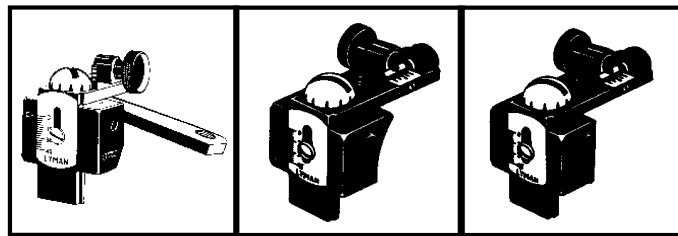


Lyman[®]



No. 57 Receiver Sight • No. 57 SML Receiver Sight No. 66 Receiver Sight



MOUNTING AND ADJUSTING

MOUNTING LYMAN NO 57 RECEIVER SIGHT The No. 57 Sight is designed primarily for rifles with round receivers. Some of the rifles for which the No. 57 Receiver Sights are designed are already drilled and tapped. In such cases, simply remove the dummy screws and attach the sight base, using the screws furnished with the sight. For rifles which require drilling and tapping, proceed as follows:

1. Remove the barrel and receiver from the stock.
2. Remove slide from sight base by pressing lock bolt on the side of the base.
3. Place base on receiver in position and fasten by means of clamps, and square up so that the windage arm will be horizontal or tipped up 1°. Be sure that base is so located that it will not interfere with the function of bolt.
4. Spot hole with No. 26 drill (same size as screw hole) and then drill with No. 31 drill, tapping with special tap 6-48 N.S. thread. Put in screw, tighten, and then proceed with second base.
5. If it is necessary to cut the stock leave slight clearance around sight so that the wood does not touch the sight in any place. This is to prevent loosening of sight from jar of recoil. Elevation scale and windage scale can be zeroed by loosening binding screws.

*The receivers of the Springfield, Krag, and some other rifles are case hardened, having a very hard outer shell. The metal under this shell is soft, but it is necessary to overcome

this hard surface before drilling. This can be accomplished in either of the following ways exercising particular care before grinding, annealing or drilling to see that the sight base will be in its proper position.

1. Brighten the spots you wish to anneal and then use a needle flame acetylene torch for annealing. Any experienced welder can do this.
2. Grind away with an emery wheel the hard shell around and over the spot to be drilled. The base of the sight will cover the spots where the wheel touches.

MOUNTING LYMAN NO. 57 SML RIFLE SIGHT

The 57 SML aperture sight is designed to fit the Lyman Trade Rifle, Lyman Deerstalker and those of similar design such as the Thompson/Center Hawken.

INSTALLATION ON LYMAN TRADE AND DEERSTALKER RIFLES AND SIMILAR GUNS

The Lyman Rifles are predrilled and tapped for the 57SML. Thompson/Center Hawken require that one hole be drilled and tapped for the enclosed 8/32 screw.

To install the sight:

1. Remove slide from sight base.
2. Unscrew rear tang screw.
3. Place sight base on tang (still in stock) and attach it using the rear tang screw.
- *4. Mark center of front hole and drill with No. 29 drill. (Removing the tang and clamping it in a vise will protect the stock of the rifle during the drilling operation.)
- *5. Tap hole for 8/32 thread.
6. Secure sight base to tang with tang screw and 8/32 screw.
7. Replace slide.

Installation complete.

* Not required for Lyman rifles.

INSTALLING ON GUNS OTHER THAN LYMAN AND THOMPSON/CENTER

The 57 SML sight will fit many guns other than Lyman and the Thompson/Center Hawken with minor adjustments as described below:

It is important that the horizontal part of the sight's slide is level and that the sight's base is mounted in line with the bore. Placing spacers under one end of the base or the other will allow the slide to move up and down vertically. Inletting the wrist of the stock allows mounting the sight's base on rifles with short tangs. Shimming and inletting will allow you to adapt the 57 SML to many tang and stock configurations. Once the sight sits level and in proper position over the bore, proceed with installation as described for the Lyman rifle. Where the rifle's tang is short, the base can be held to the wrist of the stock with two wood screws.

INSTALLATION OF 57GPR ON LYMAN GREAT PLAINS RIFLE

The Lyman Great Plains Rifle (made before April 1997) will require one hole to be drilled and tapped for the enclosed 8/32 screw. Rifles made after April 1997 will have the hole drilled and tapped at the factory.

