



DAVE
MANSON
PRECISION REAMERS



BUY THE BEST TO BUILD THE BEST

JULY 2015

Important Information

How to Order - Not on our website because the majority of our customers have technical questions about the tools they need.

By Phone: 810-953-0732 M-F 7:30 a.m. - 4:30 p.m. Eastern Time (except Holidays). Our answering machine does not accept messages so please call back if no one answers (we are talking to other customers).

By Email: If all your questions have been answered and you know what you want, provide name, phone, billing and shipping address, payment information, and items you wish to order.

- We accept Visa, MasterCard, American Express or Discover (the card information can be divided over several emails for security).
- We will acknowledge order and advise estimated ship date.

By Mail or Fax: Provide above ordering, personal and payment information in letter or fax.

Payment Methods

Domestic Orders: we accept checks, money orders, VISA, MasterCard, American Express and Discover Card.

Foreign Orders: only credit cards are accepted. We do not accept Pay Pal.

Special orders require payment when they are placed.

Shipping and Insurance

Domestic Shipping (USA addresses): we use UPS and the US Postal Service. (USPS can be insured or flat rate - uninsured - at your request and risk).

Foreign Shipping: US Postal Service Insured or Flat Rate (uninsured at your request and risk) or DHL..

Manufacturing Times

The demand for Ammunition, Firearms and Firearms Tooling has risen dramatically in the past few year. This demand has extended manufacturing times for cataloged items as well as for special tooling. We continue to work on improving our delivery times by adding new machinery and personnel and ask for your patience in this regard.

Warranty Policy

Dave Manson Precision Reamers' products are guaranteed against defects in material and workmanship. If you feel one of our tools does not perform as it should, please call for suggestions as to its use. We emphasize customer service above all else and strive to provide the best possible tooling. If a tool is not right, it will be repaired or replaced, at our option.

If You Send Tools or Samples to Us, *please* include instructions for the work you want done as well as your name, address, phone number and payment information. If this is not received we will be unable to process your order.

Contact Us

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This catalog supercedes all previous lists

July 2015

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Standard Finishers/Roughers

Reamers and headspace gauges are made to SAAMI specs . If only CIP lists a specific caliber, reamers and headspace gauges are made to those specs. Calibers not listed by SAAMI or CIP are made to the designer's or most common specifications.

Rimless Calibers

204 RUGER	6 mm-284	7 X57 ACK IMP
22 BR	6 mm REM	7 mm BR
22 PPC	244 ACK IMP	7 mm-08
221 REM	6 X 45	280 REM
222 REM	250 SAVAGE	280 ACK IMP
222 REM MAGN	250 SAV ACK IMP	7.62 X 39
223 REM	25-06 REM	30 CARBINE
223 ACK IMP	25-06 ACK IMP	300 SAVAGE
223 WSSM	257 ROBERTS	300 WIN SHORT MAGN
220 SWIFT	257 ACK IMP	300 REM ULTRA MAGN
220 SWIFT ACK IMP	260 REM	30-06 SPRINGFIELD
22-250 REM	6.5-284	30-06 ACK IMP
22-250 ACK IMP	6.5 X 47 LAPUA	308 WIN
5.56 NATO	6.5 X 55 SWEDISH	8 mm MAUSER
243 WIN	6.5 X 55 ACK IMP	8 mm-06
243 ACK IMP	6.5-06 A-SQUARE	338-06 A-SQUARE
243 WSSM	270 WIN	35 WHELEN
6 mm BR	284 WIN	35 WHELEN ACK IMP
6 mm PPC	7 X 57	358 WIN

Price:

Solid Pilot \$100.00

Removable Pilot \$130.00

17 or 20 Cal Removable Pilot
\$140.00

Rimmed Calibers

218 BEE	30-30 ACK IMP	40-65 WCF
218 MASH BEE	30-40-KRAG	444 MARLIN (Micro)
22 HORNET	303 BRITISH	444 MARLIN (Std)
22 K HORNET	7.62 X 54 R	44-40 WCF (B or C)
25-20 WCF	32-20 WIN (B or C)	45-70 GOVT
7-30 WATERS	32-40 WIN	45-90 (General
30-30 WCF	38-55 McPherson	Purpose/Starline Brass)

Price:

Solid Pilot \$110.00

Removable Pilot \$140.00

Standard Finishers/Roughers

Belted Calibers

6.5 REM MAGN	8 mm REM MAGN
264 WIN MAGN	338 WIN MAGN
7 mm REM MAGN	350 REM MAGN
7 mm STW	375 H & H MAGN
300 H & H MAGN	416 REM MAGN
300 WIN MAGN	458 WIN MAGN
30-338 WIN MAGN	

Price:

Solid Pilot \$110.00

Removable Pilot \$140.00

Weatherby Calibers

240 WEATHERBY
257 WEATHERBY
270 WEATHERBY
7 mm WEATHERBY
300 WEATHERBY
340 WEATHERBY
375 WEATHERBY

Price:

Solid Pilot \$130.00

Removable Pilot \$160.00

30-378 WBY, 338-378 WBY, 378 WBY, 416 WBY, 460 WBY

Price:

Solid Pilot \$150.00

Removable Pilot \$180.00

Additional Calibers

17 WIN SUPER MAGN	270 WSM	338 LAPUA MAGN
17 HORNET (Hornady)	28 NOSLER	338 REM ULTRA MAGN
17 REM	7 mm WSM	9.3 x 62
17 FIREBALL	7 mm REM ULTRA MAGN	375 RUGER
5.45 x 39	7 mm REM S.A.U.M.	38-40 WCF (B or C)
223 WYLDE	7.62 NATO	416 RIGBY
22/244 ACK IMP	7.62 X 25 TOK	450 BUSHMASTER
25 WSSM	300 AAC BLK	454 CASULL (B or C)
26 NOSLER	300 REM S.A.U.M	458 LOTT
6.5 CREEDMOOR	308 MATCH M-852	45 BASIC (45-120 3 1/4)
6.5 GRENDL	325 WSM	45-90 MATCH
6.8 REM SPC II	338 FEDERAL	475 LINEBAUGH (B or C)
		500 S & W

