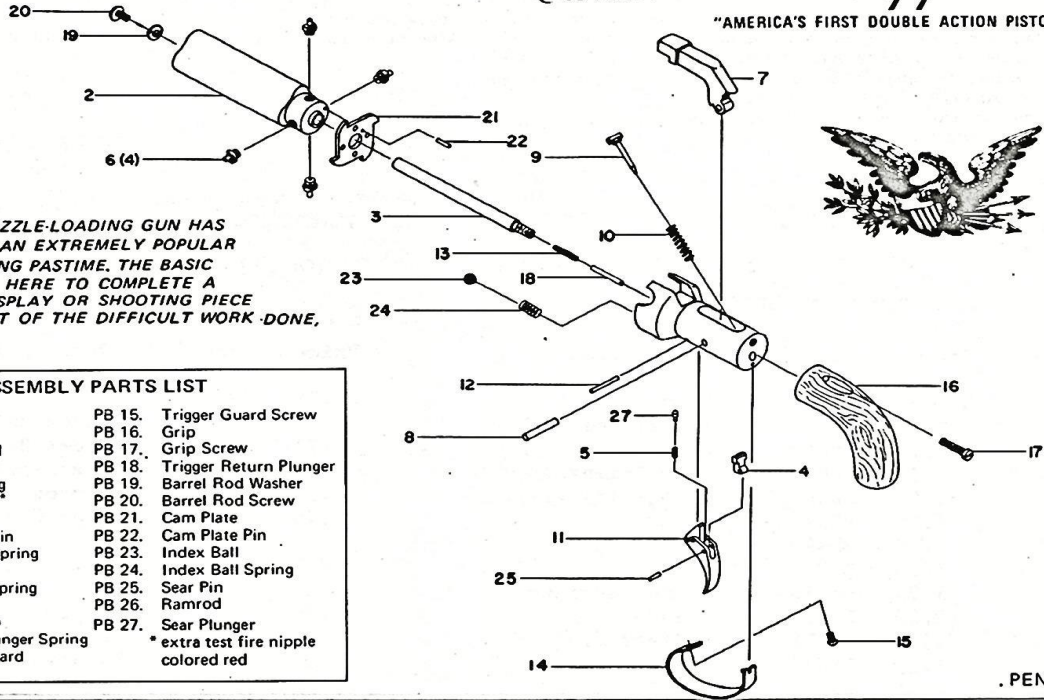


Ethan Allen Peppertox

"AMERICA'S FIRST DOUBLE ACTION PISTOL"



BUILDING A MUZZLE-LOADING 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.

ASSEMBLY PARTS LIST

PB 1. Receiver	PB 15. Trigger Guard Screw
PB 2. Barrel	PB 16. Grip
PB 3. Barrel Rod	PB 17. Grip Screw
PB 4. Sear	PB 18. Trigger Return Plunger
PB 5. Sear Spring	PB 19. Barrel Rod Washer
PB 6. Nipple (5) *	PB 20. Barrel Rod Screw
PB 7. Hammer	PB 21. Cam Plate
PB 8. Hammer Pin	PB 22. Cam Plate Pin
PB 9. Hammer Spring Retainer	PB 23. Index Ball
PB 10. Hammer Spring	PB 24. Index Ball Spring
PB 11. Trigger	PB 25. Sear Pin
PB 12. Trigger Pin	PB 26. Ramrod
PB 13. Trigger Plunger Spring	PB 27. Sear Plunger
PB 14. Trigger Guard	* extra test fire nipple colored red

. PEND.

KIT PART LIST

Part #	Description
PBK2	Barrel
PBK3	Barrel Rod
PBK4	Sear
PBK5	Sear Spring
PBK6	Nipple (5)
PBK7	Hammer
PBK8	Hammer Pin
PBK9	Hammer Spring Retainer
PBK10	Hammer Spring
PBK11	Trigger
PBK12	Trigger Pin
PBK13	Trigger Plunger Spring

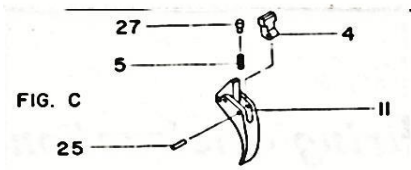
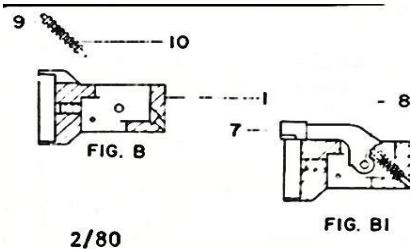
KIT PART LIST (CONT.)