1. Remove slide from sight base.
2. Unscrew and remove rear tang screw. The original rear tang will not be used.
3. Place enclosed sight adapter block on tang (still in stock) so that the thick end of the adapter block is at the rear of the tang and the angled front edge lines up with the angled front edge of the sight base.
4. Place sight base on adapter block and attach it using the wood screw supplied with the adapter block. The screw is positioned in the rear hole and will pass through the sight base, adapter block and rifles tang, and then is screwed into the stock.
5. *Mark center of front hole on the tang and drill with a No. 29 drill (removing the tang and clamping it in the vise will protect the stock of the rifle during the drilling operation).
6. *Tap hole for 8/32 thread.
7. Secure sight base and adapter block to the tang with wood screw and the 8/32 x 1/2" machine screw that is supplied with the adapter block.
8. Replace with slide.

Installation is complete.

*Not necessary on rifles that are drilled and tapped.

MOUNTING LYMAN NO. 66 RECEIVER SIGHT

The No. 66 Sight is designed for rifles and shotguns (66U) with flat sided receivers. Many of the rifles for which the No. 66 Sights are designed are already drilled and tapped. In such cases, simply remove the dummy screws and attach the sight base, using the screws furnished with the sight. When your rifle is not drilled and tapped and for shotguns, proceed as follows:

1. Remove the slide from the base of the sight by pressing the lock bolt which projects from the side of the base. This releases its hold on the elevation screw.
2. The base should be mounted as close to the rear of the receiver as possible to take advantage of the maximum sight radius. Place the base on the receiver in position and fasten it by clamps. Make sure that the base is so located that it will not interfere with the functioning.
3. Spot holes with a No. 26 drill (same size as screw hole) and then drill with a No. 31 drill and tap with a 6-48 N.S. tap. Insert mounting screw and tighten. Proceed with the second screw hole.

USING THE NO. 57 OR NO. 66 QUICK RELEASE FEATURE

Once the gun is zeroed in, the shooter may take advantage of the quick release feature as follows:

First, loosen the set screw holding the elevation scale and move it until the zero on the scale lines up with the zero line on the side of the base. Tighten the screw. Follow the same procedure for the windage scale, straddling the aperture with opposite ends of the scale markings or using any method you find convenient. Next, turn the small vertical screw (running through the top of the slide beside the elevation knob*) all the way down to the top of the sight base. This locates the zero for elevation so the slide can be removed and replaced without referring to the elevation scale. This scale can be set for longer range than the set screw allowing the use of two ranges easily and quickly, located by using the quick release feature. By pressing the end of the spring loaded slide lock at the side of the base the threads of the elevation screw are disengaged. This allows relocation or removal of the slide quickly.

*Not present on the 66U sight.

SELECTING A FRONT SIGHT

A blade front sight, combined with our 57 SML is an excellent combination for hunting and general use. A more precise sight picture can be obtained by installing our 17 AML or 17AEU hooded front sight with interchangeable inserts. 17AML fits T/C rifles. 17AEU fits Lyman rifles.

To install on the Lyman, Thompson/Center or similar rifles:

1. Use a non-marring piece of material to tap out the factory front sight (left to right as viewed from the butt).
2. Align the No. 17 sight and tap into place from right to left.
3. If fit of the sight to dovetail is too loose, remove the sight and peen down the lips of dovetail lightly and evenly. Try the sight again. Repeat until the sight is snug.
4. If the front dovetail is too small, it will have to be opened with a triangular file. This condition is common with imported rifles and you may wish to have a gunsmith fit the new front sight.

When using the Thompson/Center vernier tang sight, a sight higher than the 17 AML will be required. Lyman's 17 ATC sight is made expressly for this purpose. It is installed exactly the same way as the 17 AML sight. Height 17 ATC – .852"

NO. 3 AND 28 HUNTING SIGHTS

These sights are ideal for hunting and general field use. The front sights have a contrasting white or gold bead to enhance visibility in dim light. Installation is the same as for the 17 AML sight. Height 3 and 28 (17/32" base)– MF = .445"

ADJUSTING YOUR LYMAN NO. 57 OR NO. 66 RECEIVER SIGHT

The elevation and windage knobs are graduated to 1/4 minute of angle and for each graduation a distinct click may be heard and felt. Rotating the elevation and windage knob clockwise moves the sight and point of impact down and to the left respectively. Counterclockwise to raise and move to the right. Each click represents a change of 1/4" at 100 yards and 1/8" at 50 yards, with the same proportion for longer and shorter ranges based on a sight radius of 28':

EXAMPLE: Suppose you were shooting at 100 yards and the group was striking the target 4" below the point of aim. To correct this, move the elevation screw counterclockwise 4 minutes (16 clicks with 1/4 minute graduation) and your shot group will be 4" higher.

