

Holland's Perfect Picatinny Rail Mount

Thank you for purchasing the **PERFECT** scope mount for your rifle. This mount allows you to optically center the reticle for both windage and elevation, allowing maximum travel left and right, up and down. All bases are machined from a near perfect Remington receiver and feature a 20 MOA forward slope for your convenience. Scopes perform best when the reticle is optically centered.

A minor amount of fitting is necessary, drilling and tapping a 10-32 hole is required. Minor tolerance variations from the factory may require you to surface the bases for additional elevation adjustment. This is required in very few receivers, but should be checked for "perfect stress free" mounting of your scope.

STEP #1

Begin by attaching the bases to the receiver, do not use Loctite at this point. We are simply checking the receiver bridge heights to ensure perfect alignment. With bases attached, set a straight edge on top and see that they are in the same plane. If they are, proceed to Step # 2. **SEE FIGURE 1**

If not, we want to surface the bases for our individual receiver. This allows for stress free mounting of our scope. The bases are machined at a **20 MOA*** slope as received. Set your sine bar, or our Special Receiver Fixture with the proper shim*. **10 MOA = .014** **20 MOA = .029*** **25 MOA = .036** and **30 MOA = .043**. Take a .005 cut from the rear base and machine the front base with this setting. This should bring both bases into **PERFECT** alignment (plane) with one another. **SEE FIGURE 2**

STEP #2

Attach the Picatinny rail to the bases with the screws provided, you will use one 10-32 flat head cap screw and the 10-32 button head screw. Attach your rings to the rail and space the rings to the widest width for your particular scope. * Note: keep the rings at least 1/8 inch from the eye piece, objective bell and or turret head. Using a power lap or hand lap, lap the ring halves with valve lapping compound. Wash and clean the ring halves and attach them to the rail. **SEE FIGURE 3**

Level the rifle and base in the vise and hang a plumb bob from the ceiling across the room. Set the scope in the ring halves and snug the ring caps after aligning the reticle to the string line. Insert your collimator into the bore and align with the scope reticle. Remove the windage/elevation caps. Turn the windage dial (left or right) until the reticle stops moving in the collimator. Count the number of clicks or MOA as we turn the windage knob in the opposite direction. Take the number of clicks or MOA and divide by 2. Example: We had 40 minutes of angle from left to right. Turn the windage knob back 20 MOA or 80 clicks (if the scope is calibrated in .250 MOA click values). This centers the windage adjustment in the erector tube. Do the same with the elevation adjustment. The reticle is now centered in the erector tube.

STEP #3

With the reticle centered in our scope, remove the scope from the rail. Snug the 10-32 pivot screw on the rear base as well as the 10-32 button head screw on the front base. Attach the scope and look at the collimator/reticle alignment. Shift or tap the base left or right to align with the collimator for windage. Tighten the button head screw.