Price:

Solid Pilot \$125.00

Removable Pilot \$155.00

17 or 20 Cal Removable Pilot
\$165.00

50 U.S. ORDNANCE

Price: Solid Pilot \$170.00, Removable Pilot \$200.00

50 U.S. ORDNANCE MATCH

Price: Solid Pilot \$190.00, Removable Pilot \$220.00

Standard Finishers/Roughers

Rimless Pistol Calibers

9 mm LUGER
9 X 23
357 SIG
380 AUTO
40 S & W
10 mm AUTO
45 ACP

Price:

Solid Pilot \$70.00
Removable Pilot \$100.00

Rimmed Pistol Calibers

32 AUTO
357 MAX
357 MAGN
38 SPECIAL
38 SUPER NONTE
41 MAGN
44 SPECIAL
44 REM MAGN
45 COLT

Price:

Solid Pilot \$80.00
Removable Pilot \$110.00

32 H & R MAGN Removable Pilot Standard, \$110.00
327 FEDERAL For 30 Cal, 32 Cal or Cylinder

Rimfire Calibers

22 LR (BBL or CYL)
22 MATCH (BBL)
22 BENTZ (BBL)
22 SHORT (BBL)
22 WMR (BBL or CYL)

Price:

Solid Pilot \$45.00
Removable Pilot \$75.00

Price:

17 HMR Solid Pilot \$75.00
17 M-2 Removable Pilot \$115.00

Wildcats/Specials

Extra large reamers and gauges to quote.

Special reamers are shipped in wooden boxes

Price:

Solid Pilot \$170.00
Removable Pilot \$200.00

NOTE: *Extended manufacturing time on specials due to extraordinary demand.*

Alterations (assuming sufficient grind stock)

Removable Pilot (JGS style) \$30.00
Removable Pilot 17 or 20 Cal \$40.00
Standard Pilot Bushing \$10.00
Pilot Bushing 17 or 20 Cal \$12.00
Alter Neck Diameter \$30.00
Alter Throat/Neck Length \$30.00
Alter Shoulder Angle \$30.00
Alter Body Taper \$30.00

TICN - Coating (2 week delivery minimum) \$18.00
Re-sharpening (most makers' tools-request quote) \$30.00
Oil Grooves in Solid Pilot \$7.00
Oil Grooves in Bushing/Spindle \$10.00
Piloted bushing sets in popular bore sizes:
Six bushing set \$60.00
Four bushing set \$40.00

Headspace Gauges/Special Offers

Headspace Gauges

	Price Per Gauge
Rimfire (go, no go)	\$30.00
Rimless Rifle (go, no go, field)	\$30.00
Rimmed or Belted (go, no go)	\$30.00
Pistol (go, no go)	\$30.00
Shotgun (go or no go)	\$30.00
Large Weatherby (go, no go)	\$40.00
Additional Calibers	\$30.00
Special/Wildcat Gauges	\$50.00
50 U.S. ORD Gauges	\$60.00



Headspace gauges for any caliber listed as standard are carried in stock.

Note: to European customers: Some SAAMI Gauges differ from CIP.
Check with your Proof House if you have questions about correct specs.

“Down and Dirty” Headspace Gauges

It's what we called them during their development. Shooters that put a LOT of rounds down-range (3-gunners, etc.) like to check the headspace in their weapons periodically, but are reluctant to pay for a number of sets of our standard gauges. We wanted to take as much cost out of the most popular headspace gauges as we could without sacrificing precision or utility in order for shooters to afford the gauges they needed.

They're made to the same exacting tolerances as our standard headspace gauges--they're just not ground where they don't need to be. These gauges are offered in the following calibers as 3-gauge sets (GO, NO GO and Field) for 1/3 LESS than our standard gauges.

Price:
\$60.00/Set of 3

5.45 X 39, 223 REM, 308 WIN, 30-06, 7.62 X 39 (CIP)

Free Reamer Offer

If you publish an article about work you did with our tooling, send us a copy when it's published and we'll reimburse the original cost of the tools used in the article. Your article must contain our name, address, phone and web address; tools must have been purchased directly from us. *Call for details.*

Note: Some internet postings may be eligible for partial credit.

Writers' Tools

Occasionally our tools are used by gunwriters for their projects. When they are returned, we offer them to you as "professionally tested" at prices much lower than catalog prices.

Please call for pricing and availability.

Accessories/Other Cutting Tools

Floating Reamer Holders

Low-mass, interchangeable-shank design.
Smoother operation and easier adjustment than
previous designs. Available with the following
shanks:

1/2" straight, #2 M.T., #3 M.T. | **Price:** \$115.00

#4 M.T. with Floating
Reamer Holder | **Price:** 150.00

Shanks Only:
1/2" Straight, #2 M,T, #3 M.T. | **Price:** 25.00

#4 M.T. | **Price:** 50.00

\$20.00

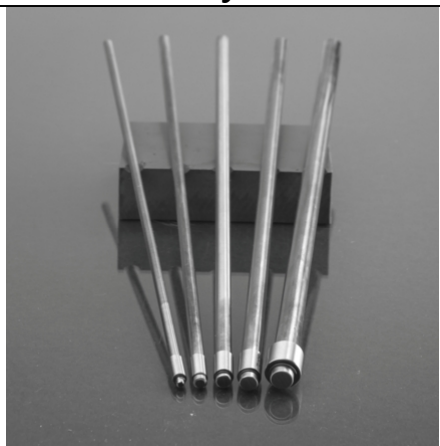
1/4" I.D. Adaptor Bushing (22 Rimfire, Throaters)

1/2" I.D. Adaptor Bushing (50 BMG)

Price: 150.00



Gritters-type Indicating Rods AKA "Grizzly" Rods



Available in the following spindle sizes:

#0: 17 & 20 Cal

#1: 22 Cal & 6 mm (inc 5.45)

2: 25 Cal through 7 mm

#3: 30 Cal through 470 Cal

4: 50 & 510 Cal

Note: These are used differently than traditional, tapered indicating rods . We highly recommend purchasing the video "Chambering a Championship Match Barrel", by Gordy Gritters. It is available from Grizzly.com #H8396.

