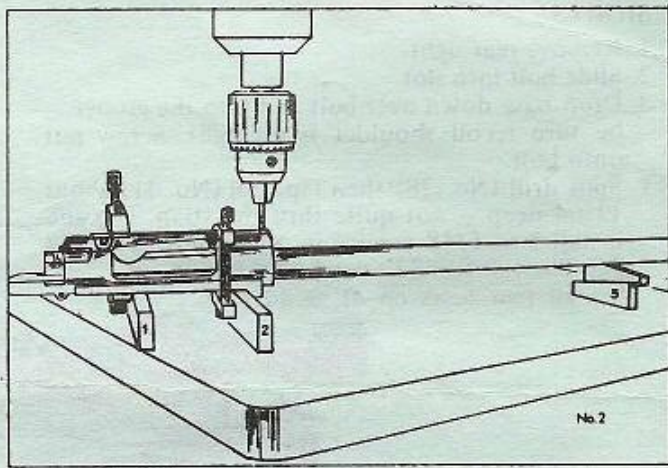
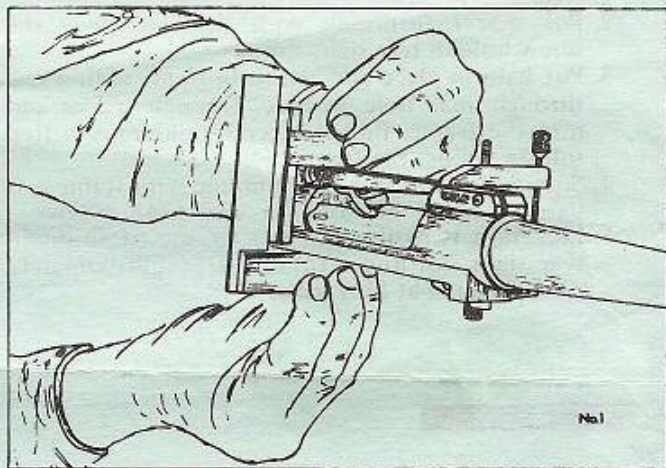


IF ALL ELSE FAILS—FOLLOW THESE DIRECTIONS

INSTRUCTIONS FOR INSTALLING THE BUEHLER MOUNT ON UNDRILLED RECEIVERS



NOTE: Scope and mount are no better than their installation. Proper installation takes experience, care and first class equipment. **DO NOT ATTEMPT TO INSTALL FRONT RING IN BASE WITHOUT THE SUPPORT OF THE SCOPE. REMOVE ALL OIL FROM SCOPE TUBE BENEATH RINGS.** The following steps are suggested:

Nothing looks worse than a mount base canted on a receiver! A good job can be assured by squaring the base with the bottom of the receiver. When those two square blades in Fig. 1 are aligned, that base is square! Use of two parallel clamps gives you the "tipping" adjustment to do this precisely. Be sure that the recoil shoulder is butted solidly first.

After clamping, rest the receiver on two parallels on the drill press table (Fig. No. 2). An adjustable parallel at 3, Fig. 2, is a big help. A fairly large production type table on the drill press is fine thing. It will pay for itself in scope mounting alone and sure beats rigging up some sort of outboard stand or clamping a 2x6 to a small table!

Now spot drill the holes with a #28 drill (if an ordinary drill just squeaks, our Carbide drill will cut) then tap drill #31. Now tap right through the base (6x48) (a ratchet "T" handle beats all others) for insured alignment. A dab of our Crossroads drilling and tapping oil will help this operation a lot. Remove base and clean out all chips and oil.

INSTRUCTIONS FOR INSTALLING THE BUEHLER MOUNT ON DRILLED RECEIVERS

Assemble with a small drop of Loc-tite on threads of screws.

Set up screws. Now with screw driver blade squarely in each screw, tap handle smartly and reset screws.

Base is carefully machined (to factory drawings) to fit perfectly level on top on unaltered receivers (except Enfield). As not too much attention is paid to the outside dimensions of many guns by the factories, shimming of base may be necessary in some instances. New higher power scopes are showing up these discrepancies. Steel shims are also used on refinished guns. If this is done accurately and carefully, stability of a TOP mount is unaffected.

We match all factory drilling where available. Due to some variance in these guns and their tapped holes, it may prove helpful to locate the base on the gun and run a 6x48 tap carefully through the base into threaded holes in the gun.

SPECIAL INSTRUCTIONS FOR INSTALLING BUEHLER SPLIT RINGS ARE PACKED WITH EACH SET OF SPLIT RINGS.

TO INSTALL SOLID RINGS PROCEED AS FOLLOWS:

Spread solid ring (1/8 inch—no more) and slip into place on scope. Set up small screw loosely—now assemble scope onto base and twist scope in ring until reticule is lined up. Remove carefully and lock up small screw tightly. This screw keeps ring in place when scope is off the gun. Split ring instructions given elsewhere.

