

PROJECT MANUAL

WRITTEN AND PREPARED BY

WILLIAM PRATOR

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TRINIDAD STATE JUNIOR COLLEGE,

TRINIDAD, COLORADO

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REVISIONS

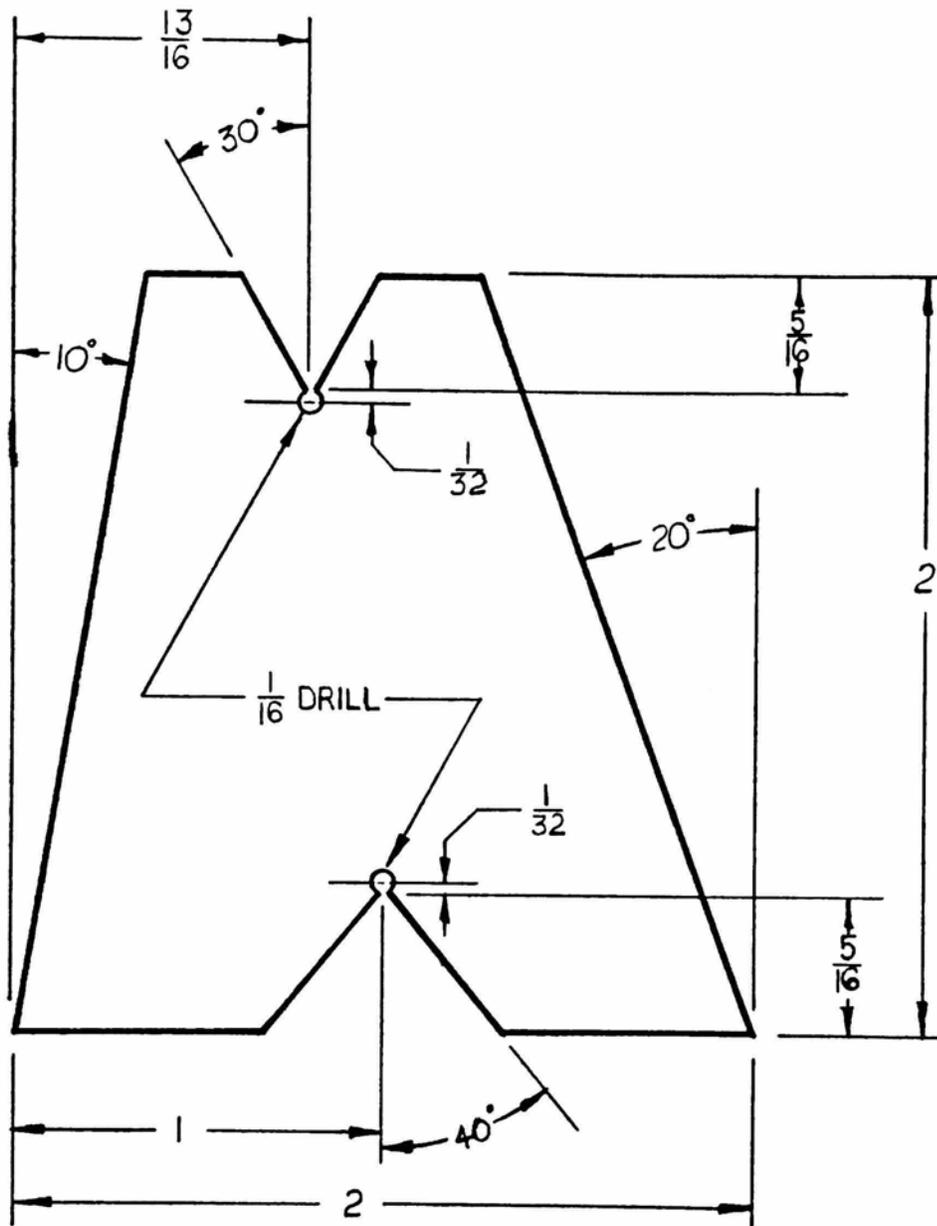
5/68 DELETED DRAWINGS NUMBER F120 "6 x 8 BUTTON DIE"
S149 "PULL GAGE"

ADDED DRAWINGS NUMBER F125A, B & C "JEWELERS SCREWDRIVERS"
F128 "CARVING GOUGES & VEINER"
0164 "CUTTS-COMPENSATOR MANDRIL"

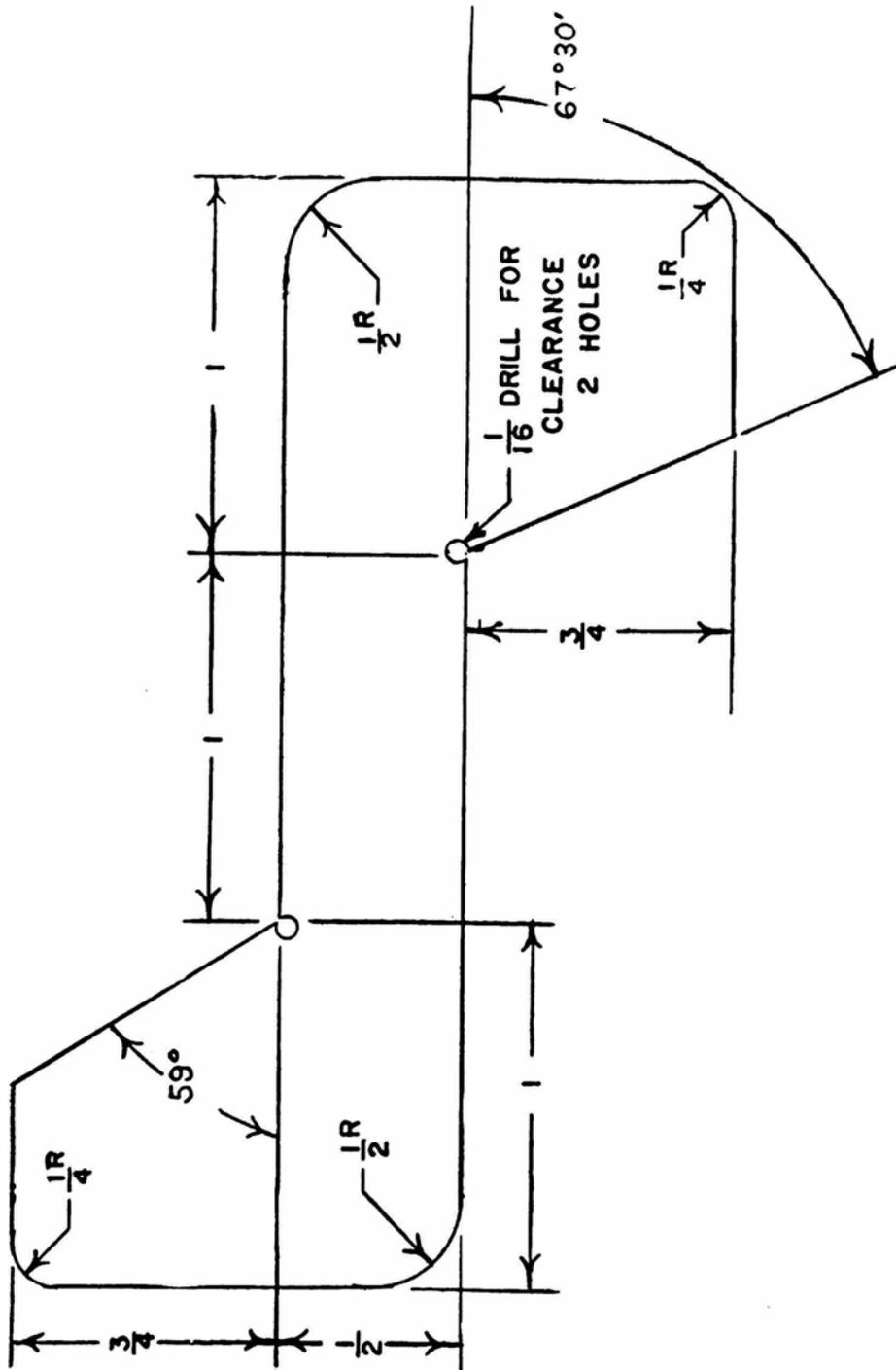
REVISED F105 "PUNCHES"
F131 "RECOIL LUG CHISEL"

COMPLETELY REVISED AND REDRAWN F129 "SCRAPPERS"
F130 "PUSH CHISELS"
F132 "GOUGES"
R170 "STANDARD STOCK DIMENSIONS"

RE-NUMBERED - S148A was S148E
S148B was S148C
S148C was S148B
S148D was S148A
S148E was S148D



HEAT TREAT: NONE			DRN DB		NAME TOOL BIT GAGE	
FIN HI POLISH			MATERIAL $\frac{1}{8}$ FCRS		DEPT OF GUNSMITHING	
SCALE 2 = 1			DATE 9/23/71		TRINIDAD STATE JR COLL.	
			APR.		TRINIDAD COLO	
					DWG NO F-101	



MADE FROM $\frac{1}{8}$ X 2 X 3 FLAT COLD ROLL STEEL

ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT: NONE	DRAWN: W.G.L.
FINISH: POLISH	MATL: $\frac{1}{8}$ F. CRS
SCALE: 2" = 1"	DATE: 4-14-64
	CHECKED: <i>sea</i>
	APPROVED: <i>Tom</i>

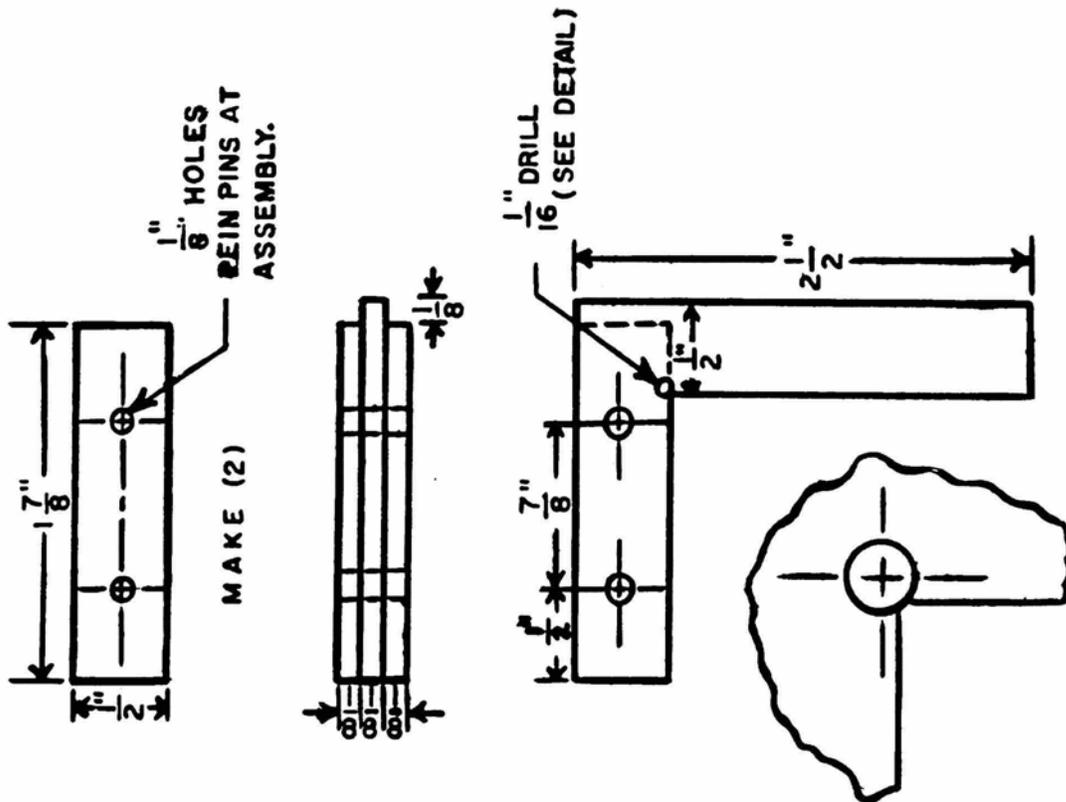
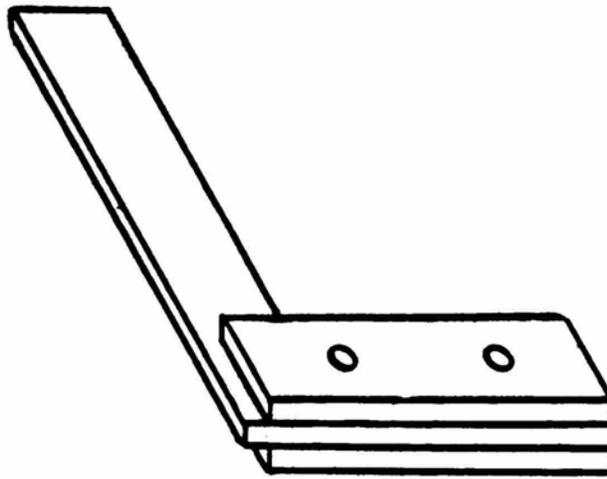
NAME

DRILL GAGE

DEPARTMENT OF GUNSMITHING

TRINIDAD STATE JR. COLLEGE

TRINIDAD, COLORADO | DWG. NO. F-102

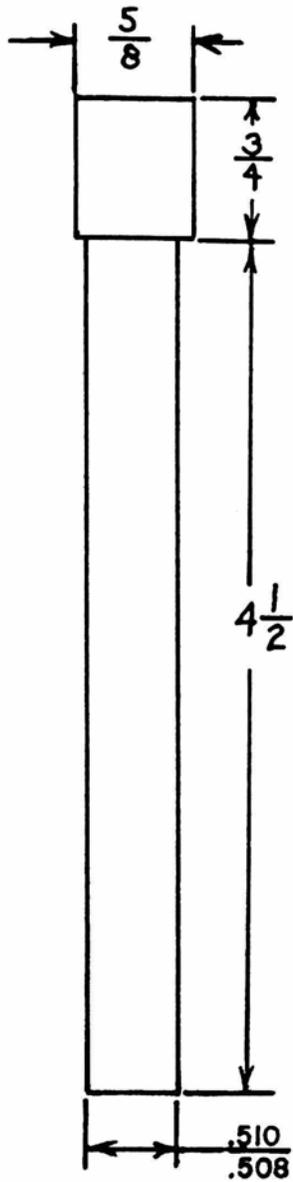


ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT: _____		DRAWN: WJF	
FINISH: POLISH	MATL: $\frac{1}{2}$ " F CRS	CHECKED: <i>[Signature]</i>	
SCALE: FULL	DATE: 4/14/64	APPROVED: <i>[Signature]</i>	

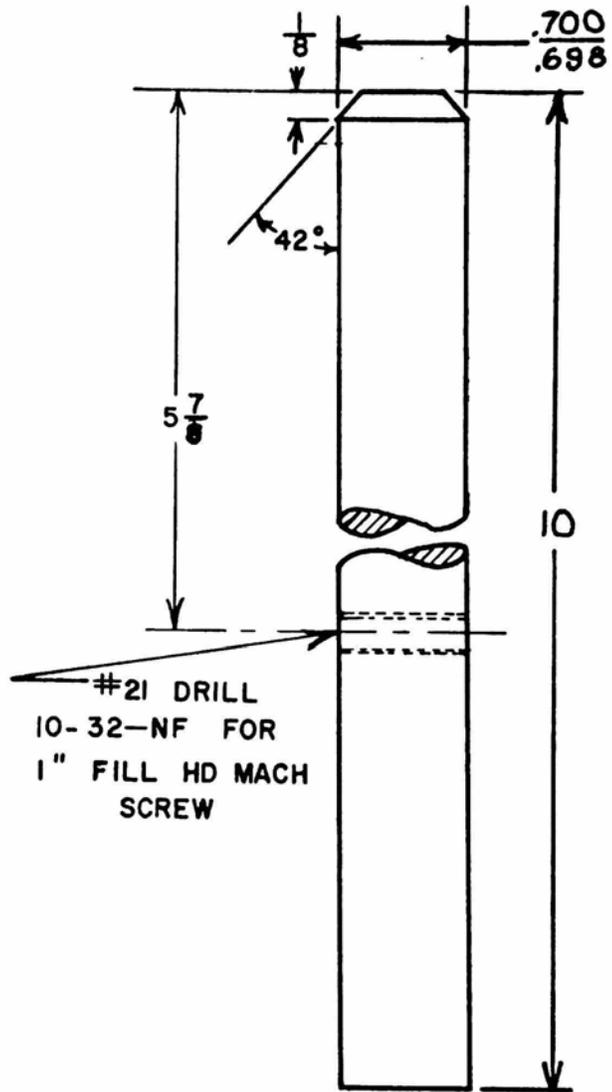
NAME MACHINIST SQUARE	
DEPARTMENT OF GUNSMITHING	
TRINIDAD STATE JR. COLLEGE	
TRINIDAD, COLORADO	DWG. NO. F-103

JAP BOLT
MANDREL



CENTER DRILL
BOTH ENDS

MAUSER & SPRINGFIELD
RECEIVER MANDREL



CENTER DRILL BOTH ENDS

ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT: NONE	DRAWN: J.R.J.
FINISH: FILE	CHECKED: <i>DH</i>
MATL: C.R.S.	APPROVED: <i>JM</i>
SCALE: 1" = 1"	DATE: 2-5-63

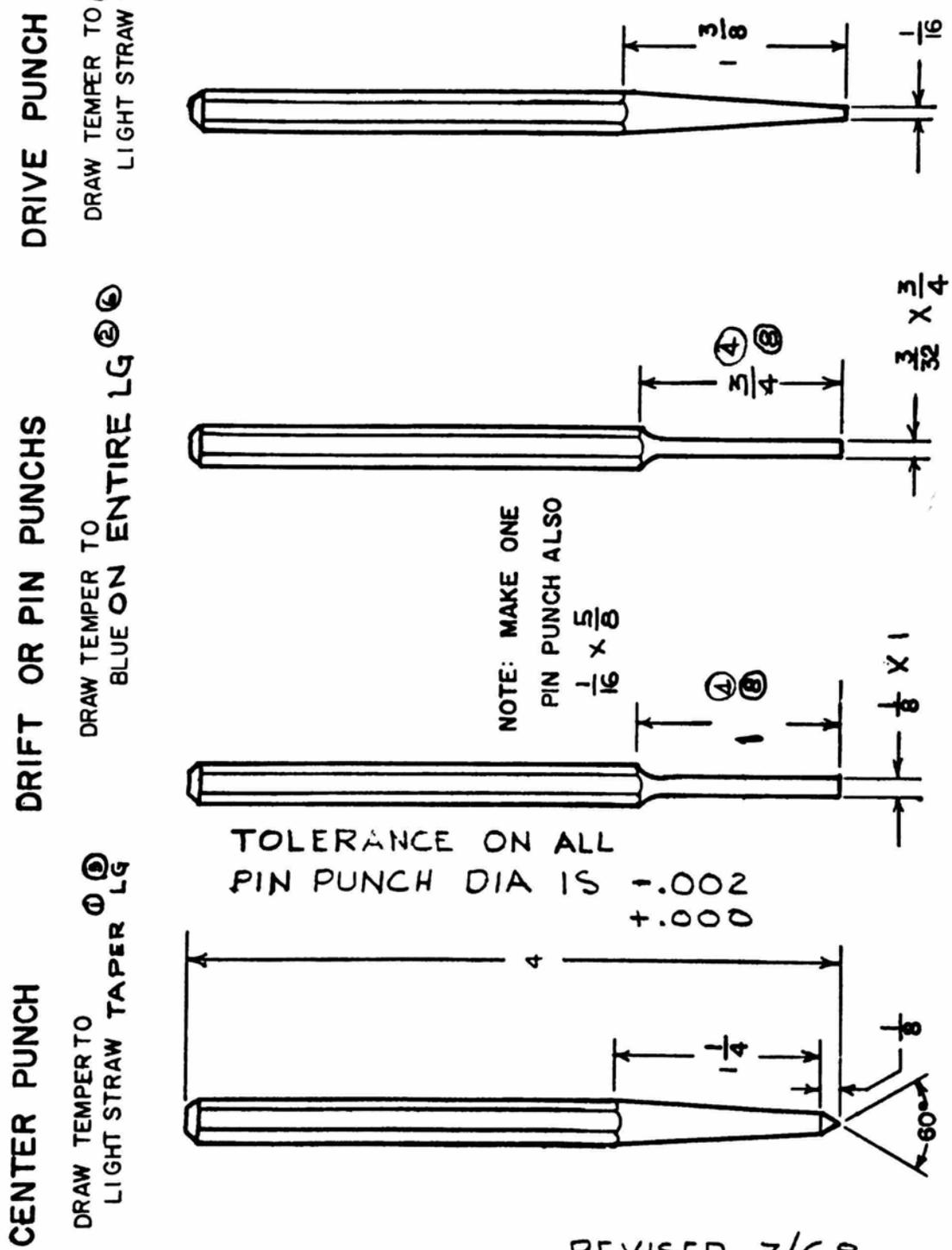
NAME	MANDRELS
DEPARTMENT OF GUNSMITHING	
TRINIDAD STATE JR. COLLEGE	
TRINIDAD, COLORADO	DWG NO. F-104

REVISED - 4/22/65

(A) ADDED - ON TIP
 (B) ADDED - ON ENTIRE 1/8
 (C) ADDED - ON END
 (D) CHANGED FROM 1/4

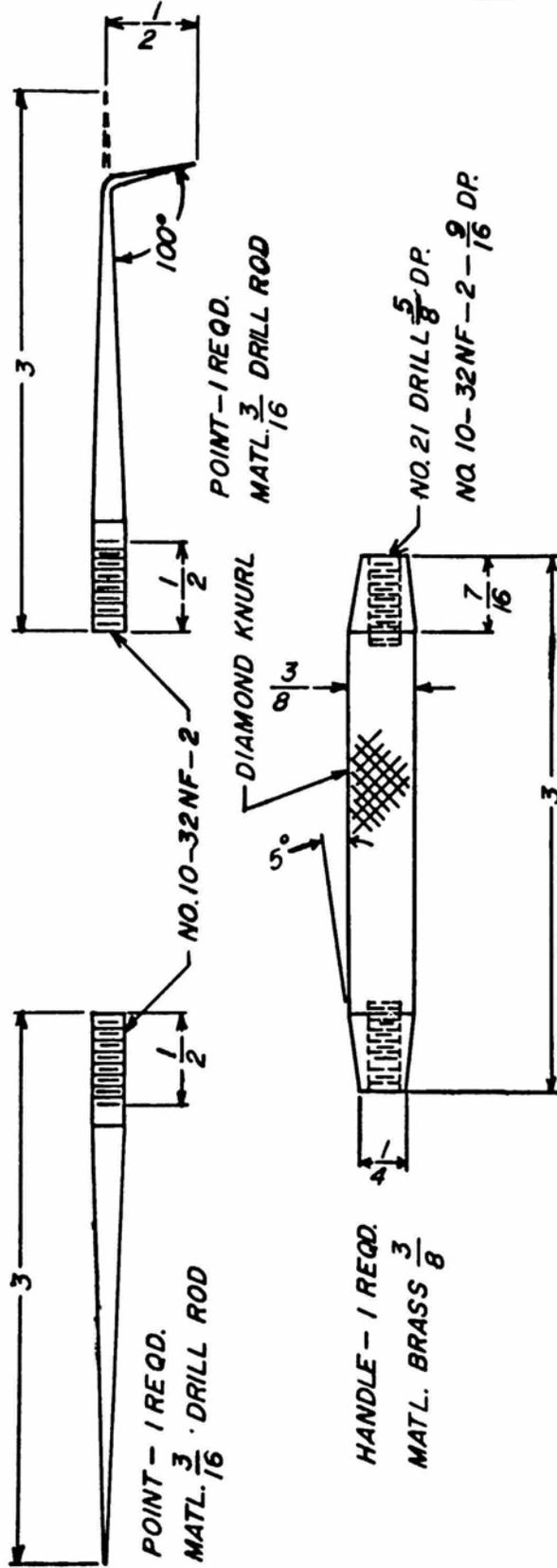
REVISED 7/29/8

(E) WAS - ON TIP
 (F) WAS - ON ENTIRE 1/8
 (G) WAS - ON END
 (H) CHANGED FROM 1/8



REVISED 7/68

ALL DIMENSIONS IN INCHES UNLESS SPECIFIED			PUNCHES	
HEAT TREAT: QUENCH IN OIL	DRAWN: J.J.		DEPARTMENT OF GUNSMITHING	
FINISH: POLISH	MATL.: OCT. TS	CHECKED: <i>[Signature]</i>	TRINIDAD STATE JR. COLLEGE	
SCALE: FULL	DATE: 1-17-63	APPROVED: <i>[Signature]</i>	TRINIDAD, COLORADO	DWG. NO. F-105



HANDLE:

1. FACE AND CENTERDRILL
2. KNURL
3. DRILL & TAP
4. TURN TAPERS

POINTS:

1. TURN IN STEPS FOR FASTER FILING
2. FEED ROD FROM CHUCK FOR EACH STEP

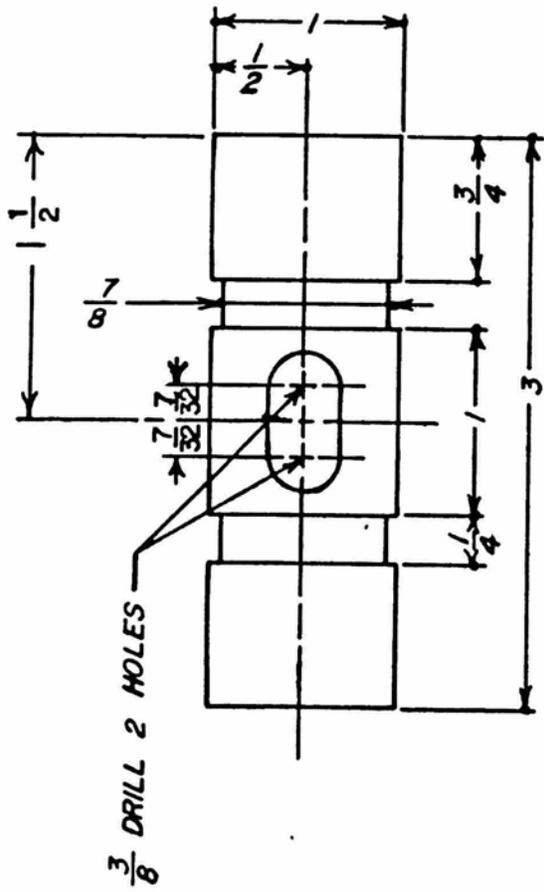
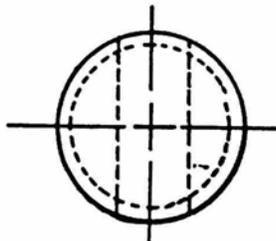


HEAT RED, QUENCH IN WATER
DRAW TO DARK STRAW
DRAW BEND TO BLUE

ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT: DARK STRAW		DRAWN: R.C.S.	
FINISH: POLISH	MATL.: SPEC.	CHECKED: <i>[Signature]</i>	
SCALE: 1 = 1	DATE: 9-25-62	APPROVED: <i>[Signature]</i>	

NAME	SCRIBE
DEPARTMENT OF GUNSMITHING	
TRINIDAD STATE JR. COLLEGE	
TRINIDAD, COLORADO	DWG. NO. F-106

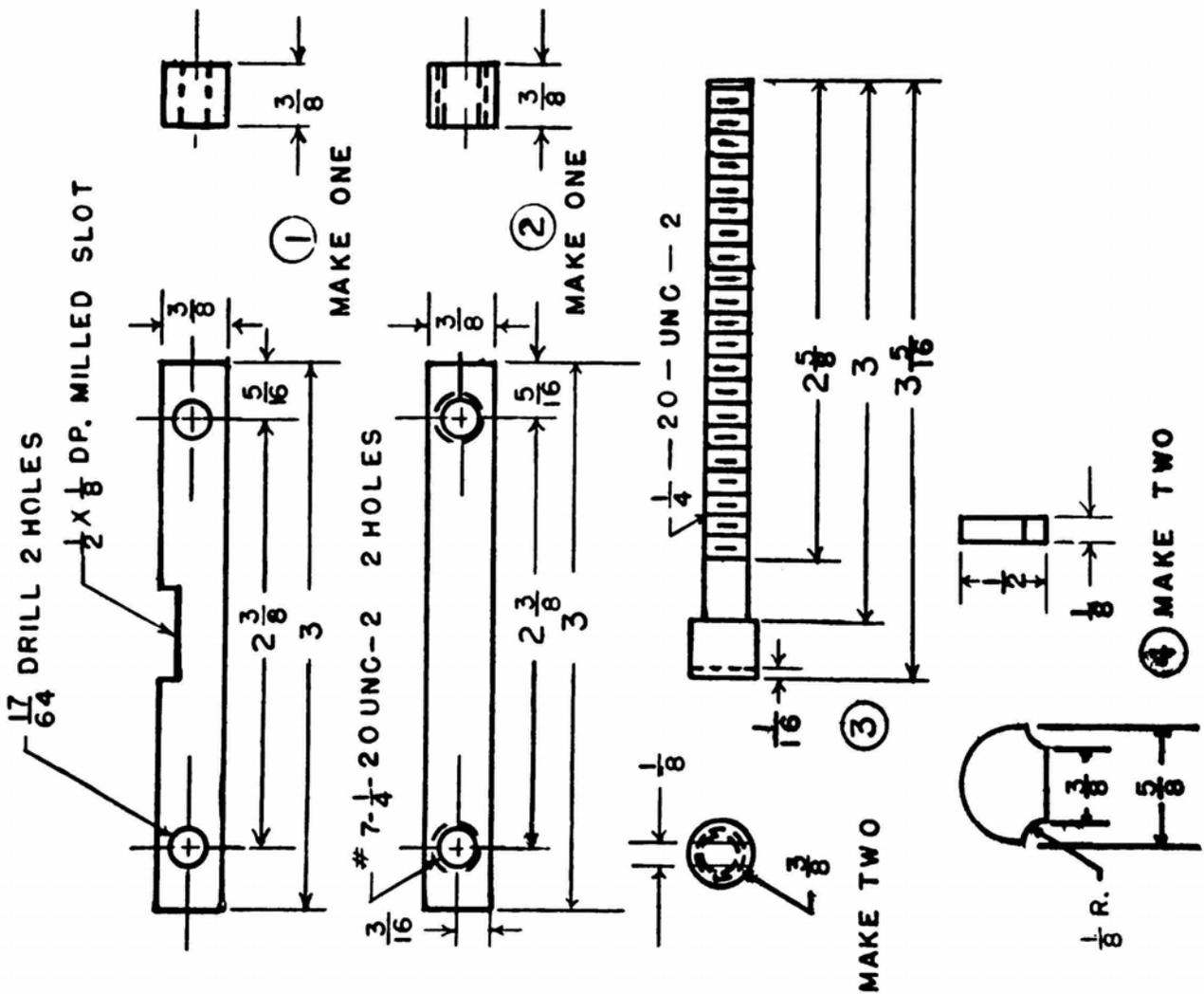
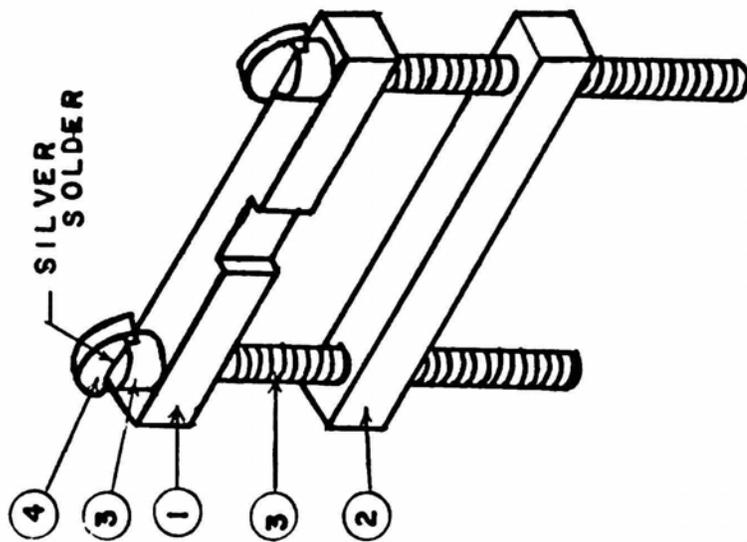


NOTE: ELONGATE HOLE WITH RATTAIL FILE
OR $\frac{3}{8}$ END MILL
HAMMER MAY BE MADE OF COPPER

ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT: NONE		DRAWN: R.C.S.
FINISH: POLISH	MATL.: BRASS	CHECKED: <i>[Signature]</i>
SCALE: 1 = 1	DATE: 9-30-62	APPROVED: <i>[Signature]</i>

NAME	BRASS HAMMER
DEPARTMENT OF GUNSMITHING	
TRINIDAD STATE JR. COLLEGE	
TRINIDAD, COLORADO	DWG. NO F-107



ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT: NONE

DRAWN: G.M.T.

