



ACCURACY SPEAKS, INC.

3960 N. USERY PASS RD. • MESA, AZ 85207 • (480)373-9499

MIA/M1 SCOPE MOUNT INSTRUCTIONS

1. Set up receiver in mill by clamping receiver legs in vise and resting receiver on top of mill vice.
2. Insert 3/8-inch dowel pin thru sight ears in receiver.
3. Touch off on dowel pin and find center.
4. Refer to chart below for distance to screw holes in barrel, move table to rear screw location.
5. Touch off on barrel and find center of barrel.
6. Drill with #31 drill, tap with 6x48 tap .200 ∇ dp.
7. Move table .500 ∇ to new screw location.
8. Drill with #31 drill, tap with 6x48 tap .200 ∇ dp.
9. Install mount spacer on barrel with 6x48 screws.
10. Mark hand guard and cut relief hole in hand guard to clear mount spacer.
11. Test fit hand guard on barrel to ensure clearance around mount spacer.
12. Test fit scope mount on receiver, loosely install screws.
13. Tighten screws do not over-torque.
14. Install scope rings, check scope for contact with mount or handguard.
15. Set eye relief and square crosshairs to rifle.
16. Tighten ring screws, boresight and go shootin'.

Hole Spacing

M1A Rifles

From C/L of rear sight hole to rear screw of scope mount spacer- 6.860 ∇

M1 Rifles

From C/L of rear sight hole to rear screw of scope mount spacer- 7.860 ∇

Helpful Hints

1. Some M1A's will experience trapped cases between the scope mount and receiver at the front. This is caused by the rifle functioning faster than the ejector can clear the fired case. It turns sideways and is trapped by the bolt. Without the scope mount the operating rod handle would have thrown the case forward. The cure requires drilling a vent hole .062" in the gas cylinder plug to vent some gas and slightly reduce the functioning speed of the operating rod. This slows the gun down just enough for the case to clear the operating rod on its way forward. It will not adversely effect functioning as the change in bolt speed is minor.
2. Garand rifles will not be able to use the 8-round clip as the scope mount blocks loading the clip. Use of a SLED clip will allow the shooter to load the magazine. Sled Clips are available from Champions's Choice 201 International Blvd. LaVergne, TN 37086 (615)793-4066.
3. If the scope mount is only used for load development, do not install handguard. After testing, remove scope mount and install handguard.