

DRILL AND TAP FIXTURE



Drilling and tapping a surplus military action to accept scope bases has never been easier. This handy, inexpensive fixture kit contains everything you need, except for an electric drill. Simply remove the barrel from the action, install the Drill and Tap Fixture, then drill and tap perfectly spaced and perpendicular holes in the top of the receiver. Kit includes one #31 drill, one #1 bushing, one 6-48 tap and one #3 bushing. Works for Mauser 93, 94, 95, 96, 98, Enfield P-14 & 1917, Springfield 03 & 03-A3, Japanese 38s & 99s. If you prefer to drill and tap 8-40 holes, also order the #28 drill, 8-40 tap and a #4 bushing.

Product #407-518

Bushing #	Prod. Number	Fits Drill	Fits Tap
1	# 190-864	# 31	--
3	# 148-395	# 28	6-40 & 6-48
4	# 175-641		8-40

Tap		Drill Bit	
Thread	Prod. #	Drill Bit	Prod. #
6-48	# 563-994	# 31	# 548-455
8-40	# 220-733	# 28	# 188-453

FRONT SIGHT INSTALLATION AND REMOVAL TOOL

This tool is designed for adjusting or removing any ramp-type front sight. It cannot be used to adjust sights that are dovetailed directly into the barrel of any firearm. Ramp-type front sights can be adjusted, installed or completely removed with ease and without fear of a slipped punch or errant hammer strike marring the sight or barrel, or loosening the ramp. The screw action of the tool allows for precise adjustment of the sight by providing constant, even force. The Front Sight Installation and Removal Tool is hand held and easily portable. The thread block is constructed of aluminum for reduced weight. The adjuster and handle are made of steel for durability.



Product #735-470

SCOPE RING ALIGNMENT AND LAPPING KIT



Aligning and lapping new rings, when a scope is installed, should be standard practice on any quality firearm. The alignment bars in this kit allow for perfect alignment of both rings and will also diagnose any misalignment problem, vertical or horizontal. The lapping bar is used to lap the rings to improve alignment, reduce stress on the scope and improve the grip of the rings on the scope. Lapping the rings can also minimize or prevent ring marring of the scope. Kit includes: Two alignment bars, lapping bar, lapping bar handle, 220 grit lapping compound and complete instructions.

Description.....	Product #
Scope Ring Alignment and Lapping Kit - 1" Rings.....	204-061
Scope Ring Alignment and Lapping Kit - 30mm Rings	633-266
Lapping Compound Kit (1 each 220, 320, and 600 grit compound)	342-303

BORE LAPPING KIT

Lap your barrels to make them shoot better and easier to clean. Lapping polishes out the tool marks left in rifle barrels during the manufacturing process. Traditional hand-lapping is very labor intensive and requires pushing lead slugs down the bore by hand. The Wheeler kit allows you to embed lead or jacketed bullets with abrasive. Lapping is as easy as roll, load, and shoot. Whether you have an old .22 rimfire with a less-than-pristine bore or a neglected hunting rifle that needs some TLC, you can clean up all but the very roughest bores with a Lapping Kit. The resulting gains in appearance and accuracy will surprise you. The kit consists of three jars of high quality abrasive pastes, two steel plates to embed the abrasive into your bullets, and complete instructions.



Description.....	Product #
Bore Lapping Kit	299-849
220 Grit Lapping Compound - 1 ounce jar	885-040
320 Grit Lapping Compound - 1 ounce jar	378-413
600 Grit Lapping Compound - 1 ounce jar	395-155
Lapping Compound Kit (1 each 220, 320, and 600 grit compound)	342-303

Wheeler™ Engineering Fine Gunsmithing Supplies

HEAVY DUTY VINYL GLOVES

These heavy-duty 10" green vinyl gloves will last through several applications of rust and blue remover, or any job where skin protection is recommended. Keep your hands free of cutting oil, lubes, preservatives, or any product that may cause skin irritation. Available in two sizes, medium and large. (See sizing chart on page 31.)



Description.....	Quantity.....	Product #
Medium.....	6 pair.....	188-399
Large.....	6 pair.....	590-420

LIQUID APPLICATOR BRUSH

These 100% natural horsehair brushes are the perfect tools for application of small amounts of lubes, solvents, Heat Control Paste, blue and rust remover, fluxes, and other liquid products in the shop. Each brush features a Ω" wide head, bright metal handle, and is 6" in overall length. Available in quantities of 2 and 12.