FIGURE 1



FIGURE 2



FIGURE 3

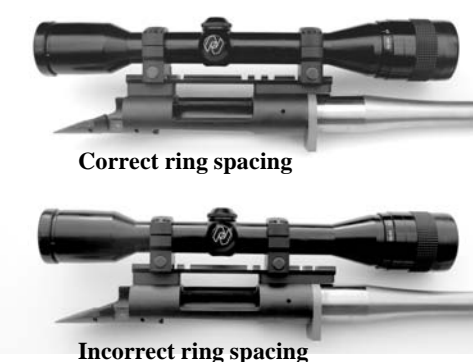


FIGURE 4



FIGURE 5

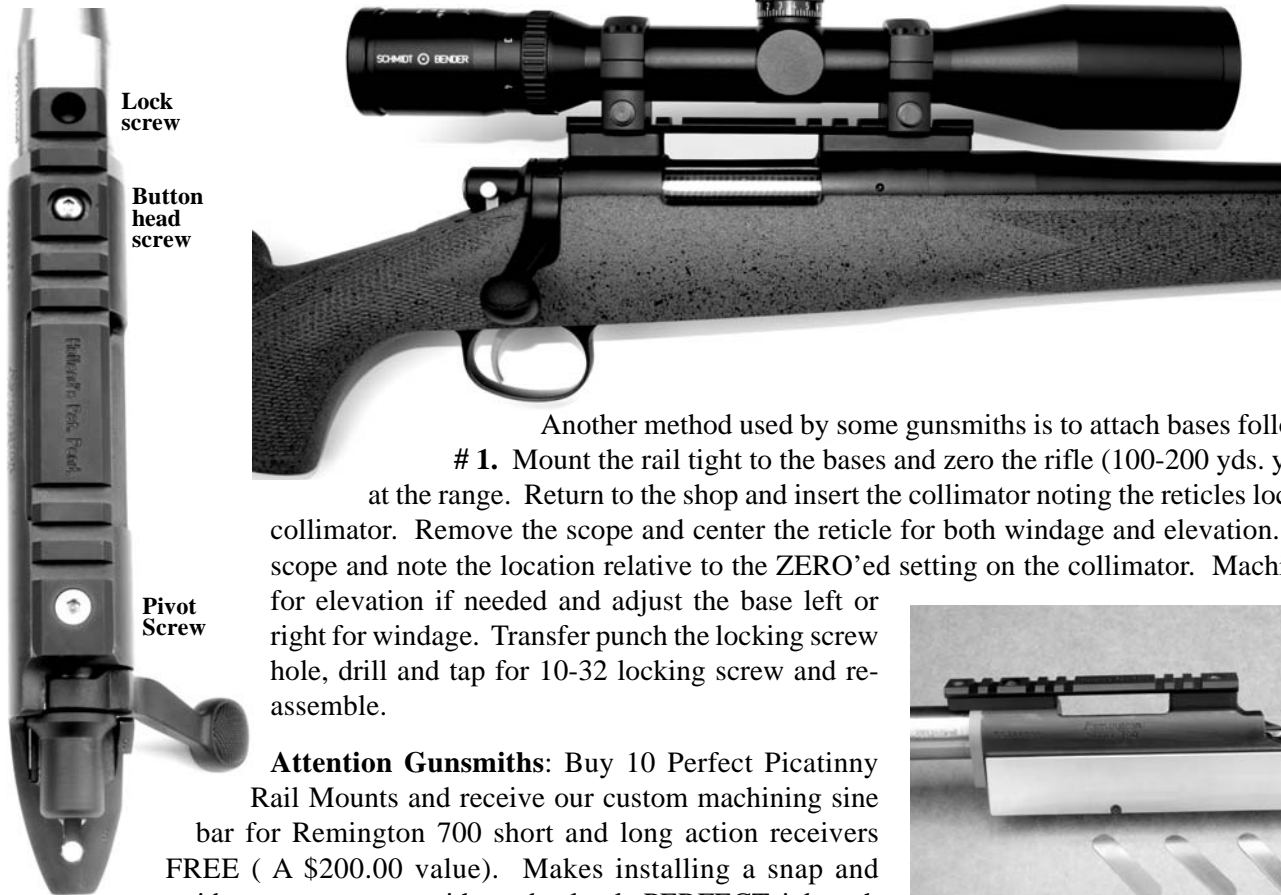


Using the transfer punch supplied with the scope mount, lightly center punch the location of the front locking screw in the front base. **SEE FIGURE 4** Remove the front base from the receiver and place in the mill vise. Locate the center punch mark and center drill, complete drilling with a #22 drill and tap with a 10-32 tap. **SEE FIGURE 5** Clean bases and refinish if necessary. Clean 6-48 tapped holes in the receiver with Acetone. Clean 6-48 base screws (4). Use a BLUE or PURPLE grade of Loctite, never Red and apply a small drop to each of the base screws. Attach the bases to the receiver and tighten the 6-48 screws.

The rear 10-32 pivot screw and 10-32 button head screw are the correct length. The locking screw is longer and may require shortening if it contacts the barrel upon tightening. With all the screws confirmed to be the correct length, clean with Acetone and apply a drop of Loctite to each screw. Install Picatinny rail on bases and tighten screws with 1/8" Allen wrench provided.

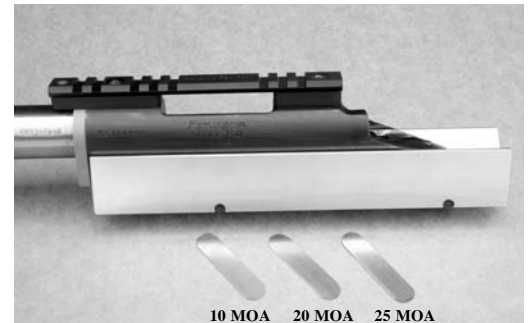
Install scope and rings, be sure to push the recoil lug on the rings to the forward abutment on the rail and tighten the ring nuts to 50-60 INCH pounds.

You are now ready to head to the range and zero the rifle.



Another method used by some gunsmiths is to attach bases following **Step # 1**. Mount the rail tight to the bases and zero the rifle (100-200 yds. your choice) at the range. Return to the shop and insert the collimator noting the reticles location to the collimator. Remove the scope and center the reticle for both windage and elevation. Mount the scope and note the location relative to the ZERO'ed setting on the collimator. Machine the base for elevation if needed and adjust the base left or right for windage. Transfer punch the locking screw hole, drill and tap for 10-32 locking screw and re-assemble.

Attention Gunsmiths: Buy 10 Perfect Picatinny Rail Mounts and receive our custom machining sine bar for Remington 700 short and long action receivers FREE (A \$200.00 value). Makes installing a snap and provides your customer with an absolutely PERFECT job each and every time. Perfect for all scopes, but especially nice for European scopes with limited adjustments.



Shims for sine bar. Allows gunsmiths to machine forward taper into the mount.

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Check out our website for rifle building supplies, parts, stocks, scopes, recoil pads,
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With Holland's Perfect Picatinny Rail Mount you'll never again fight scope mounting problems!
We are the solution to all your scope mounting needs.