FINISH: FILE

MATL: C.R.

CHECKED: *[Signature]*

SCALE: FULL

DATE: 5-14-64

APPROVED: *[Signature]*

NAME

SIGHT CLAMP

DEPARTMENT OF GUNSMITHING

TRINIDAD STATE JR. COLLEGE

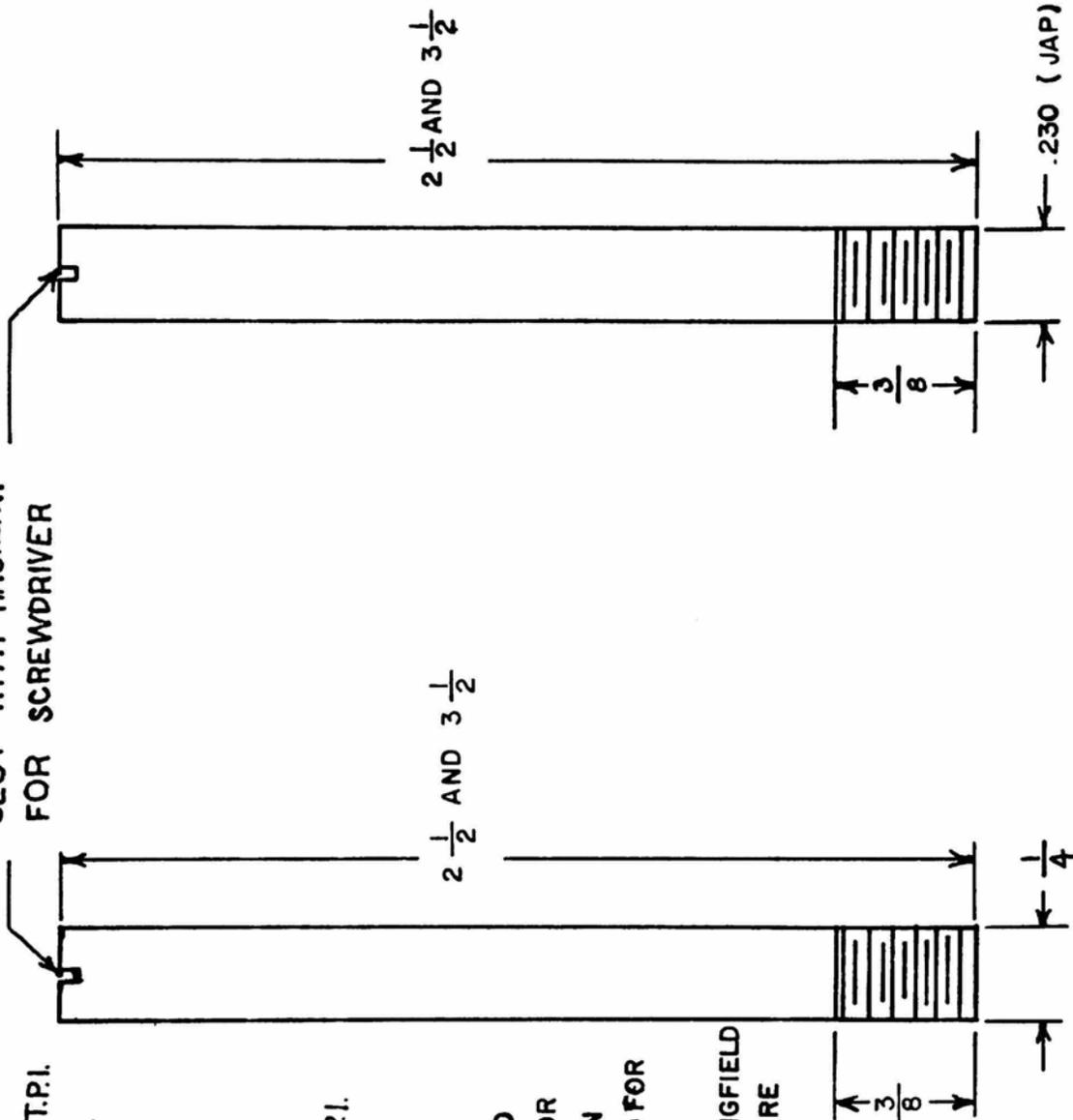
TRINIDAD, COLORADO DWG. NO. F-108

ENFIELD - $\frac{1}{4}$ x 30 T.P.I.
 M720 OR M721 - $\frac{1}{4}$ x 28 T.P.I.
 SPRINGFIELD - $\frac{1}{4}$ x 24 T.P.I.
 JAP 31 - .230 x 32 T.P.I.
 M70 WINCHESTER -
 $\frac{1}{4}$ x 24 T.P.I.
 MAUSER - $\frac{1}{4}$ x 22 T.P.I.
 JAP 6.5 - .230 x 28 T.P.I.

NOTE:
 MAKE ONE $2\frac{1}{2}$ AND
 ONE $3\frac{1}{2}$ LONG FOR
 EACH MODEL GUN
 ONLY ONE NEEDED FOR
 ENFIELD

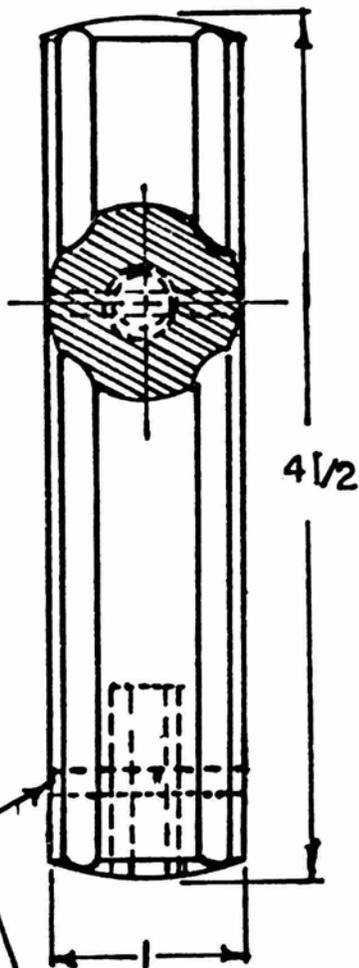
NOTICE BOTH SPRINGFIELD
 AND WINCHESTER ARE
 SAME SIZE

SLOT WITH HACKSAW
 FOR SCREWDRIVER



ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

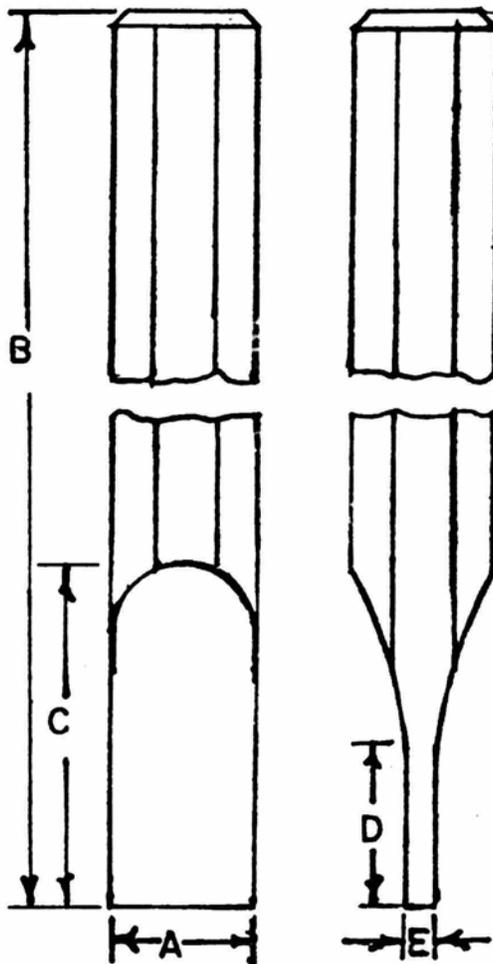
HEAT TREAT: NONE		DRAWN: J.A.J.		NAME: INLETTING GUIDE SCREWS	
FINISH: NO POL		MATERIAL: CRS		DEPARTMENT OF GUNSMITHING	
SCALE: 2" = 1"		DATE: 2-5-63		TRINIDAD STATE JR. COLLEGE	
		APPROVED: [Signature]		TRINIDAD, COLORADO	
				DWG. NO. F-109	



PLASTIC OR WOOD HANDLE
PIN IN WOOD HANDLE ONLY

NOTE: DRILL HOLE
IN HANDLE 1" DEEP
AND DIAMETER OF "A"

HARDEN AND TEMP;
OIL- PURPLISH-BLUE



MATL: OCT. TOOL STEEL
HOLLOW GRIND TO SHAPE

#	A	B	C	D	E
1	$\frac{5}{8}$	12"	1	$\frac{3}{8}$.055
2	$\frac{5}{8}$	6	$\frac{3}{4}$	$\frac{1}{4}$.040
3	$\frac{5}{16}$	12"	1	$\frac{3}{8}$.040
4	$\frac{1}{4}$	6	$\frac{3}{4}$	$\frac{1}{4}$.030

ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT: SPEC.

DRAWN: R.J.B.

FINISH: FILE

MATL.: T.S.

CHECKED: *RA*

SCALE: NONE

DATE: 4/21/64

APPROVED: *Lam*

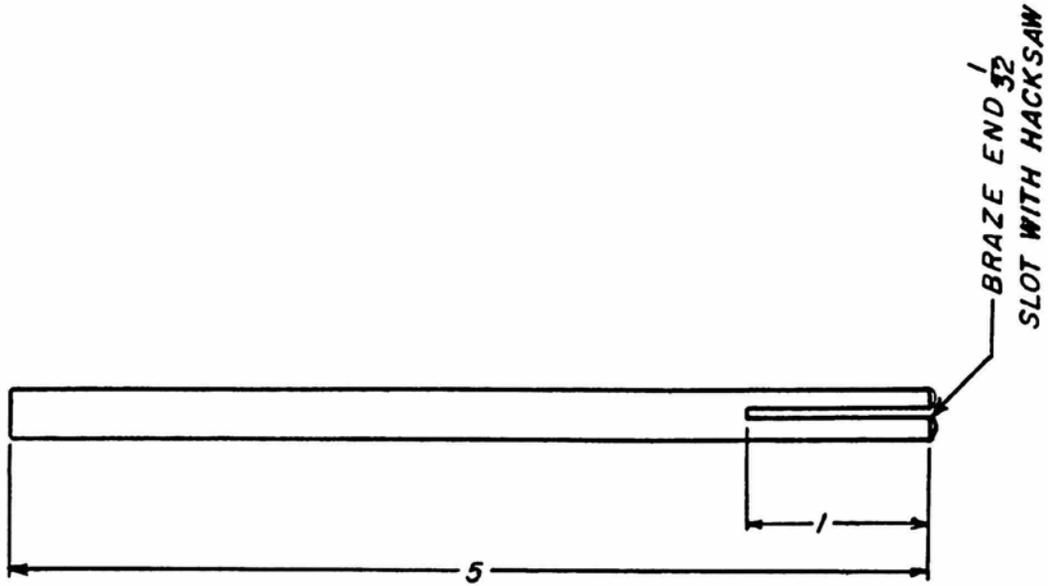
NAME

SCREW DRIVERS

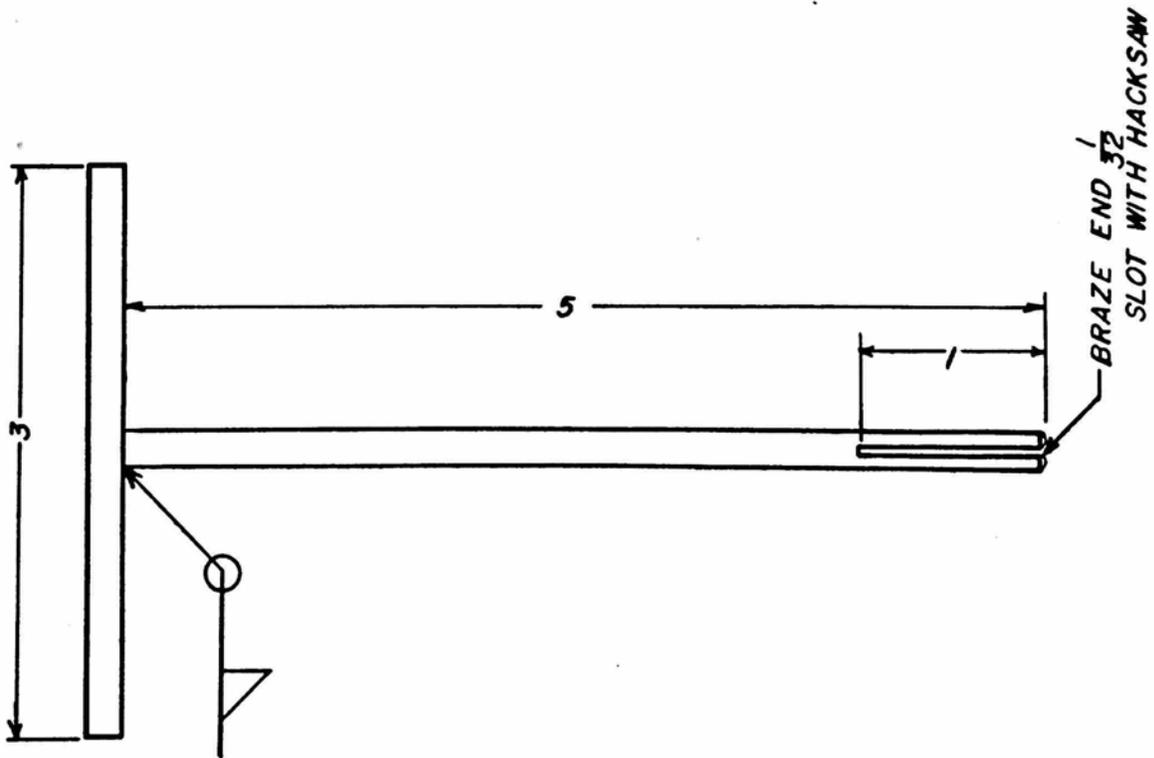
DEPARTMENT OF GUNSMITHING

TRINIDAD STATE JR. COLLEGE

TRINIDAD, COLORADO DWG. NO. F-110



MATL. $\frac{1}{4}$ C.R.S.

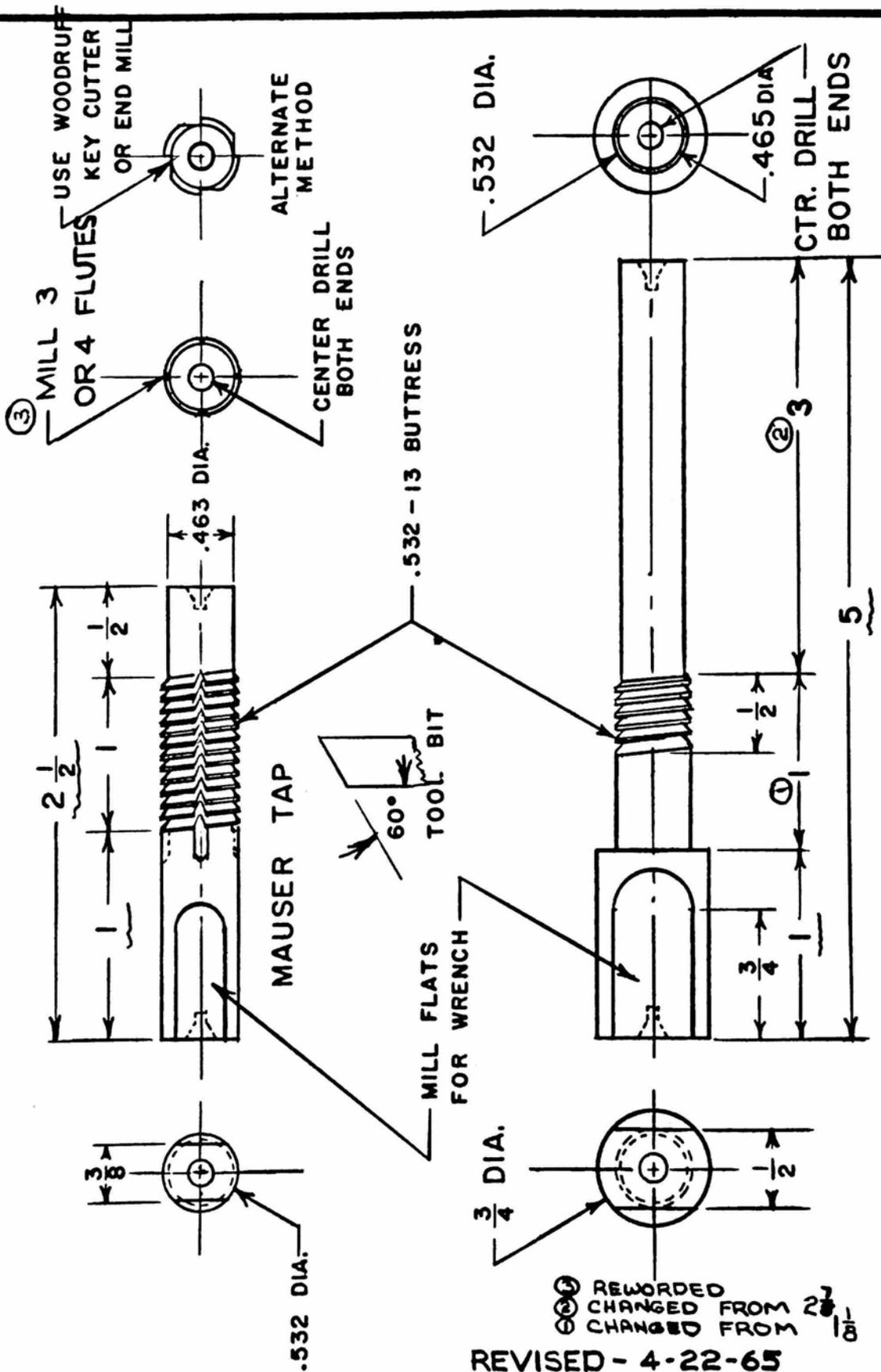


MATL. $\frac{1}{4}$ C.R.S.

ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT: NONE	DRAWN: R.C.S.
FINISH: POLISH	CHECKED: <i>RB</i>
SCALE: 1 = 1	DATE: 9-25-62
	APPROVED: <i>[Signature]</i>

NAME	POLISHING STICKS
	DEPARTMENT OF GUNSMITHING
	TRINIDAD STATE JR. COLLEGE
TRINIDAD, COLORADO	DWG. NO. F-111



MAUSER MANDREL — CRS
 USE SARATOGA OIL HARDENING T S FOR TAP
 HEAT TREAT — OIL — DRAW LIGHT STRAW

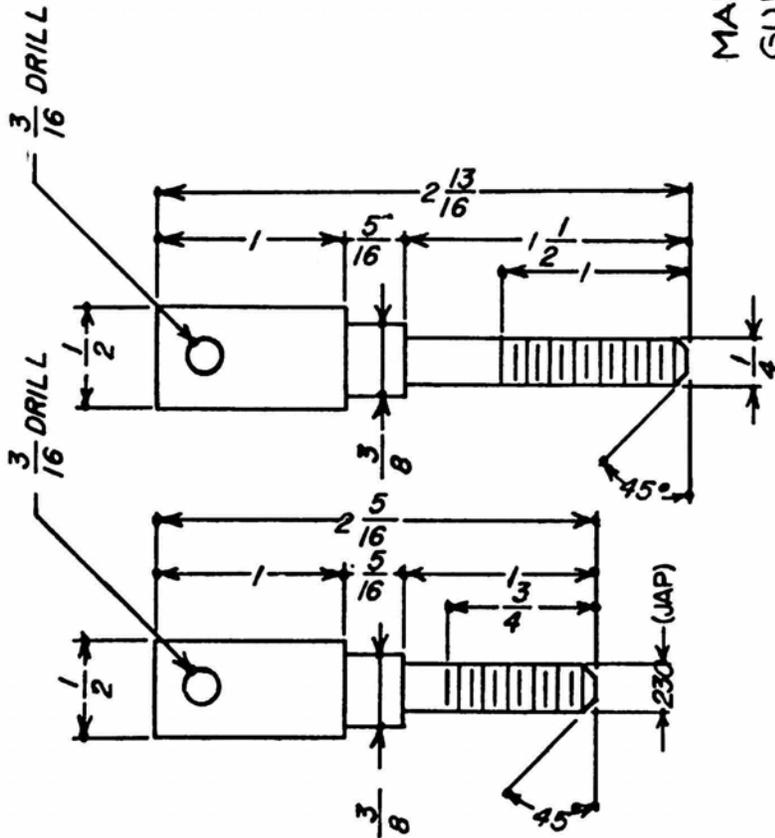
① REWORDED
 ② CHANGED FROM 2 7/8
 ③ CHANGED FROM 1 1/8

REVISED - 4-22-65

ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT: SPEC.		DR. DRAWN: <i>WH</i>
FINISH: —	MATL: SPEC.	CHECKED: <i>Lam</i>
SCALE: FULL	DATE: 4-3-64	APPROVED: <i>MP</i>

NAME MAUSER TAP & MANDREL	
DEPARTMENT OF GUNSMITHING	
TRINIDAD STATE JR. COLLEGE	
TRINIDAD, COLORADO	DWG. NO. F-112



SCREW THREADS

ENFIELD - $\frac{1}{4}$ -30UN - 2

MAUSER - $\frac{1}{4}$ -22UN - 2

SPRINGFIELD - $\frac{1}{4}$ -24UN - 2

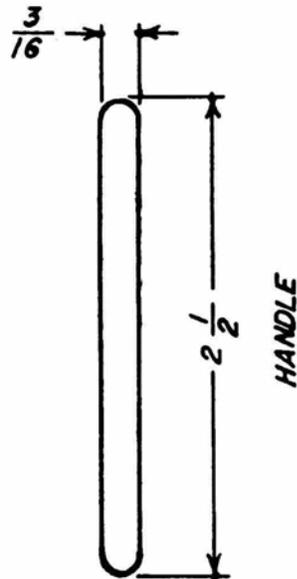
REMINGTON 721 - $\frac{1}{4}$ -28UN - 2

JAP 31 - .230-32UN - 2

JAP 6.5-230-28UN - 2

MAKE ONE PAIR FOR EACH MODEL GUN

SCREWS, USE $\frac{1}{2}$ CRS - HANDLE OF $\frac{3}{16}$ CRS



ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT: NONE

DRAWN: R.C.S.

FINISH: NONE

MATL.: C.R.S.

CHECKED: *[Signature]*

SCALE: 1=1

DATE: 12 3 62

APPROVED: *[Signature]*

NAME

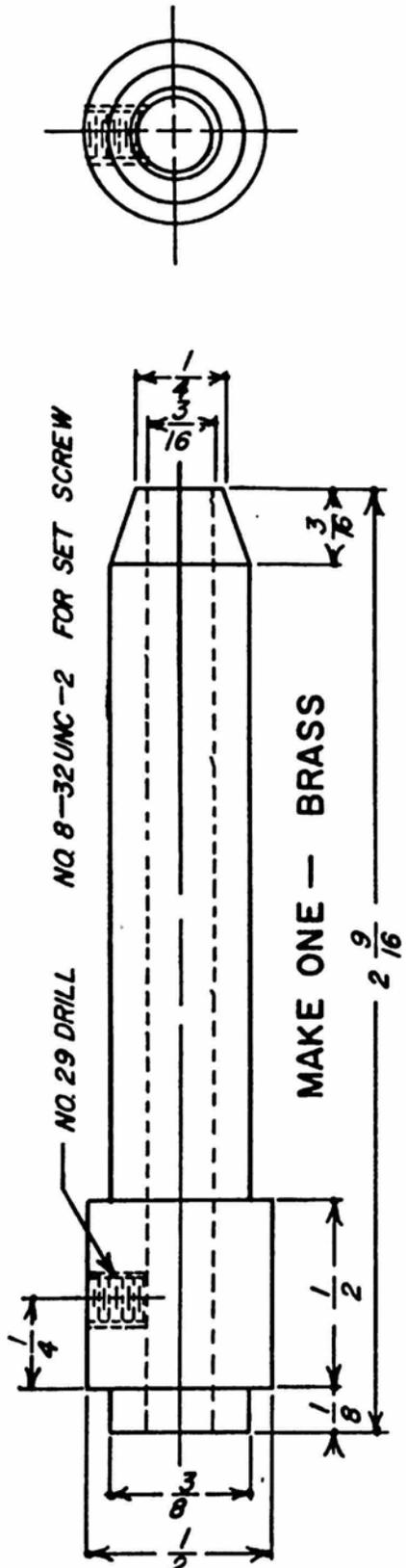
INLETING DRAWUP SCREWS

DEPARTMENT OF GUNSMITHING

TRINIDAD STATE JR. COLLEGE

TRINIDAD, COLORADO

DWG. NO. F-113



HANDLE - CRS
 NOTE-ALSO MAKE ONE 1/4 DIA.

REVISED 4-22-65 - ADDED NOTE

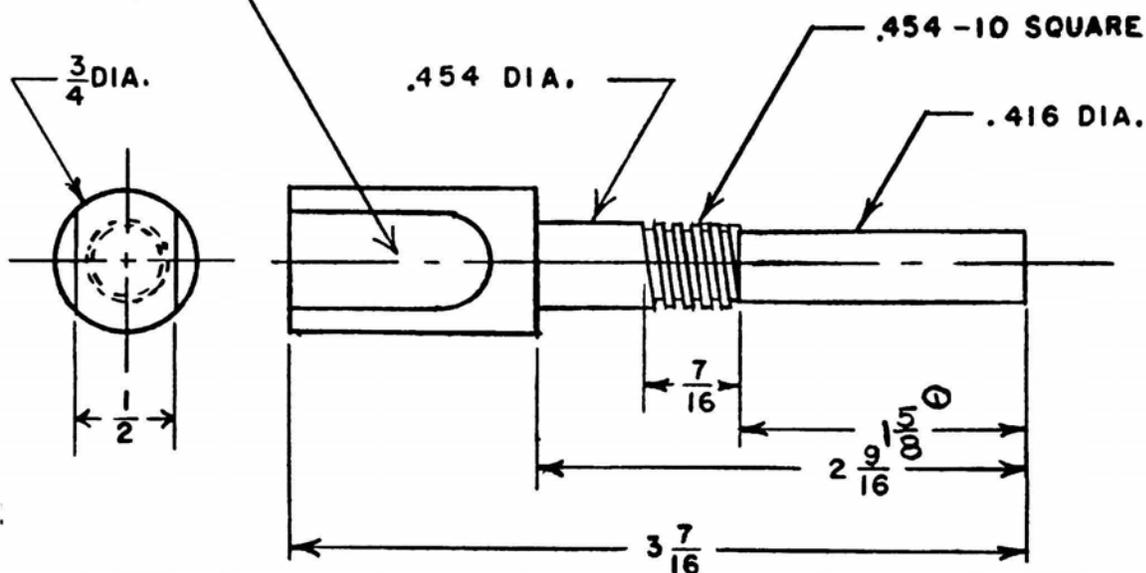
ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT: NONE	DRAWN: R.C.S.
FINISH: 320 G.R.	MATL.: 3/16 C.R.S.
SCALE: 2=1	DATE: 12-5-62
	CHECKED: [Signature]
	APPROVED: [Signature]

NAME	ENGINE TURNING TOOL
	DEPARTMENT OF GUNSMITHING
	TRINIDAD STATE JR. COLLEGE
TRINIDAD, COLORADO	DWG. NO. F-114

NOTE: CENTER DRILL BOTH ENDS

MILL FLATS
FOR WRENCH



GRIND TOOL BIT AS SHOWN

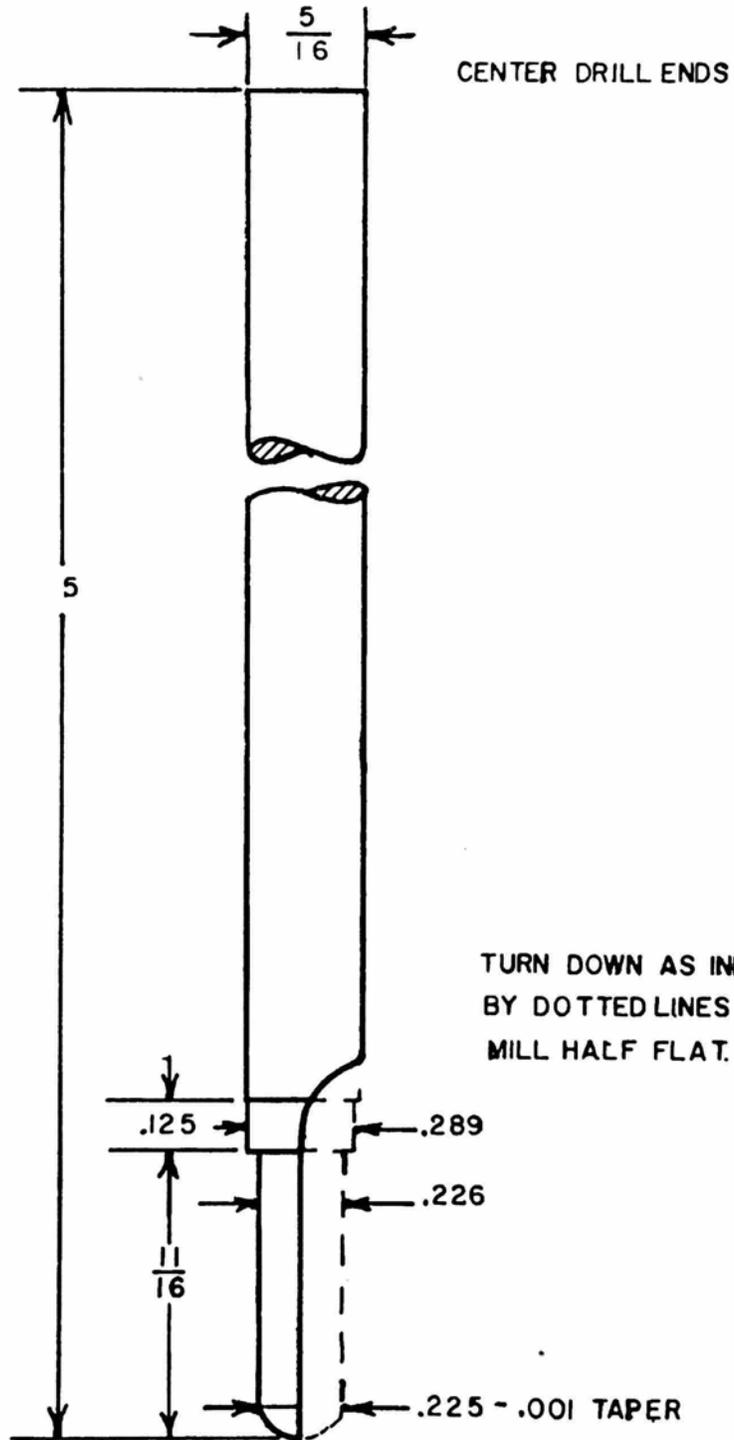
⊙ CHANGED FROM 1/2

REVISED 4-22-65

ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT:	DRAWN: <i>WJA</i>
FINISH: NONE	MATL: C.R.S.
SCALE: NONE	DATE: 5/13/64
	CHECKED: <i>WJA</i>
	APPROVED: <i>Lom</i>

NAME	SPRINGFIELD BOLT MANDREL
	DEPARTMENT OF GUNSMITHING
	TRINIDAD STATE JR. COLLEGE
	TRINIDAD, COLORADO
	DWG. NO. F-115



TURN DOWN AS INDICATED
BY DOTTED LINES AND
MILL HALF FLAT.

