



When compromise is unacceptable... When failure is not an option...

In 1994 I began getting frequent requests from my clientele to design a synthetic stocked hunting rifle with the same attention to detail as my Classic rifles. Taking a serious look at the feasibility of this project it soon became apparent that I would have to design my own components if I wanted to offer a synthetic stocked sporter of uncompromising quality. The first Legend rifles were offered for sale in 1996.

Why buy a Legend?

There are literally dozens of companies that offer synthetic stocked rifles, and many of these companies charge much less for their products. At this time, the Legend is one the most expensive rifles of its type on the market. It is an unavoidable reality that quality becomes expensive when skilled labor and quality materials are involved. Why should you consider buying a Legend rifle rather than one of the others?

- 3 decades of big game hunting experience incorporated into the design
- 3 decades of intensive professional experience as a rifle maker
- Genuine commitment to exceptional quality
- Unparalleled customer support

Since its introduction in 1996, the Legend rifle has set a new standard of excellence acknowledged by discriminating big game hunters around the world. Its distinctive appearance, style and balance are now a benchmark in the industry. These rifles are a thoughtful balance of traditional, old world craftsmanship and current technologies. They include features and components that are unique to our shop. As with any truly custom rifle, each Legend is assembled individually and thoroughly tested at each stage of production. The unique style of the Legend stock conveys an elegance that is unmatched by any other synthetic stock on the market. The attention given to cosmetic details is obvious, and also contributes greatly to the overall impression of unusual quality.

Simply stated, these rifles are elegant, rugged, and accurate and will perform under the harshest environments you may encounter around the globe

Legend Standard Sporter

1. The heart of our Legend Rifle begins with a Winchester Model 70 action made from either Chrome–Moly or Stainless Steel. Once inspected these actions are extensively refined and modified.
2. The receiver threads are re-machined to 1.032 X 16 TPI. The recoil lug seats, recoil lugs, receiver face and bolt face are re-machined and trued to remove any dimensional run out from the factory. The recoil lugs and lug seats are then lapped to remove any machine marks. A select grade chrome-moly or stainless steel barrel is then fit and chambered to the action. Our chambering procedures assure that maximum accuracy potential of the barreled action is realized. For the past 15 years the most popular chambering's for the Standard Legend's have been the following: The 7mm Remington Magnum, 300 Winchester Magnum and thirdly the 300 H&H Magnum. These three cartridges have proven time and time again their effectiveness around the world when use for the smaller Antelopes up to and including the Elands and larger Moose species. The international hunter is well served with these three cartridges. I keep an inventory of these barrels in stock at all times and have these barrels contoured into specific weights and lengths to further enhance the rifles final balance.
3. The underside of the action is re-machined to create a uniform bedding platform and to accept a proprietary Echols & Co. heat-treated, stainless steel magazine box and follower assembly. Our magazine assemblies are cartridge specific and allow our magnum magazine box to hold one additional belted magnum round, giving the shooter a total of five rounds instead of the usual four. This feature alone is almost unheard of in any currently available factory or custom produced firearm. All of our Legends will be fit with our Echols & Co. floor-plate and trigger bow assembly.
4. The receiver's feed-ramp and guide rails are then modified to assure reliable cartridge feeding. Our rifles have an established reputation for flawless reliability.
5. The ejection port is lengthened to allow easy access to magazine to permit ease in loading. A spring steel extractor replaces the factory extractor and is properly fit to fully utilize the advantages of the claw extractor system.
6. The trigger, ejector, and bolt stop are re-pinned to remove all undesirable looseness or play. The sear engagement surfaces are machined to guarantee a consistent, crisp trigger pull set at 3 lbs. The safety wing and bolt lock engagement is refined to ensure smooth and positive manipulation of the safety. The factory sleeved bolt handle is then pinned and soldered to the main bolt body to prevent any separation between the bolt handle and bolt body permanently.

7. Then I install my 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 halves that are precision fit and secured to the action with 8x40 Torx head screws. This design provides an exceptionally strong joint between the scope base and the action. The front and rear bridges 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. The top half of the ring secures the scope in place with four 8x40 Torx head screws for each ring. Done in this manner the scope tube is under no stress whatsoever. This unique arrangement provides several important advantages:

- The scope base does not overhang the ejection port front or rear
- The scope can be mounted as close to the bore as possible
- This system eliminates the joint between the base and the ring, which can become a significant weak link in the standard scope mount.

