFLE FOR MOUNTING THE R-1 QWIK-POINT.

Gunsmith's Information

- 1—The Model 94 uses a #78 rear base and a #77 front base. Both bases are tapered. The thin end of both bases must be to the rear toward the receiver.
- 2—Both bases are installed on the barrel. The rear end of the #78 should be about $\frac{5}{32}$ " in front of the receiver. The spacing between the front end of #78 and the rear of the #77 is about $3\frac{5}{16}$ ".
- 3—**Model 94 in 30-30 Winchester and 32 Winchester caliber.** Use a #32 drill (.116" dia.) drill the screw holes for the bases. The 30-30 caliber barrel thickness under the #77 base is .195". **Do not drill holes through the barrel into the bore.** Holes should be drilled .170" deep maximum if measured from the point of the drill, or .135" maximum if measured from the cutting edge (or lip) of the drill. Flatten bottom of drilled hole with a flat bottom drill.
- Model 94 in 44 Winchester Magnum caliber.** Instructions for drilling and tapping for the #78 rear base are the same as for the 30-30 above. Instructions for the #77 front base. Using a #32 drill (.116" dia.) drill the screw holes for the base. The 44 Winchester Magnum barrel thickness under the #77 base is .137". **Do not drill holes through the barrel into the bore.** Holes should be drilled .112" deep maximum if measured from the point of the drill, or .077" maximum if measured from the cutting edge (or lip) of the drill. Flatten bottom of drilled hole with a flat bottom drill.
- 4—Tap holes with a #6-48 tap. Tap as deep as possible.
- 5—Attach bases to the Model 94 rifle.
- 6—There are optional positions for the crossbolt on the R-1 Mount. The crossbolt should be in the forward position for mounting on the Model 94. See mounting instructions for the R-1.



Side View—Model 94 Winchester Rifle

End View