Price: \$40.00 each (less pilot bushings)

Accessories/Other Cutting Tools

Throaters

.001" over Nominal
Bullet Diameter

Price: \$40.00

Neck Sizers

Price: \$40.00

Note: Standard cutting diameters suit the largest popular caliber in a specific bore size.

Neck and Throaters

Price: \$50.00

Note: Standard neck diameters and throat lengths suit the largest popular caliber in a specific bore size.

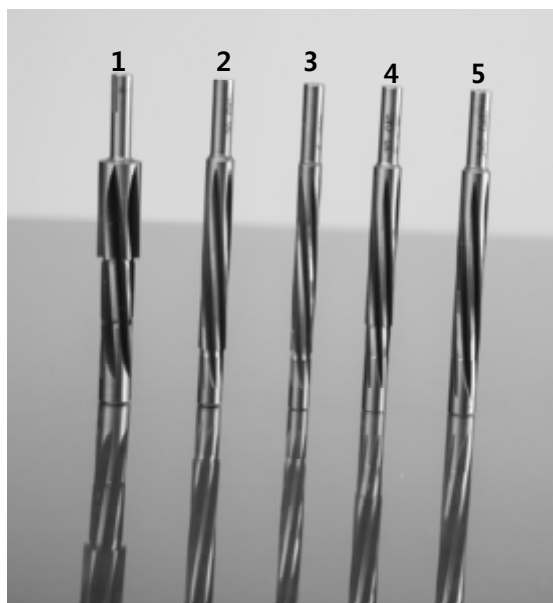
Muzzle Brake Reamers

Stocked for the following bore sizes:

22 Cal	338 Cal
6 mm	358 Cal
25 Cal	375 Cal
6.5 mm	416 Cal
270 Cal	44 Cal
7 mm	45 Pistol
30 Cal	458 Cal
8 mm	

Price: \$50.00

1. Garand Op-Rod Reamer
2. Neck Sizer
3. Muzzle Brake Reamer
4. Neck and Throater
5. Throater



Accessories/Other Cutting Tools

Cylinder Throating Reamers

Made in 32, 357, 38-40, 44 and 45 Caliber. Featuring removable pilots for optimum fit.

32 Cal sold with .3090"; 357 sold with .3540"; 38-40 sold with .3960"; 44 Cal sold with .4270"; 45 Cal sold with .4480" pilot bushings.

"Pilot Pack" of 6 additional bushings:
\$60.00 per caliber

32 Cal sizes: .3095", .3100", .3105", .3110", .3115", .3120"
357 Cal sizes: .3545", .3550", .3555", .3560", .3565", .3570"
38-40 sizes: .3965", .3970", .3975", .3980", .3985", .3990"
44 Cal sizes: .4275", .4280", .4285", .4290", .4295", .4300"
45 Cal sizes: .4485", .4490", .4495", .4500", .4505", .4510"

Price: \$80.00



Cylinder De-Leading Tool

Available in 357 and 44 Cal.

Price: \$50.00

Scope Ring Alignment Reamers

High helix design for smooth cutting past scope ring joint.

1.000" Scope Ring Reamers

Price: \$100.00

30 mm Scope Ring Reamers

Price: \$130.00

34 mm or 35 mm Hex driver on both ends

Price: \$175.00



Accessories/Other Cutting Tools

Win Model 70 Extractor Slot Cutter



A real time saver and the only way to achieve a professional looking radiussed extractor cut. Made from High Speed Steel.

Price: \$90.00

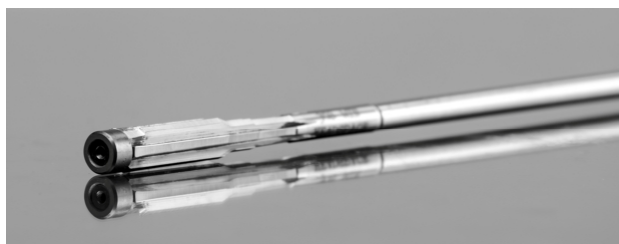
Headspacing Reamers

Available for 308 WIN, 30-06 SPRINGFIELD, OR 30 CARBINE. Complete Set includes reamer, thrust bushing - no bushing on 30 CARBINE - and extension rod.

Price: \$150.00 set

Headspacing reamer only for 7.62 NATO or M-852 MATCH: - \$150.00 each

Reamer only (SAAMI) 308 or 30-06 - \$120.00
Thrust Bushing - \$18.00
Extension Rod - \$30.00
Reamer only (30 CARBINE) - \$135.00



Garand Op-Rod Reamer

(# 1, photo page 6)

For replacing op-rod piston (oversize pistons available from Brownells).