HEAT RED - QUENCH IN OIL

DRAW WORKING END TO LIGHT STRAW - ONLY FIRST 1" ^① ADDED - ONLY FIRST

REVISED 4-22-65

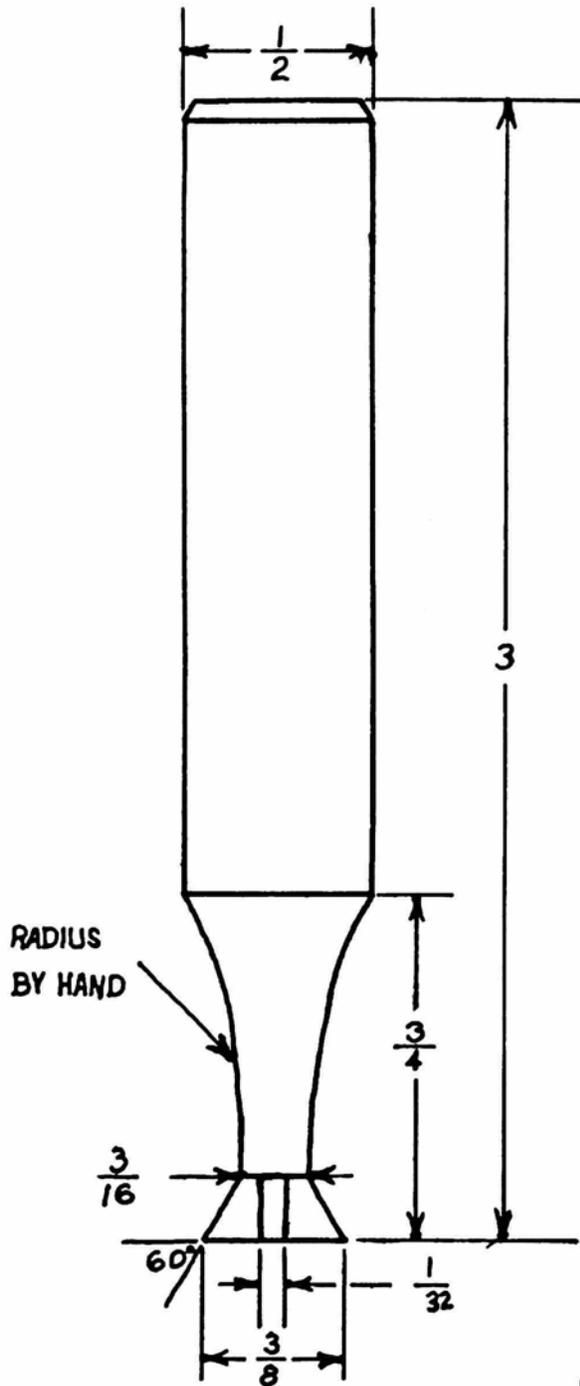
ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT: SPECIFIED DRAWN: J.A.J.

FINISH: POLISH MATL.: KETOS CHECKED: *[Signature]*

SCALE: 2" = 1" DATE: 2-5-63 APPROVED: *[Signature]*

NAME		22 L.R. CHAMBER IRONER	
DEPARTMENT OF GUNSMITHING		TRINIDAD STATE JR. COLLEGE	
TRINIDAD, COLORADO		DWG. NO F-116	



RADIUS
BY HAND

$\frac{1}{16}$ CENTER DRILL
SHALLOW HOLE

NOTE:

HAVE INSTRUCTOR CHECK
BEFORE HARDENING

BACK OFF SIDE AND
BOTTOM OF CUTTING
EDGES

REVISED - 4-22-65 ADDED NOTE

ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT: OIL - LIGHT STRAW DRAWN: J.A.J.

FINISH: POLISH MATL.: KETOS CHECKED: *Rid*

SCALE: 2" = 1" DATE: 2-5-63 APPROVED: *Lam*

NAME

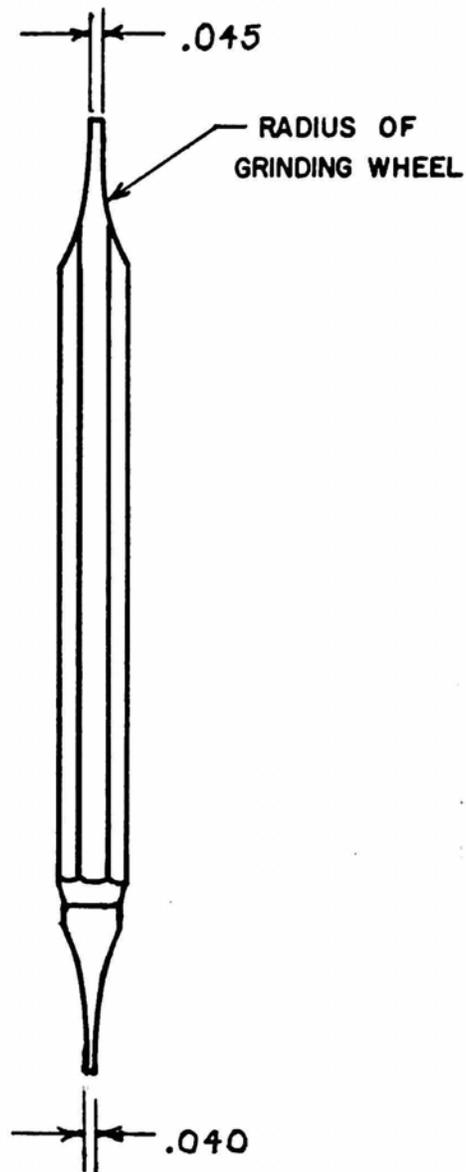
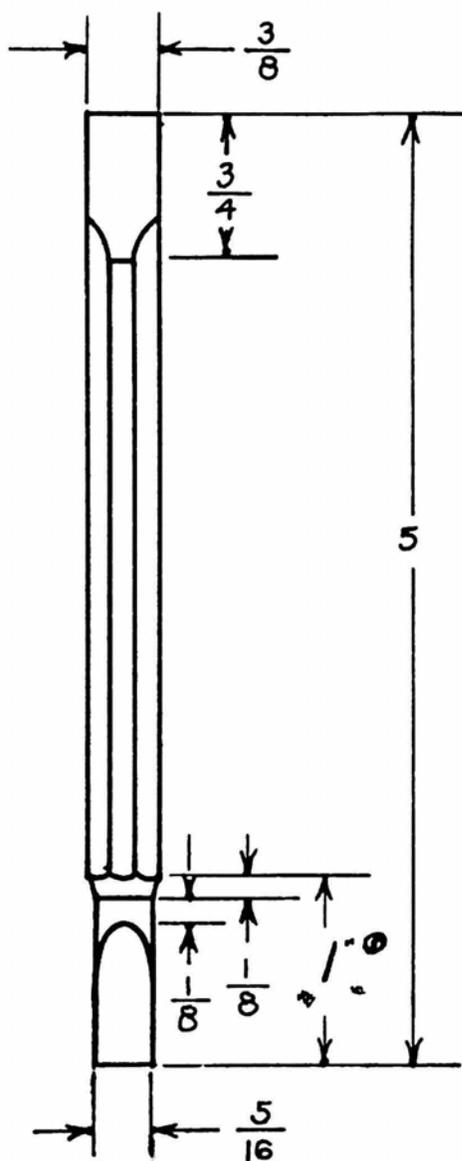
DOVE TAIL CUTTER 60°

DEPARTMENT OF GUNSMITHING

TRINIDAD STATE JR. COLLEGE

TRINIDAD, COLORADO

DWG. NO. F-118



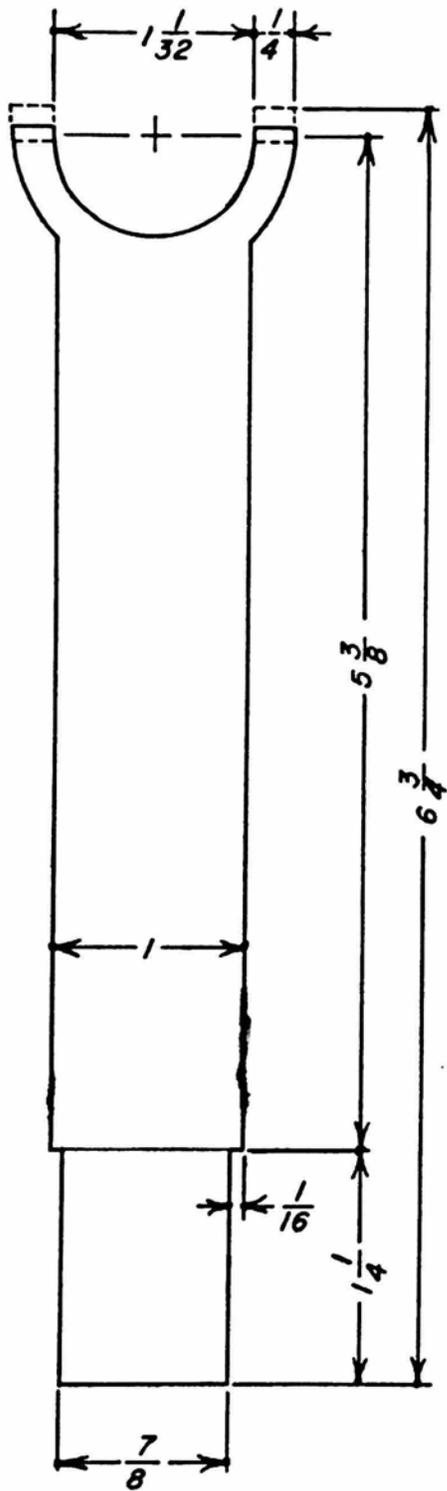
USE $\frac{3}{8}$ " x 5" OCTAGON TOOL STEEL.
 TURN ONE END TO $\frac{5}{16}$ " O.D. HARDEN
 AND QUENCH IN OIL. DRAW TO PURPLE.

Ⓢ REVISED WAS $\frac{3}{4}$

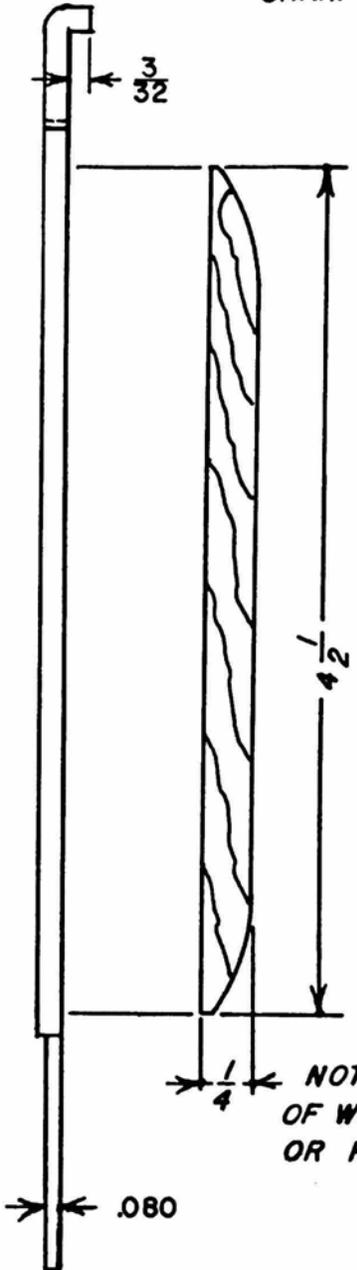
ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT: SPECIFIED		DRAWN: J.A.J.
FINISH: POLISH	MATL.: SPEC,	CHECKED: <i>[Signature]</i>
SCALE: 1"=1"	DATE: 2-5-63	APPROVED: <i>[Signature]</i>

NAME	
DRILL PRESS SCREWDRIVER	
DEPARTMENT OF GUNSMITHING	
TRINIDAD STATE JR. COLLEGE	
TRINIDAD, COLORADO	DWG. NO. F-119



HEAT RED, BEND 90°
SHARP CORNER



HANDLE
MAKE TWO (2)

NOTE: MAKE HANDLE
OF WOOD - GLUE ON
OR RIVET

ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT: NONE		DRAWN: R.C.S.
FINISH: POLISH	MATL.: 1/8 F CRS	CHECKED: <i>JA</i>
SCALE: 1 = 1	DATE: 9-30-62	APPROVED: <i>Lam</i>

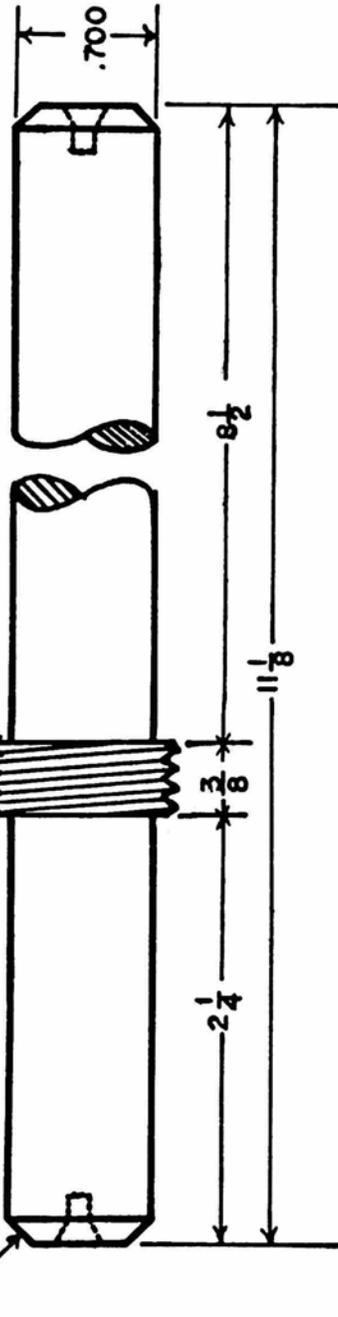
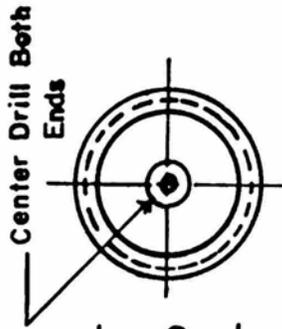
NAME SHOT GUN SPANNER WRENCH	
DEPARTMENT OF GUNSMITHING	
TRINIDAD STATE JR. COLLEGE	
TRINIDAD, COLORADO	DWG. NO. F-121

MAKE ONE EACH

M. 98 Mauser o.d. 1.100
12 T.P.I.

Mexican Mauser o.d. 1.000
12 T.P.I.

Chamfer $\frac{1}{8}$ x 45°



ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT: NONE

DRAWN: J.E.O.

FINISH: POLISH

MATL.: C.R.S.

CHECKED: *[Signature]*

SCALE: 1" = 1"

DATE: 11-30-63

APPROVED: *[Signature]*

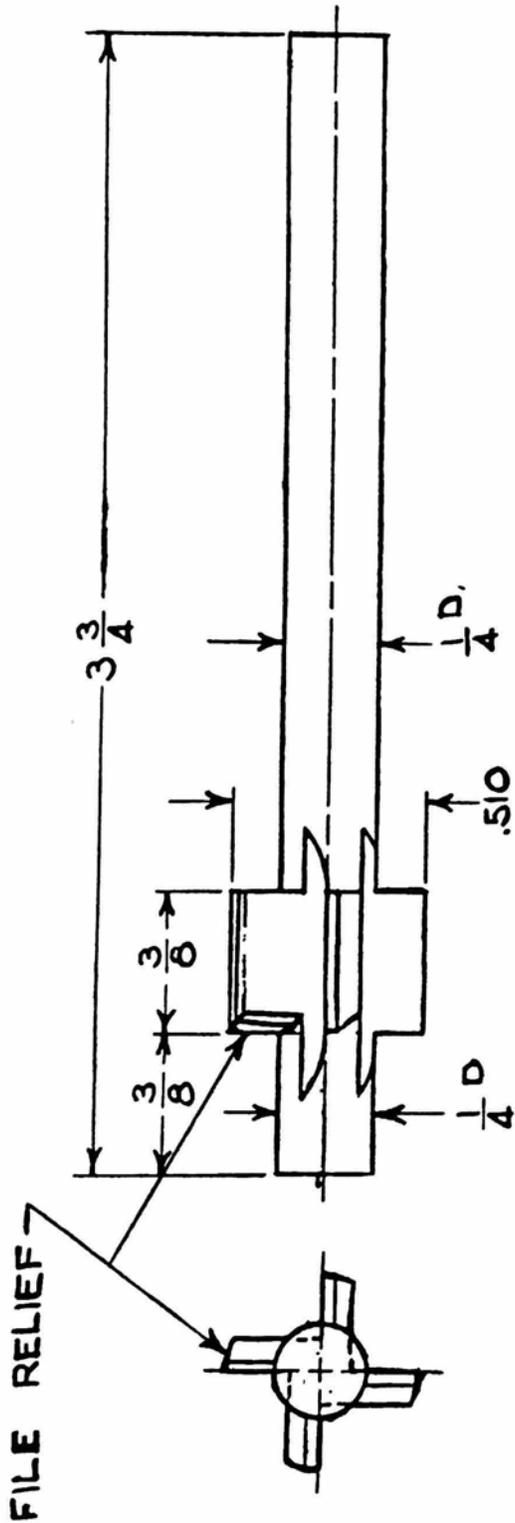
NAME

RECEIVER FACING MANDREL

DEPARTMENT OF GUNSMITHING

TRINIDAD STATE JR. COLLEGE

TRINIDAD, COLORADO DWG. NO. F-122



MAKE TWO - ONE TO FINISH A .390 O.D. $\pm .002$
 ONE TO FINISH A .510 O.D. $\pm .002$

HEAT TREAT:

KETOS OIL HARDENING
 HEAT ONLY CUTTING AREA CHERRY RED
 QUENCH IN OIL
 DRAW TO A STRAW

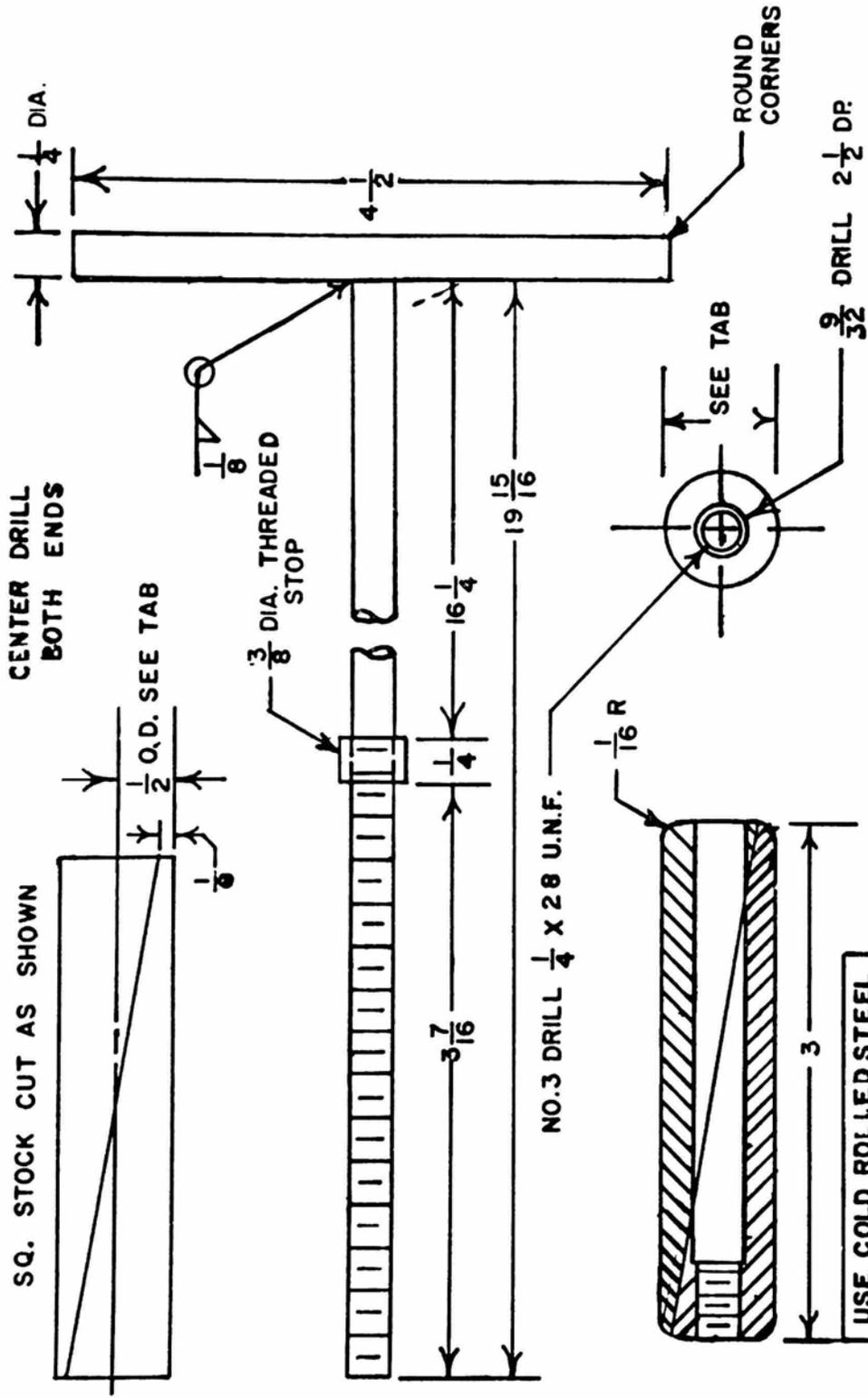
FILE RELIEF FOR SIDE AND BOTTOM CUTTING ONLY



ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT: SPEC.		DRAWN: <i>[Signature]</i>	
FINISH: POLISH	MATL: KETOS	CHECKED: <i>[Signature]</i>	
SCALE: 2" = 1"	DATE: 3-6-65	APPROVED: <i>[Signature]</i>	

NAME	STOCK COUNTERBORE
DEPARTMENT OF GUNSMITHING	
TRINIDAD STATE JR. COLLEGE	
TRINIDAD, COLORADO	DWG. NO. F-123



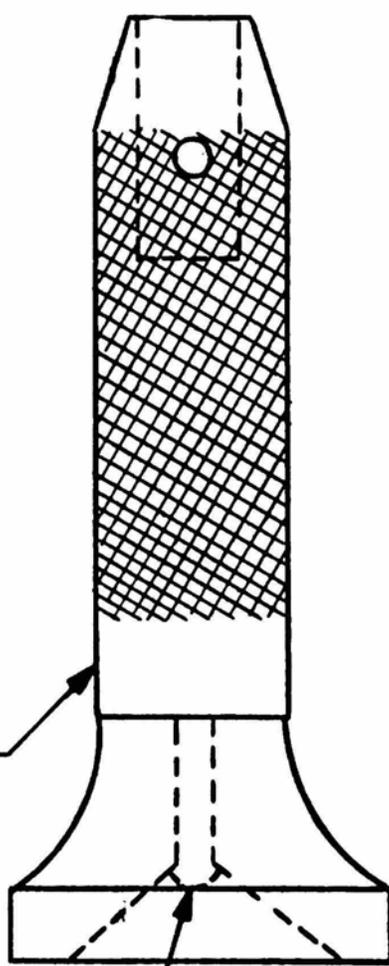
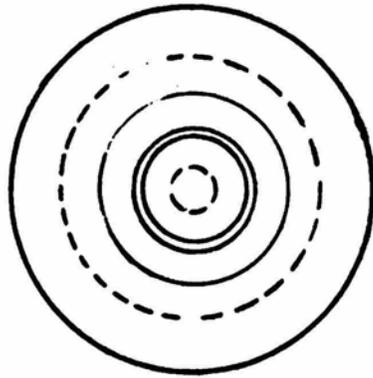
EXPANDING SHOTGUN BARREL
DENT REMOVERS

USE COLD ROLLED STEEL
12 GAUGE OD 710
16 GAUGE OD 645
20 GAUGE OD .600
410 GAUGE OD .390

ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT: NONE	DRAWN: WGL
FINISH: POLISH	MATL: CRS.
SCALE: FULL	DATE: 1-9-64
	CHECKED: <i>[Signature]</i>
	APPROVED: <i>[Signature]</i>

NAME	DENT REMOVER
	DEPARTMENT OF GUNSMITHING
	TRINIDAD STATE JR. COLLEGE
	TRINIDAD, COLORADO
	DWG. NO. F-124



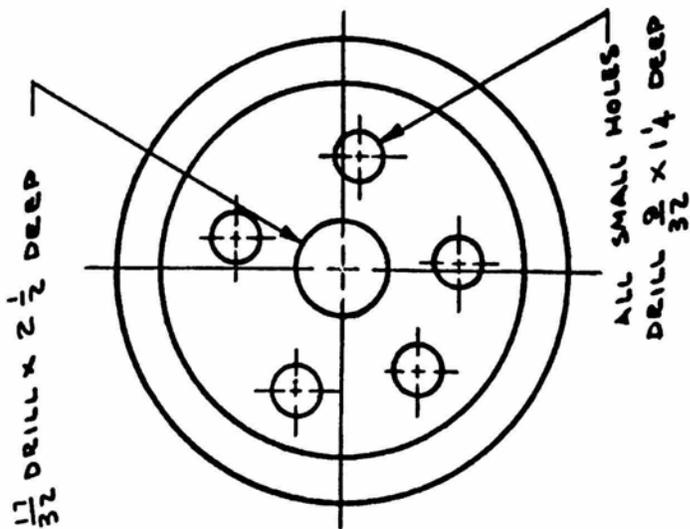
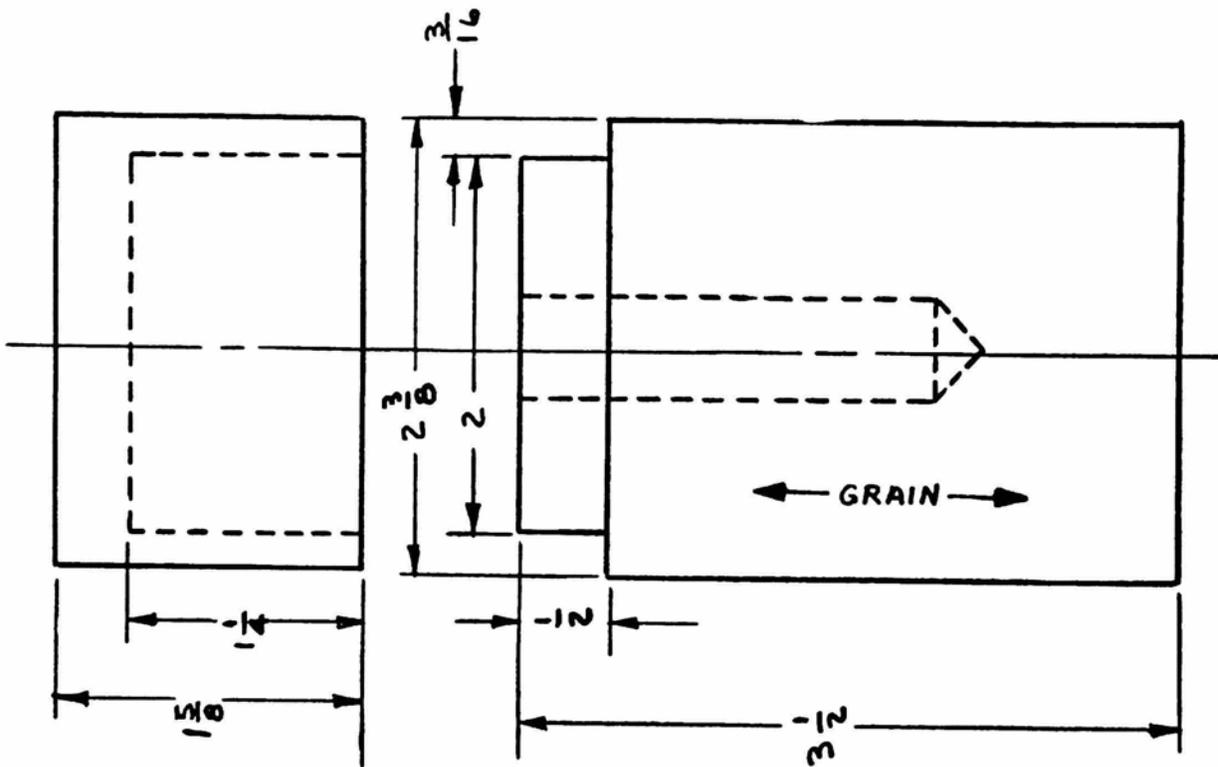
MUST SWIVEL

PEEN AT ASSY.

ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT:		DRAWN: B. & S.
FINISH:	MATL :	CHECKED:
SCALE: 2 : 1	DATE:	APPROVED: <i>WFP</i>

NAME	ASSEMBLY
DEPARTMENT OF GUNSMITHING	
TRINIDAD STATE JR. COLLEGE	
TRINIDAD, COLORADO	DWG. NO. F125 A



ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT:

DRAWN: *G.A.*

FINISH:

MATL: WOOD

CHECKED:

SCALE: FULL

DATE:

APPROVED: *MP*

NAME

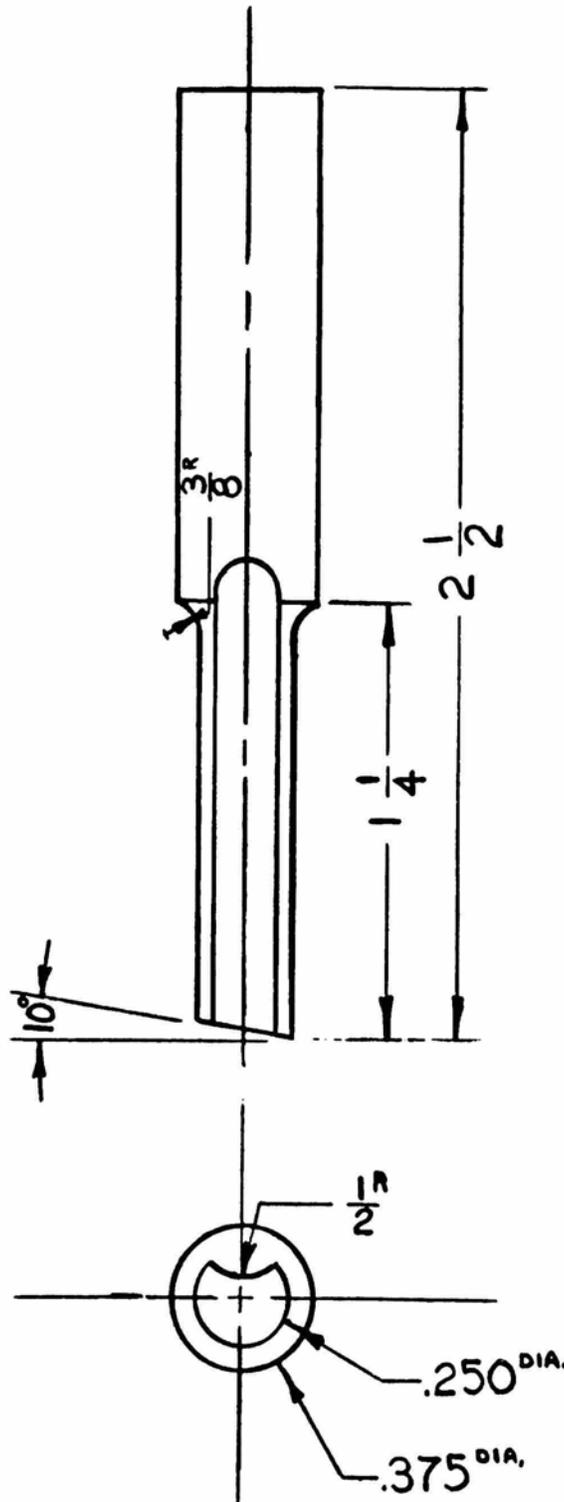
SCREWDRIVER CASE

DEPARTMENT OF GUNSMITHING

TRINIDAD STATE JR. COLLEGE

TRINIDAD, COLORADO

DWG. NO. F125C

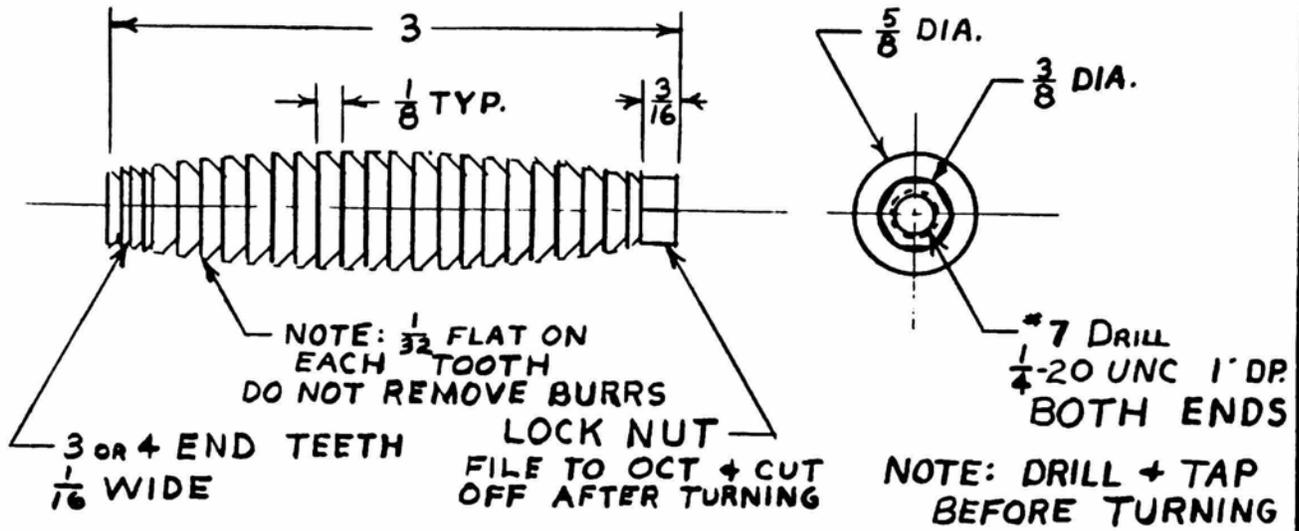


MADE FROM $\frac{3}{8}$ " OIL HARDENING TOOL
STEEL OR HIGH SPEED AIR HARDENING
TOOL STEEL.

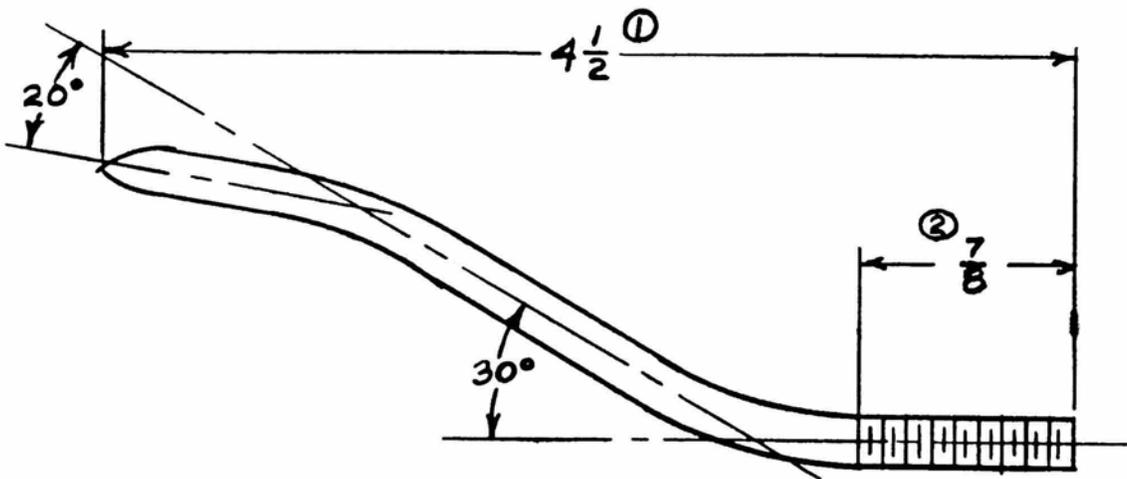
ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT: DRAW TO STRAW	DRAWN: MH
FINISH: NONE	MATL: SEE NOTE
SCALE: 2 TO 1	DATE: 4/27/66
	CHECKED: <i>[Signature]</i>
	APPROVED: <i>[Signature]</i>

NAME	STOCK ROUTER
	DEPARTMENT OF GUNSMITHING
	TRINIDAD STATE JR. COLLEGE
	TRINIDAD, COLORADO
	DWG. NO. F-126



RASP $\frac{5}{8}$ DIA. 3 LG OIL HARD. TS

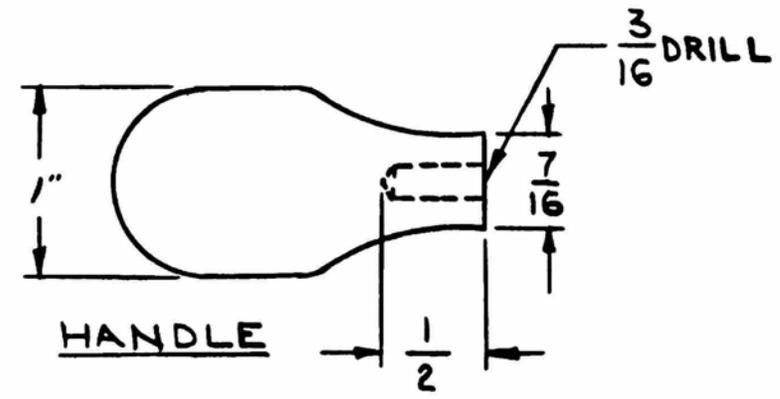
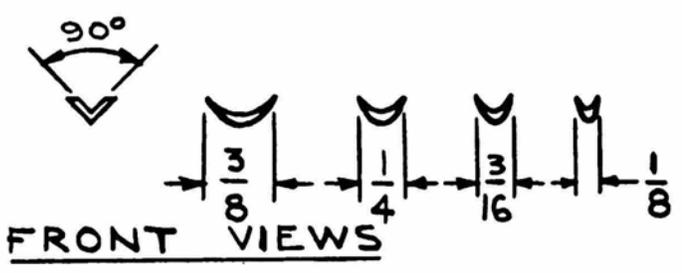
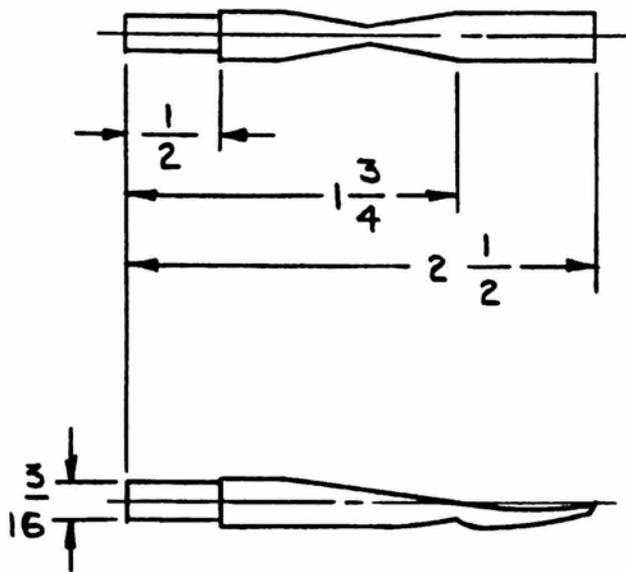


TANG $\frac{1}{4}$ DIA. C.R.S.

2	WAS 1 1/2	4-3-64	WH
1	WAS 5/8	4-3-64	WH
#	REVISIONS	DATE	BY

ALL DIMENSIONS IN INCHES UNLESS SPECIFIED			
HEAT TREAT: NO DRAW		DRAWN: WH	
FINISH: NONE	MATL: SPEC.	CHECKED: WH	
SCALE: FULL	DATE: 3/30/64	APPROVED: Lorn	

NAME	BARREL CHANNEL RASP
DEPARTMENT OF GUNSMITHING	
TRINIDAD STATE JR. COLLEGE	
TRINIDAD, COLORADO	DWG. NO. F-127

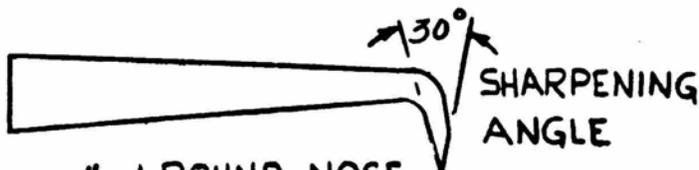
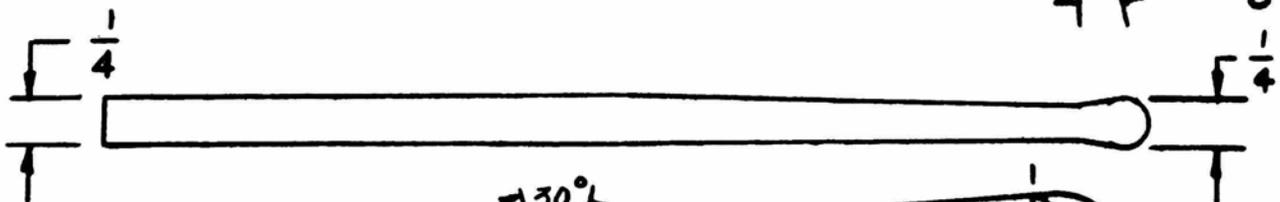
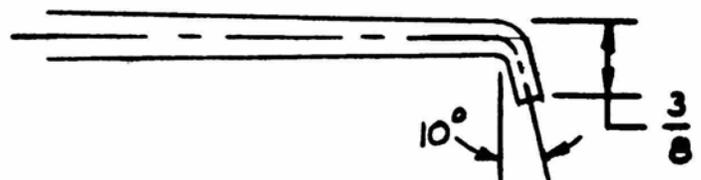
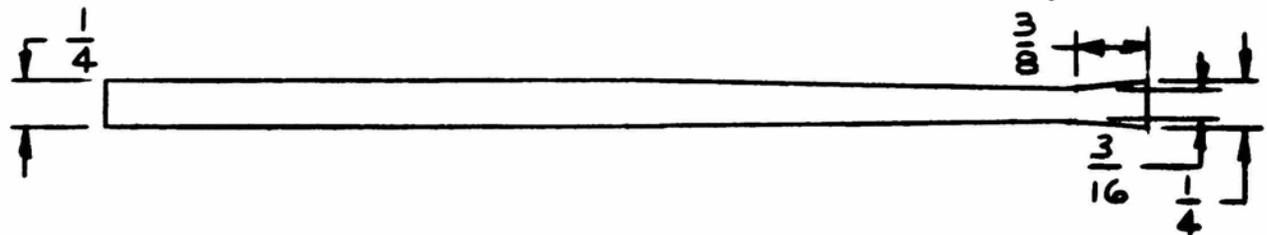
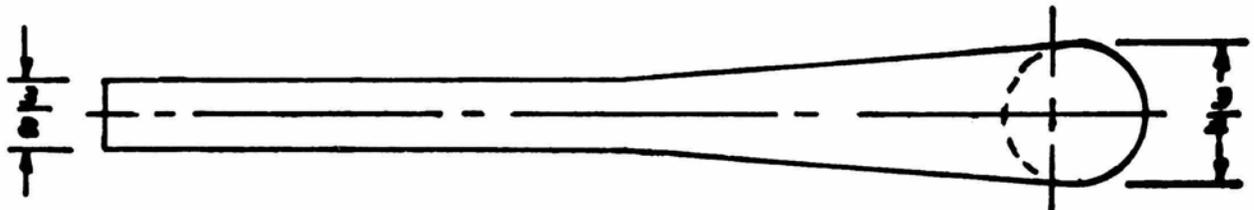
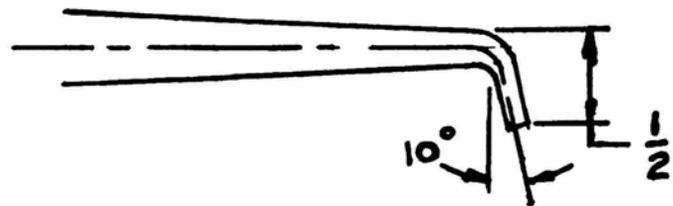
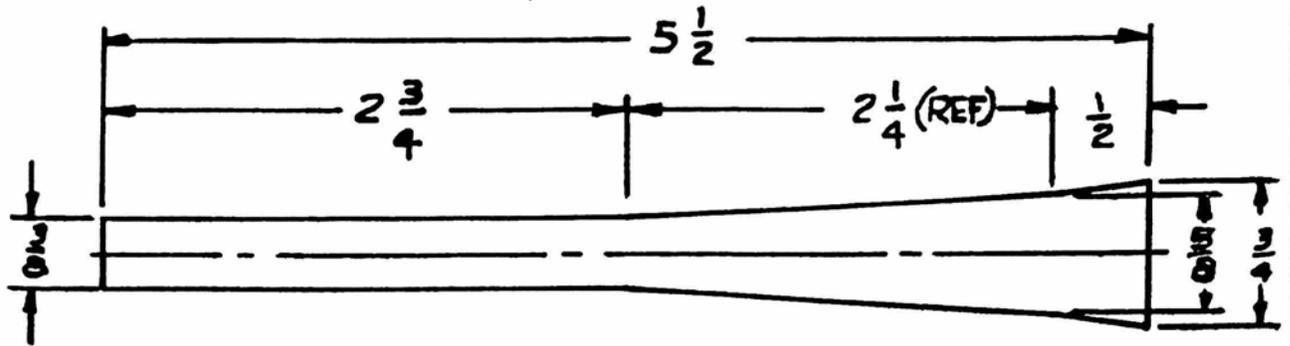


USE $\frac{1}{4} \times 2\frac{1}{2}$ HEXAGON CHISEL STOCK FOR ALL GOUGES AND VEINER. TURN TO ABOVE SHAPE & GRIND, SHAPE & FORGE.

AFTER SHAPING HEAT CHERRY RED, QUENCH IN OIL, POLISH & DRAW TO LIGHT STRAW.

ALL DIMENSIONS IN INCHES UNLESS SPECIFIED			NAME CARVING GOUGES AND VEINER	
HEAT TREAT: AS NOTED		DRAWN: BOBS.		DEPARTMENT OF GUNSMITHING
FINISH: GRIND	MATL: HEX.T.S.	CHECKED:		TRINIDAD STATE JR. COLLEGE
SCALE: FULL	DATE: 5-27-68	APPROVED: <i>WJP</i>		TRINIDAD, COLORADO DWG. NO. F128

REVISED & REDRAWN 5/68



MAKE 2- $\frac{3}{8}$ " 1 ROUND NOSE
1 SQUARE TIP

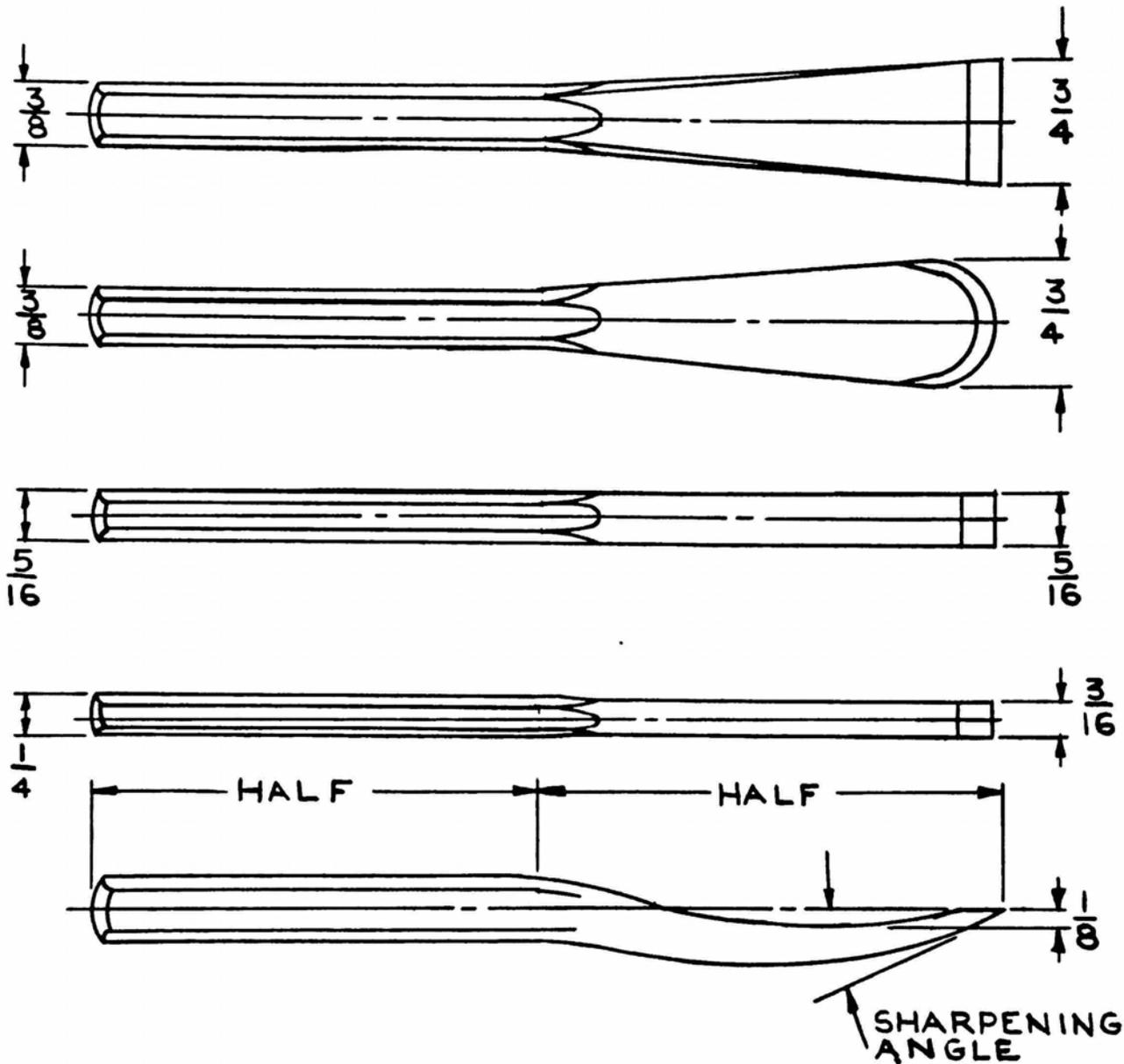
MAKE 2- $\frac{1}{4}$ " 1 ROUND NOSE
1 SQUARE TIP

TOP VIEW OF ROUND
NOSE WITH CUTTING
EDGE

ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT: AS NOTED		DRAWN: JCH	
FINISH: FILE	MATL: HEX. ST.	CHECKED:	
SCALE: 1:1	DATE: 5/68	APPROVED: <i>[Signature]</i>	

NAME	SCRAPERS
DEPARTMENT OF GUNSMITHING	
TRINIDAD STATE JR. COLLEGE	
TRINIDAD, COLORADO	DWG. NO. F-129



MAKE ONE EACH OF ALL 4 SIZES.

HEAT TREAT CUTTING EDGE 1 INCH OF LENGTH TO CHERRY RED--QUENCH IN OIL--TEST FOR HARDNESS WITH FILE AND DRAW CUTTING EDGE TO A MEDIUM STRAW COLOR.

ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT: AS NOTED

DRAWN: BOB S.

FINISH: FILE

MATL: HEX. T. S.

CHECKED:

SCALE: FULL

DATE: 5-27-68

APPROVED: *MP*

REVISED & REDRAWN 5/68

NAME

PUSH CHISELS

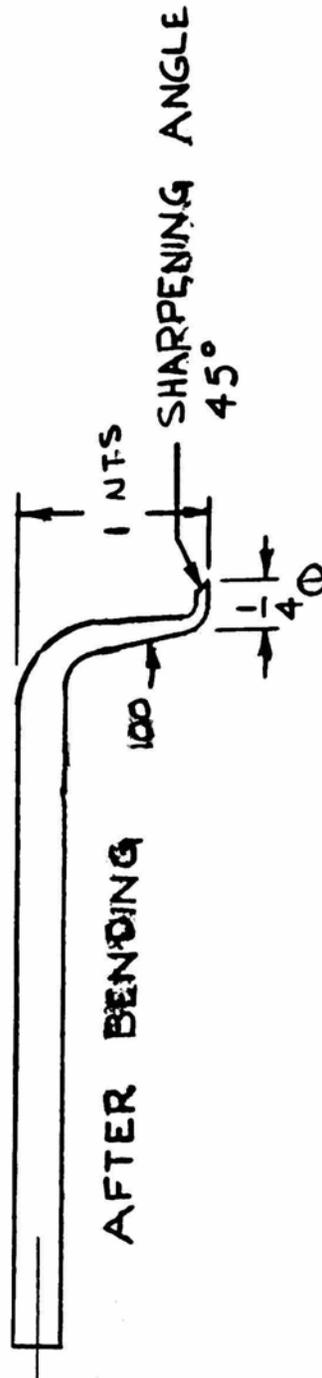
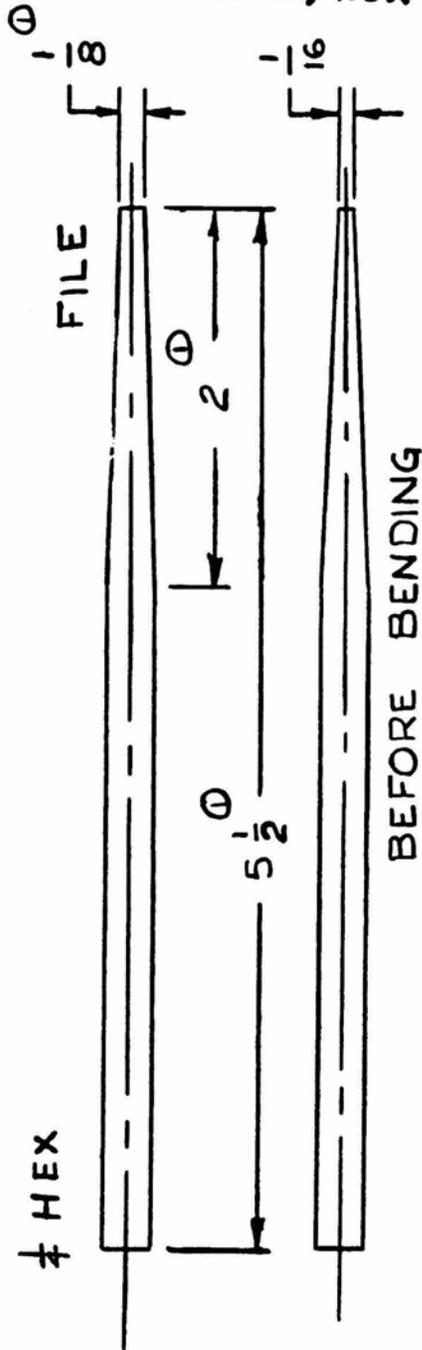
DEPARTMENT OF GUNSMITHING

TRINIDAD STATE JR. COLLEGE

TRINIDAD, COLORADO

DWG. NO. F-130

7/29/8 ① WAS $\frac{3}{16}$, NOW $\frac{1}{8}$
 WAS 1, NOW 2
 ADDED WAS $6\frac{1}{4}$, NOW $5\frac{1}{2}$



DRAW TO STRAW.