This is the only scope mount I have used that will prevent heavy 30 mm scopes from sliding in the rings under severe recoil generated by such calibers as the 458 Lott. Our scope mount system has a proven track record and is the **only** system we will install.

The customer should be aware that no other commercially made scope base will fit our rifles and they cannot be replaced by any other factory scope mounts currently on the market.

8. The Legend rifle is fitted with a synthetic stock of my own design that is the result of over three decades of Classic rifle design and construction. It allows the shooter to control heavy recoil and has the styling, feel and handling features of a best quality French walnut sporter. This stock design fills a void in the current inventory of commercially available synthetic sporter rifle stocks. McMillan Fiberglass Stocks, Inc. manufactures our stocks exclusively for D'Arcy Echols & Co. The Legend stock is available in both **left and right hand configuration**. Either version features a straight comb (with no drop from comb to heel), contemporary style cheek piece, functional point-style checkering pattern, open grip, and cast "on" or "off" both at the toe and heel depending on if the rifle is made for a left or right hand shooter. A 1" red or black recoil pad is standard. The actions are pillar bedded with 3 separate pillars and the barrels are free floated.

Length of pull is available from 13.5 " to 15" as a standard feature. Factory trigger guard and floor plate screws are replaced with high quality heat-treated Allen screws.

These stocks are available in the following solid colors: **Black, Sage Green and Desert Tan**. We then add an additional flecked and spider webbed overspray of a contrasting color to compliment the base color. A **Camouflage** pattern is also available that is based on a combination of Black, Sage Green and Desert Tan. Pictures that show this effect may be viewed on our website www.echolsrifles.com.

9. All the appropriate metal is carefully hand polished, bead blasted, wire wheeled and then caustic immersion blued. Unless other wise requested any Legend made with stainless steel hardware will be bead blasted and left a satin silver color.

10. **The rifle is test fired at the range to confirm that feed, function, accuracy, scope viability and safety requirements are completely met.** A variety of factory ammunition is used during testing to determine which ammunition delivers the best accuracy for that particular rifle.

Chrome Moly Legend Standard Sporter in either right or left hand configuration is \$15,000.00

Stainless Steel Standard Sporter is \$ 15,350.00

Sales tax will be added for Utah residents.

Optics not included in the above price

Client is responsible for shipping and handling charges. Approximate UPS ground cost in the continental US \$190.00

Test fire ammunition costs will very dependent on the caliber usually 50 to 60 rounds will be fired throughout the construction of every rifle. The cost for the ammunition and the amount used will be based on the caliber and current fair market value for the ammunition used. Minimum cost will begin at \$100.00 US

A Pelican Gun case model # 1750 can be supplied for return shipment for the current market cost for these cases. Approximate cost at the time \$250.00

Wiha Adjustable Torque 10-50 inch pound screw driver, 4mm Hex driver and T-15 driver \$150.00 US

Legend Heavy Sporter

This version is available in the following calibers: 375 H&H Magnum, 416 Remington Magnum and 458 Lott. The 375 H&H and 416 Remington have been hands down the most popular choices for the international hunter. For a number of years we did built quite a few Heavy Sporter's chambered for the 458 Lott and still do if requested. However the Lott is a fairly specialized cartridge, ideal for the Professional Hunter. The Heavy Sporter will weigh 9-3/4lbs to 10lbs depending on the scope and loaded with 5 rounds. If the rifle is to only have Iron sights I install a slightly larger barrel to bring the final loaded weight up to approximately 9-5/8lbs to 9-3/4lbs.

- The Legend Heavy Sporter is equipped with either our scope mounts or our peep sights. **At this time I offer no provision for detachable scope mounts**
- The 458 Lott comes with the front sling swivel stud mounted 2" ahead of the forend tip

Peep Sights:

Even though the stock was primarily designed for scope use, I can provide this iron sight alternative that has been specifically designed for this model. This system incorporates a NECG Universal front ramp sight coupled with a receiver-mounted peep sight of our own design. This combination has an advantage over the traditional barrel mounted express sights by allowing the shooters eyes to acquire the target very rapidly, visually focus on only the front bead and the target and has a much longer sight radius. These sights are typically zeroed 1" high at 75 yards and are easily adjusted for both windage and elevation.

Chrome Moly Legend Heavy Sporter, scoped or iron sight version, in left or right hand configuration \$15,000.00

Stainless Steel Legend Heavy Sporter \$15,350.00

Sales tax will be added for Utah residents.

