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SMITH ENTERPRISE INC. M14 SCOPE MOUNT INSTALLATION INSTRUCTIONS

For use with the following SEI Scope Mounts

<u>NSN</u>	<u>SEI Part Number</u>	<u>Description</u>
1005-01-506-5750	2006	Rail, Mount, Scope, MIL-STD-1913, M14, 5 Inch
1005-01-533-8160	2008	Rail, Mount, Scope, MIL-STD-1913, M14, 7 Inch
1005-01-535-4430	2005	Mount, ACOG, MIL-STD-1913

The following instructions provide the proper method for attaching the Smith Enterprise Inc. M14 Scope Mount to an MIL-SPEC US Government M14/M21 Rifle.

Installation is to be performed by a qualified US Military Armorer (US Army 45B / USMC 2112).

1. Remove magazine from rifle, then retract bolt and inspect chamber to ensure the rifle is unloaded.
2. Remove trigger group and then remove barrel/receiver group from stock.
3. Remove stripper clip guide from the receiver by driving the retaining pin out from the bottom of the receiver and then slide the stripper clip guide left out of the dovetail (toward bolt release side of receiver).
4. Re-assemble rifle by placing barrel/receiver group into stock and then install trigger group.
5. Mount rifle in a shooter's vise.
6. Remove the dovetail from the scope mount and slide the scope mount dovetail into the dovetail slot in the receiver ensuring that the dovetail moves freely in the slot.
7. Remove the rear sight assembly from the receiver.
8. Level the rifle on both axes's using a gage block set on the flat that is located under where the rear sight is mounted.
9. Secure the rifle in the shooter's vise without disturbing its level.

NOTE: The forward and aft alignment / leveling of the mount along the axis of the bore is more critical than the alignment of the mount to the left and right.

11. Loosen and partially back-out the set screw in the front of the scope mount.
12. Align the scope mount on the receiver taking care to:
 - a. Align the key of the scope mount with the groove in the receiver.
 - b. Place the hole in the mount over the threaded hole on the left side of the receiver,
 - c. Place the hole in the rear of the scope mount over the dovetail inserted in the receiver.
13. Verify that there is no interference between the bottom of the scope mount side plate and the stock.
14. While pressing the scope mount onto the flats on the left side of the receiver, insert the tightening cam and cam bolt into the receiver.
15. Finger tighten the cam in a **CLOCKWISE** direction. The cam lever ideally may rest between the 11 and 2 o'clock position.
16. Finger tighten the cam bolt.
17. Verify that the scope mount has not moved, rotated or otherwise shifted during this process. To do this, look at the receiver flat and both the front and rear portions of the receiver groove.
18. Finger tighten the set screw in the rear dovetail.
19. Re-verify the rifle for level on both axes.
20. Level the rifle on both axes as close as possible.
21. Tighten the rear dovetail set screw.
22. Tighten the cam bolt using a ¼" drive, adjustable click set, inch-pound torque wrench to **55-65 inch-pounds**.

WARNING: DO NOT EXCEED 65 INCH-POUNDS OF TORQUE OR YOU WILL DAMAGE THE CAM BOLT. THE CAM BOLT IS MADE FROM 4140 AND IS HEAT-TREATED TO 35-45 HRC.

23. Turn the top set screw until it contacts the front of the receiver ring.
24. Tighten the side set screw, which will lock the top set screw.
25. Verify that the rifle sight and the scope mount are generally aligned with the bore axis.
26. Re-install the rear sight assembly.
27. Mount the scope per manufacturer's instructions.
28. Sight-in using the scope manufacturer's instructions.