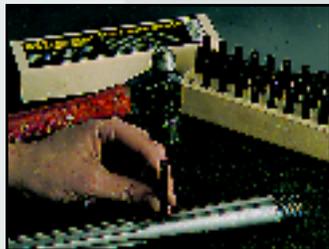
Description.....	Quantity.....	Product #
Liquid Applicator Brushes.....	2.....	325-640
Liquid Applicator Brushes.....	12.....	836-940

ACTION WRENCHES AND BARREL VISE

Heavy-duty tools to deliver the strength and rigidity required for proper barrel removal and installation. The Action Wrench safely surrounds and supports the receiver ring to prevent damage to your action. It features a 15" long handle made from 1" diameter steel to overcome even the tightest assemblies. The Savage® Barrel Nut Wrench is double-ended to fit both early and late model barrel nuts on the Savage 110 and 10 series rifles. It also features two 1/2" square drive holes for use with a swing bar or torque wrench. The Barrel Vise provides plenty of holding force to securely clamp your barrel for removal or installation. The Vise includes two pre-drilled oak block sets, 1" and 3/4", and a solid oak block for custom drilling.



Description.....	Product #
Action Wrench #1 (Mausers with Flat-Bottomed Receivers).....	808-771
Action Wrench #2 (Remington 700®).....	414-521
Savage Barrel Nut Wrench.....	123-038
Barrel Vise with 3 Oak Bushings.....	465-185
Set of 3 Replacement Oak Bushings.....	844-879
Lead Barrel Vise Shims.....	239-444



LETTER AND NUMBER STAMP SET

The Wheeler Engineering Letter and Number Stamp Set is especially useful for marking caliber designations on barrels, but you'll find yourself marking tools, keys, and other metal items with these 1/16" high stamps.

Product #194-679

AR-15 HAMMER DROP BLOCK

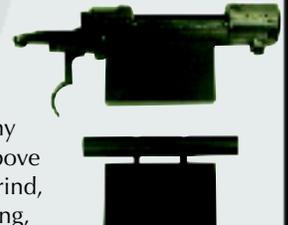
Install or rework the trigger or safety on the AR-15 and test your work without fear of damage to either the hammer or the lower receiver. The durable polymer block fits into the magazine well and blocks forward travel of the hammer, allowing dry firing plus observation of the function of the disconnecter.



Product #703-051

RECEIVER SHAPING AND POLISHING FIXTURE

This fixture will hold your Mauser or any other flat-bottomed receiver in place above the jaws of the vise so you can weld, grind, drawfile, or polish easily without bending, crushing, or marring the receiver.



Product #607-654

WheelerTM Engineering Fine Gunsmithing Supplies

PIPETTESTM

All-plastic, disposable "eye droppers" are just the ticket for measuring and transferring liquid products. Suitable for home bluing solutions, cutting oils, solvents, preservatives, etc. Two lengths, 3-1/2" and 6", to match the job at hand. Put the product just where you want it. Available in quantities of 2 and 12.



Description.....	Quantity.....	Product #
Shop Pipettes, 3-1/2".....	2.....	698-691
Shop Pipettes, 3-1/2".....	12.....	210-523
Shop Pipettes, 6".....	2.....	500-383
Shop Pipettes, 6".....	12.....	879-889

SHOP SWABS

Dozens of uses in the shop. Flood cutting oils, lubes, and preservatives onto metal components, patches, or other surfaces. Long-lasting, durable daubers with steel looped shank hold product with no drips. Available in packs of 50 and 100.



Description.....	Quantity.....	Product #
Shop Swabs.....	50.....	644-083
Shop Swabs.....	100.....	356-830

BOLT WELDING FIXTURE AND HEAT SINKS

Welding a new bolt handle on a military rifle has historically been a frustrating and time consuming part of the sporterizing process - especially for the amateur gunsmith. The Wheeler Engineering fixture is a simple, inexpensive way to make this job easier. Simply lock the bolt handle into alignment, then concentrate on welding. A bolt heat sink is a necessity any time you weld or forge the handle on a bolt. The heat sink is a 6" long aluminum rod that threads into the rear of the bolt, in place of the striker assembly during the welding or forging operation. The heat sink conducts heat away from the steel, protecting the locking lugs and cocking cam.



Description.....	Product #
Bolt Welding Fixture.....	872-125
Heat Sink for Mausers.....	667-507
Heat Sink for Springfield 03 and 03-A3.....	856-915

BOLT HANDLE FORGING BLOCKS

Now there's an easier way to get a Mauser's bolt handle to clear a scope. Fixture your bolt in these blocks and heat the stem with an Oxy-acetylene torch. Forge and sweep back as necessary, then file and polish to suit the job. We recommend using Wheeler Heat Control Paste and Heat Sinks (purchased separately) when forging bolt handles.



Product #473-720

HEAT CONTROL PASTE



Wheeler Heat Control Paste actually blocks the heat that's generated during welding. It's especially useful when welding on new bolt handles. 16 oz jar.

Product #.....628-225

REPLACEMENT BOLT HANDLE

The Wheeler Replacement Bolt Handle is machined from high-nickel alloy bar stock that welds, polishes, and blues easily to match the rest of your gun.