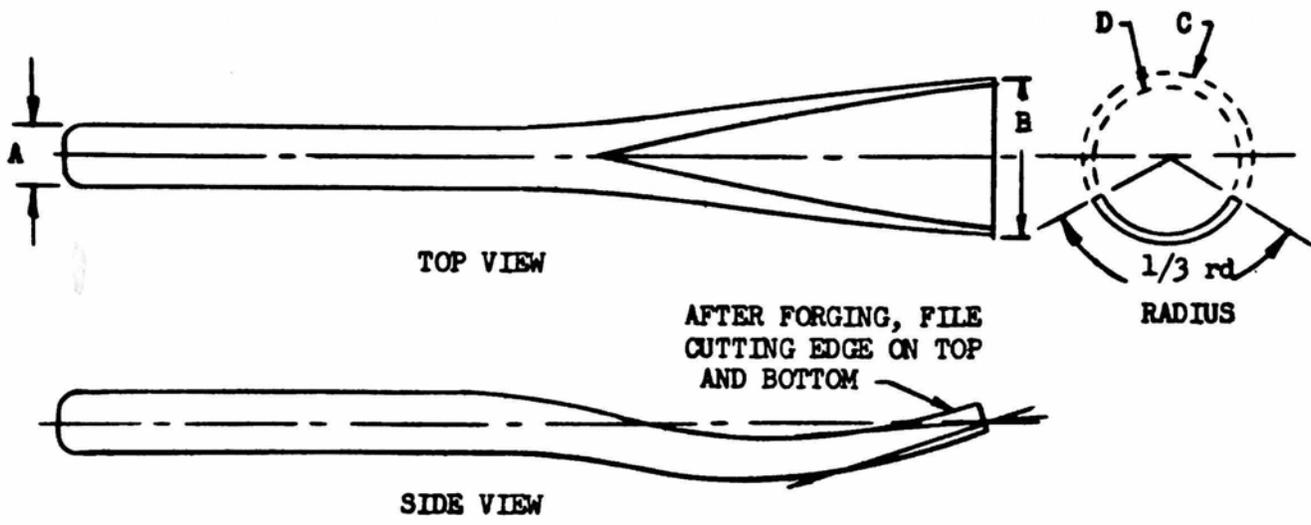
HEAT TREAT END ONLY

REVISED 7/68

ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT:	DRAWN: D.L.H
FINISH: FILE	MATL: $\frac{1}{2}$ OCT. TS
SCALE: 1-1	DATE: 2/25/65
	CHECKED: <i>KA</i>
	APPROVED: <i>Lam</i>

NAME	RECOIL LUG CHISEL
DEPARTMENT OF GUNSMITHING	TRINIDAD STATE JR. COLLEGE
TRINIDAD, COLORADO	DWG. NO. F-131



NOTE: FILE POINTS BEFORE FORMING GOUGES

ALL BLANKS FORGED FLAT HALF ITS LENGTH 1/16 THICK AT END

HEAT TREAT CUTTING END ONLY 1 INCH

CHISEL #	A	B	C	D
1	3/8"	7/8"	3/4"	5/8"
2	5/16"	3/4"	5/8"	1/2"
3	5/16"	5/8"	1/2"	3/8"
4	1/4"	7/16"	5/16"	1/4"
5	1/4"	1/4"	3/16"	1/8"

- A - SIZE OF STOCK
- B - WIDTH OF TIP BEFORE FORMING RADIUS
- C - DIAMETER OF BLOCK RADIUS
- D - OUTSIDE DIA OF FORMING MANDRILL

REVISED & REDRAWN 7/68

ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT	OIL & STRAW	DRAWN: <i>RK</i>
FINISH: FILE	MATL: T.S.	CHECKED:
SCALE: NONE	DATE: 7/68	APPROVED:

NAME	GOUGES
DEPARTMENT OF GUNSMITHING	
TRINIDAD STATE JR. COLLEGE	
TRINIDAD, COLORADO	DWG. NO F - 132

SLOT WITH HACKSAW (MUST BE STRAIGHT) $\frac{3}{8}$ DEEP



BEND COLD AS SHOWN



USE $\frac{1}{8}$ SQ. CRS 4 $\frac{1}{2}$ LG
MAKE THREE (3)

SHAPE END TO FIT CUTTER



SQUEEZE END, TOGETHER TO HOLD CUTTER

ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT: NONE

DRAWN: *RH*

FINISH: NONE

MATL: $\frac{1}{8}$ SQ. CRS

CHECKED: *RH*

SCALE: FULL

DATE: 4-10-69

APPROVED: *JM*

NAME

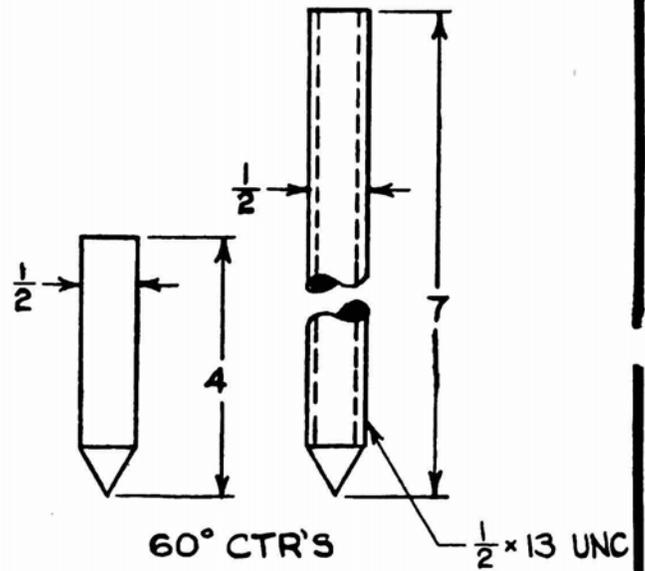
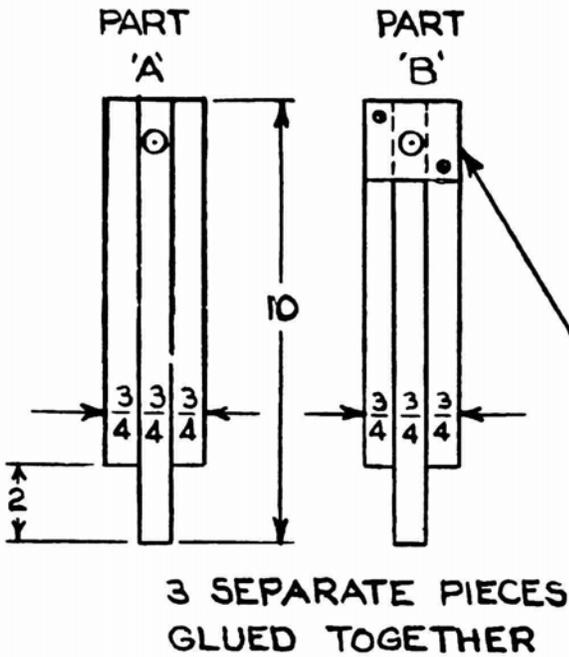
CHECKERING SHANKS

DEPARTMENT OF GUNSMITHING

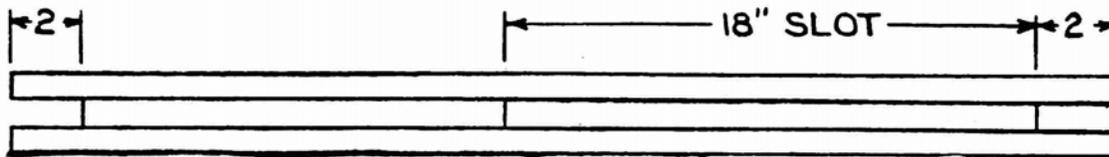
TRINIDAD STATE JR. COLLEGE

TRINIDAD, COLORADO DWG. NO. F-133

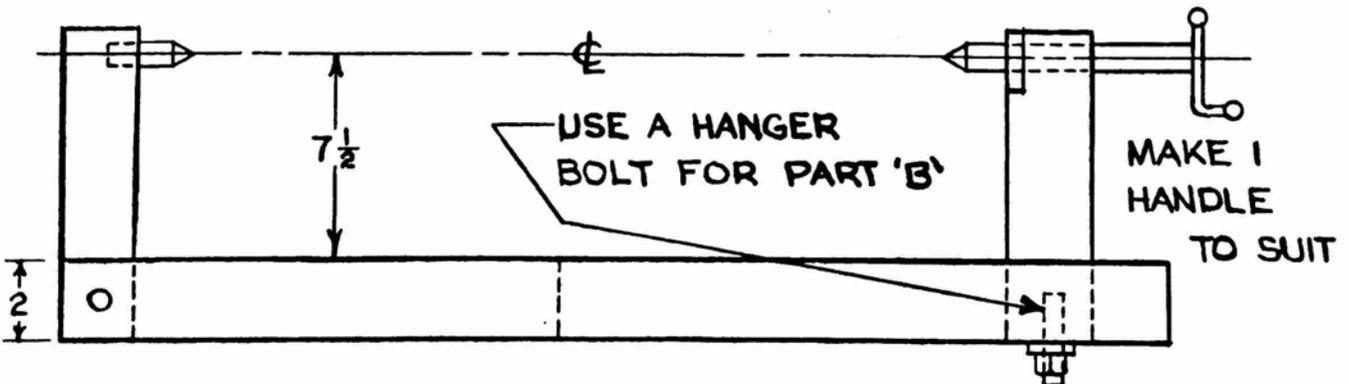
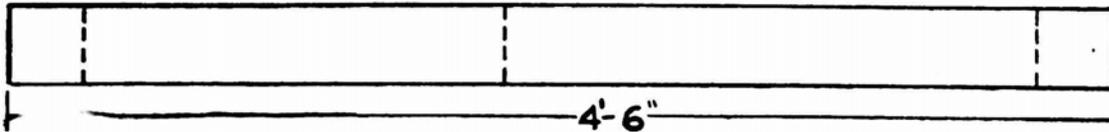
GLUE OR BOLT
PART 'A' INTO 'C' AS
SHOWN



MAKE 1 CRS PLATE WITH
A $\frac{1}{2}$ -13 UNC TAPED HOLE
ON CTR - SIZE $\frac{1}{4} \times 1 \times 2\frac{1}{4}$



PART 'C'



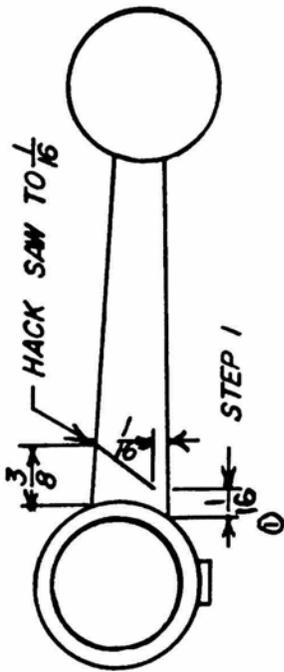
ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT: _____ DRAWN: *J.F.S.*

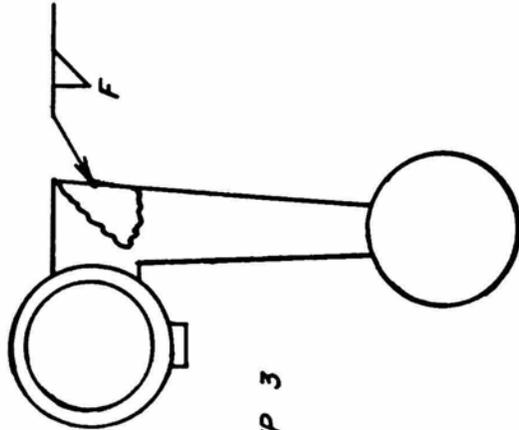
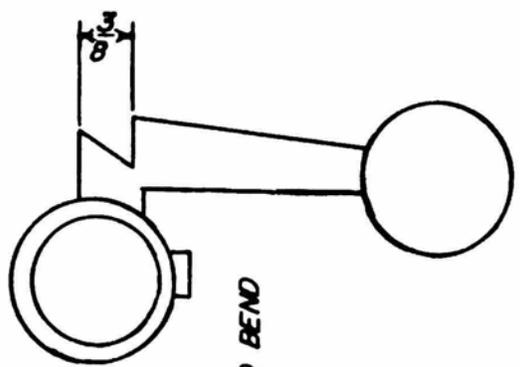
FINISH: _____ MATL: NOTED CHECKED: *[Signature]*

SCALE: _____ DATE: 3-10-66 APPROVED: *[Signature]*

NAME
CHECKERING CRADLE
DEPARTMENT OF GUNSMITHING
TRINIDAD STATE JR. COLLEGE
TRINIDAD, COLORADO DWG. NO. F-134

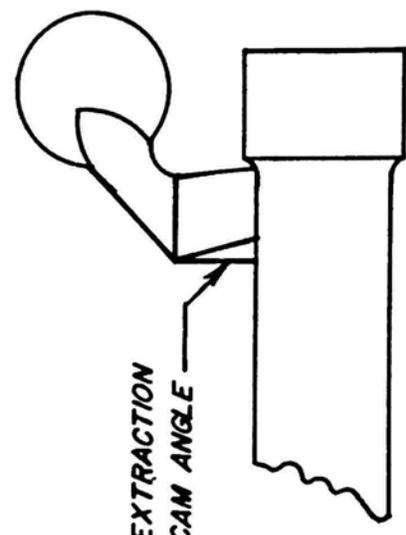


STEP 2
HEAT TO BEND



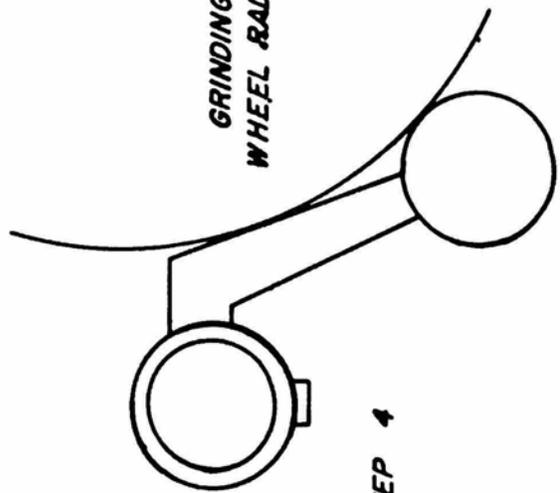
STEP 3

INITIAL EXTRACTION
MAINTAIN CAM ANGLE



STEP 5

GRINDING
WHEEL RADIUS



STEP 4

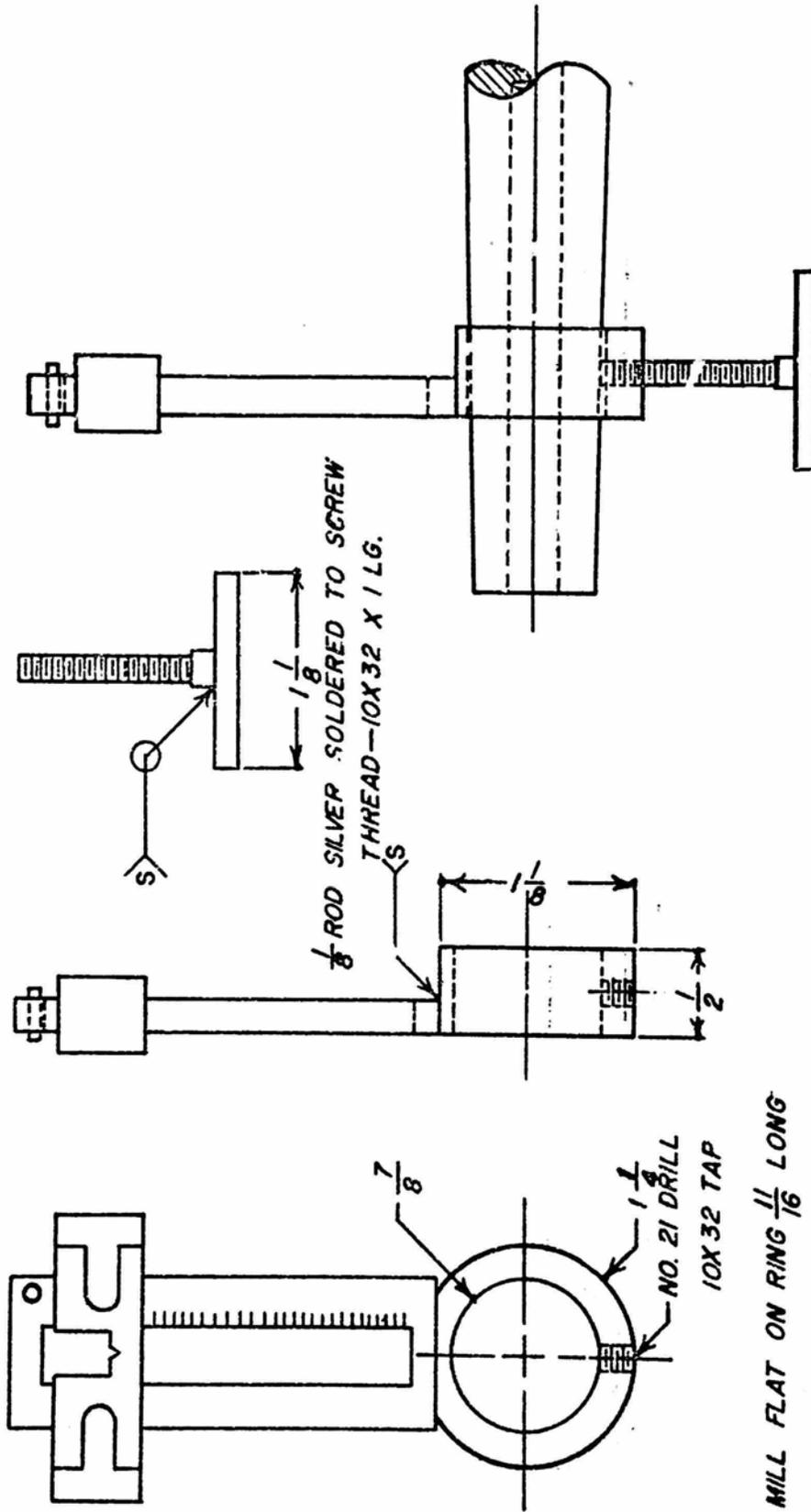
① REVISED 9/21/65 WAS 1/8

ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT:		DRAWN: R.C.S.
FINISH:	MATL.:	CHECKED: <i>[Signature]</i>
SCALE:	DATE: 12-5-62	APPROVED: <i>[Signature]</i>

NAME ALTERING A BOLT BY WELDING	
DEPARTMENT OF GUNSMITHING	
TRINIDAD STATE JR. COLLEGE	
TRINIDAD, COLORADO	DWG. NO. S. 135

USE OLD ENFIELD OR JAP REAR SIGHT
SILVER SOLDER BASE OF SIGHT TO FLAT ON RING



MILL FLAT ON RING 1/16 LONG

ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT:

DRAWN: R.C.S.

FINISH:

MATL.: CRS

CHECKED: *DS*

SCALE: 1=1

DATE: 12-3-62

APPROVED: *Lam*

NAME

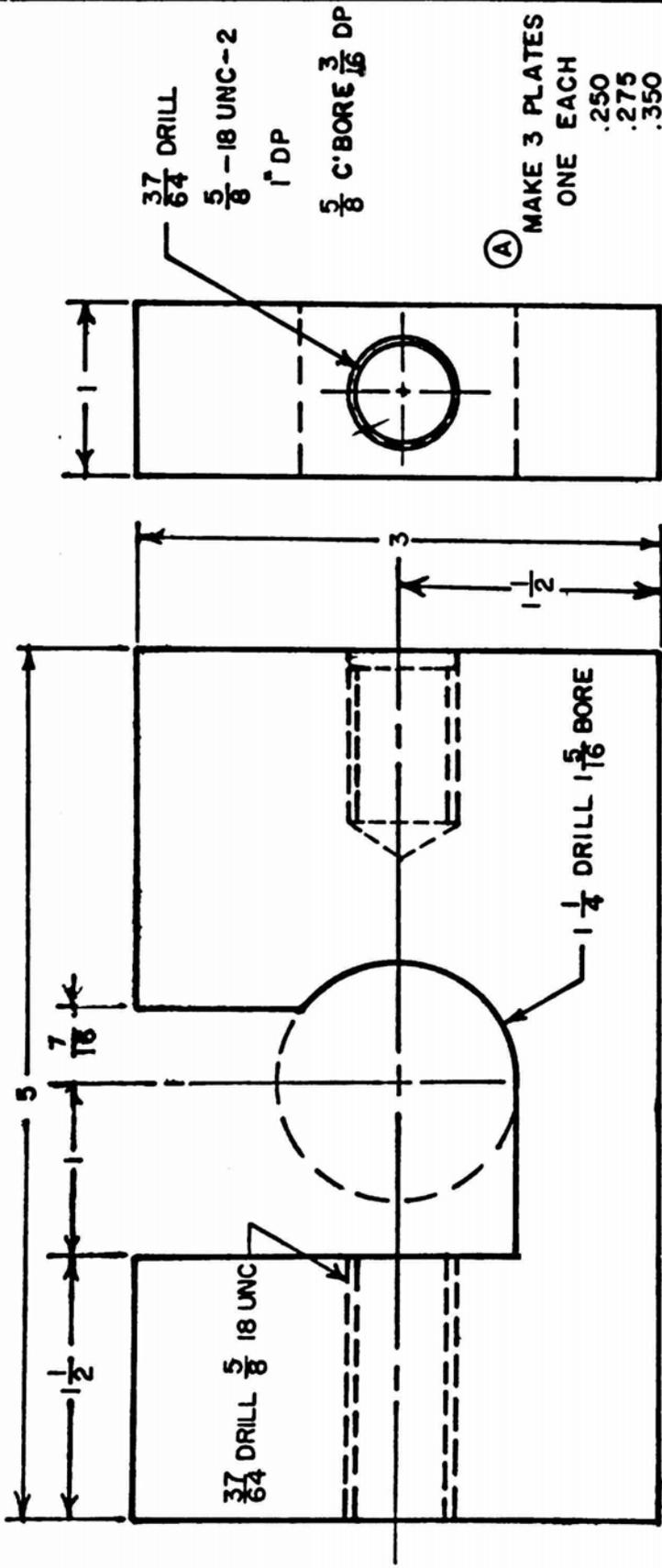
SIGHT GAGE

DEPARTMENT OF GUNSMITHING

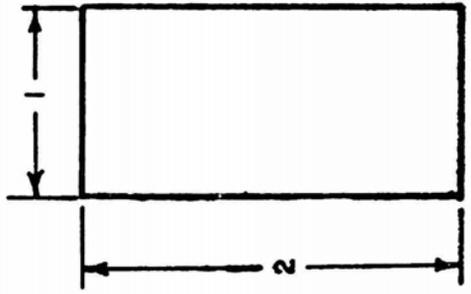
TRINIDAD STATE JR. COLLEGE

TRINIDAD, COLORADO

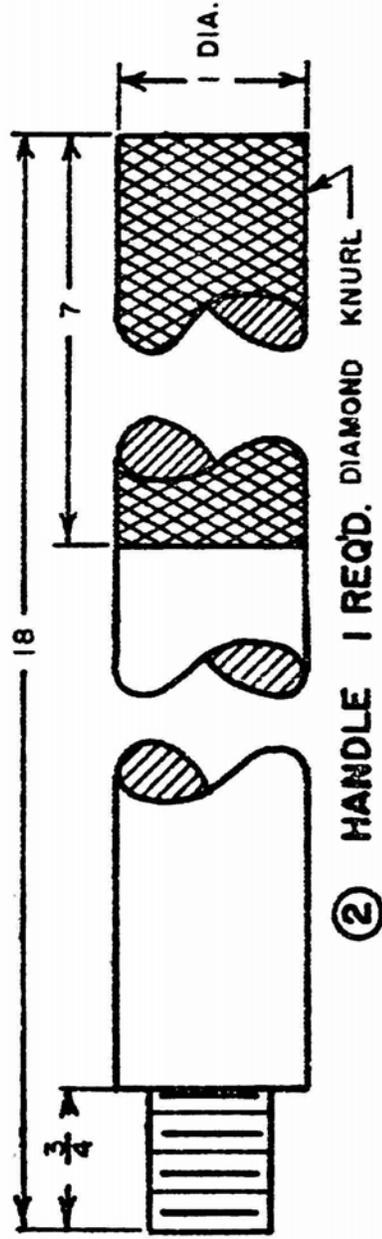
DWG. NO. S-136



① BODY 1 REQD.



③ PLATES



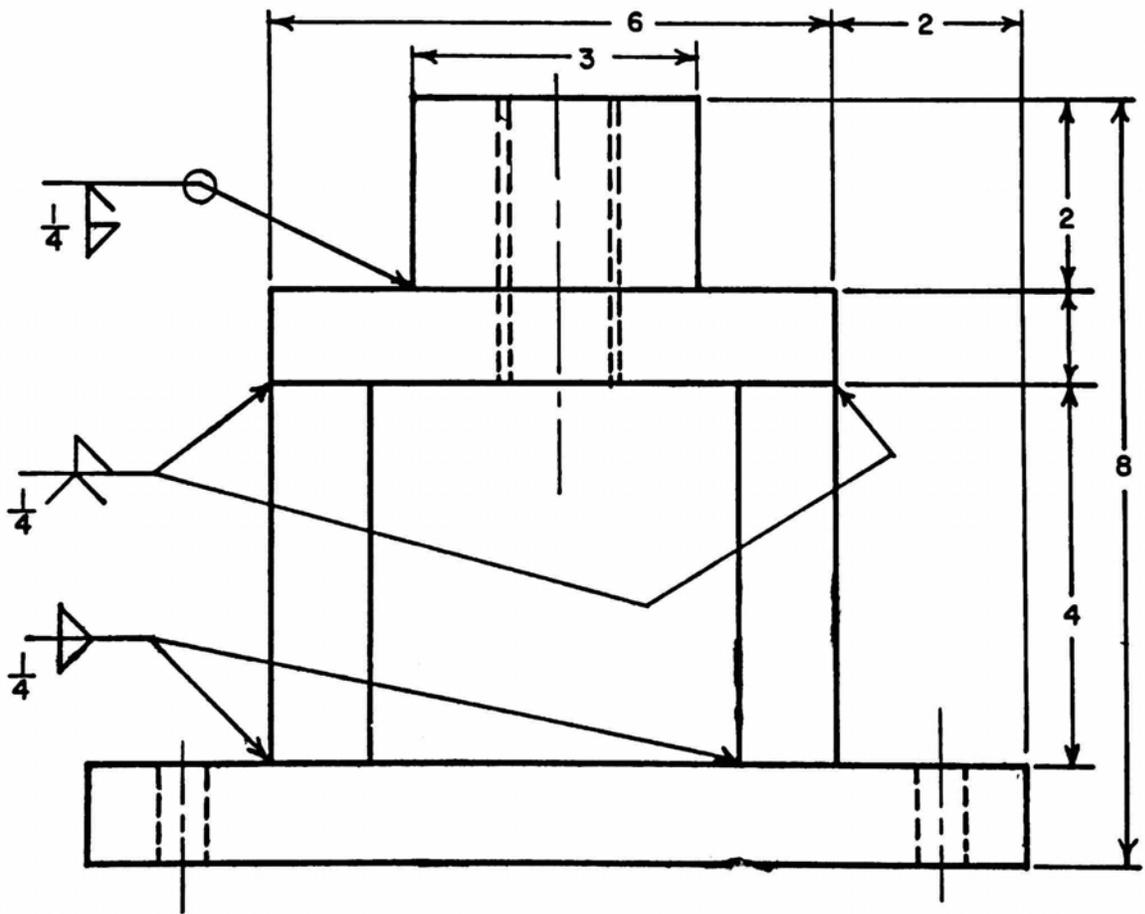
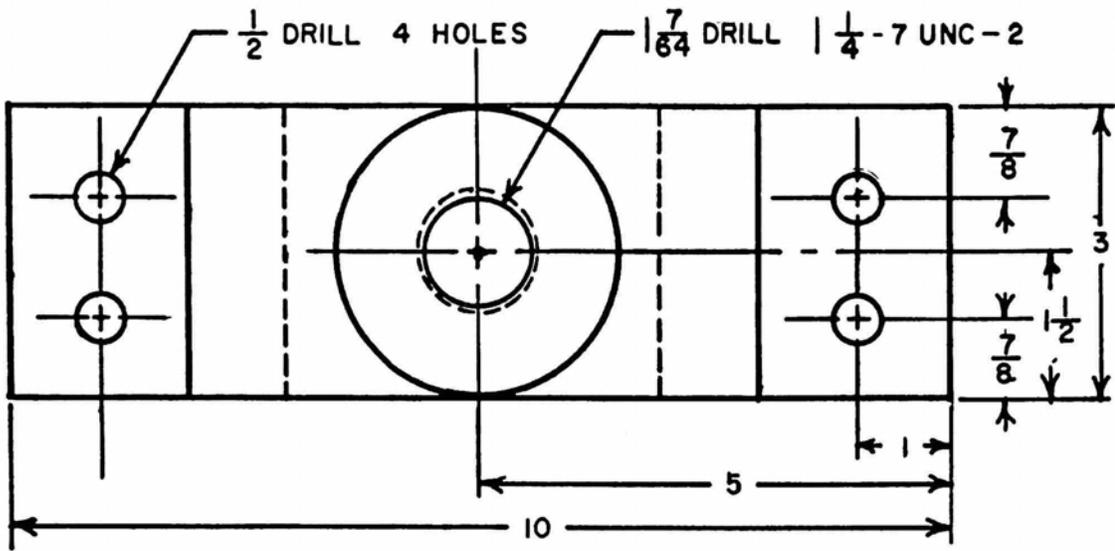
② HANDLE 1 REQD. DIAMOND KNURL

④ PURCHASE ONE 5/8 18 UNC - 2 X 3 HEX MACH BOLT

ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT: NONE	DRAWN: <i>W.A.P.</i>
FINISH: NONE	CHECKED: <i>W.A.P.</i>
SCALE: FULL	APPROVED: <i>W.A.P.</i>
MATL.: CRS	DATE: 1/5/64

NAME	ACTION WRENCH
DEPARTMENT OF GUNSMITHING	TRINIDAD STATE JR. COLLEGE
TRINIDAD, COLORADO	DWG. NO. S-137



NOTE: ALL PLATES 1" THICK

ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT: NONE

FINISH: NONE

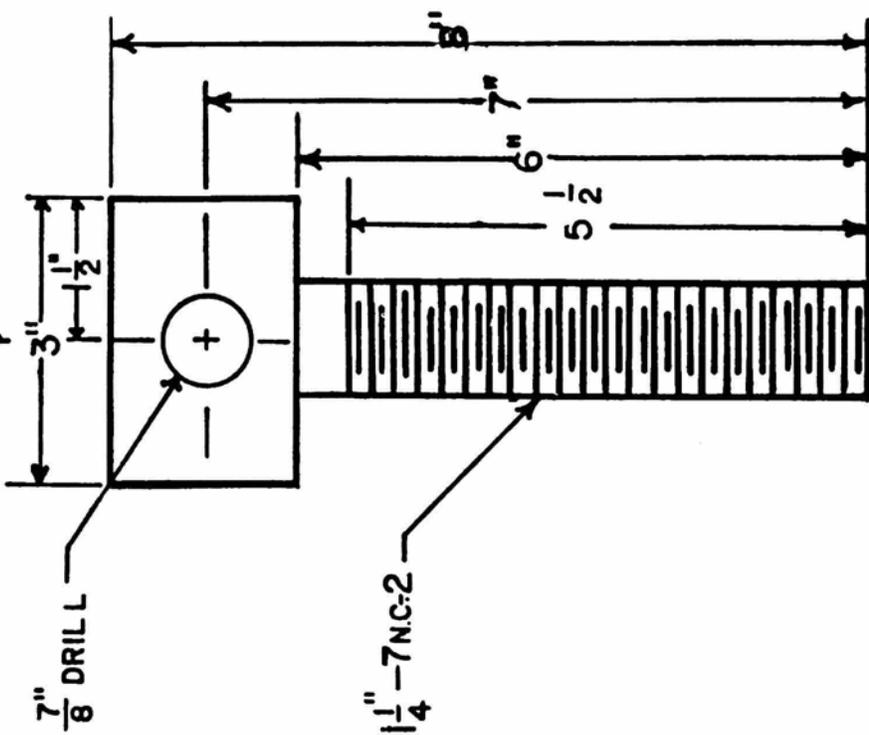
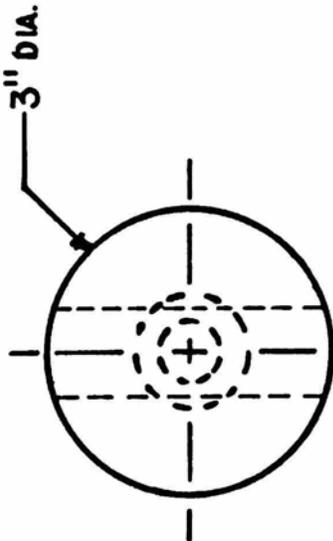
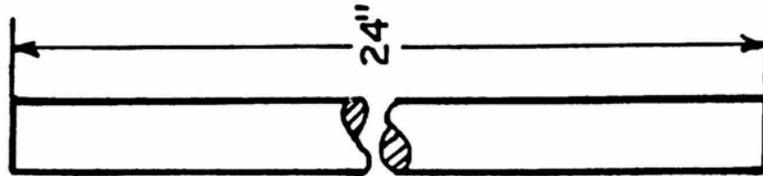
SCALE: HALF

DRAWN: L. R. R.

CHECKED: *[Signature]*

APPROVED: *[Signature]*

NAME: BARREL VISE	
DEPARTMENT OF GUNSMITHING	
TRINIDAD STATE JR. COLLEGE	
TRINIDAD, COLORADO	DWG. NO. S-140 A



ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT: NONE

DRAWN: L.R.R.

FINISH: ORIGINAL

MATL: C.R. 8.

CHECKED: *SEA*

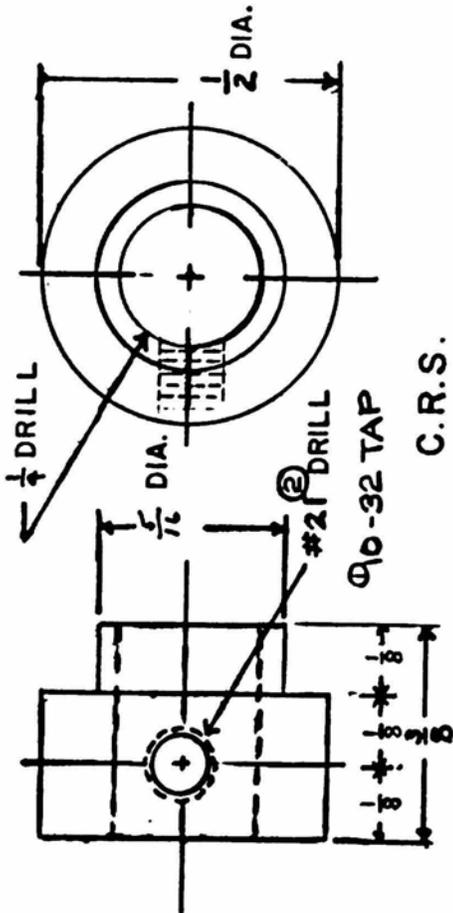
SCALE: 1" = 1/2"

DATE: 10-17-63

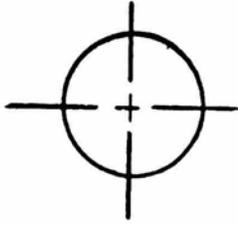
APPROVED: *W.A.P.*

NAME	
BARREL VISE SCREW AND HANDLE	
DEPARTMENT OF GUNSMITHING	
TRINIDAD STATE JR. COLLEGE	
TRINIDAD, COLORADO	DWG. NO. S-140 B

NOTE. $\frac{1}{4}$ DRILL LEAVES HOLE SLIGHTLY OVERSIZE FOR $\frac{1}{4}$ DRILL ROD



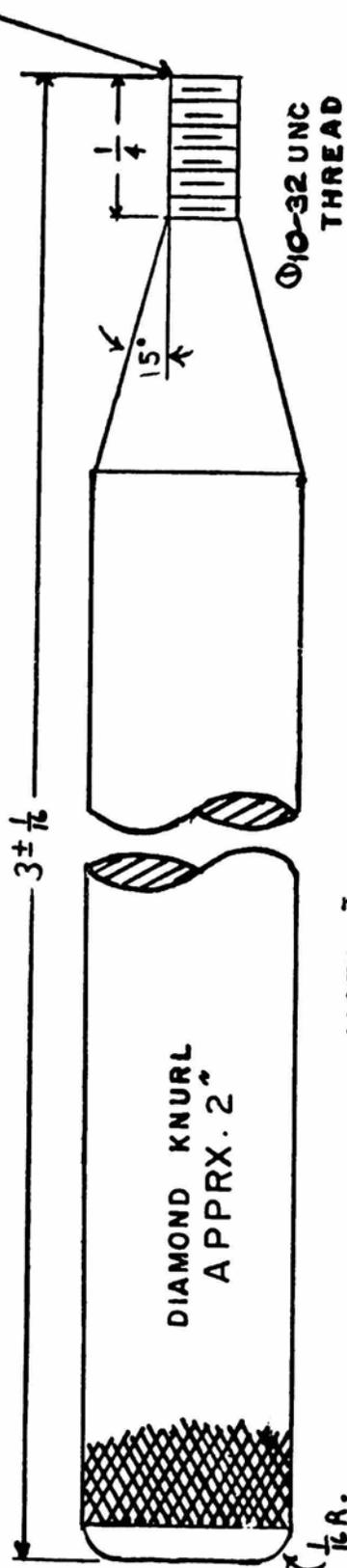
PLUNGER
 $\frac{1}{4}$ DRILL ROD $\frac{3}{8}$ LONG



C.R.S.

HANDLE ACTS AS LOCK FOR PLUNGER

TURN THREAD SHANK TO .190



MATL. $\frac{3}{8}$ DIA. C.R.S.

① REVISED TAP & THREAD SIZE FROM 8-32 TO 10-32 — 3-12-65
 ② REVISED TAP DRILL SIZE FROM #28 TO #21 — 3-12-65

ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT: _____

DRAWN: *[Signature]*

FINISH: _____

MATL: SPEC.

CHECKED: *[Signature]*

SCALE: None

DATE: 4-7-64

APPROVED: *[Signature]*

NAME

PROTRUSION GAUGE.

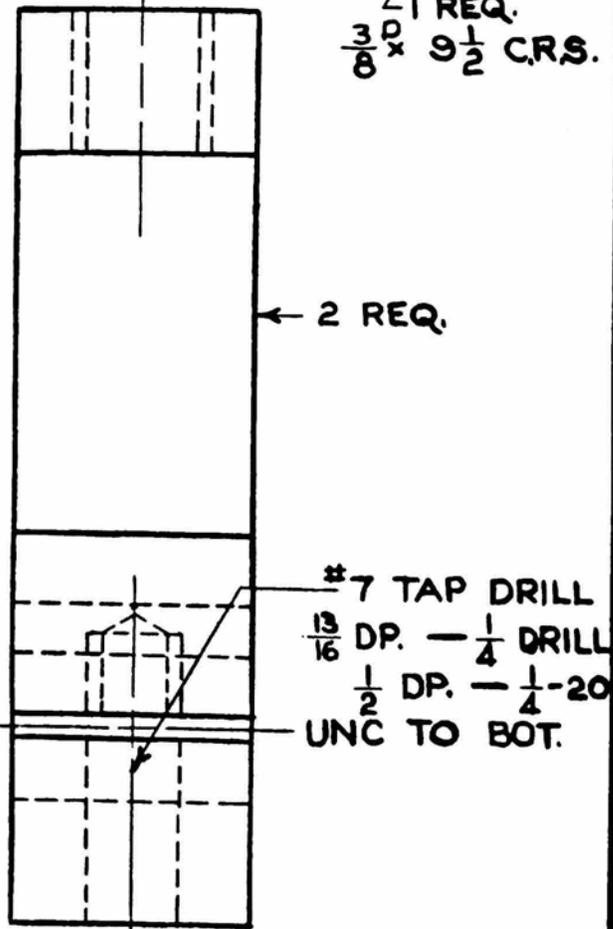
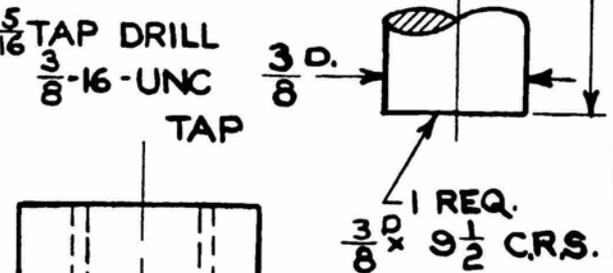
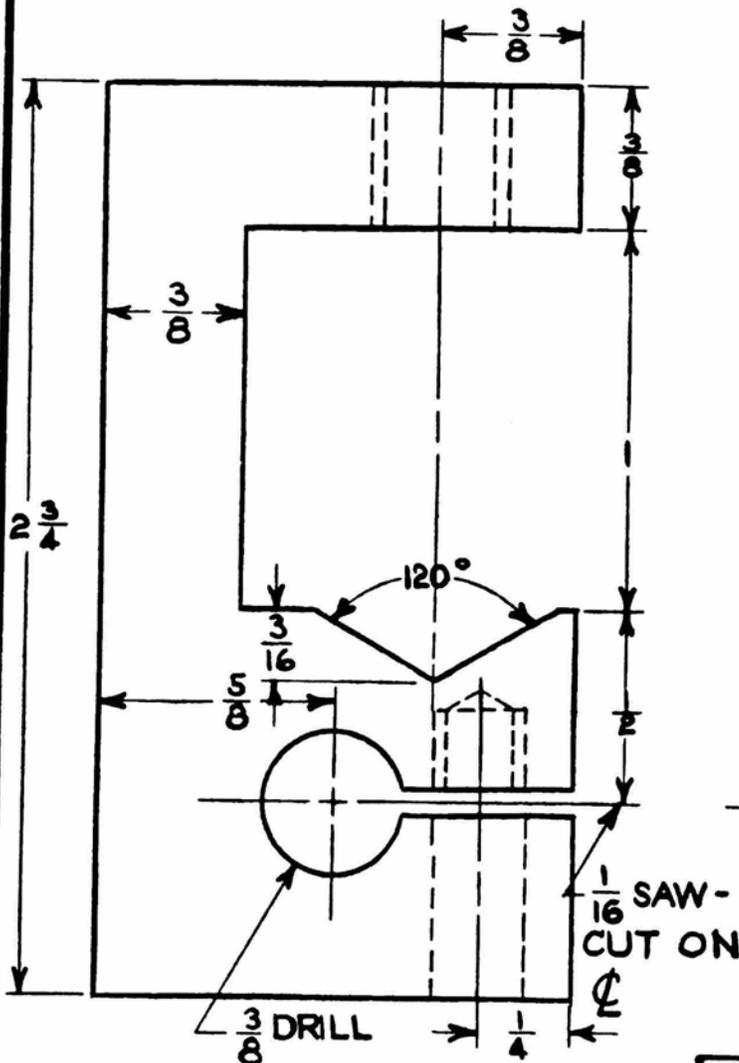
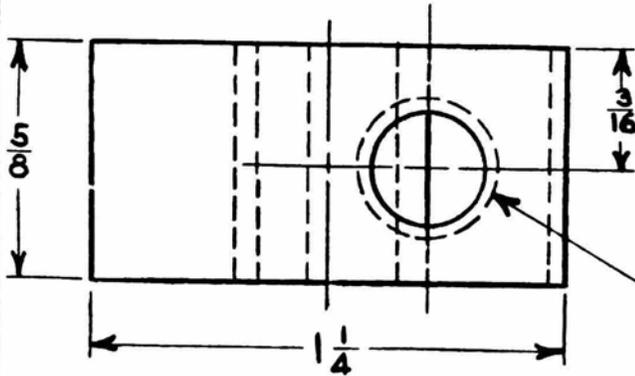
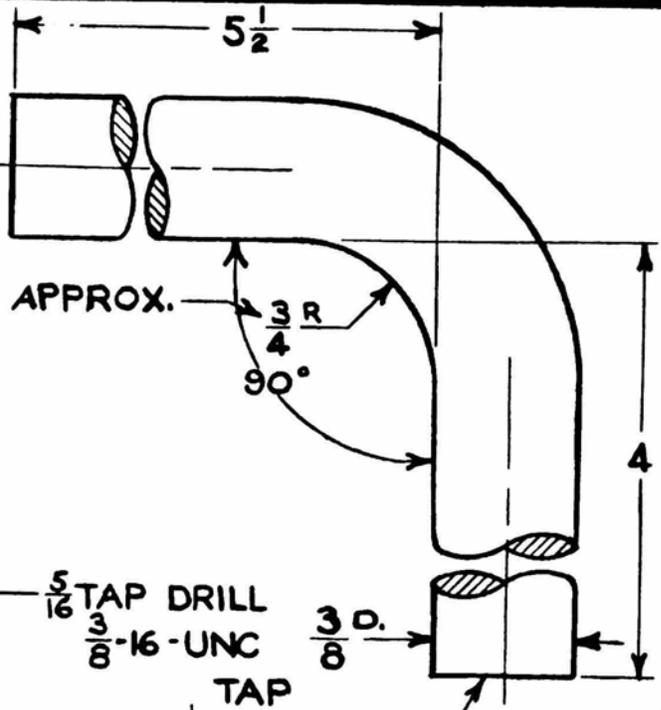
DEPARTMENT OF GUNSMITHING

TRINIDAD STATE JR. COLLEGE

TRINIDAD, COLORADO DWG. NO. S-142

$\frac{1}{4}$ -20 x $\frac{5}{8}$ -ALLEN SCR'S - 2 REQ.

$\frac{3}{8}$ -16 x $\frac{1}{2}$ -ALLEN SCR'S - 2 REQ.



ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT: NONE

DRAWN: *D.G.U.*

FINISH: NONE

MATL: C.R.S.

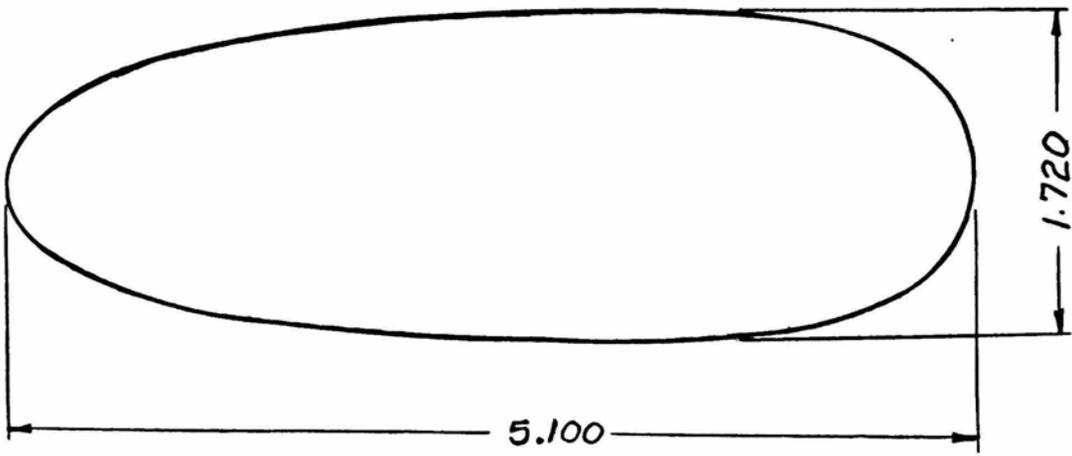
CHECKED: *[Signature]*

SCALE: 2" = 1"

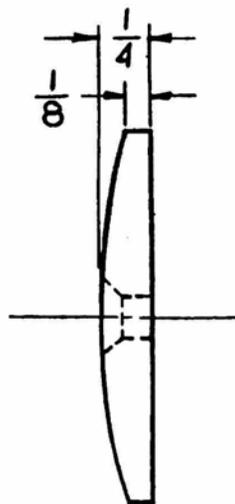
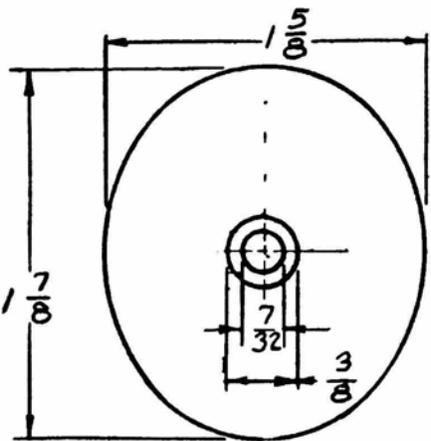
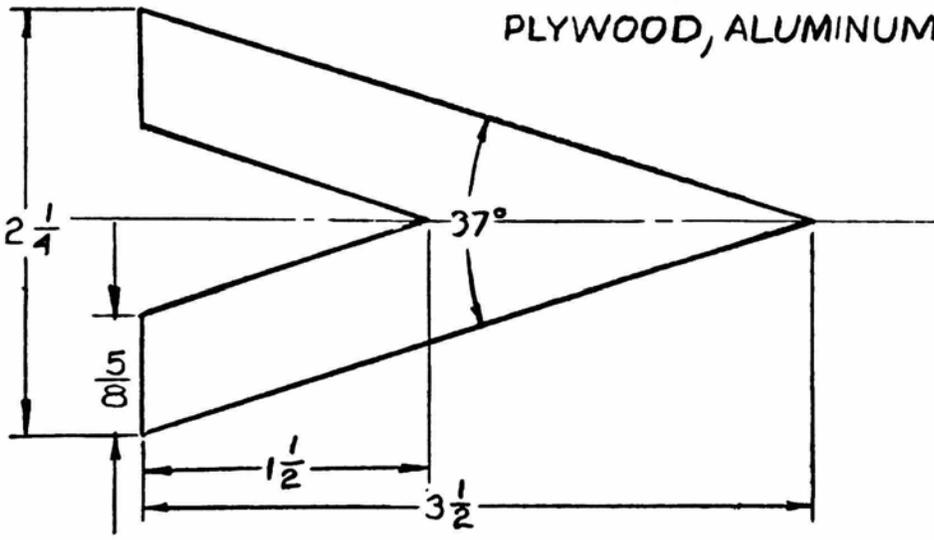
DATE: 2-27-65

APPROVED: *[Signature]*

NAME	BOLT WELDING JIG
DEPARTMENT OF GUNSMITHING	TRINIDAD STATE JR. COLLEGE
TRINIDAD, COLORADO	DWG. NO. S-144



MATERIAL: OPTIONAL
 SUGGESTED MATERIALS ARE
 PLYWOOD, ALUMINUM AND PLASTIC



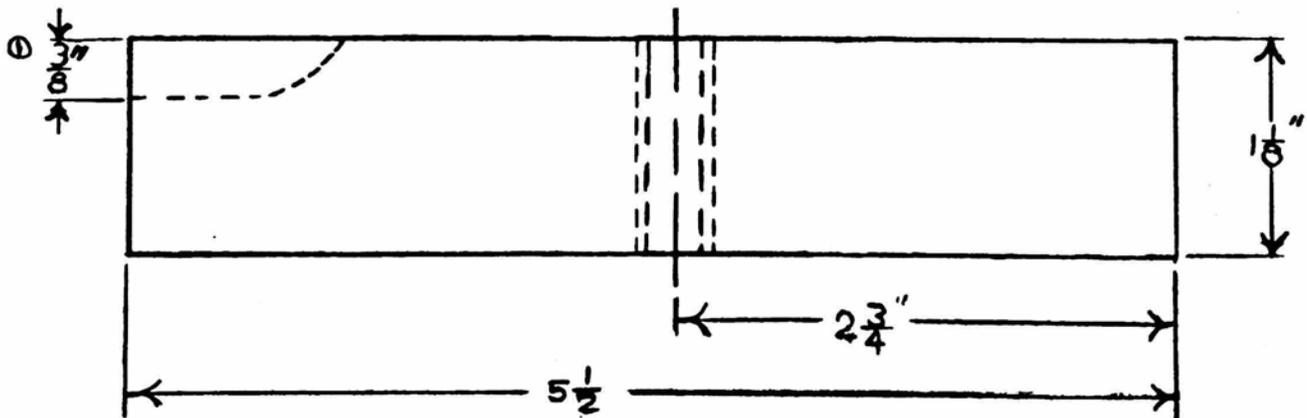
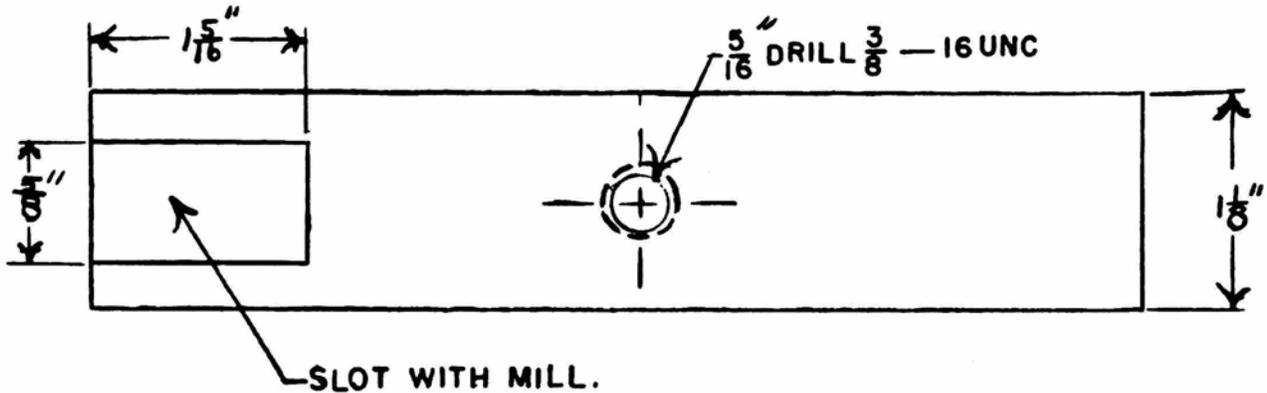
ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

NAME **STOCK TEMPLATE**
 DEPARTMENT OF GUNSMITHING
 TRINIDAD STATE JR. COLLEGE
 TRINIDAD, COLORADO DWG. NO. S-145

HEAT TREAT: _____	DRAWN: <i>J.P.C.</i>
FINISH: _____	CHECKED: <i>[Signature]</i>
MATL: <i>OPT.</i>	APPROVED: <i>E.S.</i>
SCALE: <i>FULL</i>	DATE: _____

1 $\frac{3}{8}$ " x 16 ALLEN SET SCREW 2" LONG. PURCHASE.

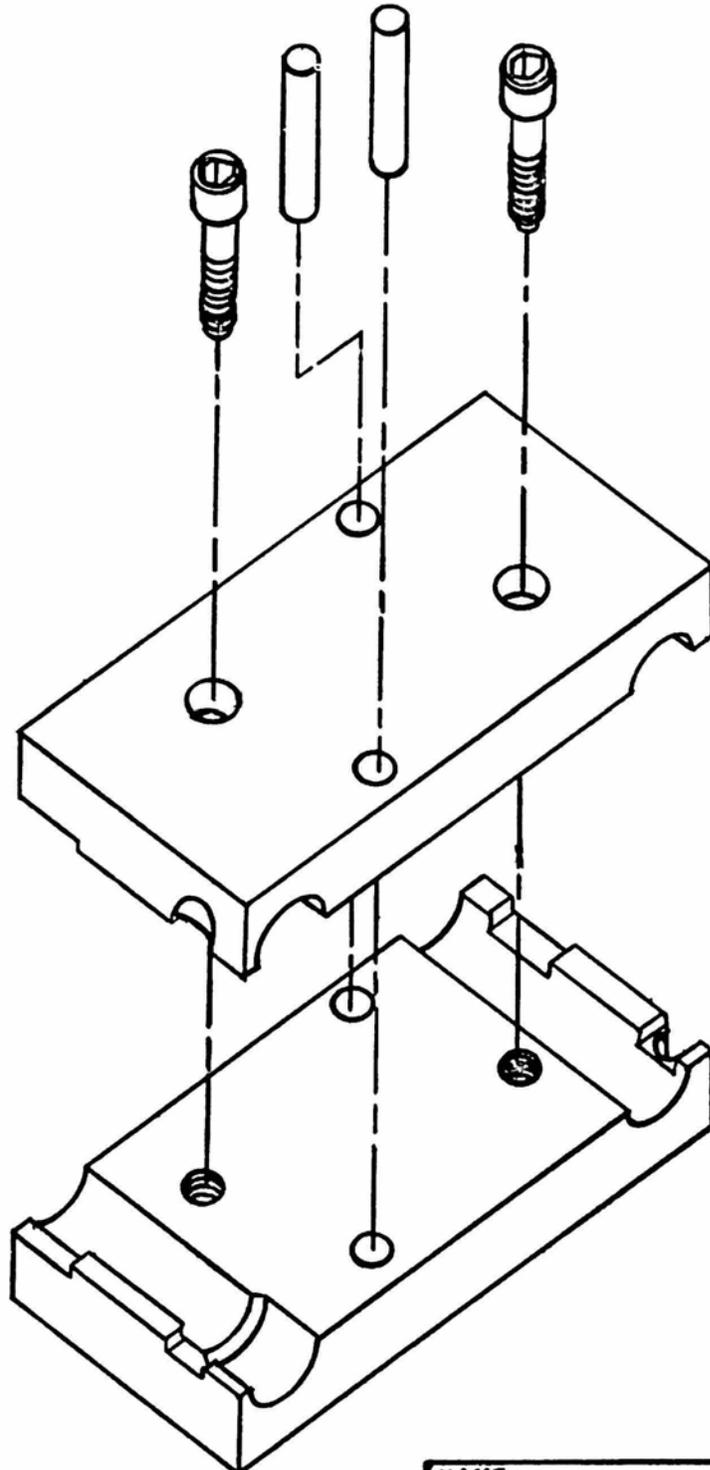
MAKE 1 BRASS WASHER 1" D. $\frac{3}{16}$ " THICK WITH $\frac{3}{8}$ " HOLE.



① REVISED 9/21/65 WAS $\frac{5}{16}$

ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT: _____		DRAWN: J Y		NAME RECEIVER BLOCK	
FINISH: FILE		MATL: C.R.S.		DEPARTMENT OF GUNSMITHING	
SCALE: FULL		DATE: 4/14/64		TRINIDAD STATE JR. COLLEGE	
		CHECKED: <i>xxx</i>		TRINIDAD, COLORADO	
		APPROVED: <i>Loyl</i>		DWG. NO. S-146	



ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

NAME

BOLT BENDING JIG

HEAT TREAT: **NONE**

DRAWN: *ll. meston*

FINISH: **NONE**

MATL: **C.R.S.**

CHECKED:

SCALE: $\frac{1}{2}'' = 1''$

DATE: **5-25-66**

APPROVED:

DEPARTMENT OF GUNSMITHING

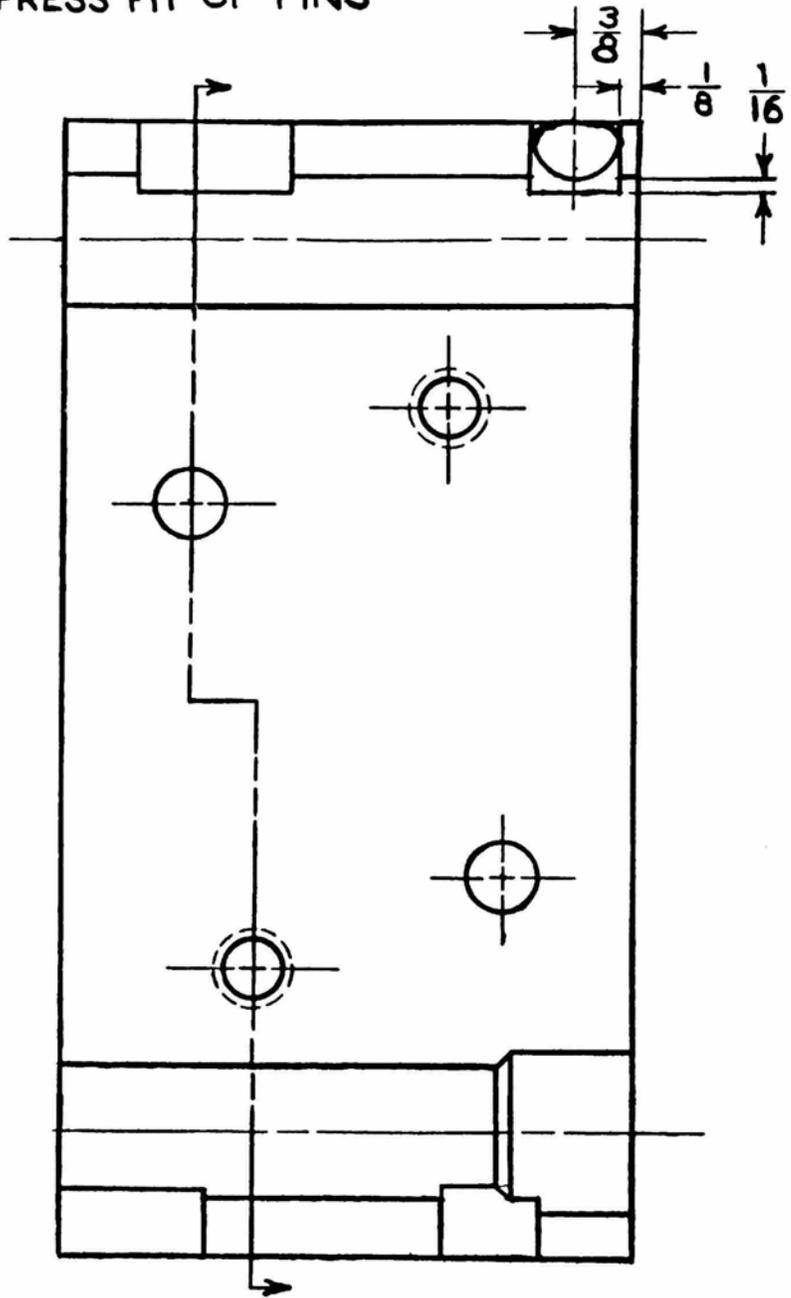
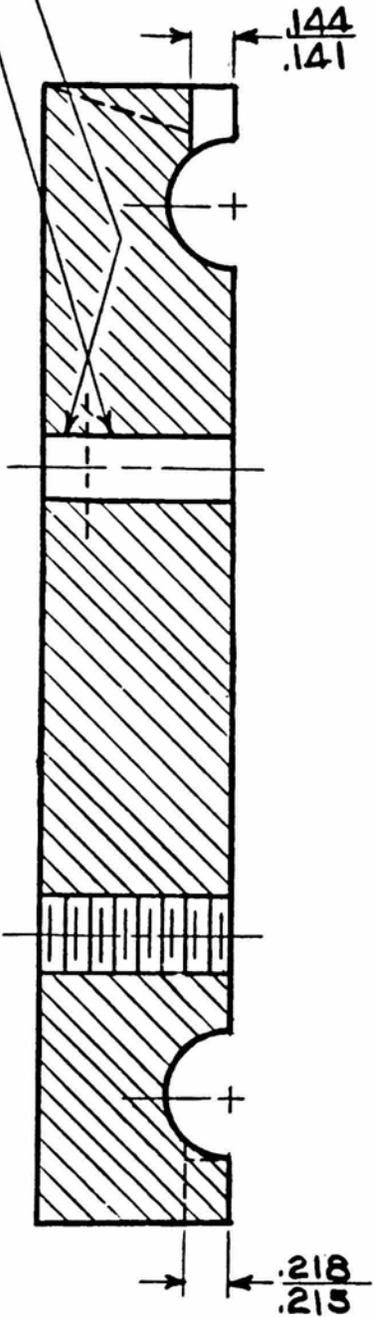
TRINIDAD STATE JR. COLLEGE

TRINIDAD, COLORADO

DWG. NO. **S-148-A**

$\frac{3}{8}$ REAM ONLY TO ^{THE} BOTTOM AND STOP

TAPER REMAINS FOR PRESS FIT OF PINS



2 PINS - 2 x $\frac{3753}{3748}$ DIA.

2 SOC. HD. CAP SCR'S - $\frac{3}{8}$ - 16 x $\frac{1}{2}$

FOR REMAINING DIMENSIONS
SEE DWG NOS. S-148-C & D

BOTTOM VIEW

ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT: NONE

DRAWN: *J.F.T.*

FINISH: NONE

MATL: C.R.S.

CHECKED: *LA*

SCALE: FULL

DATE: 2-6-65

APPROVED: *L.M.*

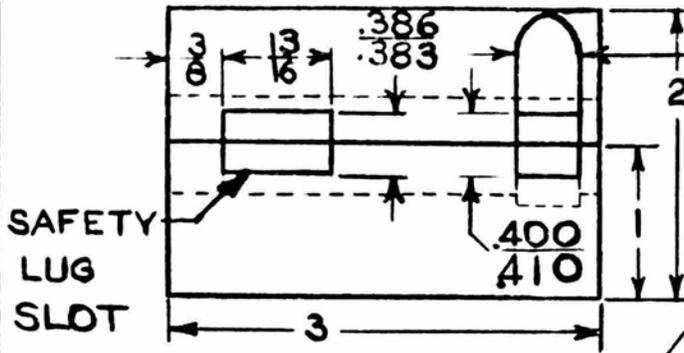
NAME

BOLT BENDING JIG

DEPARTMENT OF GUNSMITHING

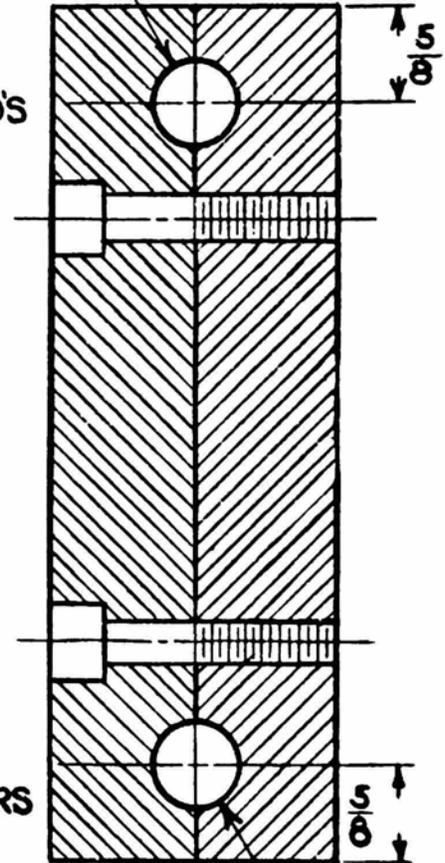
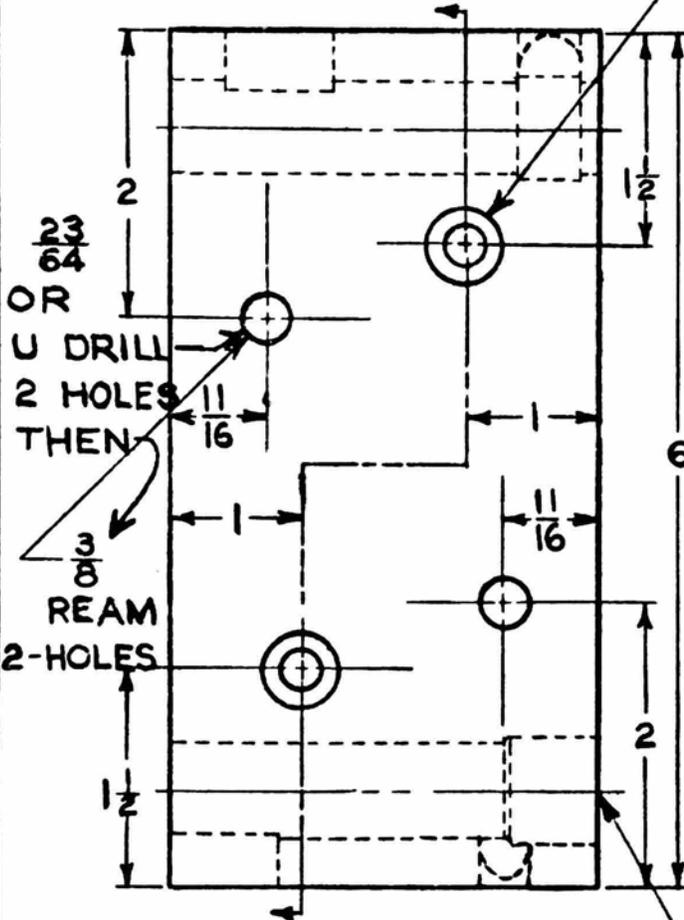
TRINIDAD STATE JR. COLLEGE

TRINIDAD, COLORADO DWG. NO. S-148-B



$\frac{452}{455}$ $\frac{5}{16}$ TAP DRILL THRU
 CLEAR: $\frac{3}{8}$ DRILL - 1 DP.
 $\frac{3}{8}$ - 16 UNC
 $\frac{9}{16}$ C'BORE $\frac{3}{8}$ DP.
 2 HOLES

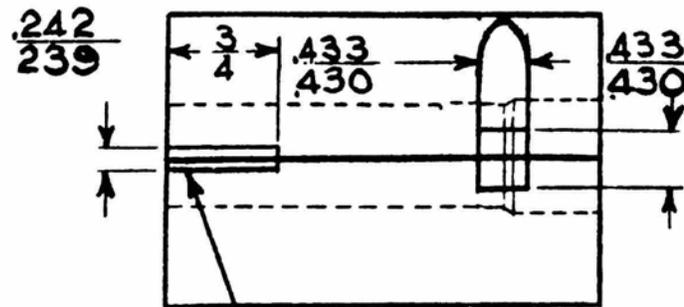
$\frac{45}{64}$ DRILL



ALL MAUSERS

20 MM C'BORE
 $\frac{5}{8}$ DEEP

$\frac{45}{64}$ DRILL



FOR REMAINING DIMENSIONS
 SEE DWG NOS. S-148-B & C

PARTIAL ASSEMBLY

ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT: NONE

DRAWN: *[Signature]*

FINISH: NONE MATL: C.R.S.

CHECKED: *[Signature]*

SCALE: NONE DATE: 1-30-65

APPROVED: *[Signature]*

NAME	BOLT BENDING JIG
DEPARTMENT OF GUNSMITHING	
TRINIDAD STATE JR. COLLEGE	
TRINIDAD, COLORADO	DWG. NO. S-148-D

NOTES ON THE BOLT FORGING JIG

1- ALL CUTS TO BE HALF OF THE BOLT, OR THE PORTION THAT IT ENCLOSES.

2- OPERATIONS:

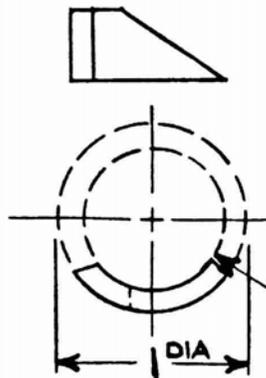
A-- DRILL, C'BORE, & TAP FOR BOLTS & INSTALL

B-- FACE ENDS IN 4-JAW

C-- DRILL THE $\frac{45}{64}$ HOLES & C'BORE 20 MM

D-- END MILL & KEYWAY CUTTING OPERATIONS

E-- MAKE AND FIT SPRINGFIELD INSERT:



MAKE OUT OF 1" DIA.
CRS. - DRILL $\frac{45}{64}$ HOLE
CUT OFF $\frac{7}{16}$ LENGTH OF
STOCK - CUT PIECE
IN HALF & FILE TO
FIT

$\frac{45}{64}$ DRILL

F-- DRILL & REAM FOR PINS

G-- MAKE & INSTALL PINS

ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT: _____		DRAWN: <i>[Signature]</i>
FINISH: _____	MATL: _____	CHECKED: <i>[Signature]</i>
SCALE: _____	DATE: 5-11-65	APPROVED: <i>[Signature]</i>

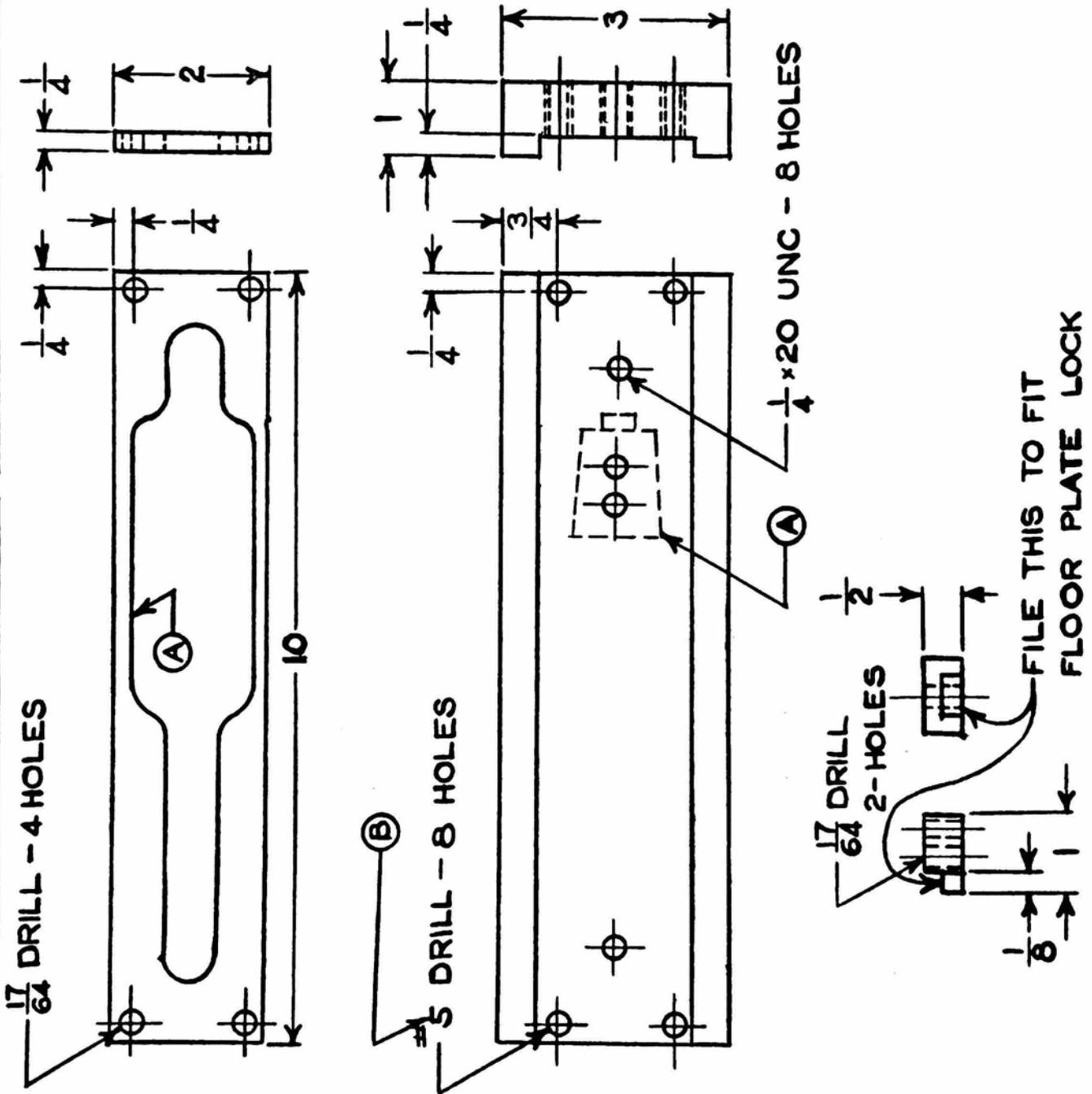
NAME BOLT FORGING JIG
DEPARTMENT OF GUNSMITHING
TRINIDAD STATE JR. COLLEGE
TRINIDAD, COLORADO DWG. NO. S-148-E

NOTES:

A-ALL DIMENSIONS NOT INDICATED MUST BE DETERMINED AFTER LAYOUT IS MADE.

B-OVERSIZED TAP DRILL TO PREVENT TAP BREAKAGE.

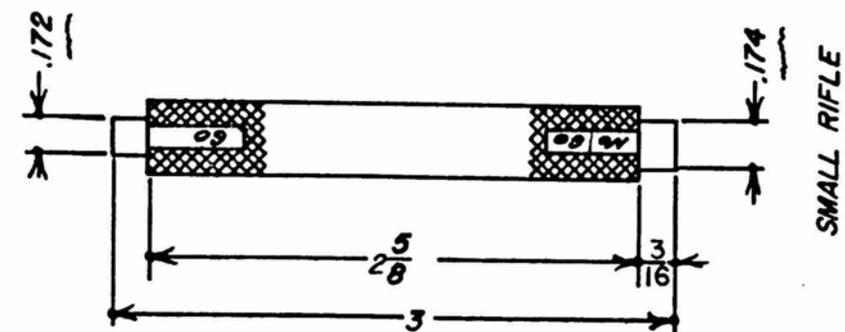
C-USE AMERICAN 1917 TRIGGER GUARD AS TEMPLATE FOR LAYOUT.



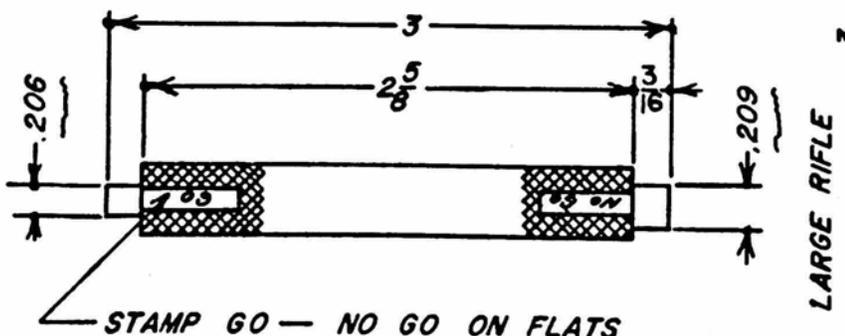
ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT: NONE		RE- D:AWN. <i>[Signature]</i>
FINISH: FILE	MATL: C.R.S	CHECKED: <i>[Signature]</i>
SCALE: NONE	DATE: 5-14-65	APPROVED: <i>[Signature]</i>

NAME ENFIELD-GUARD JIG
DEPARTMENT OF GUNSMITHING
TRINIDAD STATE JR. COLLEGE
TRINIDAD, COLORADO DWG. NO. S-151



SMALL RIFLE



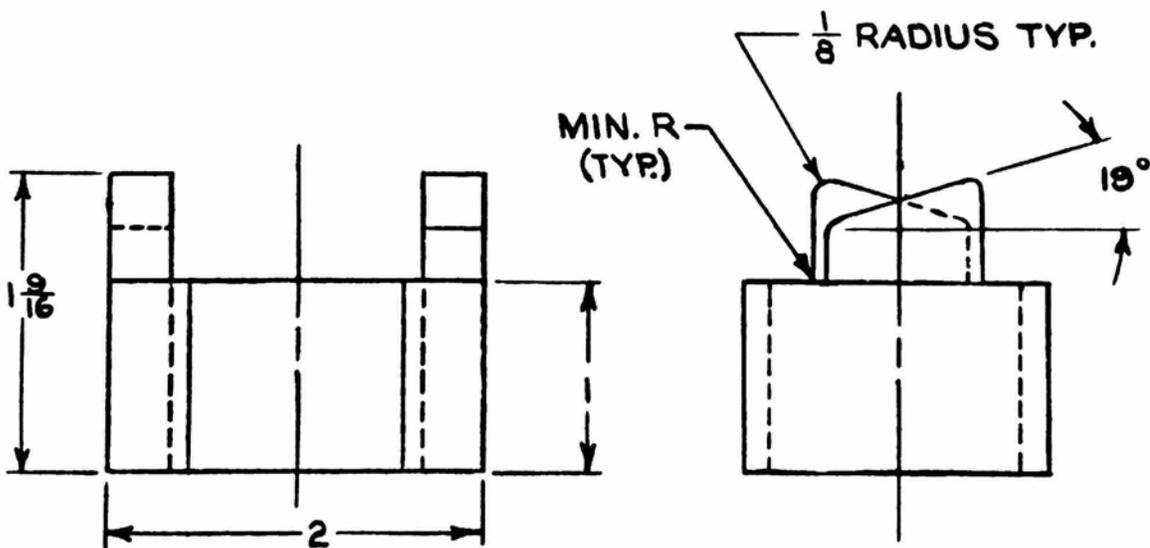
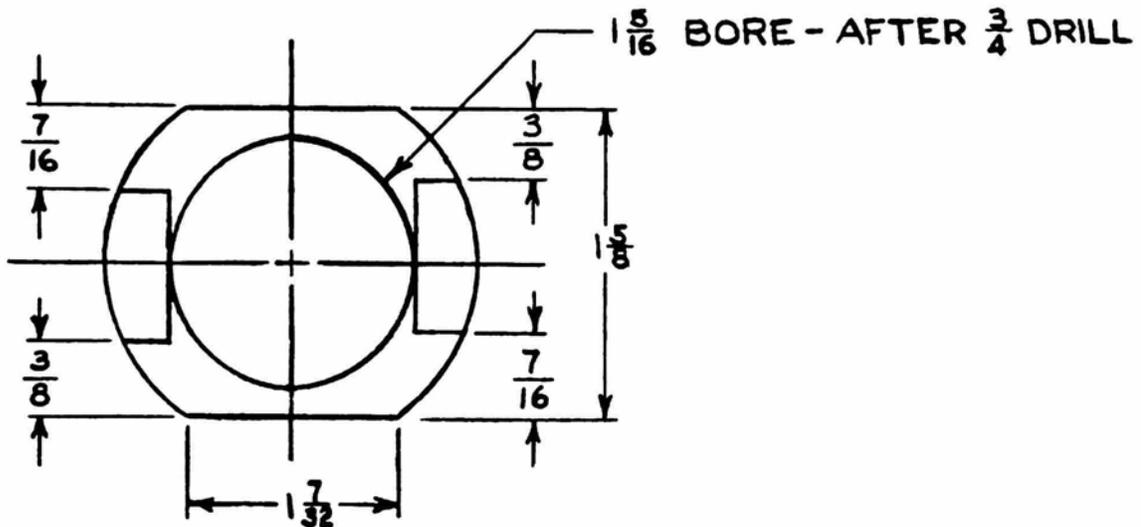
LARGE RIFLE

USE $\frac{3}{8}$ X 3 C.R.S.
 KNURL & CASE HARDEN

ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT: CASE HARDEN	DRAWN: R.C.S.
FINISH: KNURL	MATL.: C.R.S.
SCALE: 1=1	DATE: 12-3-62
	CHECKED: <i>[Signature]</i>
	APPROVED: <i>[Signature]</i>

NAME	PRIMER POCKET GAGE
	DEPARTMENT OF GUNSMITHING
	TRINIDAD STATE JR. COLLEGE
	TRINIDAD, COLORADO
	DWG. NO. O-153



ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

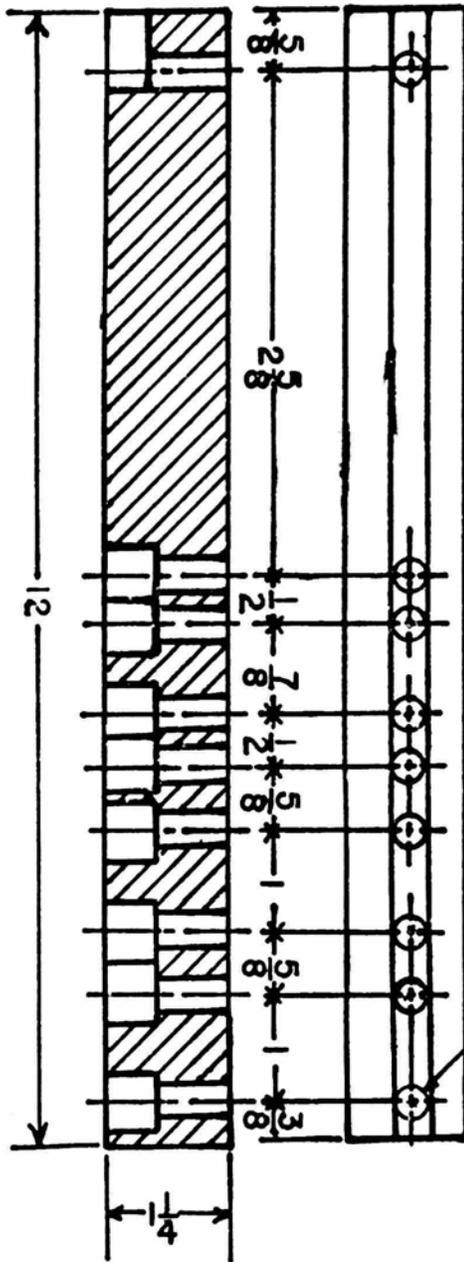
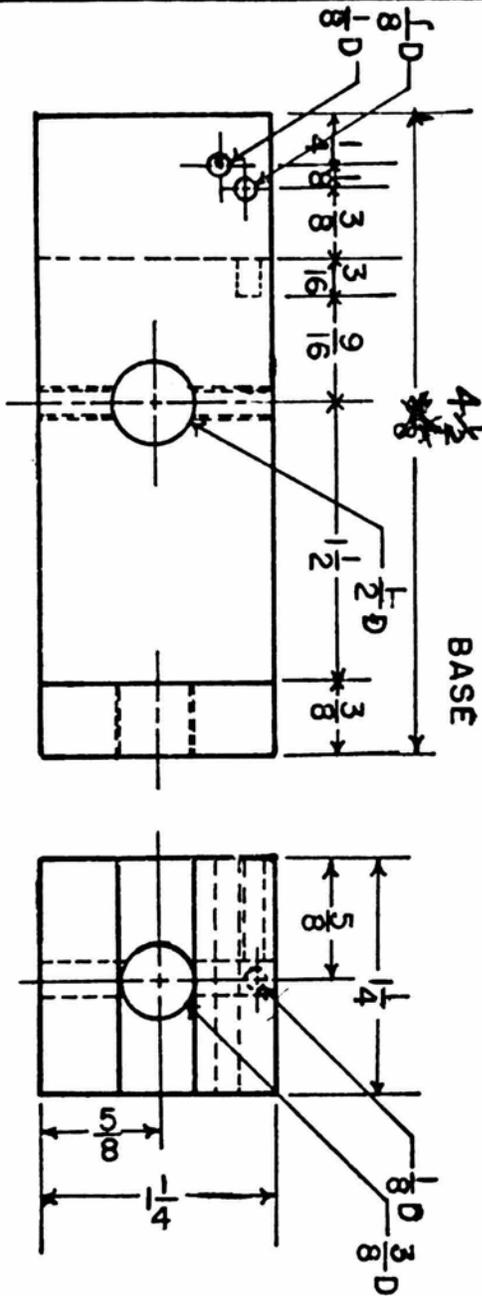
HEAT TREAT: _____ DRAWN: *[Signature]*

FINISH: _____ MATL: CRS CHECKED: *[Signature]*

SCALE: FULL DATE: 4-26-60 APPROVED: *[Signature]*

NAME KRAG RECEIVER NUT - FOR
REMOVING BARRELS
DEPARTMENT OF GUNSMITHING
TRINIDAD STATE JR. COLLEGE
TRINIDAD, COLORADO DWG. NO. C-135

HEAD - STANDARD

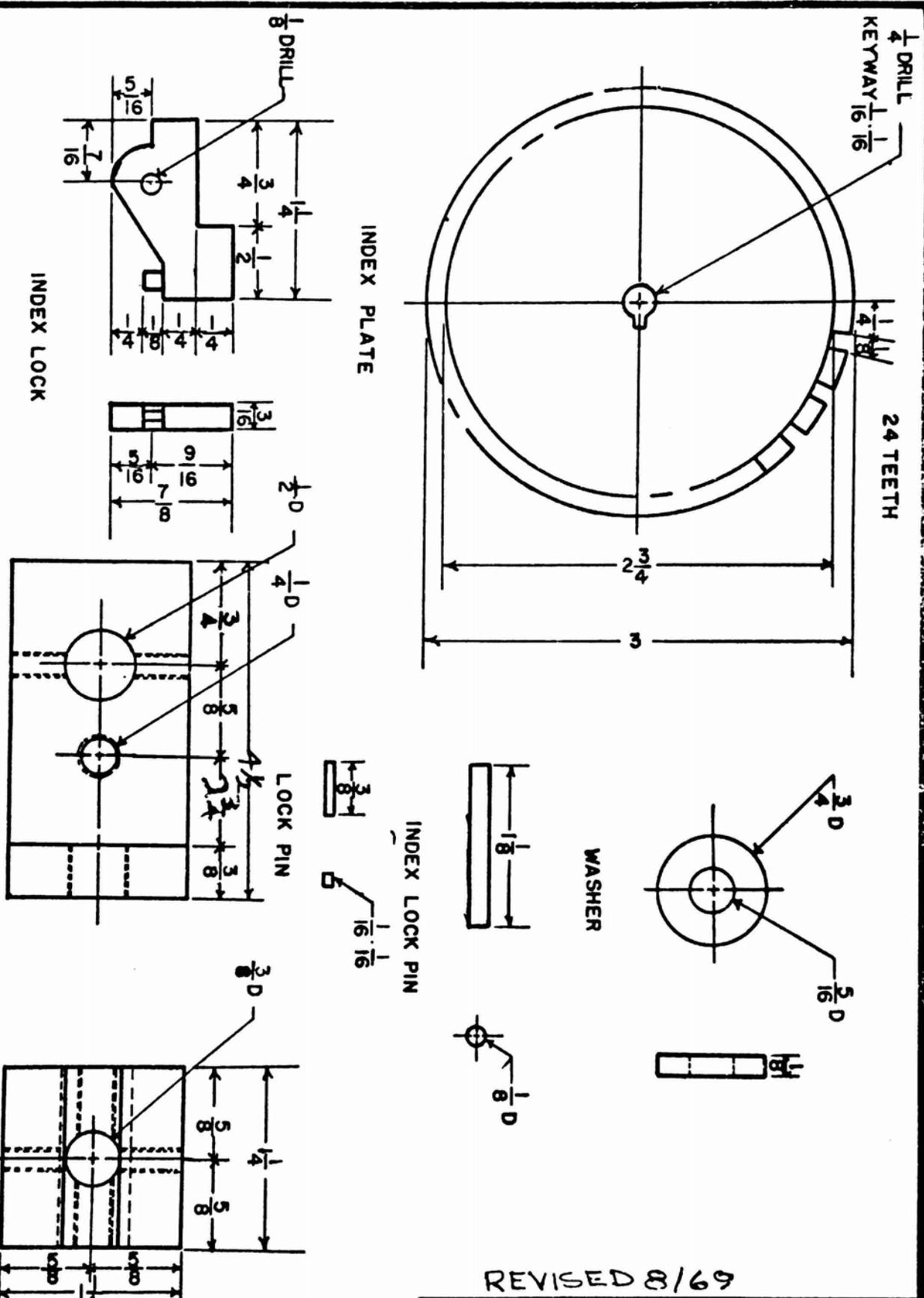


DRILL $\frac{1}{8}$ - 9 HOLES
COUNTERSINK $\frac{1}{2}$ - 9 HOLES

REVISED 8/69

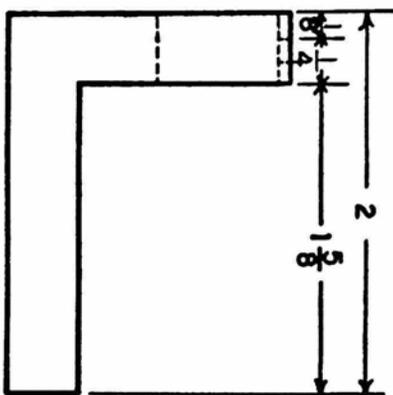
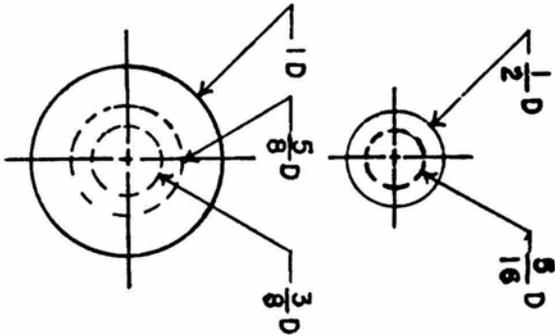
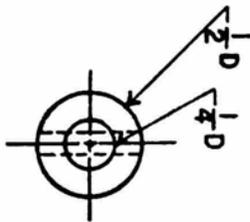
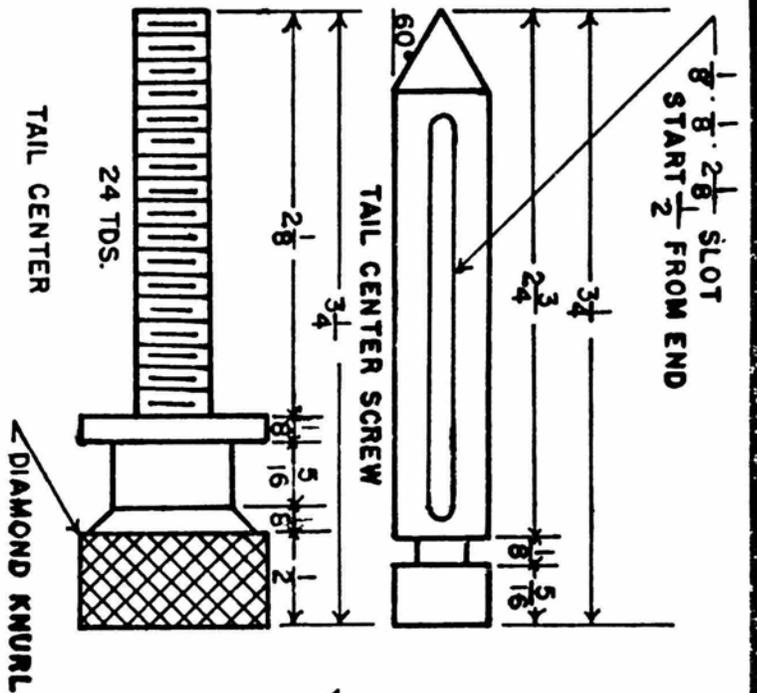
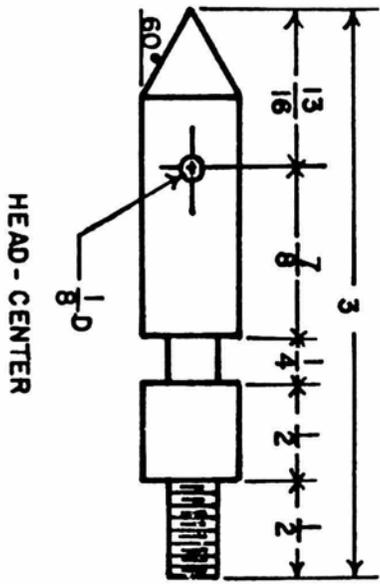
ALL DIMENSIONS IN INCHES UNLESS SPECIFIED		
HEAT TREAT: _____	DRAWN: J.E.O.	
FINISH: BLUE	MATL: CRS	CHECKED: <i>[Signature]</i>
SCALE: NONE	DATE: 1-14-64	APPROVED: <i>[Signature]</i>

NAME	ENGINE TURNING INDEX
DEPARTMENT OF GUNSMITHING	
TRINIDAD STATE JR. COLLEGE	
TRINIDAD, COLORADO	DWG. NO. O-156-A

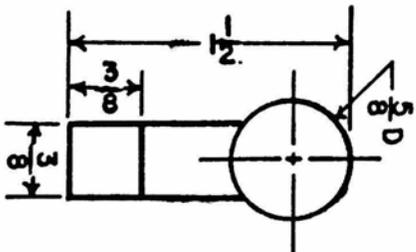
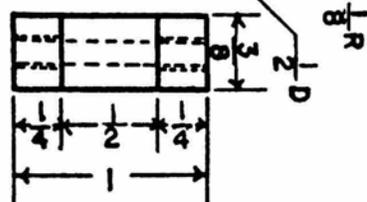
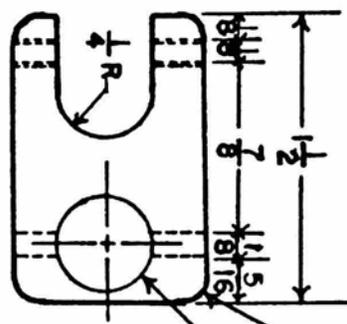


REVISED 8/69

ALL DIMENSIONS IN INCHES UNLESS SPECIFIED			NAME
HEAT TREAT: _____		DRAWN: J.E.O.	ENGINE TURNING INDEX
FINISH: BLUE	MATL: CRS	CHECKED: <i>[Signature]</i>	DEPARTMENT OF GUNSMITHING
SCALE: FULL	DATE: 1-14-64	APPROVED: <i>[Signature]</i>	TRINIDAD STATE JR. COLLEGE
			TRINIDAD, COLORADO DWG. NO. 0-156-B



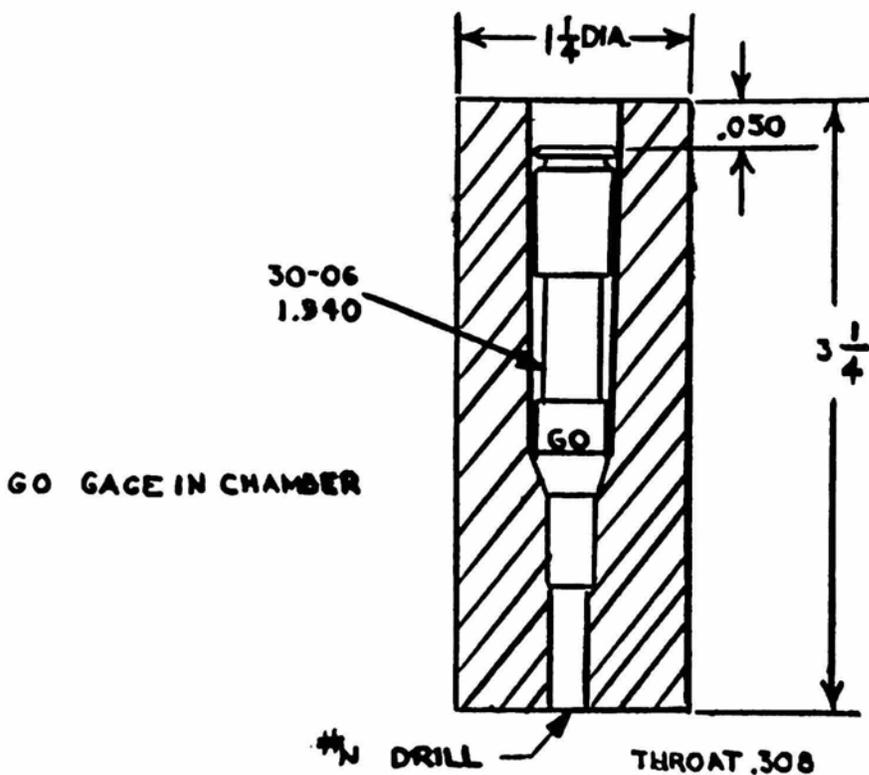
DOG ADAPTER PIN



ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT: _____	DRAWN: J.E.O.
FINISH: BLUE	MATL.: CRS
SCALE: FULL	DATE: 1-14-64
	CHECKED: <i>[Signature]</i>
	APPROVED: <i>[Signature]</i>

NAME	ENGINE TURNING INDEX
	DEPARTMENT OF GUNSMITHING
	TRINIDAD STATE JR. COLLEGE
	TRINIDAD, COLORADO
	DWG. NO. O-156-C



#N DRILL FOR PILOT HOLE - DRILL THROUGH
ROUGH CHAMBER, FINISH WITH REAMER
USE DEPTH MICROMETER FOR .050

ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT: NONE

DRAWN: K. P.

