



Brownells Hole Center Punches are designed to simplify the job of properly locating scope base, receiver sight, sight ramp and handgun rib screw holes when a fixture such as Forster Universal Sight Mounting Fixture is not available.



### WARNING



Never attempt to disassemble or reassemble a firearm unless you are absolutely certain that it is empty and unloaded. Visually inspect the chamber, the magazine and firing mechanism to be absolutely certain that no ammunition remains in the firearm. Disassembly and reassembly should follow the manufacturer's instructions. If such instructions are not immediately available, contact the manufacturer to see if they are available. If they are not available at all, then you should consult other reference sources such as reference books or persons with sufficient knowledge. If such alternative sources are not available and you have a need to disassemble or reassemble the firearm, you should proceed basing your procedures on common sense and experience with similarly constructed firearms.

With regard to the use of these tools, the advice of Brownells Incorporated is general. If there is any question as to a specific application it would be best to seek out specific advice from other sources and not solely rely on the general advice and warnings given.

### HOW TO USE

Disassemble the gun as required and secure the appropriate components in a padded vise on the drill press table. Make absolutely sure the action, barrel or workpiece is properly leveled and squared.

The sight, sight base or item to be attached is then positioned on the receiver or barrel. Using a level or other suitable instruments, MAKE CERTAIN the item to be attached is properly leveled and positioned. DO NOT HURRY through this step! Check your work at least twice. Once a hole is drilled, it can be very difficult to move or reposition!

With the base or sight properly and accurately positioned, secure it in place. Machinist clamps are often especially helpful for this. Other methods successfully used include holding parts with double-sided tape or quick-setting epoxies or glues. Select the Hole Center Punch from the set that is a snug, close fit in the bases' attaching screw hole. Because the Hole Center Punch fits snugly inside the screw hole, the punch point automatically centers in the hole.

When using any punch, appropriate safety precautions should be taken. **SAFETY GLASSES SHOULD ALWAYS BE WORN WHEN STRIKING ANY HARDENED TOOL.** In addition, the sharp point on the end of a punch should be maintained. If the punch becomes dull or blunted, resharpen it. If the head of a punch begins to "mushroom" from extended use, grind away all material that extends beyond the basic shaft diameter. Many of these problems can be avoided if care is exercised in the use of these punches. Most importantly, DO NOT USE EXCESSIVE FORCE when striking any of the Brownells Hole Center Punches. Use only enough force to mark the surface that is to be drilled.

Use a small machinist hammer, such as a 4 oz. ballpeen, to LIGHTLY strike the head of the punch. DO NOT use excessive force. A light strike, just enough to dimple the surface of the barrel or receiver, is all that is required. Once this is done, the base or sight can be removed and the mark you

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## HOLE CENTER PUNCHES



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**INSTRUCTIONS**

have made can be deepened or restruck if necessary. Remember, the Hole Center Punches are "spotter" punches only, for marking or indicating the location of the required holes. Use a good quality, standard, center punch to deepen the mark and save your Brownells Hole Center Punches for use where precision and accuracy are critical.

After the first hole has been drilled and tapped, and before drilling any more holes, install the base or sight and secure it with a suitable screw. Recheck for proper alignment and position. If an error has been made, it MUST be corrected at this time. It is easier to redrill one hole than to attempt to deal with two or more improperly positioned holes!

If everything checks out properly, use the proper Hole Center Punch to locate and mark the center of the other hole or holes. Remove the base or sight and drill and tap as required. The base or sight can now be installed.

Reassemble the firearm according to the manufacturer's instructions. Check for proper functioning using **ACTION PROVING DUMMIES**. Make sure **ALL SAFETY MECHANISMS** are fully functional as designed and approved by the manufacturer. If these tests prove satisfactory, test-fire the firearm with live ammunition in a **SAFE** and **APPROPRIATE** manner. **IMPORTANT!** Start the live ammunition tests by first loading an **ACTION PROVING DUMMY**, then a live round, into the magazine. Only after several tests have been conducted in this manner should additional rounds be placed in the magazine and fired.