

### Barrel Band Installation:

- 1) If your musket has barrel bands, you can begin to fit these to the stock once the barrel has been fully inletted to the channel.
- 2) Carefully slide each barrel band onto the stock/barrel assembly, slowly removing material with files, tools, and sandpaper until it slides into place with a slight interference fit. If the fit is too tight or requires force, carefully note where the barrel band is contacting the stock and sparingly remove material until it is fully seated against its respective shoulder on the stock.
- 3) If your model has barrel band retention springs, be sure to check the fit of these springs in the process of installing the bands themselves. Ideal fit should be that the spring “snaps” on the shoulder the band as the band contacts the shoulder on the stock.

### Sling Swivel Installation:

- 1) If your musket has sling swivels with a mechanical screw installation, be sure to check the fit into their respective areas. Screws can be burnished at this point as well, as previously described for machine screws.

### Checking Overall Parts Fit Post- Dry Fitting:

- 1) Make sure that the barrel is against the back of the channel as described on page 5.
- 2) Rotate the hammer on your lock assembly to captive ½-cock position and slide into the lock plate recess area on the stock. Tighten lock plate screws to being into position.
- 3) Make sure that the bolster and/or area of the breech where the nipple is installed has clearance and does not touch the lock plate.
- 4) The nipple area of the breech or bolster should be positioned in alignment with the radial recess cutout corresponding on the lock plate, with a slight gap of clearance as described above.
- 5) Insert the tang screw into the respective hole and secure the barrel into place prior to securing down the lock plate.
- 6) At this point, the hammer should be positioned so that it will fall squarely onto the nipple.

**NOTE: In the case of a flintlock, the priming pan should be in alignment with the communication hole found on the barrel, where priming powder will have direct access to the communication hole.**

- 7) If the hammer alignment is off, one or more the following steps can be taken to correct alignment:
  - Remove wood from the bottom of the lock recess, until the lock is in alignment.
  - Remove wood from the barrel/tang area until barrel and lock are in alignment.
  - Check that the lock plate and lock plate screws are snugly fitted into the stock and that the lock is properly positioned into the inletting recess.

### Sight installation:

- 1) Once the barrel and lock are in alignment, sights may be installed to check alignment of sights onto top-line of the barrel.
- 2) Front sight should be installed first and then the rear sight. Be sure to install retaining spring into the rear sight with rifled models that have a more complex rear sighting system.
- 3) Check mechanical function and alignment of sights on the barrel.

### Brass/Metal to Wood Assembly:

Keep in mind that both the stock wood and metal parts can both be filed when installing parts into the stock. Brass is much easier to manipulate those steel parts that are in the white, but both materials can be carefully filed/sanded to flush with the stock, in order to ensure aesthetic beauty and a sound mechanical fit.

Some notes on filing metal and wood are listed below:

- 1) When fitting metal and wood parts together (or sanding for final aesthetics prior to finishing) wood will file & sand easier and faster than the metal materials.
- 2) If the metal material needs to be filed and removed, then it is recommended that the metal component be removed from the stock and filed/sanded first to the point that it is almost perfectly flush and in alignment with wood surfaces, then reinstalled on the wood are on the stock for final aesthetic sanding to higher desired grits.
- 3) If brass and steel are in the same area working in tandem in a mechanical or aesthetic capacity, brass will file and sand faster/easier than steel components.

### Final Fitting:

After all of the parts have been dry fitted to the stock, the stock, barrel, and any small parts need to be prepared for final finishes.

### Stock & Small Parts

- Using progressively finer wood rasps, files, and sandpaper, bring wood and metal surfaces flush with one another. File and sand together to achieve a smooth transition between the surfaces. Proceed carefully, deliberately and slowly.
  - Once surfaces are flush, use an orbital sander or hand-sanding block to continue to smooth imperfections on the stock.
  - Begin with 150-180 grit sandpaper when sanding parts, progress to 220-400 grit sandpaper to achieve a finer finish. Then progress to 600+ grit.
  - Remove or tape over metal parts before staining or finishing stock.
  - Once all sanding is complete, stain with your choice of stain/oil in desired color. Follow instructions from stain/oil supplier for best results.
  - Once wood finish dries/cures completely, apply an even coat of urethane finish for added protection.
- NOTE: If using a gun stock oil or velvet oil for finishing the stock, urethane finish might not be required and can actually damage the finish. Be sure to check instructions prior to using urethane.**

### Barrel:

- Polish bare steel parts with varying and progressively finer levels of metallic sandpaper & emery cloth. Finish with fine steel wool, or using a polishing wheel and compound.
- Apply desired metal finish, utilizing relevant chemicals for the finish desired (such as Liquid Blue). Be sure to thoroughly degrease the surface of the metal with degreasing agent prior to applying metal finish.

### Brass:

Draw-file/shape and then polish brass and bare steel parts with varying grits of metallic sandpaper and emery cloth, progressively moving towards a finer grit. Final finish can be achieved with a fine steel wool.

**FOR QUESTIONS OR FURTHER INQUIRIES  
PLEASE CONTACT**

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## TRADITIONS™ MUSKET REPRODUCTION MUZZLELOADER KIT INSTRUCTIONS



Congratulations on purchasing your new Traditions™ musket reproduction muzzleloader kit. When you are finished, you will have a fully functional and operating muzzleloader that you can take to the range or in the field. For this reason, it must be handled with the same precautions and respect due any firearm. Before loading or shooting this gun, read and understand these instructions, and always be prepared to follow the precautions in this text, as well as the warranty and shooting instructions as laid out in the musket manual included with this kit.

Please be sure to read the instructions completely before assembling your Traditions™ musket kit. Please note that once the kit has been opened from the packaging and altered in any way (i.e. sanding, staining, bluing, filing, etc.), you will need to call Traditions™ directly and not your dealer in order to resolve any issues that have arisen.

The following instructions will help to enable a moderately handy person to build a safe, serviceable, and shootable muzzleloader. This kit is to be considered moderately hard (Intermediate Skill Level) and you should expect to do some filing on both the metal and wood to ensure a proper fit and inlet. The great skill and patience involved in completing this kit is rewarded with a truly fine musket reminiscent of the classical musket era. **NOTE: Additional tools and recommended items for completion are listed on the following page. Please contact our customer service team with any further questions.**

**⚠ WARNING: PRIOR TO BEGINNING THIS KIT YOU MUST READ THE SAFETY & INSTRUCTION MANUAL FOR MUSKET REPRODUCTION MUZZLELOADERS INCLUDED WITH THIS KIT.**

### **Additional Items & Tools:**

Please note that the below listed items are recommended hand tools and aides that we advise using to finish out the kit. These items are meant to ease the assembly of the kit and allow for a better fit and finish.

- 1) Wood Files & Rasps (several different shapes and sizes)
- 2) Wood Carving Tools (chisels, wood gauges, or Dremel Tools are acceptable)
- 3) Bench Vise (padded for holding the stock, the barrel, or the parts without marring the surfaces)
- 4) Cordless Drill (for drilling or opening the diameter on any holes).
- 5) Sandpaper (for both wood and metal; ranging from 150 grit to 800-1000 grit for final sanding/finish)
- 6) Emery Cloth (of varying grades)
- 7) Fine Grade Steel Wool (for final finish)
- 8) Bluing Kit (if your musket requires bluing for metal finish; Traditions™ Liquid Blue is recommended)
- 9) Wood Putty
- 10) Stock Finishing Kit (Available from Traditions™; other wood stains, wood and stock finishing oils, and urethane finishes can be used as well)
- 11) Safety goggles
- 12) Latex Gloves

### **Step 1**

After removing the kit from the packaging, lay all the parts out on a table or a clean flat surface and inventory that all parts are present. The easiest way to do this is to print off a schematic of your kit model and check off each item and quantity. Then place them in a closeable container or tray for safekeeping, until they are needed for a given stage of the build. To find a copy of your schematic please visit [www.traditionsfirearms.com](http://www.traditionsfirearms.com) or contact our customer service department.

### **Step 2**

Once all of your parts are present and accounted for, you can begin the “dry fit” of parts to the stock. This process should be carried out with the upmost care, as it greatly dictates the results of the final fit and finish at latter stages.

### **General Assembly Instructions**

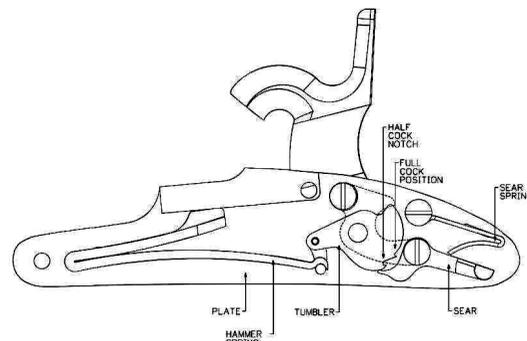
- 1) Fitting: All metal parts should be placed into their respective inlet locations on the stock. These could require filing and use of tools mentioned previously in order to ensure a snug fit. Remove wood sparingly, and only as needed with a sharp chisel or carving tool. Proceed slowly, as it is always better to remove too little wood than too much.
- 2) Wood Screws: Any wood screws should be marked and pilot holes drilled into the stock prior to assembling. This will help to ensure that the wood will not crack when installing and removing the wood screws.
- 3) Metal/Machines Screws: Rotate machine screws into and out of their intended threaded holes several times to burnish the threads on the screw shank and ensure a smooth fit.