Remove ocular lens, spread (1/8 inch) and slip on rear ring. Replace lens.

INSTRUCTIONS FOR INSTALLING RINGS AND SCOPE ON BASES

Insert front ring into base with scope held 90 degrees to barrel, projecting to right with clamp screw loose — do not remove this screw.

Push down flush with top of base and give quarter turn to bring scope into alignment. There is an intended mechanical interference to insure perfect mating between front ring and mount base the first time scope is turned into place.

Bore sight with reticule in center of field using windage screws. **SET UP WINDAGE SCREWS AND FRONT RING BASE CLAMP SCREW SECURELY.**

To remove scope remove right hand windage screw and loosen front ring screw. Turn scope 90 degrees to right and lift out.

NOTE: CHECK BASE WITH STRAIGHT EDGE.

Sometimes rifles (such as M70) with matting on the receiver ring will require a few thousandths shimming under the forward screw to fill up the matting and level up the forward end of the mount. Black photographic paper is good for this use. This applies to 2-piece bases, all 4 inch bases as well as Micro-Dial.

Enfield wings and clip lips must be removed and receiver ground to same contour as front receiver ring.

It may be necessary to remove a small amount of metal from the clip lips on the Springfield and some Mexican Mausers directly beneath the windage adjustment screws.

Many models of Buehler bases can be supplied completely finished except for the mounting screw holes. These are made so you good gunsmiths can drill them to match the off-center holes put into nice receivers by amateurs.

INSTRUCTIONS FOR INSTALLING PISTOL BASES

TO INSTALL 'K' BASES ON ALL SMITH & WESSON FRAMES WITH ADJUSTABLE REAR SIGHTS

1. Remove rear sight.
2. Slide bolt into slot.
3. Drop base down over bolt and into the groove — be sure recoil shoulder is up tight. Screw nut onto bolt.
4. Spot drill (No. 28) then tap drill (No. 31) about 11/64 deep — not quite thru the strap. Tap and install two 6/48 screws in all frames above 22 cal. The rim fire 22's need only one screw. Use all four holes on 41 & 44 Mag.



All pistol bases are a few thousandths higher at the rear to help offset bullet trajectory.

ALL BUEHLER MOUNT RINGS FIT THESE PISTOL BASES

Code number is stamped on bottom of each ring.

TO INSTALL RUGER "RB" & COLT "C" BASES

1. Remove rear sight.
2. Put spacer furnished with the base over the screw hole in rear sight slot.
3. Put base in place and attach to frame with screw through rear hole in base, through spacer and into the frame. Be sure recoil shoulder is butted solidly against the frame.
4. Square the mount base up in line with frame and barrel. Clamp and drill for two 6/48 screws.
5. Elevation is easily adjusted by use of shims in rear sight slot under the spacer. (approximately .002 per inch at 50 yards).



Ruger 22 automatic with Buehler mount reduced the group from 1-3/4" to 3/8"! Same Shooter, Same Day, Same Ammo, Same Bench!

BUEHLER PRODUCTS AND PARTS LIST

Buehler Mount Replacement—Screw Assortment \$2.75



SOCKET HEAD CAP SCREWS

Each
6-48; 15/64, 19/64, 11/32, 25/6425
Socket Wrench20

LOW SAFETY PARTS

Screw & Lock Washer, . . Assy. 40c — Spring 40c
Pin (Specify Model) \$5.00
Lever (Specify Model) \$5.00

RECOIL SLEEVE



Installed between the front mount ring and turret of a Leupold M8 2X scope. It is an aid on heavy recoil pistols such as .44 Mag, 30 Herrett \$5.00

INSTRUCTIONS FOR INSTALLING THE MICRO-DIAL BASE

1. Please turn over and read instructions for installing BUEHLER mount.
2. Tighten dial and lock nut on center stud just enough to keep the cones in the dial and lock in contact with the base but not so tight that all three cannot be turned easily as a unit. The screw hole through this stud is made oversize for a 6/48 so as to help in lining it up squarely with the base. Use a No. 23 drill if it is necessary to spot a hole through the stud.
3. Align receiver cut on the bottom of the stud so it is pointing fore and aft — top of stud should be about flush with face of dial.
4. Now install base on rifle with two forward screws. Tighten rear screw through the stud while feeling it in with the left hand. Gently moving dial-lock-stud unit back and forth to seat the stud squarely on receiver bridge. If stud is tipped elevation adjustment will also give windage and not work smoothly.
5. Now install scope and bore sight to barrel. We've found the Sweany Collimator (Alley Supply Co., Carson Valley Industrial Park, Gardnerville, Nevada) a very accurate and fast method of bore sighting — in fact we used it throughout the development of this mount.
6. Graduations, both elevation and windage, equal one inch at 100 yards approximately. Elevation clicks equal 1/4" (these figures may vary a little with different rifles). Maximum elevation recommended is 1-2/3 turns of dial equal to about 25" at 100 yards — less than 1/2 degree.
7. To install FI-U base on M98 Mauser the bridge must be shaped like an FN by removing clip lips and hump. Further information on separate instruction sheets enclosed.

