



## CLASSIC RIFLES

### **Functional elegance that endures**

My Classic Rifles represent the best of my skills as designer, craftsman and artisan. Each project combines precision metal work and the finest stock work to accomplish the client's goals. I carry with me many decades of experience in the traditional school of classic rifle making, component engineering and manufacture.

My goal is to create a piece of functional art that offers the owner intrinsic value. My standards emphasize exceptional fit, feel, accuracy and balance. I build the Classic rifles to withstand the rigors of the field around the world.

Within this text you will find a general layout for what materials I prefer to use for each project and the typical construction parameters. I will consider any reasonable request for those that seek something out of the ordinary. I believe my finest projects have always appeared quite subtle. With this in mind simplistic elegance is always my goal.

### **Classic Light Sporter**

I have found the following components ideal for a Classic Light Sporter. The current production long and medium, right and left handed Winchester Model 70 actions. Chambering choices are limited to those calibers for which factory ammunition is currently available. Popular favorites are the 257 Roberts, 260 Remington, 270 Winchester, 7x57 Mauser, 7mm Remington Magnum, 30-06 Springfield, 300 H&H Magnum, 300 Winchester Magnum, 338 Winchester magnum and 9.3x62 Mauser.

## **Metal Work**

1. Machine and modify the action's magazine well, rails, bullet ramp and ejection port as required for the chosen caliber. Surface-grind and machine the action to re-establish all appropriate external flat and radial surfaces above and below the stock line.

2. Re-machine the receiver threads when necessary; re-machine the recoil lug seats, recoil lugs, receiver face and bolt face. Install a premium grade Chrome-Moly barrel. The barrel contour and length will be appropriate for the particular caliber chosen. Each barrel is installed with techniques and tooling which assure the maximum accuracy potential from the chosen components.

3. Install a custom made Echols & Co. straddle-guard magazine assembly that is appropriate for the caliber and action. Magazine capacity will be determined by the caliber chosen. All standard calibers such as the 270 Winchester and 30/06 magazine assemblies have a five round capacity. Our standard length Model 70 magnum magazine assembly will hold 4 rounds down and 1 in the chamber, without being a drop-box design.

4. Install an Echols & Co. two-piece scope mount system. This solid steel mount is available for both 1" and 30 mm scopes, and features an integral base and lower ring half that is precision fit and secured to the action with at least four (and sometimes five) 8x40 Torx head screws. The front and rear rings of the action are surface ground concentric to the centerline of the bolt bore before the scope mount is installed. The ring I.D. is bored to the actual external diameter of the scope tube, thus assuring a perfect mechanical fit with the scope, a step virtually unheard of in the industry today. The top half of the ring secures the scope in place with four 8x40 Torx head screws. After final installation of the rings the scope tube is under no stress whatsoever. The mounts are made individually to allow the scope to be mounted as close to the centerline of the bore as is possible with the chosen scope, without crowding or overhanging the ejection port. This is a non-detachable scope mount and the only one that we will install on our Classic or Legend rifles. It is the only mount that I have used which will positively hold a heavy scope and prevent motion under extreme recoil.

5. Install a custom bolt handle that has a checkered bolt knob with an engraved, bordered rosette pattern. The position of the new handle will allow the desired scope to be mounted as low as possible and will assure easy manipulation of the bolt. Replace, rebuild, or install the appropriate wing safety.

6. Modify, detail and/or checker the bolt stop. Modify and precision-finish the factory trigger unit or install and modify a quality aftermarket trigger unit. The trigger lever will be modified and detailed as well.

7. Engrave the lettering for the following items: Caliber, Model #, Construction Ser #, D'Arcy Echols & Co., Millville, Utah, USA. If requested as an option the customer's Initials will be engraved in a gold initial inlay, installed in the corporal line of the stock or into the trigger bow itself. The socket head guard screws, sling swivel bases, cross bolt heads and grip cap screw will also be engraved with a rosette pattern.

8. All the appropriate metal work will be hand polished prior to being caustic immersion blued. The bolt body will be left blued with only the bullet ramp and side rails polished bright, unless otherwise requested.

### **Stock Work**

9. Every rifle stock I make today originates from a pattern stock I've made. This pattern is modified to anatomically fit the client's required stock dimensions. The French walnut blank is first machined 1/4" oversized, removed from the machine, and then allowed to **stress relieve** for a month. The stock is then returned to the Hoenig pantograph and machined to the final dimensions. The barreled action is then hand fit into the machined blank. The actions and magazines are fully bedded with metal to wood contact and supported by aluminum pillars. Unless otherwise requested the barrel is tastefully **Free Floated** from the barrel shank forward with a minimal amount of clearance along the barrel on both sides and an adequate amount of clearance under the barrel. After 30 years of building both Legends and Classics I am convinced this method is far superior to the traditional full-length bedding procedure with forend contact on a bedding pad behind the tip. I have observed over time that bedded in the traditional method that the point of impact will begin to change as the forend wood begins to **relax** over the years. It is fashionable for rifle makers to insist that they apply 5 to 10 lbs of upward barrel pressure at the tip and that this is the secret to accuracy. I have never been able to understand how a **steel** rifle barrel can be pre-loaded or bent by 10 inches of French walnut. The reverse actually happens and as the years go by the forend wood **relaxes**. At this point there is variable pressure applied to the forend and errors in accuracy can occur as well as zero for the iron sight point of impact begins to change vertically.