If you find that your rifle is still shooting high though your receiver sight slide is turned all the way down the receiver, then a higher front sight is necessary.

The Front Sight Elevation Correction Chart shows you how to figure the correct height for your front sight.

When ordering a front sight, if you want us to check your selection indicate the height of your present sight, the amount of error, what range you are shooting, also the make, model and caliber of the rifle.

SIGHT ADJUSTMENT RULE

To make corrections always remember to move the rear sight in the direction you wish to move the center of the group. That is, if you are shooting low raise the rear sight. If you are shooting to the right, move the rear sight to the left.

Do you have the current Lyman catalog?

**Lyman's annual full-line catalog is
ready in January of each year.**

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visit our web site
www.lymanproducts.com**

FRONT SIGHT ELEVATION CORRECTION CHART FOR IRON SIGHTS

Amount of Error at 100 Yards Given in inches	Distance Between Front and Rear Sights									
	14"	15"	16"	17"	18"	19"	20"	21"	22"	23"
1	.0038	.0041	.0044	.0047	.0050	.0053	.0055	.0058	.0061	.0064
2	.0078	.0083	.0089	.0094	.0100	.0105	.0111	.0116	.0122	.0127
3	.0117	.0125	.0133	.0142	.0150	.0159	.0167	.0175	.0184	.0192
4	.0155	.0167	.0178	.0189	.0200	.0211	.0222	.0234	.0244	.0255
5	.0194	.0208	.0222	.0236	.0250	.0264	.0278	.0292	.0306	.0319
6	.0233	.0250	.0267	.0283	.0300	.0317	.0333	.0350	.0367	.0384

AMOUNT OF ADJUSTMENT NECESSARY TO CORRECT ERROR

Amount of Error at 100 Yards Given in inches	Distance Between Front and Rear Sights										
	24"	25"	26"	27"	28"	29"	30"	31"	32"	33"	34"
1	.0066	.0069	.0072	.0074	.0077	.0080	.0082	.0085	.0088	.0091	.0093
2	.0133	.0138	.0144	.0149	.0155	.0160	.0156	.0171	.0177	.0182	.0188
3	.0201	.0209	.0217	.0226	.0234	.0243	.0251	.0259	.0268	.0276	.0285
4	.0266	.0278	.0289	.0300	.0311	.0322	.0333	.0344	.0355	.0366	.0377
5	.0333	.0347	.0361	.0375	.0389	.0403	.0417	.0431	.0445	.0458	.0472
6	.0400	.0417	.0434	.0450	.0467	.0484	.0500	.0517	.0534	.0551	.0567

AMOUNT OF ADJUSTMENT NECESSARY TO CORRECT ERROR

HOW TO USE TABLE ABOVE – Suppose a rifle, having a sighting radius of 27 inches between front sight and receiver sight, shoots 4 inches high at 100 yards even with the rear sight adjusted as low as possible. Remove front sight and measure overall height, preferably with a micrometer. This might be .360 inches, such as a Lyman 31HA. Reference to columns for 27 inches and 4 inches on above chart will show a necessary correction of .0300 inches. This would mean a new higher front sight, with an overall height of .360 plus .030 or .390 inches, such as a Lyman 31JA should be installed.

DOVETAIL TYPE FRONT SIGHTS

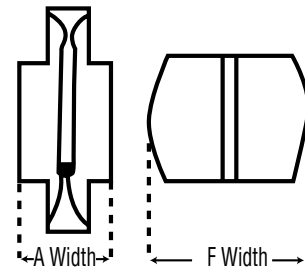
(First letter following number of sight gives the height, the second letter the width)

For Barrel Mounting*

MODELS SUPPLIED		HEIGHT .IN	WIDTH .IN
1/16" BEAD	3/32" BEAD		
3CF	28CF	.290	17/32
3FF		.330	17/32
3GF		.345	17/32
3HF	28HF	.360	17/32
3JF		.390	17/32
3KF		.410	17/32
3MF		.445	17/32
3SF		.500	17/32
3VF		.560	17/32