Price: \$65.00

Reamer Storage Boxes & Tubes

Tongue and Groove Wooden Boxes

Price: \$6.00

Telescoping Square Reamer Tubes

Small and Medium

Price: \$.75

Large

Price: \$1.00

Specialized Piloted Cutters

Four Piloted Cutters

We offer four (4) different cutters to help make barrel fitting and gunsmithing work easier and more profitable. They are:

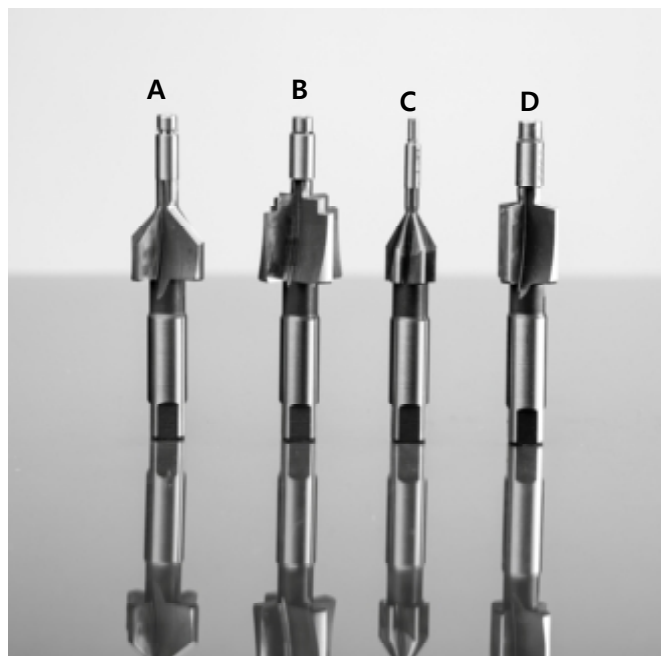
- A. 96 Degree Feed Cone Reamer
- B. Bolt Body Counter Bore
- C. Piloted Center Drill
- D. 11 Degree Muzzle Crown Cutter

Price: \$80.00 each
Including 1 bushing

Bore-specific Pilot Packs available from stock

4 Bushings **Price:** \$40.00

6 Bushings **Price:** \$60.00



Five Different Spindle Sizes

All cutters utilize removable pilots and come in FIVE DIFFERENT SPINDLE SIZES to cover the bore sizes common to gunsmithing.

Spindle Size	Calibers Covered	Bushings
#0	17 thru 20 Caliber	For: 17 or 20 Caliber
#1	22 Cal thru 6mm	For: 22 Cal or 6mm
#2	25 Cal thru 7mm	For: 25 Cal, 6.5mm, 270 Cal, 7mm
#3	30 Cal thru 475 Caliber	For: 30 Cal, 8mm, 338 Cal, 358 Cal, 9.3mm, 375 Cal, 40/10 mm, 416 Cal, 44 Cal, 45 Pistol, 458 Cal, 475 Cal
#4	50 Caliber	For: 50 Cal or 510 Cal

Please note that bushings from all other reamer makers - except Clymer - fit these spindles .

Specialized Piloted Cutters

Feed Cone Reamers (*Photo A* previous page)

The feed cone in barrels being fitted to pre-'64 Model 70, Springfield, and Enfield receivers can be difficult to cut. Our piloted Feed Cone Reamers cut the required configuration quickly and accurately to help improve your profit. ***Please specify caliber or bushing size (see page 9).***

Price: \$80.00

Bolt Body Counterbores (*Photo B* previous page)

Price: \$80.00

Used to cut the .705" diameter counterbore for the bolt nose when fitting barrels to Remington 700 actions. Unlike other designs, our cutter also faces the end of the barrel at the correct depth and cuts a small radius at the counterbore entrance to facilitate feeding. ***Please specify caliber or bushing size (see page 9).***

Piloted Center Drills (*Photo C* previous page)

Used to cut centers in barrel blanks concentric to the bore. Very useful when turning barrels between centers or when the original center--used by the maker to profile the blank--has to be re-cut. ***Please specify caliber or bushing size (see page 9).***

Price: \$80.00

11 – Degree Muzzle Crowning Cutters (*Photo D* previous page)

Price: \$80.00

An 11-degree "target" crown is often requested by customers for the muzzles of their rifles. Our Muzzle Crowning Cutters make cutting this configuration a quick and accurate operation. Closely fitted pilots ensure the concentricity necessary to a proper crown and staggered flute spacing creates a smooth, chatter-free surface. A very useful tool. ***Please specify caliber or bushing size (see page 9).***

Receiver Truing Tooling

Remington 700 Piloted Tap/Mandrel

TiCN - Coated (including two hardened, tapered pilot bushings). 1 1/16" - 16 + .010"

Price: \$295.00

Roughing Tap

Used when tapping WIN Receivers to REM Spec. 1 1/16" - 16 minus .010". TiCN. (Uses Tapered bushings from finish tap).

Price: \$240.00

Piloted Taps

Savage Actions. TiCN - Coated (including two tapered, hardened pilot bushings). 1 1/16" - 20 +.010" Or 1 1/8" - 20 + .010"

Price: \$295.00

Piloted Tap ONLY for WIN M 70 1" - 16 + .010"

Price: \$240.00

New: +.010" Oversized Piloted Tap for WIN 1 1/16" - 28 Actions

Requires different Receiver Reamer*

Receiver Reamers

For 1 1/16" threads. (Reams receiver I.D. to proper size for 1 1/16" - 16 + .010" Piloted Tap and cuts receiver lugs to same height). Uses same bushings as Tap.

Price:
\$175.00

Receiver Reamer for 1" threads (WIN M 70)

*Receiver Reamer for use with 1 1/16" - 28 WIN Tap

Recoil Lug Reamer

For Oversize Barrel Shank

Price: \$75.00

Complete Accurizing System

Piloted Tap, Receiver Reamer, Recoil Lug Reamer and Two Tapered Bushings in Wooden Storage Box

Price: \$550.00

Receiver Truing Tooling

Receiver Ring Cutter

Pilots off the shank of the Piloted Tap when in receiver to true receiver face. This hand tool eliminates the need for a lathe when truing receivers with this method.