Client is responsible for shipping and handling charges.

Optics not included in the above price.

Accuracy and Reality

When a rifle is shipped from this shop it has met my accuracy requirements that are based on the type of hunting for which the rifle was designed. Practicality and intelligence dictates that a 416 Remington shooting the appropriate soft point and solid ammunition will not require the same level of accuracy that can be expected from a Legend Standard Sporter chambered for 300 Winchester. When a rifle is put through this accuracy trial I am shooting bullets that are known for their performance on big game accuracy. We use either a fixed 12X or fixed 16X test scope of known reliability and repeatability for these accuracy test. The vast majority of these accuracy trials are done with precision hand-loaded ammunition shot from a solid bench and under ideal range conditions. **We consider a developed hand-load to be the very best ammunition to use** in any rifle as it allows the best bullets to be implemented and tailored to the individual rifle barrel.

However I no longer offer load development due to the current difficulty in acquiring the necessary components. Our range results may or may not be duplicated by the client. However, we will make the following guarantee:

We will supply you, the hunter, with a rifle that will maintain a consistent point of impact, with more accuracy than you can realistically utilize in the field.

Optics

To date we have installed and tested almost every model and manufacture of riflescopes that would be applicable for the international hunter today. In my experience there is no real hands down winners when it comes to performance, longevity or reliability when mounted on a standard weight big game rifle. It matters little if the manufacturer is domestic or foreign, 1" or 30mm; they all have their trade offs such as overall weight, physical size, and eye relief and all have a potential for failure right out of the box. As a general rule the more expensive the scope the better the lens quality. Unfortunately I no longer believe this always applies to the internal mechanical engineering. Unless we have a very good reason to object, we will install any scope the customer requests.

However

We will not be held responsible for any scope that fails during the rifle's construction or after the rifle's delivery. This will include any scope purchased by us at the customer's request or supplied to us by the customer. If a scope fails during any stage of the rifle's construction, all additional expenses such as supplemental labor cost, range cost, ammunition expense, shipping and insurance will be charged to the customer.

Options Available

Checkered Bolt Stop Release

Available in both Chrome Moly and Stainless Steel **\$250.00**

Fluted Barrels-POR

Muzzle Brakes-POR

Custom Checkered Bolt Knobs

Remove and replace the factory knurled bolt knob with a 4 panel checkered bolt knob. Available in both Chrome Moly and Stainless Steel **\$925.00**

Pelican model # 1750 rifle case for the final shipping to the client. These can be purchased at current market value. These cases offer outstanding protection and meet all the requirements for insurance protection from the major shipping companies i.e. **UPS, FED-EX, DHL**, etc. These cases also offer excellent protection for airline travel. Approximate current market cost **\$265.00**

Placing an Order

Ordering a Legend rifle is simple. It can be done by letter, phone, E-mail, or in person. I encourage any prospective customer to visit the shop if at all possible. A **\$3500.00** deposit is required to **confirm** and **schedule** a project and acquire the raw materials, with the balance due prior to shipment. A current and signed Federal Firearms License is required from the dealer in your area who will be receiving shipment of the rifle. Rifles not claimed within 30 days of completion will be considered forfeited. Deposit will also be forfeited in cases where the rifle is unclaimed within the 30-day window. Any rifles ordered with non-standard options or an unusually long or short length of pull that is returned for a refund will be subject to a refund that forfeits the cost of all option upgrades or non-standard length of pull stock installed by request on that particular rifle.

Delivery at this time is approximately under 12 months. Since you have read this brochure to this point you will have hopefully become aware that these Legends are not in any way a mass-produced "box" rifle. Each individual rifle is assembled with the utmost care and attention to detail. Unfortunately, unexpected delays are sometimes encountered, which are most often due to a particular rifle that is not performing as we think it should, thereby requiring additional time for diagnosis and correction. This is a rare occurrence, but should give the prospective client an idea of our dedication to excellence. Please feel free to contact us directly if you have any further questions.

Brochure # 21 Dated 6/15/2014
Prices subject to change without notice

D'Arcy Echols & Company
PO Box 421
Millville Utah 84326
USA
435-755-6842
echolslegend@comcast.net

Please feel free to visit our Web Site at www.echolsrifles.com and our Blog site at www.echolsrifles.blogspot.com

A reference list can be supplied upon request as well as a list of publications that our rifles have been featured in over the years.