



Scope Mount Installation Instructions .303 Enfield No.4

Scope mounting brackets are designed to accommodate all rings and scope fittings based upon the Weaver type dovetail and are unique. They normally require no gunsmithing and are designed to fit Enfield No.4 pattern receivers avoiding the distortion appearing on the other similar looking brackets. In addition, these mounts are engineered to sit at a forward rake of approx. 20 to 30 minutes of angle* when clamped home. This enables an equivalent capacity of adjustment within the scope to be retained for use in ranging the sight to accommodate bullet drop rather than this being used up in essentially zeroing the axis of the scope to the bore.

The rail extends forward over the action to allow for all normal-sized scopes and optical sights. The cross-slots along its entire length accommodate the anti-recoil Weaver ring type fixing the screw shanks in several optional positions to achieve the requisite eye relief.

*A pair of adhesive-backed packing strips may be fitted where required to give additional elevation on the bracket of approximately 30 minutes of arc. These may be needed where manufacturer's tolerances in the rifle, rings or sight etc. may not allow the scope to be depressed far enough to achieve the basic short-range zero. When required peel off the protective paper strip and apply the packing pieces on each side of the bearing shoulders on the underside of the mount that impinges onto the two sides of the receiver's bridge. Make sure they are fully flattened by holding down the bracket as the M6 socket head screw is re-tightened home.

Fitting:

1. While keeping the barrel pointing in a safe direction with fingers well away from the trigger first ensure that the rifle is empty by removing the magazine, opening the bolt and ascertaining that there is no round in the action or the chamber. Preferably, remove the bolt until the fitting of the sight bracket is complete.
2. Support the rifle on a padded benchtop or hold it gently but securely between padded vice jaws, so to be able to access the rear sight assembly generally, except where a Spirol type pin has already been used (see para.3). You will need to be able to position a small (1/16" max) diameter punch on the retaining pin set through the left-hand side end of the rear sight cross pin shank. (This has a slotted screw-like head on the right-hand side but in fact, is not threaded and is a push-fit held in place by the small 1/16" retaining pin). The retaining pin needs to be punched out upwards, away from the receiver body. If it proves impossible to remove, or part of the pin shears off, it may be possible, using a larger diameter flat-nosed punch carefully applied and stuck square to the end of the sight retaining cross pin shank. Once the cross pin is removed, any remnants of the retaining pin should be punched out with the cross pin supported over a V-block or vice jaws.
3. Replacement Spirol pins are available to use in place of the original solid retaining pins when reinstating the original sight retaining cross pins. These are longer and more easily restored and removed. It is recommended that these inexpensive retaining pins are replaced each time the cross pin shank is replaced after removal.

4. Remove and carefully set aside the original iron sight components. The plunger and spring may also be set aside for further use or left within their pocket when this sight bracket is fitted.
5. Using the 5mm Allen key wind the socket screw anti-clockwise to back off the steel locking piece to be clear of the cross-bridge when the mount is placed on the rifle.
6. Ensure that the inside face of the ears of the rifle's receiver which retained the rear sight is free of any burrs or distortion so that the rear of the bracket is a snug fit between them. Align the holes with those in the bracket and insert the long cap head screw through the hole of the left-hand side of the receiver (through which the rear sight retention pin previously terminated). Push this through the hole in the body of the bracket. This nut should be trapped between the bracket's pocket and the inside face of the right-hand standing ear of the rear sight support. Screw home the cap head screw with this nut but do not tighten fully.
7. Seat the middle part of the bracket over the bridge so that the underside of the pocket in the bracket is in proper contact with both sides of the receiver's bridge. Holding the bracket to maintain gentle contact, rotate the larger (M6) cap head screw with the 5mm Allen key until the locking block is loosely drawn up squarely into contact with the inside slopping face of the charger guide. Do not tighten fully at this stage.
8. Take the smaller Allen key and tighten home fully into the hex nut of the left-hand rear securing socket screw. Start the second hex nut on to the shank of this rear cap head screw where it projects through the hole in the right-hand rear of the receiver and tighten home this locking nut with a suitable sized socket set or wrench. Now tighten home the M6 socket head screw which pulls down the bracket onto the bridge via the charger guide block. Finger pressure on the longer leg of the standard 5mm Allen key should be adequate force in tightening this screw.
9. When loosening the large socket clamp screw to remove the bracket it may be necessary to gently tap the end of the Allen key to back the locking block away from its bearing with the charger guide.
10. When secured fit your Weaver style rings on the scope rail in the normal way. Use the most conveniently placed cross-slots to locate and secure each of the Weaver rings anti-recoil cross shanks to deliver proper and adequate eye relief and clearance between the eye and the eyepiece of the optic allowing for the effects of recoil when fixed.
11. Replace the bolt assembly and ensure that the bolt runs clearly along with its full travel without fouling the mounting assembly.
12. You are now ready to zero the scope on its mount at the range. When this has been done if you wish to help secure the mountings from movement under vibration we recommend that a drop of Loctite (pink) stud lock 222e or equivalent be used on the relevant screws after ensuring they have been de-greased.