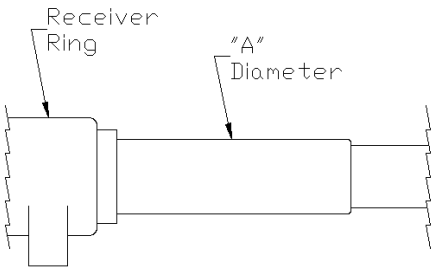

REMEMBER:

Before installing or adjusting your sights, unload and/or check to ensure the firearm is unloaded.

XS Clifton Scout Scope Mount

*not likely compatible with featherweight barrel.

1. UNLOAD THE RIFLE. Check again to verify the UNLOADED condition of the rifle. You can NEVER be too careful about this.
2. Strip rifle to bare receiver and barrel.
3. Any refinishing of the barrel or barreled action MUST be completed BEFORE the mount is installed. Some refinishing processes (bluing, Parkerizing, etc.) can damage the mount. Check for process compatibility with aluminum.
4. If the rifle is a Military Mauser, the original rear sight base must be removed. At the front of the sight leaf, where it pivots, press the leaf downward until it can be slid rearward clear of the base. On some models there is a pin through this pivot point that must be driven out first. Remove the leaf spring and the locator screw on the sight base. Clamp the barrel muzzle down in a vise. Allow 4-6 inches for the sight base to be driven off its mounting step. Using a regular propane torch, slowly heat the barrel and sight base until the soft solder starts flowing from under the base. Drive it forward until it clears the step that it sits on. Allow barrel to cool, then use a file or emery paper remove the excess solder leaving only bare metal.
5. Measure the barrel shank at the "A 'diameter point, round up to the neared .010” (e.g. .982” rounds to .99”) and add .010 to that measurement to obtain the proper Inside "B" Diameter of the mount EXAMPLE: barrel shank diameter measures .96 add .010 = .97 part# 097.
6. If the rifle has a commercial barrel, then it will need to be turned on a lathe. Ideally the first step would be turned to a 1.14 diameter for .270 inches, and the second step turned to 1.050 diameter for an ideal length of 1.75 inches. Check the barrel diameter at 3.25 inches from the receiver face to ensure that the diameter is below .935". If not, a third step will have to be turned to clear the mount.
7. When the barrel is ready for the mount, clean both the barrel and the inside of the mount carefully to ensure a good surface for the Acraglas to bond to. Slide the mount onto the barrel and lock in place using the two set screws. Tighten the front screw first, putting a slight forward cant on the mount. If the set screws in your barrel/mount combination protrude from the mount, then lightly coat the threads with wax before installation so they can be removed later. Check the alignment carefully. With the mount in place, seal off the receiver/mount joint with modeling clay. Lightly coat the outside of the mount with a car wax so the epoxy does not stick. Place the action upside down in a vise so that the angled front portion of the mount is not quite level.
8. Mix the Acraglas per manufacturer’s instructions. Slowly pour the epoxy down into the gap between the barrel and mount. Let the epoxy settle and keep adding until the mount is 80-90% filled.
9. Let epoxy cure for several hours in the vise. After several hours, clean any excess or spills with rubbing alcohol and a clean cloth. Place the barrel in an undisturbed position for 24 hours, allowing the epoxy to cure.
10. Finish clean up and inlet the scout mounted barreled action into the stock.