Price: \$100.00

Boltway Reamer



For qualifying receiver boltway when sleeving the bolt. .710" and .715" cutting diameters - others on special order. Includes one tapered pilot bushing.

Price: \$220.00

False Center

For Squaring Remington Bolt Lugs

Price: \$50.00



Bolt Face Truing Tooling

For truing bolt face after lugs have been lapped.

Tooling Block (specify 1"-16 or 1 1/16" - 16 thread)

Price: \$100.00

Carbide Face Burrs (specify size)

Price: \$65.00

.590" Face Burr (Rigby, Lapua)

Price: \$75.00



Receiver Truing Tooling

Action Indicating Set (includes 2 tapered bushings)

For setting up receivers in the lathe for traditional, single-point action blueprinting.
Bushings are available for various receivers.



Price: \$135.00

Receiver Truing Tooling - in photo - see previous pages for pricing

Remington 700 Receiver Reamer

Remington 700 Piloted Tap

Recoil Lug Reamer

False Center

Bolt Face Truing Tooling

Boltway Reamer

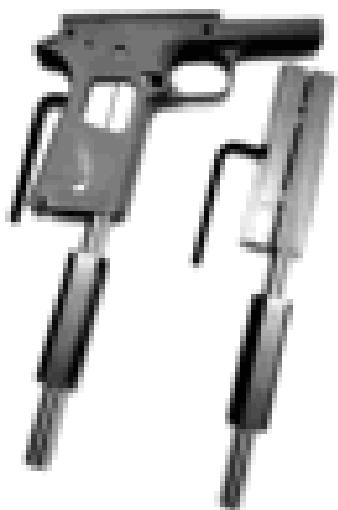
Tapered Bushings



1911 Tooling

Frame Jig

Allows positioning of a 1911 frame at any angle. - very useful to the custom pistol builder.



Price: \$150.00

45 ACP .906" Gauge w/ flag

Optimum length 45 ACP Headspace Gauge combined with maximum throat depth indicator.



Price: \$40.00

Reamer Stop

Handgun calibers only. Makes fast work of reaming consistent chamber depths.



Price: \$25.00

Government and Officer's Rivet Plate

Provides strong, rigid backup when riveting grip-frame bushings. Plate has spacing for both Government/Commander and Officer's models.,



Price: \$30.00

Muzzle Crown Refacing Tool Kit

Developed from auto racing technology, the Muzzle Crown Refacing Tools allow you to cut or re-cut a precision crown without removing the barreled action from the stock. A hand operation that's complete in less than five minutes, these tools will make money for you while restoring a gun's accuracy lost due to a damaged crown. The carbide inserts cut smoothly, last indefinitely, and are easily replaced if damaged.

Tool Kits

2 Pilots	Price: \$300.00
<i>With deburring/chamfering cutter</i>	Price: \$365.00
5 Pilots	Price: \$405.00
<i>With deburring/chamfering cutter</i>	Price: \$470.00
7 Pilots	Price: \$490.00
<i>With deburring/chamfering cutter</i>	Price: \$555.00
10 Pilots	Price: \$595.00
<i>With deburring/chamfering cutter</i>	Price: \$660.00

Crowning Cutters

17 Cal (0 or 11 degree)	Price: 95.00 each
20 Cal (0 or 11 degree)	



Available Pilots (18)

22 Cal	30 Cal	416 Cal
6 mm	8 mm	44 Cal
25 Cal	338 Cal	45 Pistol
6.5 mm	357/358	458 Cal
270 Cal	375 Cal	475 Cal
7 mm	40/10 mm	50 Cal

Our standard pilot assemblies cannot be used in 17 and 20 Cal barrels - the small bore diameters don't allow for sufficient rigidity in an expandable pilot design. If you wish to re-crown barrels in these bore sizes, special Crowning Cutters, with integral, solid pilots, must be used (see left).

Individual Component Prices

11 Degree Cutter	Price: 68.00
0 Degree Cutter	
45 O.D. Deburr/Chamfer Cutter	
Driver	

Standard Pilot Assembly	Price: \$45.00
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5/64" Hex Wrench	Price: \$6.00
1/8" Pilot Wrench	
1/8" Set Up Gauge	

Cleaning Brush	Price: \$2.50
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Case	Price: \$17.00
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Set of (3) Replacement Inserts	Price: \$30.00
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New: Add power drive adaptor to any manual muzzle crown kit	Price: \$30.00
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Military Rifle Muzzle Re-Crowning Tool Kit

Our Muzzle Crown Refacing Tool Kit has proven very popular in that a barrel may be precisely re-crowned by hand, without a lathe, or even having to remove the action from the stock. It's been a money-maker for the gunsmith who has a fair number of customers whose guns' accuracy have fallen off and could be restored by re-crowning.

Some not in the trade are understandably reluctant to purchase an expensive kit if they don't have many rifles that would benefit from this work. It's these shooters we were thinking of when we developed our "Military Rifle Re-Crowning Tool Kit".

It's a basic Kit, utilizing only those components absolutely necessary to re-crowning a damaged or worn muzzle - as is often seen on old military rifles. To reduce the cost of the Kit further, we designed a simplified Driver Adaptor that is driven by a low speed (less than 300 RPM) cordless drill motor, with a ball-end Hex Bit to ensure proper alignment.

Please note that all standard Muzzle Crown Kit components will work with the Military Kit. For example, if you want to crown other calibers, simply order the appropriate Pilot Assemblies. Likewise, if you wish to chamfer the outside of the barrel, request our De-burr/Chamfer Cutter. A listing, with pricing, of all Muzzle Crowning accessories appears below.

