The purpose of this class, is to teach you the latest Mil-spec accepted procedures used by the Marine, Navy and Army National Match armorers in the late 1980's when they were at the top of their game with the M14 before switching to the M16 for national match competition. The procedures I will teach have produced for me and my shooters, many sub-minute, national champions with the M1 garand and the M14/M1a.

National match Barrel prep and installation procedures will be discussed but time may not allow installing barrels, if you need to install a barrel I suggest getting a short chambered Krieger or criterion barrel and notifying me so I can plan.

**Phil Arrington** was born Jan. 27, 1946 in Dallas, Texas. He was introduced to shooting at the age of 6 by his grandfather and has been shooting, hunting and reloading ever since. He was a Volunteer Arizona Hunter Education Instructor for many years and is now an appointed NRA shooting coach in high power. He has competed in High Power competition nationally with an expert classification (arthritis has caused him to stop competing). He have built rifles for himself and friends since he was 18 years old. Since the early 1980’s he has been building high quality US service rifles for himself and other shooters. He is well trained in the Marine/Army/Navy way of building National Match Service rifles. Many shooters have used rifles he built for them to become state and national champions and to earn distinguished rifleman medals. He specializes in building National Match M-1, M-14/M1A and M-16/AR-15 rifles, the Army/Marine/Navy way. He also builds tactical and long-range rifles for the military, LE units and individuals. His articles on match tuning M-1, M-14/M1A and M-16/AR-15 service and Tactical rifles have appeared in *Gun World magazine and Shotgun News* and his match armorer's work was written up in the July, 2001 issue of the *NRA's USA Shooting Sports* Magazine. Since the early 1990’s during the summer, he has taught the NRA Armorer’s school for match conditioning and accurizing of the M1 Garand, M14/M1A rifle, and AR-15/M16 rifle and an AR15/M16 Law Enforcement Armorer Certification class at Lassen College in Susanville, Ca. and now at Murray College in Tishomingo, OK. He has taught hundreds even thousands of gunsmiths and individuals how to build match service rifles the way the Navy, Army and the Marines do and how to maintain those rifles for top accuracy.

*Phil Arrington*
Tools and supplies

Required:
1- Brownells steel bed #081-040-003
2- Brownells bedding fixture. M1#080-727-001WB  M14/M1a #080-727-014WD.
3- denatured alcohol or lacquer thinner or acetone and rags or roll of paper towels for clean-up.
4- Brownells Epoxy spray release agent #081-028-000.
5- artificial flower arrangement clay and masking tape used for stock bedding.
6- Dremel tool - Foredom tool.
7- asst of 1/8 inch burrs for inletting stock.
8- 1/4 inch triangle ceramic, india or Arkansas fine cut stone for trigger work.
9- diamond or valve lapping compound medium grit.
10- small smooth cut file for bedding clean-up.
11- standard gunsmithing tools- screw drivers, pin punches, small hammer, vise jaw protective pads.
12- Lubriplate grease.
13- NM hooded rear ramp aperture.
14- NM windage knob from springfield Inc.
15- NM front sight .062".
16- 3/4" or 1" putty knife.
17- 1/8" carbide drill bit.
18- small bottle #271 Loctite.
19- .65" straight reamer.
20- 2(2) 6-40X1/4" set screws and hand tap.

Optional

21- small 3/8"X4" Long smooth flat Mill file w/ safe edge to make a NM frt sight.
22- if stock refinishing- bring sand paper, stain, stock finish, your choice.. I will note be teaching finishing..
23 - #7 taper reamer to modify M14/M1a flash suppressor(I will have mine).
24 - rifle cleaning kit, rod, patches, solvent.

if you have spare M1,M14/M1a parts, bring them someone may need and want to buy them
I will have some parts available for sale.

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