Part #	Description
PBK14	Trigger Guard
PBK15	Trigger Guard Screw
PBK16	Grip
PBK17	Grip Screw
PBK18	Trigger Retainer Plunger
PBK20	Barrel Rod Screw
PBK21	Cam Plate
PBK22	Cam Plate Pin
PBK23	Index Ball
PBK24	Index Ball Spring
PBK25	Sear Pin
PBK27	Sear Plunger

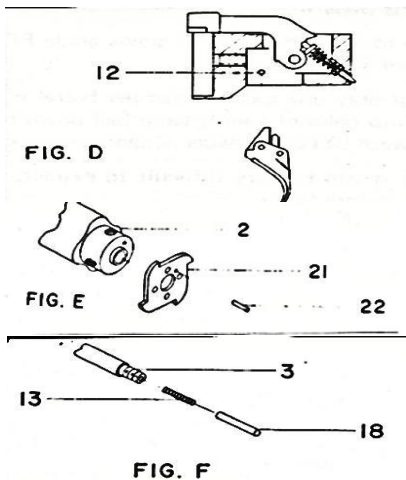
Unpack contents of the kit and inspect parts using exploded view drawing and assembly parts list. It is suggested that builder read through the instructions before starting in order to become familiar with the assembly. At this time, remove any unnecessary burrs from the parts and polish to your liking.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

A. Group together Grip-16, Grip Screw-17, Receiver-1 and attach Trigger Guard-14 as described in step H. Attach unfinished grip to receiver and carefully scribe a ring on the grip around the receiver. Remove grip and trigger guard. Using a sanding belt, file or sand paper attached to a block, 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 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 of the Pepperbox.

B. Assemble Hammer Spring Retainer-9 and Hammer Spring-10, insert this assembly pointed end down in the hole of the receiver(Fig. B)placing Hammer-7 into slot of receiver(Fig. B1), care must be taken so that radius cut on end of hammer fits end of hammer spring retainer. Push hammer down until hammer pin hole in receiver is in alignment with hole in hammer. Insert Hammer Pin-8 into hole and tap into position. Check for proper engagement of hammer spring retainer and radius cut of hammer.



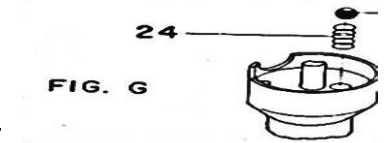
C. Insert Sear Plunger-27 into Sear Spring-5 and assemble into hole at bottom of Trigger-11(Fig. C). Place Sear-4 between ears of trigger, hold between thumb and forefinger to align holes of sear and trigger-hold assembly on flat surface, Sear Pin-25 is placed in hole on one side of trigger, tap pin down flush with side. Move sear back and forth to check for any binding, if binding occurs, disassemble unit and reassemble again until sear swings freely.



D. Insert trigger assembly into bottom slot of receiver(Fig. D). End of sear must engage groove in bottom of hammer. Align holes in trigger and receiver and tap Trigger Pin-12 into position.

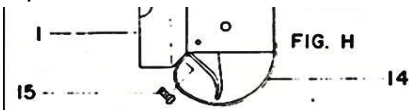
E. Place Cam Plate-21 on end of barrel with the four indents facing outward(Fig. E). Align small hole in cam plate with small hole in barrel end, insert Cam Plate Pin-22 and tap it flush. It may be necessary to file lightly the end of the pin flush. Assemble red test nipple and 3 standard nipples into barrel.

F. Assemble Trigger Plunger Spring-13 and Trigger Return Plunger-18 into Barrel Rod-3(Fig. F). Screw rod into center hole in receiver, tighten securely.



G. Insert Index Ball Spring-24 into hole in front of receiver(Fig. G), place Index Ball-23 on end of spring, slide barrel on barrel rod with cam plate facing receiver, hold barrel firmly against receiver. Cup upward, on end of barrel rod. Fasten barrel to rod with Barrel Rod Screw-20 and tighten securely. Barrel can now be turned by hand to check indexing.

H. Trigger Guard-14 may now be placed on the receiver with the tang inserted in the small hole at rear of receiver. Round head Trigger Guard Screw-15 fits thru guard and into bottom of receiver, tighten firmly(Fig. H).



I. Place finished grip on receiver and fasten with Grip Screw-17.

J. Place red test nipple under hammer, pull trigger to check the proper function of assembly. If any binding occurs, disassemble, check for hidden burrs, reassemble. Remove red test nipple and barrel and complete assembly by installing the one remaining standard nipple on barrel. AVOID DRY FIRING of hammer, as it will damage the nipples and cause misfiring.

K. The rotation of the barrel when pointed down range is counter clockwise. Use receiver slot for loading primer caps when barrel is rotated to a position aligning nipple with slot. After firing, barrel must be HAND ROTATED to next position as in the original.

L. Lightly oil all moving parts with a fine quality gun oil. When reasonable care is used during the assembling of this kit, the end result will produce a very striking replica of the old time Ethan Allen Pepperbox.

SUGGESTED TOOLS FOR ASSEMBLY

- