Note: If you have black side plates they will fit over the round holes and not in them. Do not alarmed, the recessed holes are designed for brass plates that would have already come already installed on the stock. Since this note attains the task to the trigger assembly we will install that next. Once all of the areas have been removed and holes aligned proceed to the next step.

9. Seat the hammer in the half-cock position. The barrel bolster should be positioned concentrically into its cut-out in the back plate and the lock plate should be against the barrel.

10. Insert the tang screw through the hole in the tang and against the trigger assembly. We will install them as we go.

11. At this point the hammer should be positioned so that it will fall squarely onto the trigger. If it does not one or more of the following steps may be taken.

• Remove wood from bottom of lock recess, until is flush with the barrel.

• Remove wood as needed from under and behind the brass channel(s) including tang area.

• Check that the lock plate and lock plate screws are snugly fitted into the stock and the lock is properly positioned in its cut-out.

12. If proper alignment is not obtained with the previous steps, the hammer may be bent slightly by removing it from the lock, heating it and bending it again to obtain the correct alignment.

13. Using the two rear sight screws attach the rear sight base and tighten them securely.

14. Insert the tang screw through the hole in the tang into the corresponding screw holes on the top of the barrel.

15. Press the rear of the trigger guard into the stock. Then press it lightly until the tang is locked into the rear sight base.

16. Note: As with the barrel bores front fitting of sights should be done only after staining or bluing the barrel.

Now that the parts are completely together and dry you need to check for functionality. Be sure to visually inspect the entire gun and components. Some common problems that can result are listed below with solutions.

Hammer won’t cock back completely:

• After removing lock from stock. Status inspecting for “slant” or “shims” standing. They will most likely be along the bottom of the barrel where they are added to change the position to correct the fit. If it can’t be completely adjusted use a slim file. Be sure Cerium Tool to remove excess wood. Make sure to take out small amounts and check if lock functions properly. (Continue to remove wood until lock operates properly.

Look Plate sits too far in:

• File if the look sticks out too far for small amounts away from the lock. Continue to cut or adjust it if necessary.

Look Plate sits too far out:

• If the look sits in too far for small amounts away from the lock. Continue to cut or adjust it if necessary.

17. Place the trigger guard screws.

• Press stockwood into stock removing wood as necessary with a file or small chisel. Remember to remove wood sparingly.

• Insert and tighten two patchbox screws.

18. Note: As with the barrel bores final fitting of sights should be done only after bluing or staining the barrel.

This kit is to be considered moderately hard (Intermediate Skill Level) and you should expect to do some filing of both metal and wood to make it fit properly. Greater skills and patience will be rewarded with a truly finished and operable 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 any firearms. Before loading or shooting this gun, read and understand and always be willing to follow the instructions, leads, and precautions as outlined in the Instructional Manual and Shooting Instructions Online. If this booklet is not with your kit, contact Traditions for a free replacement copy.

Congratulations and thank you for purchasing your new Traditions muzzleloading rifle. When you are finished you will have a fully functional and operable muzzleloader that you can take to the range or in the field.

The following instructions will 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 of both metal and wood to make it fit properly. Greater skills and patience will be rewarded with a truly finished and operable muzzleloader.

Skil Level:

Beginner:

• Stock: 95% installed. Will require final fitting of metal parts, final sanding & finish. May require some holes to be drilled.

Intermediate:

• Stock: 95% installed. Will require some minor shrink fitting & final shaping of metal to stock, final sanding & finish. Will require holes to be drilled. Metal: Will require polishing &orianing or liking.
**Additional Items:**
- Latex Gloves
- Stock Finishing Kit (Wood Stain & Polyurethane)
- Bluing Kit (Birchwood Casey)
- Fine Grade Steel Wool
- Sandpaper (150, 180, & 220)
- Cordless Drill
- Vise
- FT-53011
- 36011
- K-20201-2
- K-20201-1
- 20201
- 20201
- 20201
- 20201
- 20201

**Dry Fitting:**

1. Start with the lock assembly. Press firmly into the pre cut emptying. Place the back end in first and then the front of the lock assembly. (Note: it should sit snugly but not so tight that you need to force it in.) Place all other screws in the areas where wood removal needs to occur. In the event that the lock is loose you will need to add spacers in the gaps to ensure a proper fit. Wood putty can be used to fill in these holes, but do not use lock assembly in place.

2. Position the Rammers Retaining Spring into the Stock so that the end of the spring which has the loop is positioned towards the muzzle & the curve is downwards towards the ramrod channel.

3. Once the lock assembly is in place visually verify that the screw holes line up. If holes are not perfectly aligned, enlarge one or both screw holes with a drill or drift to permit screws to be tightened. Screws should be snug against the barrel.

4. Insert the front lock plate screw & washer through the hole in the stock, passing it through the loop hole in the retaining retaining spring and into the corresponding hole in the lock plate.

5. Insert the second lock plate screw & washer. Note areas where additional filing is required. You can use a pencil to outline areas where wood needs to be removed. Once all the excess areas have been removed and holes aligned proceed to the next step.