Price: \$130.00

The **Military Rifle Re-Crowning Tool Kit** is packed with instructions in a square telescoping storage tube, and includes the following:

- (1) Pilot Assembly - specify caliber
- (1) Muzzle Crowning Cutter - specify 0 or 11 degree
- (1) Driver Adaptor
- (1) Ball-End Hex Bit



Muzzle Crown Polishing Accessories

While most customers consider re-crowning complete after using our Muzzle Crown cutters, some have asked us to develop tooling that allows the crown to be polished without losing any of the precision of the cut crown. We've done this, and the various components of the kit appear below.

Polishing a crown requires that the same Pilot Assembly be used to guide the Polishing Bob as was used to pilot the Cutter to ensure the polished crown is concentric. The Bobs match the angles of the Cutters (0-degree and 11-degree). Their front surfaces are covered with self-adhesive felt discs that carry polishing abrasive. Bobs are driven by an Adaptor Body, which in turn is driven by a ball-end Hex Bit to be used in your cordless drill motor. Note: If you already have our Military Rifle Re-Crowning Kit, the Adaptor Body and Hex Bit are included, so you don't need to purchase these items to polish crowns.

Complete Polishing Kit, including (1) Polishing Bob (specify angle),
(1) Adaptor Body, (12) Felt Discs, (1) Ball-end Hex Bit

Price: \$50.00

Mini-Kit (above items, less Hex Bit and Adaptor Body)

Price: \$30.00

Replacement Felt Discs (12)

Price: \$6.00

Tooling for SAA Revolvers & Their Clones

For many years we've designed and made custom tooling for SAA 'smiths who needed it in their work. We refined the best ideas and now offer a "system" of gauges, guide bushings, reamers and a turning arbor that facilitates accurizing of SAA/Clones. Everything from gauging the frame and base pin hole location/diameter to line-reaming a new cylinder to achieve perfect timing is made much easier with these tools.

SAA Tooling - Individual Parts

Firing Pin Port Location Gauge

Price: \$48.00

Tapered Precision Frame Bushing
(Specify Thread spec)

Price: \$80.00

Set of (3)

Price: \$220.00

Piloted Base Pin Reamers
(Specify 1st, 2nd or 3rd OVERSIZE)

Price: \$40.00

Set of (3)

Price: \$112.00

Cylinder Line Reamers (.3905)

Price: \$48.00

Chambering Reamer (Combination Reamer)
(Specify Caliber -- 38-40, 44-40, 44 SPEC, 45 COLT,
475 LINEBAUGH, 500 LINEBAUGH)

Price: \$125.00

Set of any (4)

Price: \$440.00

Turning Arbor for Cylinder Bushings/Ejector Rod Housing

Price: \$80.00

New Tooling for Revolvers

It's always been difficult to work on the forcing cone/barrel extension of revolvers with the barrel in the frame. The frame window limits cutter length and it's hard to drive a cutter efficiently. Previous cutter designs utilized a drive shaft through the barrel that screwed into the cutter. This was fine as far as it went, but the shaft was used to guide the cutter--something it couldn't do well because of the distance to where cutting took place and the non-rigid threaded joint. While better-than-nothing, this design often allowed chatter and off-center cutting.

In designing our tools, we wanted to overcome the problems of previous designs and feel we have done so.

Our cutters are piloted on the shaft of the *cutter* itself, immediately adjacent to where cutting takes place. This gives the cutter the best possible support and ensures smooth cuts that are dead-concentric with the bore. Further, we offer a range of pilot bushing sizes for each bore diameter to allow the closest possible fit.

Cutters are driven by a T-handle that screws into the pilot section. They cut when turned in a clockwise direction as viewed from the muzzle. The T-handle is equipped with a spring-loaded centering collar, designed to provide feed pressure and keep the drive shaft from damaging the bore. Finally, we include a "Key" with each T-handle to assist in removing the cutter from the T-handle after use.

Three operations are usually performed on the barrel extension, within the frame window:

1. **Squaring Cutters** - Squaring and cutting-to-length to achieve proper barrel/cylinder gap. We offer 4 squaring cutters for this operation sized for specific frames: **#1 (.500) for J-frames; #2 (.560) K, L and Python Size; 3 (.650) N-frame, Blackhawk and similar; #4 (.700) Redhawk.**
2. **Forcing Cone Cutters** - Cutting the 11 degree forcing cone. We offer 2 forcing cone cutters for this operation. There is some size overlap, but generally; **#1 will be used on 32 through 41 caliber; #2 will be used on 44 through 510 caliber.**
3. **Chamfering Cutters** - Chamfering the sharp corner between forcing cone and the end of the barrel. We offer 2 chamfering cutters for this operation. Again, there is some overlap, but:
#1 will be used on 32 through 41 caliber; #2 will be used on 44 through 510 caliber.

Revolver Tooling

Cutters (each)	Price: \$48.00
Pilots (interchangeable between all Cutters)	Price: \$12.00
T-Handle including "Key" (used with all Cutters)	Price: \$24.00
Additional Keys	Price: \$4.00

Please note, we don't make
forcing cone gauges.

Please order from Brownells.

Shotgun Tooling

Screw-In Choke Tooling



	Price:
12 ga. WinChoke Reamer	\$140.00
12 ga. Win/RemChoke Tap	\$150.00
12 ga. RemChoke Reamer (uses 12 ga. Win/RemChoke Tap)	\$160.00
20 ga WinChoke Reamer	\$140.00
20 ga WinChoke Tap	\$150.00
12 or 20 ga TruChoke Reamer	\$140.00
12 or 20 ga TruChoke Tap	\$190.00
12 ga Thinwall Reamer	\$140.00
12 ga Thinwall Tap	\$190.00

Chambering Reamers

(Spiral Fluted, less 1" Pilot Bushing)

Available in:

12 ga. x 2 3/4"

12 ga. x 3"

16 ga. x 2 3/4"

20 ga. x 2 3/4"

20 ga. x 3"

410 ga. x 3"

Price: \$120.00



Long Forcing Cone Reamers



Left-hand Spiral, right-hand cutting; use with a standard tap handle.
NOT FOR USE IN CHROME-PLATED BARRELS.

