



**REMEMBER:**

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

**XS Lever Scout Mount for Winchester 94 AE Rifles**

Package includes: scope mount, dovetail pillar, Hex pillar screw, Hex wrench for this screw, pillar nut, two 3/16th long #6 x 48 oval head screws, ¼-28x 3/16 headless Hex jackscrew, Hex wrench for this screw.

Tools needed for installation: Screwdrivers of various sizes to fit the weaver screws, the pillar nut and the screws of the rifle magazine tube and forearm assembly, a pencil, a small sharp knife or ¼" round chainsaw file, Isopropyl alcohol, Vaseline, Q-tip swabs, non-marring punch (brass, delrin, nylon), MarineTex or J-B Marine Weld epoxy require, a plastic knife or wooden tongue depressor to mix and apply the epoxy.

Installation of this mount will require the removal of the magazine tube assembly and forearm to epoxy the mount onto the barrel. The epoxy is used to fill the gap between the barrel and scope mount and custom fit the mount to your rifle. Removal of these items will give you better access to the area and prevent epoxy from getting on the forearm.

1. UNLOAD THE RIFLE. Check again to verify the UNLOADED condition of the rifle. You can NEVER be too careful about this.
2. Using a sharp pencil, mark a line along the top edges of the forearm.
3. Loosen and remove the screw at the front of the magazine tube. Then remove the magazine tube plug, magazine spring and magazine follower. CAUTION: the plug is under tension.
4. Loosen and remove the magazine and forearm band/cap screws. Then remove the magazine tube and forearm. The hanger for the forearm cap does not have to be removed if your rifle is so equipped.
5. Remove the factory rear sight and plug screws from the front of the action.
6. Disassemble the Mounting Pillar and try it in the dovetail slot on the barrel. Try from both sides as one might start easier. If it will not readily start in the slot, then metal needs to be removed from the bottom of the Mounting Pillar with a file or Emory paper until it starts into the dovetail slot. The closeness of the fit is not critical, as the Jack Screw will take up any slack. Tap the Mounting Pillar into the dovetail slot using a non-marring punch until centered.
7. Try the mount on the rifle. Verify that the holes at the rear lineup with the ones on the top of the receiver and that the mount will fit over the dovetail pillar. If the dovetail pillar does not lineup, remove metal from the rear portion of the pillar hole with either a ¼" round chainsaw file or a sharp knife. Cut slowly and carefully; do not to remove too much metal.
8. Once the mount fits correctly, install the weaver screws and tighten them just enough to keep the mount in place.
9. Due to variations in the Winchester rifles, you will have to adjust the mount/barrel angle using the front jackscrew until the mount is parallel with the bore centerline. Use the previously scribed pencil line and the bottom edge of the mount as a guide. The top of the rail should be parallel with the bore or the nose of the mount tipped down slightly.



10. Install pillar nut and tighten just enough to snug mount in place. Hold the rifle to your shoulder and look at the mount in relationship to the front sight. The centerline of the mount should match that of the front sight. If needed, adjust the mount right or left by shifting the mounting pillar in the dovetail.
11. Remove the mount. Clean and degrease the barrel and the underside of the mount with isopropyl alcohol.
12. Use a Q-tip to apply a small amount of Vaseline to the action screw holes and the top of the receiver. This is to keep any epoxy out of the screw holes.
13. Mix together approximately half of each tube of Marine-Tex epoxy. This epoxy will begin to set in 5 minutes and cure within 1 hour. Before mixing the epoxy together, be sure you are ready to complete the installation.
14. Apply the epoxy in a thick ribbon along the center of the underside of the mount on the portion of the mount that covers the barrel. There should be more than enough epoxy to fill the gap between the barrel and the mount.
15. Place mount on the rifle and install the weaver screws and pillar nut. Tighten them just enough to hold the mount in place while the epoxy cures.
16. Recheck the mount alignment and adjust as needed.
17. Use a Q-tip and alcohol to clean up the excess epoxy that has squeezed out from under the mount and through the pillar hole. It is not necessary to fill the gap. A gap between the mount and barrel is expected given the epoxy provides at least 75% contact.
18. Set the rifle aside, upside down, and allow the epoxy to cure for 24 hours.
19. After the epoxy has cured, tighten all attaching screws. Torque to 20 inch pounds
20. Reassemble the magazine and forearm onto the rifle.
21. When mounting the scope, be sure that the rear of the scope is far enough forward to clear the ejection port.

\* Very early Angle Eject Model rifles and Model 94 rifles made prior to the current Angle Eject series will require the front receiver bridge to be drilled and tapped for 2x #6 x 48 screws using the mount as a template to locate the holes. Also center of rear sight dovetail must be within the range of 3.875-4.00" from front of receiver.