For Ramp Mounting*

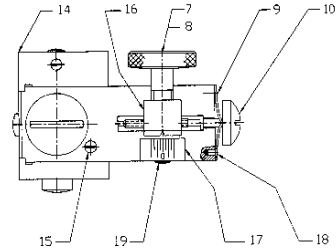
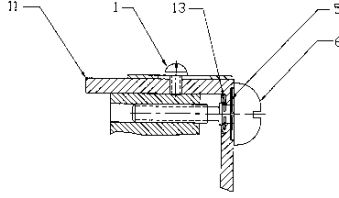
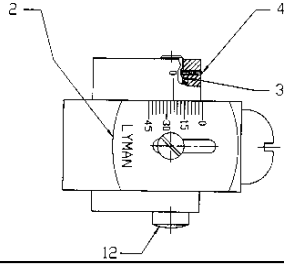
MODELS SUPPLIED		HEIGHT .IN	WIDTH .IN
1/16" BEAD	3/32" BEAD		
31BA		.240	11/32
31CA	37CA	.290	11/32
31FA		.330	11/32
31GA	37GA	.345	11/32
31HA		.360	11/32
31JA		.390	11/32
31KA	37KA	.410	11/32
31MA	37MA	.445	11/32
31SA		.500	11/32
31VA	37VA	.560	11/32



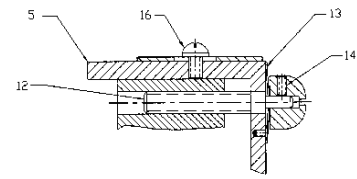
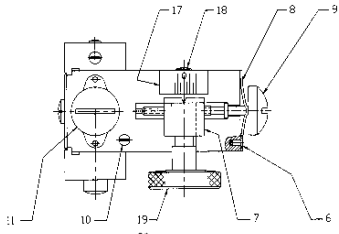
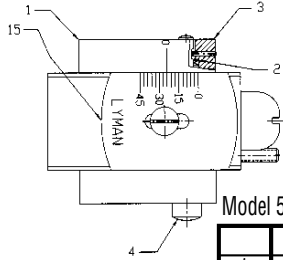
The illustration above show the difference in size and appearance of the two standard widths.

*Subject to availability

Model 57 Receiver Sight



Model 66 Receiver Sight



Model 57 Receiver Sight

	Part No.	Part Description
1	3990723	Elevation Plate Screw
2	3990812	Elevation Plate
3	3990678	Lock Bolt Spring
4	3990729	Lock Bolt Set Screw
5	3990680	Elevation Click Spring
6	3990685	Elevation Screw
7	3060960	Hunting Aperture 1/2 x 0.93
8	3060964	Target Aperture 5/8 x .040
9	3990683	Windage Click Spring
10	3990686	Windage Screw
11	---	Slide-Factory service only
12	3990677	Lock Bolt
13	3990817	Yoke
14	---	Base-Factory service only
15	3990720	Elevation Stop Screw
16	3992611	Aperture
17	3990684	Windage Plate
18	---	Pin-Factory service only
19	3990726	Windage Plate Screw

Mounting Screws
 57WJS, 57WTR, 57SME, 57SMET
 Long-3990787 Short 3990786
 57SML 2-3990730
 57GPR Wood Screw 3990731 Short 3990732

Model 66 Receiver Sight

	Part No.	Part Description
1	---	Base-Factory service only
2	3990702	Lock Bolt Spring
3	3990729	Lock Bolt Set Screw
4	3990701	Lock Bolt
5	---	Slide-Factory service only
6	---	Pin-Factory service only
7	3992611	Aperture
8	3060683	Windage Click Spring
9	3990686	Windage Screw
10	3990720	Elevation Stop Screw
11	3990615	Elevation Screw (head only)
12	3990705	Elevation Screw (threads)
13	3990683	Elevation Click Spring
14	3990727	Set Screw
15	3990815	Elevation Plate
16	3990723	Elevation Plate Screw
17	3990684	Windage Plate
18	3990726	Windage Plate Screw
19	3060960	Hunting Aperture 1/2 x .093
20	3060964	Target Aperture 5/8 x .040

Mounting Screws
 66A, 66A A, 66SKS, 66U, 66MC 2-3990791
 66MK Long 3990785 Short 3990786

Lyman Products Corporation
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 Item# 3962503