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## Scope Mount Drill Fixture

The William's Scope Mount Drill Fixture can be used to drill almost any receiver between the diameters of .630 to 1.440; round, flat, or octagon. With a hole spacing choice of .500, .605, or .860, you can install almost any scope mount base in the industry.

TO USE: After selecting the hole spacing of your choice (see drawing), simply set the fixture over receiver and squeeze together. (Laying a piece of paper under the fixture will avoid scratching the receiver.) The scissor action of the fixture will automatically center itself. Make sure both receiver and fixture are level and square. Secure in place by using a C-clamp or table top vice around outside of fixture.

The Scope Mount Drill Fixture comes complete with one each #31 and #28 hardened steel lock bushing. Insert the proper bushing and twist to lock in place (#31 for 6-48 and #28 for 8-40 threads). These lock bushings will not spin in fixture when drilling causing unwanted scratches around drilled holes.

TAPPING 6-48 HOLES: After #31 holes are all drilled, leave fixture in place and use the #28 bushing as a guide for 6-48 tap.

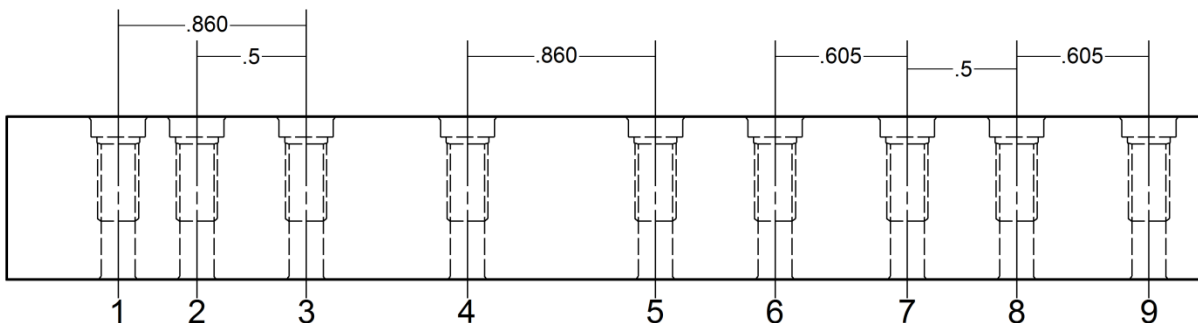
### EXAMPLES: FACTORY HOLE SPACING FOR:

Marlin - Early 36 & 336 ..... Holes 2&3, 7&8

(Note: On Marlin, use a 1/16" (.062") or larger shim under both sides of fixture to allow for proper clearance of front receiver shoulder.)

Remington – Early 760, 740 ..... Holes 4&5, 8&9\*

\*This spacing also works very well for scope mount installations on many shotguns – Remington 870, Mossberg 500, Ithaca 37 & 87, and Winchester 1200 and 1300. (Not recommended for Remington 1100, 11/87 or Browning Autos because of thin receiver.)



NOTE: Do not over-tighten socket screws in cross bars.