12, 16, 20, 28 or 410

Price: \$92.00

10 ga.

Price: \$100.00

Shotgun Tooling

Shotgun Pilot Bushings

Std. Sizes 1" or 2" long-- bronze
12 ga.: .725", .726", .727", .728", .729"
16 ga.: .665", .666", .667", .668", .669"
20 ga.: .610", .611", .612", .613", .614"
410 ga.: .409", .410", .411", .412", .413"

Finished Standard Bushings

Price: \$14.00

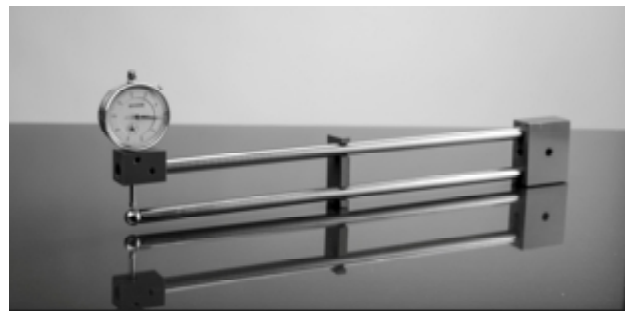
Bushing Blanks (finished I.D.)

Price: \$8.00

Barrel Wall Thickness Gauge

Measures thickness to .001"
in 10 ga through 20 ga
barrels

Price: \$100.00



Shotgun Bore Reamers (standard sizes)



12 ga. sizes: .725", .730", .735", .740", .745"

Uses large 34" extension

20 ga. sizes: .605", .610", .615", .620", .625"

Uses medium 34" extension

Other sizes on Special Order.

34" Drive Extension (for above reamers)

Price: \$80.00

Price: \$30.00

Shotgun Muzzle Facing Cutter (#5 in photo)

(less 2" Bronze Pilot Bushings)

This new *hand* tool utilizes replaceable carbide inserts to square muzzles of 10 through 20 ga. Shotgun barrels quickly and smoothly. Available with 0 degree cutter for squaring muzzles or 11 degree cutter for I.D. chamfering. Use 2"- long shotgun pilot bushings.

Set of (3) Replacement Carbide Inserts

Price: \$90.00

Price: \$30.00

1. Headspace Gauges
2. Chambering Reamer with Pilot Bushing
3. Bore Reamer
4. Long Forcing Cone Reamer
5. Shotgun Muzzle Facing Cutter
6. Screw-In Choke Reamer with Bushing
7. Screw-In Choke Tap with Bushing



Cartridge Comparator

This tool was designed to make life easier for the advanced shooter and re-loader by allowing precise measurement of ammunition, case, and chamber headspace. With this information, the shooter/re-loader will be able to fine-tune clearances and fits between his ammunition and chamber, with resultant improvements in accuracy and case life.

The primary functions of the Comparator are:

- 1 - Measure headspace of factory or reloaded ammunition
- 2 - Quantify chamber headspace by measuring headspace of a fired case
- 3 - Ensure minimal shoulder set-back when setting up re-loading dies

In addition to the Dial Indicator and Stand, the Comparator is supplied with Datum Blocks of precise inside diameter and length. These are used in conjunction with the supplied chart - "Cartridge List" - to determine actual headspace of factory or reloaded rounds, as well as fired cases.

By measuring headspace of a fired case, the shooter can come very close to knowing the headspace of the chamber in which the round was fired. This information can be useful if he has several rifles in the same caliber and wants to know if the same re-loads may be used in all of them, or if one has significantly different headspace than the others and should use re-loads made with a different die setting.

Finally, reloaded cases last longer and locate more consistently within the chamber with minimal resizing—you don't want to push the shoulder back more than necessary for proper chambering. This is also true of rimmed and belted cases and the Cartridge Comparator provides a means of setting your dies to achieve minimal re-sizing.

Price: \$125.00

Includes: Cartridge Comparator, Datum Blocks (1", 3300"/.3750", .4000"/.4375"), Dial Indicator and Instructions with Headspace Table.

Ogive Insert Adaptor (fits Hornady and Sinclair)	Price: \$15.00
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Safety Barrels for Glock Pistols

Glock semi-auto pistols have a reputation for reliability and performance. As such, they have become the duty weapon for many police departments and governmental agencies. Civilians also own Glocks in record numbers for self-defense and competition.

As with all firearms, it is the owner's responsibility to insure it's handled safely and is not misused if discovered by those not competent in its use. Responsible gun owners also practice to maintain skill with their weapon - this can be a safety issue as well.

Manson Precision Reamers offers a selection of Safety Barrels for Glock pistols that helps solve these problems. By replacing the stock barrel with the appropriate Safety Barrel, the weapon is made absolutely safe and unable to chamber a round. Further, your weapon fitted with a Safety Barrel will fit your standard holster and can be used to practice the draw stroke, re-holstering, etc. Since external dimensions of the Safety Barrel are similar to the original, the slide may be cycled and the weapon dry-fired normally.

Safety Barrels are made from aluminum and anodized bright red. The muzzle protrudes slightly from the slide and is therefore easily visible from both sides of the weapon. That your weapon is SAFE is also evident by the red Barrel showing in the ejection port.