6. Install the ramrod thimbles/sling swivel assembly to the underside of the barrel with the threaded barrel rivets.

7. At this time set the stock components off to the side. We are going to move onto the barrel at this time. For the next step you will need the Barrel Assembly, barrel tenon & nipple.

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

1. Test that the tang screw turns smoothly within its corresponding threaded hole in the trigger guard by turning it in and out several times to burnish the threads to an smooth fit.

2. Test that the trigger moves freely within the trigger guard. If not, move it back & forth a few times to free up any binding. Pushing the trigger sides into its housing will also help loosen it's movement.

3. Place the Trigger Assembly (Part B) into the cut out slot. Here again you want a snug fit but not so tight that it has to be forced in.

4. If fitting scars occur note areas that need to be filed or removed. Remove wood sparingly.

5. Ensure the lip bar of the trigger does not touch any wood.

6. If hole locates areas where wood is needed.

7. After inspecting trigger assembly fit make sure that it is properly aligned with the tang hole. If the hole is not perfectly aligned index with a wood file or drift bit.

8. Give all the excess areas have been removed and holes aligned proceed to the next step.

**Lock Assembly:**

1. Using a rubber mallet or small hammer gently tap in place until snug. At this time you can also screw the bolster screw into its designated spot. Using a straight slot screw driver tighten till snug.

2. Coat the thread with nail for any future removal.

**Note:**

- Once these parts are installed we will fit the barrel to the stock.

- To properly fit the barrel to the stock place the barrel into the barrel tang and gently set into stock. Make sure that barrel is all the way back into the stock slot. You need to visually inspect to make sure that barrel lines up with hammer and that when the firewall fits into the cap squarel. You must also pay close attention that there is a very slight gap between the bolster & locking plate.

- Take the barrel tang and insert into its cut out area. This part should go into place rather easily. Visually inspect to make sure holes are correctly aligned.

**General Assembly Instructions:**

1. Fitting: All metal parts should be placed into their respective cut-out slots of the stock and should fit snugly. Remove wood sparingly and only as needed with a sharp chisel or carving tool. Proceed slowly, it is better to remove too little wood than force the lock.

2. Removing wedge. Place the back end in first and then the front of the lock assembly. (Note: it should sit snugly but not so tight that you need to force it in.) Place all other screws in the areas where wood removal needs to occur. In the event that the lock is loose you will need to add spacers in the gaps to ensure a proper fit. Wood putty can be used to fill in these holes, but do not use lock assembly in place.

3. Position the Rammed Retaining Spring into the Stock so that the end of the spring which has the loop is positioned towards the muzzle & the curve is downwards towards the ramrod channel.

4. Once the lock assembly is in place visually verify that the screw holes line up. If holes are not perfectly aligned, enlarge one or both screw holes with a drill or drift to permit screws to be tightened. Screws should be snug against the barrel.

5. Insert the front lock plate screw & washer through the hole in the stock, passing it through the loop hole in the retaining retaining spring and into the corresponding hole in the lock plate.

6. Insert the second lock plate screw & washer. Note areas where additional filing is required. You can use a pencil to outline areas where wood needs to be removed. Once all the excess areas have been removed and holes aligned proceed to the next step.

7. Install the ramrod thimbles/sling swivel assembly to the underside of the barrel with the threaded barrel rivets.

8. At this time set the stock components off to the side. We are going to move onto the barrel at this time. For the next step you will need the Barrel Assembly, barrel tenon & nipple.

9. We first want to attach the barrel tenon to the barrel assembly. This is done by installing the tenon into its slot on the barrel. Using a rubber mallet or small hammer gently tap in place until tenon is even centered on barrel.

10. Make sure angle end is pointing towards the muzzle.

**Note:**

1. File the tang or breech touch surfaces sparingly and only if needed to obtain a smooth finish. Such work is minor.

2. Those parts should require a moderate amount of force to be indexed.

3. If holes are not perfectly aligned, index with a round wood file or drift bit in parallel alignment.

Since this hole attaches the tang to the trigger assembly we will install the throttle. Once all the problems areas have been removed and holes aligned proceed to the next step.

Next you want to make sure that the barrel tenon lines up correctly through its hole. To do this barrel wedge from right into left and gently tap into place. Note: Barrel Tenon should fit snugly. If the fit is too tight, sparingly on the dovetail portion of the tenon with a tri square file to reduce it slightly. If the tenon is too loose, using a hammer and a punch, indent the surface at the base of the dovetail with the punch so as to raise the edges around the punch indentations. Additional amount of filing is required. We are going to position the tenon to line up with the dovetail edges of the dovetail with a hammer and punch so as to capture the tenen.  

**Note:** 

1. It will be necessary to remove the tenon in order to completely coat the dovetail and tenon surfaces with bluing or browning solutions. Final fitting will happen after coating.

2. If tenon is thickening the wedge hole you will need to either spread the tenon or use a metal file to take away excess metal to allow a proper fit. (Since the barrel wedge slides through snugly)

3. To tighten you can place the wedge in a vise and slowly tap with a hammer in the direction it needs to go.