Description.....	Quantity.....	Product #
Replacement Bolt Handle.....	1.....	182-970
Replacement Bolt Handle.....	6.....	855-383

RECEIVER LUG RACEWAY POLISHING TOOL

A Receiver Lug Raceway Polishing Tool is the fastest, easiest way to achieve glass-smooth bolt travel. Wrap a piece of fine grit sandpaper around the split end, secure with the set screw, and slide the polishing tool back and forth in the bolt raceway in the receiver to get a glass-smooth feel in your action. It works for most popular bolt action rifles.



Product #620-017

RECEIVER FACE TRUING MANDREL

One of the important variables in accuracy is the squareness (or relationship) of the face of the receiver to the barrel shoulder. Factories hold this to typical manufacturing tolerances, which you can almost always improve upon. Installing this tool in the barrel threads (in place of the barrel), then holding it securely in the headstock and tailstock of the lathe allows for a light cut across the face of the receiver that will provide for a perfect mating of the barrel shoulder to the receiver face.



Description.....	Product #
Mauser 98 Large Ring.....	736-059
Mauser 93, 94, 95, 96 Small Ring.....	125-866
Remington 700®.....	601-783

BOLT FACE LAPPING TOOL

To obtain the utmost in bolt-action rifle accuracy, the bolt face should be perpendicular to the centerline of the action. Typically bolts are manufactured independently of receivers (sometimes even in different plants), and are installed without regard to actual squareness. Because attention is usually not given to the relative squareness of the bolt face to the centerline of the receiver, squaring the bolt face gives us another opportunity to potentially improve the accuracy of the rifle. To use this tool, simply screw it into the receiver threads, apply polishing compound to the face of the mandrel and use a 3/8" electric drill to turn the mandrel and polish the bolt face square to the centerline of the bore. Lapping compound not included, order separately below.



Description.....	Product #
Mauser 98 Large Ring	214-558
Mauser 93, 94, 95, 96 Small Ring.....	548-543
Remington 700®	146-975
Savage 110, 112®	155-509
Lapping Compound Kit (1 each 220, 320, and 600 grit compound)	342-303

BOLT LUG LAPPING TOOL

The bolt locking lugs cam and lock into the corresponding lug recesses in the receiver as the bolt is closed. For the smoothest operation of the bolt and utmost accuracy, both lugs should be smooth and in full contact with the corresponding lug recesses. In factory production rifles and in surplus military rifles, this is the exception, rather than the rule. Before final headspacing, simply thread this tool into the receiver threads, apply lapping compound to the bolt lugs, then open and close the bolt to lap the lugs smooth and into perfect contact with the lug recesses. Lapping compound not included, order separately below.



Description.....	Product #
Mauser 98 Large Ring	172-500
Remington 700®	166-702
Lapping Compound Kit (1 each 220, 320, 600 grit compound)	342-303

MAUSER RAIL MILLING FIXTURE

When converting a Large Ring Mauser 98 to one of the Magnum calibers, it is usually necessary to open up the feed rails of the receiver to ensure reliable feeding. This simple fixture clamps easily in a milling vise and securely holds the stripped receiver for convenient milling of the feed rails.



Product #	546-636
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8 OZ BRASS HAMMER

Perform delicate work without jeopardizing the finish on even your most prized rifles. Features a non-marring brass head and a hardwood handle. A must for any gunsmith, from beginner to veteran.

Product #	358-496
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RECEIVER THREAD TAP

Installing a new barrel can be a lot easier if you "chase" the barrel threads in the receiver first. This is especially true on Mauser rifles, because we use a 12 threads per inch, 60-degree tap, which is consistent with most aftermarket Mauser barrels. If you have drilled and tapped with the barrel off, this tap will conveniently remove the burrs in the bottom of the threads.

Description.....	Product #
Mauser 98 Large Ring	392-792
Mauser 93, 94, 95, 96 Small Ring.....	303-631
Remington 700®	274-113
Savage 110, 112®	621-516

UNIVERSAL BENCH BLOCK

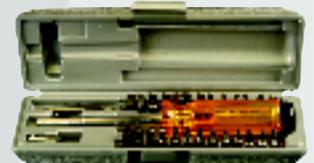
When you need to install a pin, detent, or spring, or do many other jobs, the Universal Bench Block becomes your best friend. It features a variety of notches, grooves, and holes on both sides and is ideally suited for M1911-style pistols. Non-marring urethane for long use.



Product #.....	672-215
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SPACE SAVER GUNSMITHING SCREWDRIVER SET

Less than half the size of comparable gunsmithing screwdriver sets! The Wheeler Space Saver Gunsmithing Screwdriver Set takes up very little space on your bench, but contains a durable and comprehensive set of 26 bits chosen to meet most of your gunsmithing needs. It's also the perfect size to include on your trips to the range and the field. Included with the standard, Phillips, hex, and torx bits, is a 2" long #2 Phillips bit which is ideal for recoil pad installation, and a hex-to-square conversion bit which allows you to use 1/4" square drive sockets and other attachments. The magnetic handle is perfectly sized for gunsmithing needs, and is also hollow-handled, allowing you to carry a variety of bits should the need arise.



Product #.....	664-507
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