FINISH: REAM

MATL: 1 1/2 C.R.S.

CHECKED:

SCALE: FULL

DATE:

APPROVED: *[Signature]*

NAME

MASTER DIE (30-06)

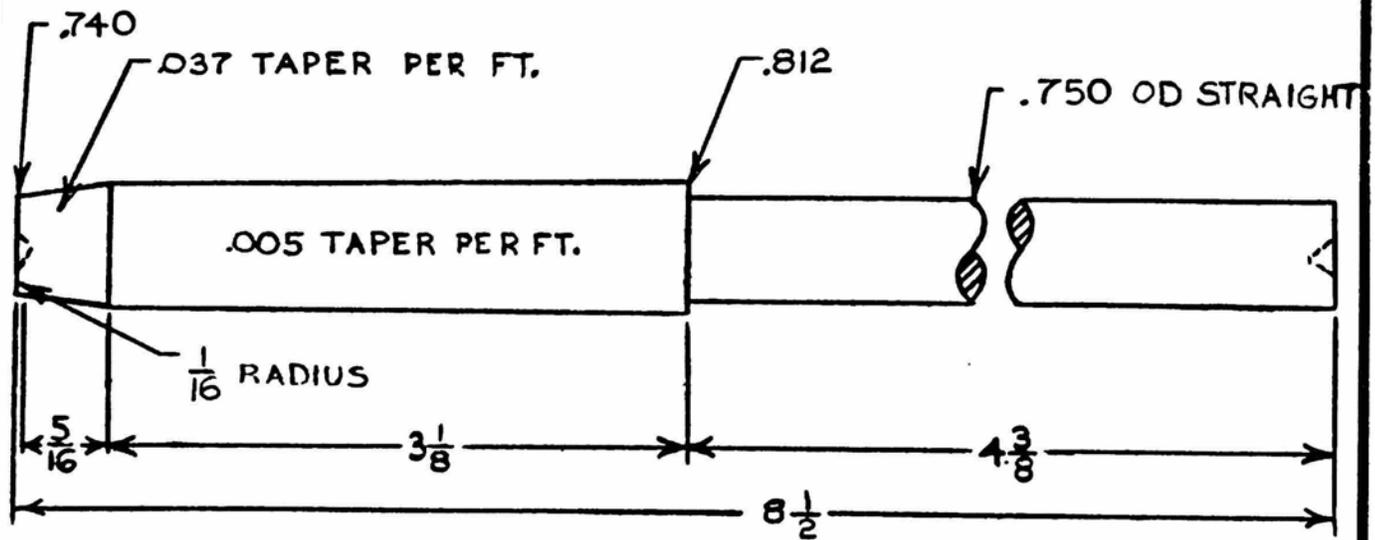
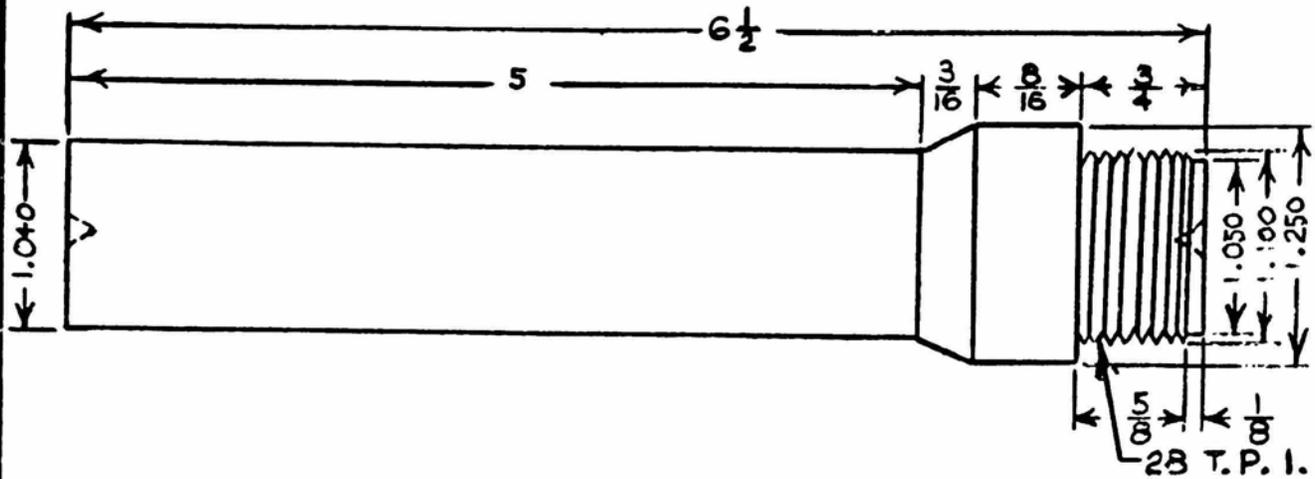
DEPARTMENT OF GUNSMITHING

TRINIDAD STATE JR. COLLEGE

TRINIDAD, COLORADO

DWG. NO. 0157

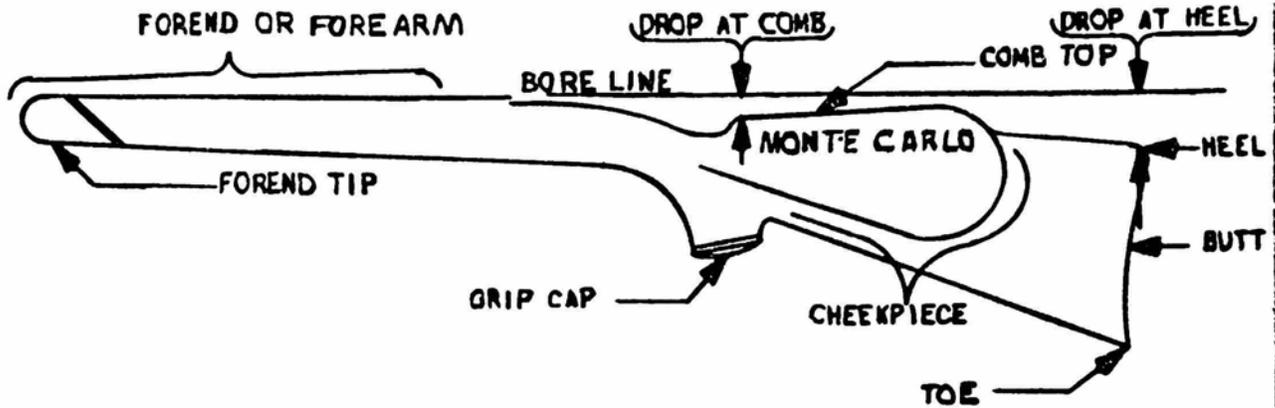
USE $1\frac{1}{4} \times 6\frac{1}{2}$ COLD ROLLED STEEL. POLISH FINISH



$7\frac{7}{8} \times 8\frac{1}{2}$ COLD ROLLED STEEL
POLISH FINISH

ALL DIMENSIONS IN INCHES UNLESS SPECIFIED			NAME CUTTS - COMPENSATOR MANDRIL	
HEAT TREAT:		DRAWN: T. MUDD		DEPARTMENT OF GUNSMITHING
FINISH: POLISH	MATL: CR	CHECKED:		TRINIDAD STATE JR. COLLEGE
SCALE: 1=1	DATE: 5/28/68	APPROVED: <i>AMP</i>		TRINIDAD, COLORADO DWG. NO. 0-164

ESSENTIAL INFORMATION:



STANDARD DIMENSIONS:

- LENGTH OF PULL-DISTANCE FROM THE TRIGGER TO THE MIDDLE OF THE BUTT----- $13\frac{1}{2}''$
- LENGTH OF GRIP PULL-DISTANCE OF THE TRIGGER TO THE FRONT TIP OF GRIP----- $3\frac{1}{2}''$ to $4''$
- LENGTH OF BUTT----- $5''$ by $1\frac{9}{16}''$
- PITCH-ANGLE OF BUTT----- $3/8''$ IN AT TOE
- GRIP CAP----- $2''$ by $1\frac{3}{8}''$
- DROP AT HEEL----- $1\frac{1}{4}''$
- DROP AT COMB-DISTANCE FROM BORE LINE TO COMB-BOLT CLEARANCE
- FOREND LENGTH-----HALF THE LENGTH OF THE BARREL MAXIMUM- $12''$

COMPLETELY REVISED 5/68

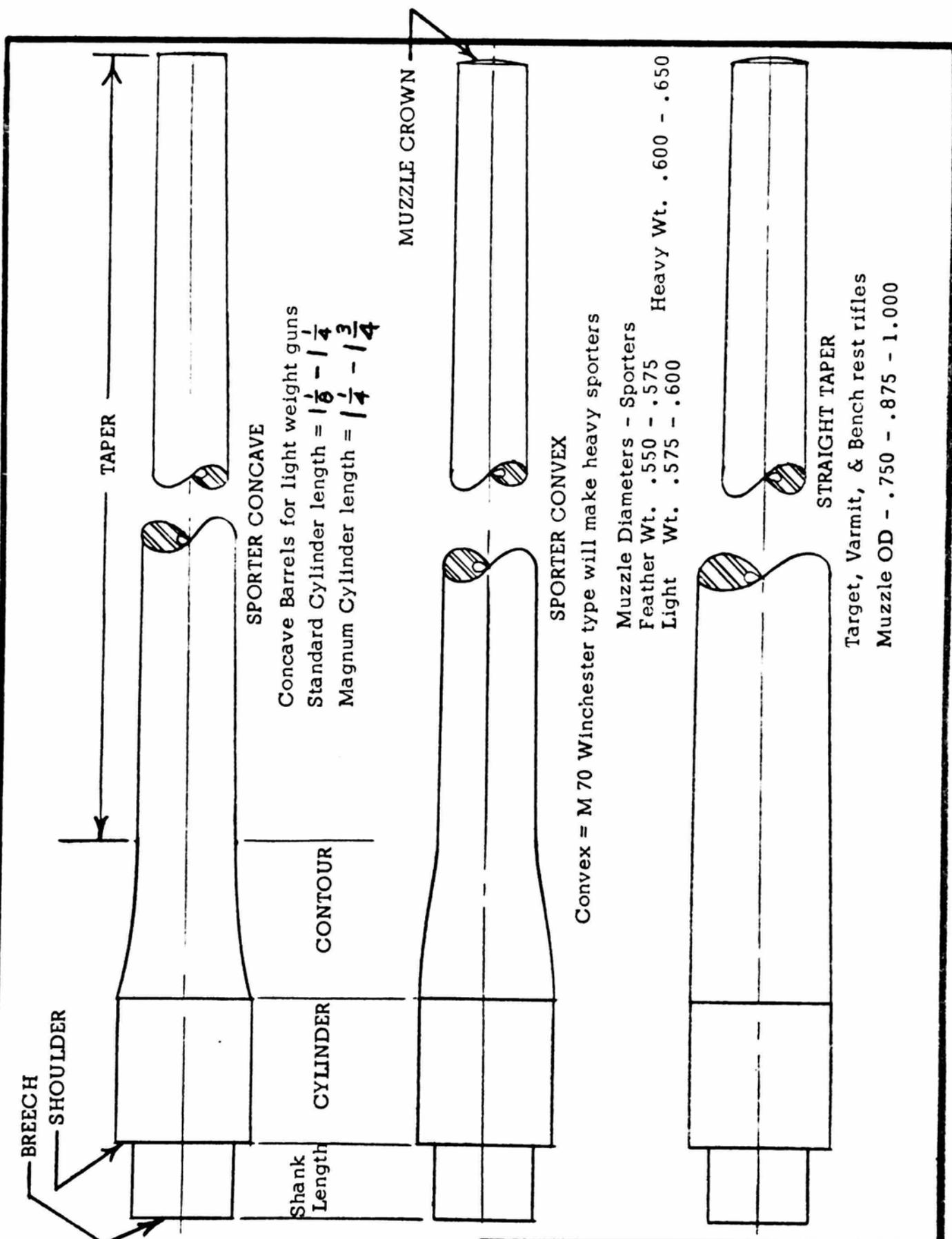
ALL DIMENSIONS IN INCHES UNLESS SPECIFIED			NAME	
HEAT TREAT: _____		DRAWN: R M	STANDARD STOCK DIM'S	
FINISH: _____	MATL: _____	CHECKED: _____	DEPARTMENT OF GUNSMITHING	
SCALE: NONE	DATE: 5/24/68	APPROVED: _____	TRINIDAD STATE JR. COLLEGE	
			TRINIDAD, COLORADO DWG. NO. R-170	

DIE INFORMATION

<u>Cal.</u>	<u>Bores</u>	<u>Groves</u>	<u>Die Pilot</u>	<u>Drill</u>	<u>Decimal Equivalent</u>
17	.168	.172	.166	18	.1695
224	.219	.224	.217	2	.2210
228	.220	.226	.218	2	.2210
6mm	.236 6mm	.242-6mm .243 .244	.232	B	.238
257	.250	.257	.248	1/4	.250
615mm	.256 6.5mm	.264	.254	F	.257
270 Win	.270	.277	.268	I	.272
7mm	.276 7mm	.284	.274	J	.277
30	.300	.308	.298	N	.302
8mm	.312 8mm	.320	.310	5/16	.312
357	.350 9mm	.357	.348	S	.348
375	.368	.375	.366	U	.368
405 Win	.405	.413	.403	13/32	.453
458 Win	.450	.457	.448	29/64	.453
505 Gibs	.494	.505	.492	1/2	.500

DIE INFORMATION

*224
form*



ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT:		DRAWN: <i>[Signature]</i>
FINISH:	MATL:	CHECKED: <i>[Signature]</i>
SCALE: NONE	DATE:	APPROVED: <i>[Signature]</i>

NAME	BARREL BLANK NOMENCIATURE :
DEPARTMENT OF GUNSMITHING	
TRINIDAD STATE JR. COLLEGE	
TRINIDAD, COLORADO	DWG. NO. R-172

BORE AND GROOVE DIMENSIONS

CALIBER	BORE	GROOVE
257R	250	257
250-3000	250	257
25-35	250	257
250 Mag.	250	257
25-20	250	257
6.5 MM	256	264
270	270	2776
7 MM	276	284
280 Ross	280	288
30-60	300	308
300 Savage	300	308
300 Mag.	300	308
30-30	300	308
32-20	305	312
32 Special	312	320
8 MM	315-312	3266-323
350 Newt. Mag. Whelen	350	357
375 Mag.	368	375
45 Mag.	450	4576
50-100	500	5076
45 Pistol	445	450
17 Cal.	168	172
22 L.R.	217	2222
Wasp	219	224
Zipper-, bee-, Lovel-,	219	224
228	220	226
6 MM	236	242
22 W.F.C.	220	226
22-250	219	224
Hornet	219	224
220 Swift	220	224

[BORE AND GROOVE DIMENSIONS]

dot
Lam

[R-173]

SHOTGUN CHOKES

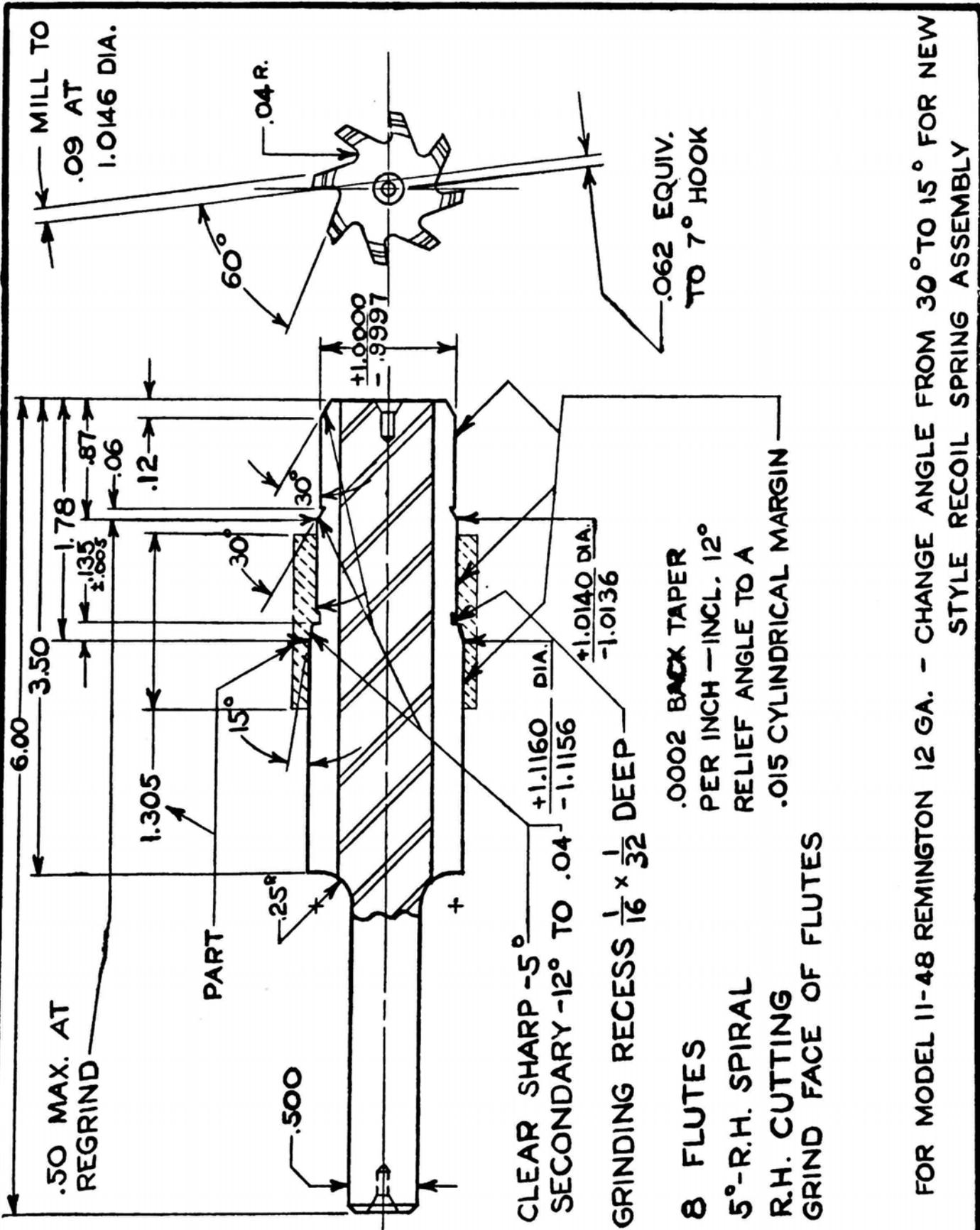
Cutts Comp-28 T.P.I.
 Polly- 40 T.P.I.
 Weaver- 40 T.P.I.

BARREL DIAMETER AND THREADS

	Diameter	Threads	Length of Shank
MAUSER (large ring)	1.100	12 V	.625-.635
MAUSER (sm all ring)	1.000	12 V	.625-.635
Some Mex. Mausers	.890	12 V	.625-.635
Mannlicher	1.060	12 V	.7031
JAP (6.5)	1.20	14 V	.6875
JAP (7.7)	1.02	17 V	.703
WIN. (65)	.805	20 V	.625
WIN. (95)	.930	16 V	.875
WIN. (86)	.872	20 V	.7189
WIN. (Hi-Wall)	.935	16 V	.8437
WIN. (low-Wall)	.821	16 V	.8437
WIN. (Model 70)	1.000	16 V	.733
WIN. (54)	1.000	16 V	.733
KRAG	.980	10 sq.	.750
NOR. KRAG	1.056	12" (Left)	.750
REMINGTON ROLLING BLOCK	.977	12 Sq.	.977
REMINGTON HEPBURN	.978	12 Sq.	1.000
REMINGTON #30 (1917)	1.120	10 Sq.	.8125
REMINGTON & #30 721	1.060	16 V	.880
SHARPS	.945	16 V	1.125
SAVAGE 99	.900	12 Sq.	.9375
SAVAGE SUPER SPORTER	.900	12 Sq.	.925 with collar
SPRINGFIELD	1.040	10 Sq.	.750
NEWTON	1.040	10 Sq.	.750
STEVENS 44	.8125	12 V	1.916
STEVENS 44 1/2	.875	16 V	
BALLARD SS	.950	18 V	
GER. MARTINI	.878	14 V	.750
ENFIELD	1.118	10 Sq.	.840
MARLIN 336	.7777	12 Sq.	.850 with collar
ENFIELD MARTINI	1.000	14 V	.700
M I GRAND	.775	10 Sq.	.700
M I CARBINE	.745	20 V	.635
Hainel SS	.950	14 V	3.000 sleeve 740 D.
French Maas	980	17 12 V	873 .710

BARREL DIAMETER AND THREADS

BT
LAM



MILL TO
.09 AT
1.0146 DIA.

.062 EQUIV.
TO 7° HOOK

.50 MAX. AT
REGRIND

PART

CLEAR SHARP -5°
SECONDARY -12° TO .04

GRINDING RECESS $\frac{1}{16} \times \frac{1}{32}$ DEEP

.0002 BACK TAPER
PER INCH -INCL. 12°
RELIEF ANGLE TO A
.015 CYLINDRICAL MARGIN

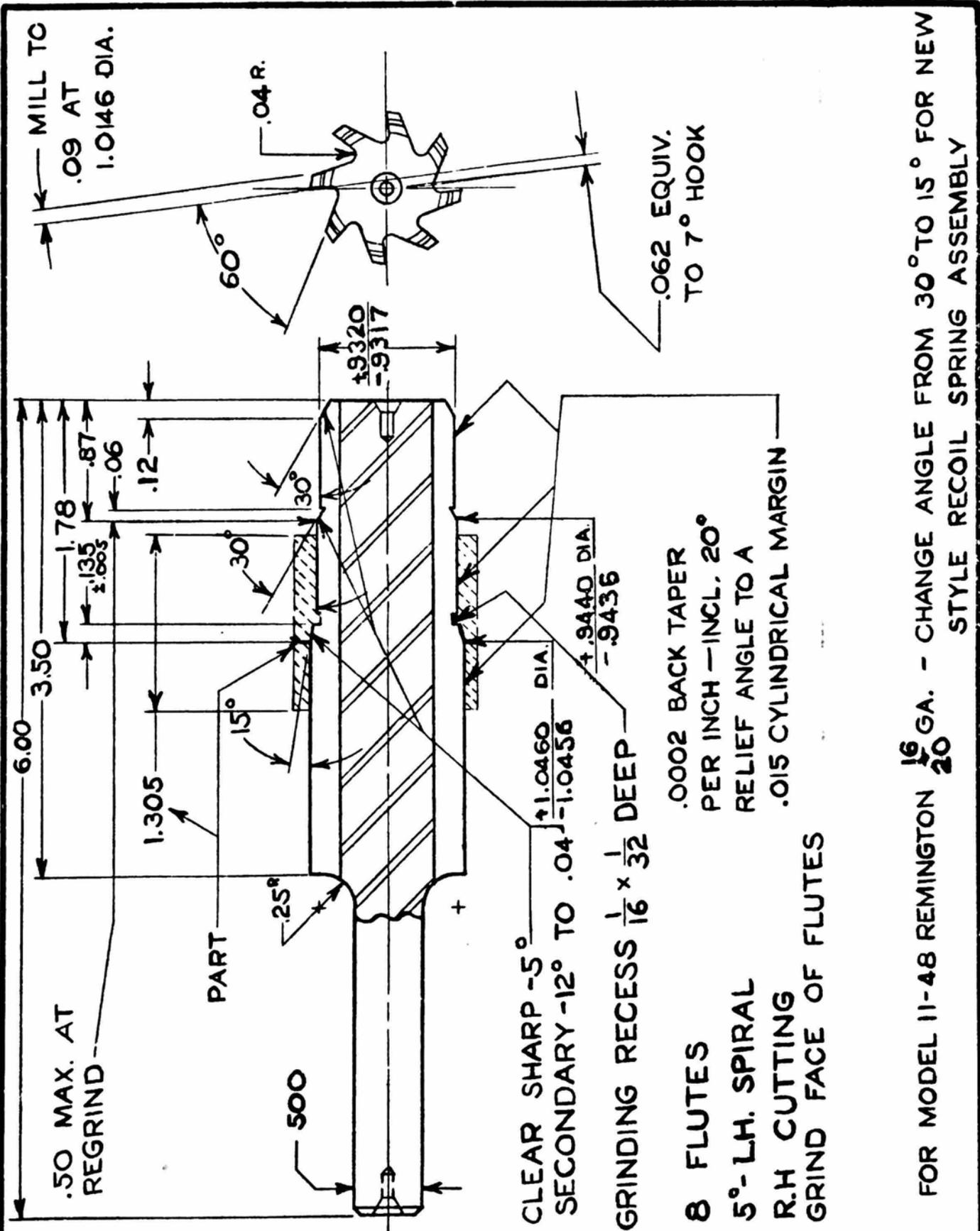
8 FLUTES
5°-R.H. SPIRAL
R.H. CUTTING
GRIND FACE OF FLUTES

FOR MODEL 11-48 REMINGTON 12 GA. - CHANGE ANGLE FROM 30° TO 15° FOR NEW
STYLE RECOIL SPRING ASSEMBLY

ALL DIMENSIONS IN INCHES UNLESS SPECIFIED

HEAT TREAT: HDN. - R _c - 63/65		DRAWN: <i>[Signature]</i>
FINISH: GRD.	MATL: H.S.S.	CHECKED: <i>[Signature]</i>
SCALE: FULL	DATE: 1-23-65	APPROVED: <i>[Signature]</i>

NAME	REAMER - B-59414
DEPARTMENT OF GUNSMITHING	
TRINIDAD STATE JR. COLLEGE	
TRINIDAD, COLORADO	DWG. NO. REM-300



ALL DIMENSIONS IN INCHES UNLESS SPECIFIED			
HEAT TREAT: HDN. - R/c - 63/65		DRAWN: <i>[Signature]</i>	
FINISH: GRD.	MATL: H.S.S.	CHECKED: <i>[Signature]</i>	
SCALE: FULL	DATE: 1-23-65	APPROVED: <i>[Signature]</i>	

NAME	REAMER - B-59415
DEPARTMENT OF GUNSMITHING	
TRINIDAD STATE JR. COLLEGE	
TRINIDAD, COLORADO	DWG. NO. REM-301

FOR MODEL 11-48 REMINGTON $\frac{16}{20}$ GA. - CHANGE ANGLE FROM 30° TO 15° FOR NEW STYLE RECOIL SPRING ASSEMBLY