The stock design will incorporate a contemporary straight comb or Monte-Carlo when required or requested. An appropriate grip profile and a contemporary American style cheek piece or European style cheek piece with a shadow line depending on the clients taste. The stock will be made from thoroughly dried French, European, New Zealand, Turkish or Californian thin shell walnut only. Dramatic contrast and mineral marking is quite desirable in a stock blank, and many stock blanks are chosen for these characteristics only. However, proper grain layout in the blank is a critical consideration, and great care is taken in the selection of every stock blank. All critical stock dimensions



## Scope Sighted Heavy Sporter

The Scope Sighted Heavy Sporter is available in 375 Holland & Holland Magnum, 416 Remington Magnum, 404 Jeffery and 458 Lott calibers. These will be built on a current production right-hand or left-hand Winchester Model 70 action.

Construction details for the Heavy Sporter rifle are very similar to those listed above for a Classic Light Sporter, with the exception of the following items:

- Secondary recoil lug installed on the barrel
- Installation of a barrel band sling swivel base
- Installation of two engraved cross bolts
- Comb height is designed for scope use
- Overall weight and balance will be appropriate for the caliber;  
Normal weight range is from 9 to 10 lbs

**Total labor and material cost** **\$ 32,600.00**

**This price does not include the cost of the scope, test fire ammunition or final shipping and handling expenses.**

## Iron Sighted Heavy Sporter

Construction details for the Iron Sighted Heavy Sporter are also similar to the Scope Sighted Heavy Sporter, with two important exceptions: the iron sights require that the comb height be lower, and a slightly modified barrel contour is chosen to alter the overall balance point of the rifle. The sight system most often installed is our Ghost Ring Peep sight. A traditional front and single blade shallow "V" rear sight are available as well. I typically do not install any additional auxiliary folding leaf rear blades. The Iron Sighted Heavy Sporter rifles are zeroed for 50 yards, and are offered in the following calibers 375 Holland & Holland Magnum, 416 Remington Magnum, 404 Jeffery, 458 Lott

**Total labor and material cost** **\$ 33,000.00**

**This price does not include the cost of the scope, test fire ammunition or final shipping and handling expenses.**

## Available Options

**Ebony Forend Tip-** These tips are installed with a widows peak and are made from excellent quality ebony **\$400.00**

**Gold oval initial inlay** - inlaid into the corporal line on the butt stock – **\$600.00**

**Quarter Rib** - The ribs are made as a separately machined unit and are precision fit to the barrel with one standing rear sight blade and corresponding front ramp and bead - **\$1,800.00**

## Accuracy and Reality

Every Classic rifle produced in my shop is shot extensively with a variety of ammunition before the rifle is ever near its final completion. By doing so we can determine if that particular barrel is going to deliver the type of accuracy requirements for the rifles intended purpose. If a particular barrel does not meet our accuracy standards it is replaced accordingly. Practicality and intelligence dictates that the accuracy requirements for such elephant cartridges as the 458 Lott will not be near as stringent as those rifles chambered for use on typical North American or African game shot at much longer ranges. Every rifle made for scope use is tested under ideal range conditions with our test scopes of known reliability. The majority of the tests are done with precision hand-loaded ammunition that is assembled in house. Consequently our accuracy results may or may not be always exactly duplicated by the client. However I will make the following guarantee:

**I will supply you with a rifle that will maintain a consistent point of impact with more accuracy potential than you can realistically utilize under any field conditions you may encounter.**

## Optics

To date I have installed and tested about every make, model and manufacture of riflescope foreign and domestic that is available to big game hunters today. In my experience there are no hands down winners when it comes to the required critical eye relief, weight, low light performance, longevity or reliability rolled into one package. It matters little if the scope has a 1" or 30mm tube diameter, has a 20mm or 56mm

objective diameter they all have trades offs and the potential for failure right out of the box. Unless we have good reason to object, we will install any scope that the customer request. If I had to pick one brand of scope today it would likely be a Schmidt & Bender Summit or Zenith model.

## However

We will not be held responsible for any scope that fails and requires replacement during the rifle's construction or after the final delivery. This includes any scope purchased by us at the customer's request or supplied by the customer directly. If a scope malfunctions at any stage during the rifle's construction, all additional expenses such as supplemental labor cost, range time, ammunition, shipping and handling for the scope repair or replacement etc incurred as a result will be charged to the customer regardless

### **Customer Supplied actions and stock blanks**

D'Arcy Echols & Company reserves the right to accept or reject the use of any customer provided item or items. All actions sent for evaluation regardless of its outward appearance will be subject inspection to determine the actions dimensional aspects and subsequent use or rejection.

## Placing an order

A deposit of \$4000 US dollars will be required to **confirm** and **schedule** a project and acquire some of the major raw materials.

A payment of \$8000 will be required when the project is at the mid point of construction.

The final balance due will be required within 30 days after completion of the project, and/or prior to shipment of the rifle. The customer will also accept the cost for the required test fire ammunition, desired optics and insured UPS or parcel post shipment of the rifle. The client will also assume all VAT taxes place towards the rifles value by the country the firearm will reside in.

Proper cleaning equipment for home and for the field will be supplied, if requested, at current market value.

Cancellation of the project is possible up to 30 days after the deposit has been accepted. Any expenses incurred for the project by D'Arcy Echols & Co, between the date of project confirmation and date of cancellation, will be subtracted from the original deposit and forfeited by the client. D'Arcy Echols & Co will return the remaining amount to the

client.

The projected delivery time, as of this date is approximately 36 months. Completion delays can occur as well as accelerated completions.

Please feel free to contact D'Arcy Echols & Co. for further information concerning projects that are not addressed in this brochure.

\*\* Prices are subject to change without notice, with the exception of work in progress or projects that have been confirmed by deposit prior to price change.

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