### **Dry Fitting**

#### **Sear Engagement:**

Before inserting the lock assembly into its cutout inlet, verify that the lock is in proper working order and that the sear engages correctly. Visually inspect the back of the lock plate and that the sear does not have any burrs or defects that will prevent it from functioning properly. To perform this check, rotate the hammer into captive half-cock position. Watch to ensure that the sear falls correctly into the captive notch. After the sear is found to be properly seated, rotate the hammer into full-cock position and check to ensure that it engages into the full cock notch on the sear. Repeat this check several times to look for mechanical repeatability.

#### **Lock Assembly:**



- 1) Begin with the lock assembly in-hand. Press firmly into the cutout inlet. (Note: This should fit snugly into the inlet, but not so tight that you need to force it.) If forcing is required, note the areas of resistance in the inlet and remove wood material from these areas sparingly until the lock fits. If the lock fits loosely from removal of too much material, spacers will need to be added in order to ensure a proper fit. Wood putty can be used to fill in small gaps where too much wood was removed.
- 2) Once the lock plate is installed, visually verify that the screw holes are in alignment with their respective holes in the stock. If they are not, enlarge one or both stock holes with a round file or drill bit to permit full alignment.
- 3) Install the front lock plate screw (and washer if included) through the hole in the stock, and into the corresponding hole in the lock plate.  
**NOTE: For models where the ramrod retaining spring engages this screw, be sure to pass the screw through the ramrod retaining spring recess and make sure that the screw aligns with its corresponding threaded hole. Most models utilize an independent through pin in front of the screws to install the ramrod retention spring.**
- 4) Install the second lock plate screw (and washer if included).  
**Note all the areas where additional fitting is required. You can use a pencil to outline the areas where wood needs to be removed. Once all the excess areas have been removed and holes aligned, proceed to the next step.**

#### **Barrel Assembly & Trigger Assembly into Stock:**

- 1) Carefully begin checking the inlet of your barrel into the barrel channel. Ideal inlet for the barrel into its channel should be with the barrel slightly past ½-depth into the channel.
- 2) Check the fit of the tang and back of barrel against the back of the barrel channel. The tang should not prohibit the barrel from contacting the back of the channel. It is best practice to leave about .010-.015” of space between the back of the tang and the back of the tang channel.  
This will help prevent the tang from recoiling into the stock at a focal point, which could cause a stock to split over time.

**NOTE: The barrel & breech should be fully inleted into the stock and sitting against the back of the channel prior to referencing the other parts in relation to the barrel.**

- 3) If your musket has a tang screw, test that the tang screw turns smoothly within its corresponding threaded hole by turning it in and out several times to burnish the threads, helping to ensure a smooth engagement during disassembly and reassembly.
- 4) Place the trigger assembly (if your gun has a trigger that installs into an independent housing/body via a screw or through pin, be sure to check the fit of the housing first prior to installing the trigger shoe itself) into the cut out recess in the stock. A snug fit is desirable, without requiring much force to install and remove.
  - If the trigger (or housing) needs to be forced into the stock, a slight removal of material on the wood might be required.
  - Ensure that the upper engagement parts of the trigger are not touching any wood.
  - If too loose, shim and/or wood putty might be needed.
  - After inspecting the trigger itself and its fit into the recess, double check the trigger alignment in relation to the barrel tang and barrel channel.
- 5) Test that the trigger moves freely within the trigger guard. If not, move it back & forth a few times to free up any binding.  
**NOTE: On many musket models, the guard installs directly onto the trigger housing/metal body via machined threads, and does not directly engage the wood on the stock.**
- 6) Test stock wedges and/or barrel & stock retention pins to ensure that they move freely from right-to-left on removing and left-to-right upon installation. Check any through pins on trigger systems as well.
- 7) Test the ramrod recess, thimbles and retention components to ensure that they are in alignment with the barrel channel, and can be installed without wood material interfering. If wood interferes, sparingly remove material until in alignment and ease of installation is possible.