NOTE: CHECK BASE WITH STRAIGHT EDGE. Sometimes reflex (such as M70) with matting on the receiver ring will require a few thousandths shimming under the forward screw to fill up the matting and level up the forward end of the mount. Black photographic paper is good for this use. This applies to 2-piece bases, all 4 inch bases as well as Micro-Dial.

HAVE YOUR SCOPE INSTALLED BY A COMPETENT GUNSMITH

Manufactured and Guaranteed by
MAYNARD P. BUEHLER, INC. — ORINDA, CALIF. 94563

ADDITIONAL PISTOL MOUNT INSTRUCTIONS

(Please read green Mount Instruction Sheet first)

45 ACP & S&W M52

Remove the slide. Remove the leaf from the rear sight if in the way of the scope. Position the mount on the slide, square to the sides of the slide and with the rear of the cartridge cutout flush with the breech face. This is important so that the forward two 19/64 screws clear the ACP locking lugs. Let these screws extend into the inside of the thin M52 slide. Clamp in place. Spot drill No. 28, tap drill No. 31. Drill just deep enough for the two 11/32 rear screws. Use Code #7 rings. Rotate scope 90° to clear ejection.

AUTO-MAG

Iron sights can be used over mount base. Remove receiver and barrel assembly. Position mount base on ramp so rear edge of 1/2" hole lines up with forward end of the receiver. Clamp. Spot drill No. 28. Now touch ramp with No. 31 Cobalt Drill. Set depth stop on drill press and drill four holes 3/16" deep. Tap through base. Best to retap with bottoming tap. Install base with four 19/64 socket screws. Check each one to be sure no screw is bottoming. Smear Loctite thinly on bottom of mount and screws. A Recoil Sleeve is necessary on these pistols.

RUGER .22 AUTO.

Remove receiver and barrel assembly. Position the mount base on the receiver just ahead of the rear sight so the ejection port is approximately centered in the cartridge cutout. Using two small squares, adjust the base so it is parallel with the bottom of the slide. Clamp. Drill just deep enough for the screws.

HIGH STANDARDS & COLT WOODSMAN

Locate mount base on the barrel so the shoulder on the bottom just clears the slide. Drill just deep enough for the screws.

SMITH & WESSON M41 & M46 PISTOLS

Remove the barrel assembly and the rear sight. Position the mount base so the recoil shoulder butts solidly against the rear sight shoulder. Clamp and drill just deep enough for at least two screws.

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(see other side)

MOUNTING SCOPES ON PISTOLS WITH HEAVY RECOIL

The most difficult weapon to mount a scope on is a pistol with sharp, heavy recoil. In a rifle, we have mass and a good ratio of weight of weapon to weight of scope and mount. This does not exist in a pistol.

We've successfully mounted scopes on .600 Nitro doubles, anti-tank rifles - even automatic anti-aircraft rifles. .44 Magnums, .30 and .357 Herretts are worse!

Pistol scoping must be done with caution. Invariably we find scope slippage to be due to improper installation. As installation is out of our hands, and more and more power is being poured into pistol cartridges, we cannot guarantee a mount on any lightweight heavy-recoil pistol.

For those who want to try a mount on the heavier recoil pistols, our Recoil Sleeve (with Leupold M82X scopes only) will help. Be sure to follow all mounting instructions scrupulously.

In addition to carefully following the instruction sheets, be sure to clean the scope tube with solvent beneath each ring. Also use clean solvent on the bottom of the mount base and top of the barrel. Smear a little Loctite under the mount base and on the mounting screws. Don't forget to tighten the front clamp screw. Do not use Loctite on the ring screws or the clamp screw. It is not needed and will make scope removal almost impossible.

If the windage screws start deforming the rear ring cuts, it means that the front ring is not tight. The 6/48 screw at the top and the 3/48 screw through the bottom of the ring must be tight after the proper adjustments have been made as per Figure 2, Split Ring Instruction Sheet. Then the clamp screw through the base must be tight.

The Buehler mount is designed to absorb 75% of the recoil in the front ring, if properly fitted. Please carefully follow the instruction sheet enclosed so no damage will occur to the rear ring or screws - which, of course, should also be tight.

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(see other side)