Safety Barrels are available for the following Glock pistols. *Quantity purchases are eligible for discounts.*

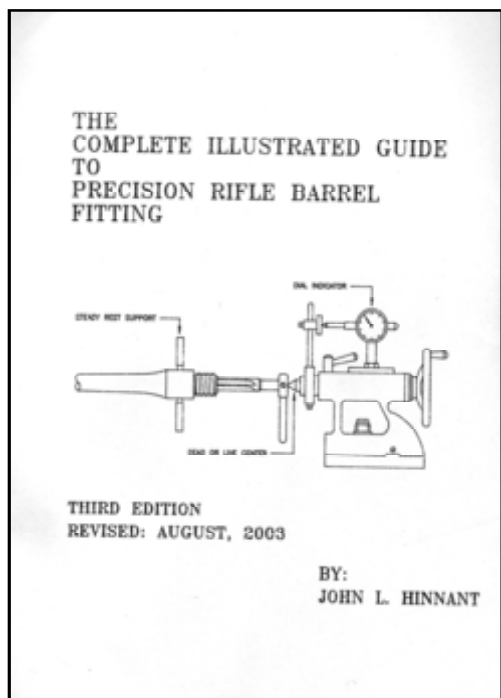
Stock #	Fits These Guns	Price: \$20.00 each
GSI-1	G-22, G-31	
GSI-2	G-17, G-22, G-31	
GSI-3	G-23	
GSI-4	G-19	
GSI-5	G-20, G-21	



Please call for additional information on this product.

The Complete Illustrated Guide to Precision Rifle Barrel Fitting

By John Hinnant



It's unusual for us to offer for sale - and by doing so recommend - a specific gunsmithing text. There are many well-written books available to those who wish to take up "the art of the spiral tube" and each has something to recommend it. None, however, in our experience, offers such a wide range of information on basic and advanced riflesmithing techniques, toolmaking and materials as does John Hinnant's book on the subject. He covers virtually every aspect of barrel fitting on bolt action rifles. From turning and threading the shank, chambering and crowning, his book is a wealth of information. A new section of his book describes several methods of "blueprinting" actions and the relative merits of each.

Gunsmiths need a number of special tools in their work. Mr. Hinnant describes in detail how to make many of these tools and fixtures and provides detailed material lists for the reader. Heat treating/hardening

methods are described in practical ways that will allow the reader to achieve good results. All in all, it's a text that could be used to teach any number of classes on the subject.

I've been fortunate to know John for many years and it's no surprise that his book is so effective. He has, after all, just retired from a lifetime of riflesmithing, machining and teaching industrial arts. Growing up in Texas (west of the Pecos) in the '40s and '50s, John had an early interest in firearms and machining processes. These interests remained throughout his life as he taught both to students lucky enough to be enrolled in one of his classes.

Life in Texas during those times was not easy and one learned ways of doing things that got the job done efficiently and economically. The practical aspect of John's teaching is readily apparent throughout his book - nothing is done without a reason.

Take a look at what he's written - I'm confident you'll come to rely on it more and more in your riflesmithing work.

Dave Manson

Price: \$35.00

Headspace Gauge Interchangeability Chart

Please Note: If the caliber is not listed, it has its own unique gauge.

GAUGES	USED WITH
BELTED	.535" BASED CALIBERS
BR	22 BR, 6MM BR, 7MM BR, 30 BR
PPC	22 PPC, 6MM PPC
TCU	6MM TCU, 257 TCU, 6.5 TCU, 7MM TCU
17 M2	17 HS/AGUILA
22 LR	22 BENTZ, 22 LONG, 22 MATCH, 22 SHORT
22 HORNET	HORNET BASED WILDCATS
22 WRFM	17 HMR
222 REM MAG	6X47
223 REM	6X45
223 WSSM	243 WSSM (DO NOT USE WITH 25 WSSM)
25-20 WIN	218 BEE, 218 MASHBURN BEE, 32-20 WCF
26 NOSLER	28 NOSLER
7X57	257 ROBERTS
284 WIN	22-284, 6MM-284, 25-284, 6.5-284, 270-284, 30-284, 338-284, 35-284
308 WIN	243 WIN, 260 REM, 7MM-08, 308 MATCH, 338 FEDERAL, 358 WIN
30-06 SPR.	25-06, 6.5-06, 270 WIN, 8MM-06, 338-06, 35 WHELEN
30 REM	32 REM
300 RSAUM	7MM RSAUM (REM SHORT ACTION ULTRA MAG)
300 RUM	7MM RUM, 358 RUM, 375 RUM, 458 RUM (REM ULTRA MAG) (DO NOT USE WITH 338 RUM)
300 WSM	270 WSM, 325 WSM, 338 WSM (WIN SHORT MAG) (DO NOT USE WITH 7MM WSM)
30-30 WCF	219 ZIPPER, 219 ZIPPER IMP., 219 DON-WASP, 25-35 WCF, 7-30 WATERS, 7MM INT'L, 30-30 BASED WILD-CATS, 300 HERRETT, 303 SAVAGE, 307 WIN, 32-40 WCF, 32 WIN, 357 HERRETT, 38-55 WCF
30-40 Krag	303 BRITISH, 40-70 STRAIGHT
32 H&R	32 S&W LONG, 327 FEDERAL
357 MAG	256 WIN MAG, 357 MAX, 38 SPECIAL
416 RIGBY	450 RIGBY
44 MAG	445 SUPER MAG, 44 SPECIAL
44-40 WCF	38-40 WCF
45-70 GOVT.	33 WIN, 348 WIN, 40-65 WCF, 40-82 WIN, 45 BASIC (45-120 3-1/4"), 45-90, 45-110, 450 ALASKAN, 50-70 GOVT., 50-90 2-1/2", 50-110 WCF, 50-140 3-1/4"
45 COLT	454 CASULL, 460 S&W
378-460 WBY	30-378 WBY, 338-378 WBY, 378 WBY, 416 WBY, 460 WBY

Dave Manson, President



**Red Stag taken with Ultra Light Arms model 20
chambered in 284 Winchester with Manson reamer.**



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