



**SUGGESTED TOOLS FOR ASSEMBLY**  
 Wood Rasp or Coarse File  
 Fine-toothed File 6-8" in Length  
 Emery Paper—Medium 180 Grit, Fine  
 240 Grit and Very Fine 400 Grit  
 Fine-toothed 3-Corner File  
 Screwdrivers, Various Sizes  
 Small Hammer  
 Small Pin Punch (Nail Set will do)  
 Brass Polish

**ACE WITH RAMROD ASSEMBLY PARTS LIST**

1. Receiver	5. Ramrod	9. Hammer Spring Retainer	13. Trigger Spring
2. Barrel	6. Nipple	10. Hammer Spring	14. Trigger Guard
3. Front Ramrod Mount	7. Hammer	11. Trigger	15. Trigger Guard Screw
4. Rear Ramrod Mount	8. Hammer Pin	12. Trigger Pin	16. Grip
			17. Grip Screw

*BUILDING A MUZZLELOADING GUN HAS PROVEN TO BE AN EXTREMELY POPULAR AND FASCINATING PASTIME. THE BASIC ELEMENTS ARE HERE TO COMPLETE A TRULY FINE DISPLAY OR SHOOTING PIECE AND WITH MOST OF THE DIFFICULT WORK DONE THIS KIT CAN BE ASSEMBLED BY THE REASONABLY ADEPT DO-IT-YOURSELFER WITH JUST THE TOOLS IN HIS WORKSHOP.*

Unpack contents of the kit and inspect parts using exploded view drawing and assembly parts list. It is suggested that the reader read through the instructions before starting in order to become familiar with the assembly. At this time remove any unnecessary burrs from the parts and polish to your liking.

**A. Grip-16** Using *Grip Screw-17*, attach unfinished grip to *Receiver-1* and carefully scribe a ring on the grip around the receiver. Remove grip screw and grip. Use a sanding belt, file or sandpaper attached to a block, and shape the front of the grip to match the contours of the receiver. Remove all extra wood until the grip has the contours of the grip in the drawing. Assemble grip to receiver to be sure the fit is proper. Again remove and finish WITH the grain of the wood until a very smooth surface is obtained. You are now ready to apply a finish of your choice. Put grip aside to dry and proceed to complete the rest.

**B. Hammer-7** Note! Necessary parts have been precision heat treated for your convenience. DO NOT ALTER the grooves and machined surfaces at the bottom of the hammer.

**C. Trigger-11** DO NOT FILE OR ALTER in

any way the part of the trigger that will come in contact with the *Hammer*.

**D. Hammer & Trigger Polishing** Polish the trigger and hammer, and if a high bright polish is preferred, buff the finger surface of the trigger and all of the top of the hammer using a cloth buffing wheel and buffing compound.

**E. Rear Ramrod Mount-4** Assemble ramrod mount into the dovetail slot at the rear of the barrel. *Front Ramrod Mount-3* should then be assembled into dovetail slot at the front of the barrel. It may be necessary to file a small lead on the ramrod mount dovetails so they will start into the barrel dovetail slots more readily.

**Final Assembly of the Ace** to follow after all finishing coats have been applied to grip and the grip is dry.

**F. Assemble Nipple-6** by screwing into receiver.

**G. Slip Hammer Spring-10** over the *Hammer Spring Retainer-9*. Insert the pointed end of the spring retainer into angled hole in the lower inside of receiver. Hold this assembly in place with

and force hammer against the spring until the hole in the hammer lines up with the hole in the receiver, at which time *Hammer Pivot Pin-8* must be inserted into the left side of receiver. Once again, taper end of pivot pin must be inserted into receiver first. Pivot pin will have to be tapped into place with a punch, being careful not to scratch the receiver. Do not let hammer fall onto the nipple without a percussion cap.

**H. Assemble Trigger-11** into receiver, inserting *Trigger Pivot Pin-12* from the left side of the receiver as shown on diagram. Look at pivot pin carefully. One end is has a slight taper to allow it to assemble easily. Tap pivot pin through trigger into right hand side of receiver.

**I. Assemble Trigger Spring-13** into blind hole inside trigger guard. Assemble *Trigger Guard-14* into receiver using *Trigger Guard Screw-15*. Screw barrel into place.

**L. Assemble grip** to receiver with grip screw. Your Ace is now complete! We suggest wiping off all finger prints and applying a light coat of oil to prevent rusting. If going to be fired a drop of oil on the trigger and hammer pivot pins and the end of the spring retainer.

## KIT PARTS LIST

Part#	Description
AKS2	Barrel Smoothbore
AK3	Front Ramrod Mount
AK4	Rear Ramrod Mount
AK5	Ramrod
AK6	Nipple
AK7	Hammer
AK8	Hammer Pin
AK9	Hammer Spring Retainer
AK10	Hammer Spring
AK11	Trigger
AK12	Trigger Pin
AK13	Trigger Spring
AK14	Trigger Guard
AK15	Trigger Guard Screw
AK16	Grip
AK17	Grip Screw
APPS2	Barrel Smoothbore
AP3	Front Ramrod Mount
AP4	Rear Ramrod Mount
AP5	Ramrod
AP7	Hammer
AP8	Hammer Pin
AP11	Trigger
AP14	Trigger Guard
AP16	Grip

Polished parts are generally ordered for finished guns, but may be ordered by kit builders if they so desire. Each part is polished for assembly into a finished product.

## New Orleans Ace-Firing Instructions

- 1) WILL NOT FIRE CARTRIDGE BULLETS. DO NOT USE SMOKELESS POWDER OR ANY COMBINATION THEREOF. FIRES BLACK POWDER ONLY.
- 2) **NOTE:** Follow safety procedures at all times when loading and firing any firearm, shooting glasses also recommended.
- 3) Use No. 11 percussion cap over nipple to ignite powder, 18 grains grade FFG black powder only into barrel, with recommended solid lead ball sizes and patches:

### Smoothbore

.440 Round Ball/.015 patch

- 4) Place oiled patch around ball and holding ramrod between fingers (not in palm of hand), tamp ball down barrel. Firm pressure necessary when starting ball into barrel - ball starter may be used to start ball.

**TAMP BALL DOWN BARREL FIRMLY SEATING IT AGAINST POWDER. DO NOT LEAVE AIR SPACE BETWEEN BALL AND POWDER. DANGEROUS COMBUSTION MAY RESULT.**

- 5) Place percussion cap over nipple, aim, and fire. To maintain and preserve your firing piece, and prevent corrosion and fouling from black powder residue, thoroughly clean with suitable cleaning solvents after each use. Hoppes 9+ or similar lubricant may be used for oiling patches as well as later cleaning your firearm.

## CAUTION

**NEVER FIRE A MUZZLELOADING FIREARM UNLESS THE BALL IS FIRMLY SEATED AGAINST THE POWDER CHARGE**

Do not overload the bbl with excessive amounts of black powder. The best velocity creating the lowest, safest pressures will be obtained using recommended charges of black powder. Increasing the pressures in the barrel will not increase accuracy. Unreasonably heavy charges of black powder can be dangerous.

Do not attempt to shoot a stuck ball free from the barrel. If due to powder fouling or other circumstances, the projectile becomes lodged part way down the barrel then the firearm must be disassembled and the charge and ball removed. This is extremely important for, under such a condition, the stuck ball is acting as a bore obstruction. Firing will cause damage to the firearm and possible injury to the shooter.