

SCOPE MOUNT INSTRUCTIONS



Please understand that information and tips provided here are meant to benefit our customers who have carefully considered the possible hazards of modifying a firearm. We, by no means, want to alleviate your concerns regarding the safety and value of your firearm should you make a mistake. Please consider your skill level, experience, and competency before purchasing any of these tools or trying to use these methods.

Funding USA LLC accepts no responsibility for results that may occur by following these tips. If you have already purchased the scope mount, and are having second thoughts about drilling your receiver, please consider taking the scope mount to a qualified gunsmith and ask them to perform the work.

Make sure also to verify the legality of your modifications. State, Local, and Federal laws apply.

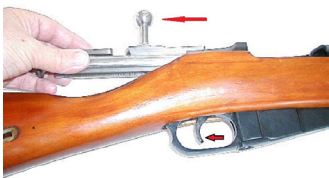
INCLUDED IN BOX

- (1) DELTAC[®] receiver Scope mount
- (1) ATI Bolt handle MOI700
- (1) 5/32 short arm hex key
- (1) 10-32x1/2 hex screw
- (1) M35 drill bit #21
- (1) hand plug tap 10-32
- (1) Transfer punch
- (1) Scope Mount Instruction



DRILLING INTO CHAMBER AREA (INCORRECT MOUNT POSITIONING) MAY RESULT IN INJURY OR DEATH

STEP 1



Point the rifle in a safe direction and place the safety in the "on" position. Next, remove the magazine, pull back the bolt, and carefully inspect the chamber to be sure the rifle is unloaded.

Remove the bolt from the action by squeezing the trigger and pulling out towards the rear.

STEP 2

Remove the barreled action from stock.

STEP 3

Place the scope mount (holes forward) on the receiver flush with the receiver ring front face. Square the mount on the receiver using the flat area on the bottom of the receiver magazine well.

STEP 4



Clamp securely in position. Double check positioning for squareness. A drill press is recommended for this step. Caution: Make sure the mount and drill are square and centered.

STEP 5



Use the supplied transfer punch to create a dimple where you will be drilling. Make sure the dimple is centered.

STEP 6



With the mount still clamped, use the supplied #21 drill bit, lower the drill press until the drill bit contacts the dimple, drill slowly so as not to burr the inside of the receiver below the hole. (It is recommended to use cutting oil during this process.) Drill speed should be between 1000 and 12000 R.P.M.



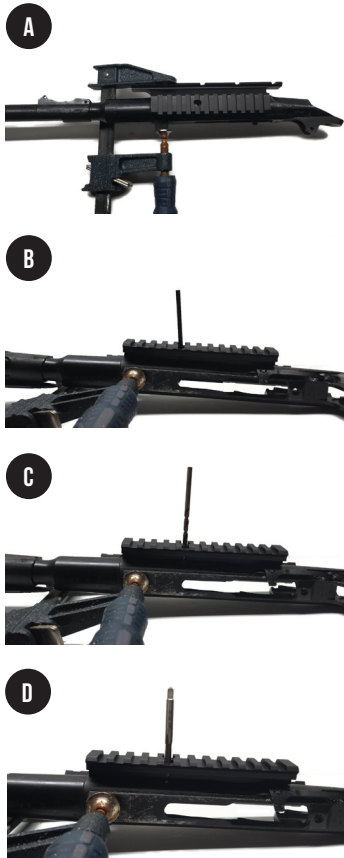
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STEP 7



With the mount still clamped, use the supplied 10-32 tap (and oil), to tap through the receiver. Without unclamping, clean area and securely screw in the supplied 10-32 x 1/2" screw. Repeat this process for the forward hole.

STEP 8



Repeat Steps 5 through Step 7 for the side hole.

STEP 9

Remove the scope mount and the action. Remove any burr(s) from the tapped holes.

STEP 10

Set the scope mount in place, install and tighten screws. (Thread lock is recommended.) Check screws to be sure they do not protrude below the inner surface of the receiver.
Note: Mount must be used with a bent bolt handle or bolt will not operate.

STEP 11

Install the barreled action back into the stock by placing the action into the stock.

STEP 12

Install both the bottom magazine screw and the top receiver screw to secure the barreled action to the stock.

STEP 13

Install the bolt assembly by squeezing the trigger and pushing the bolt into the chamber.

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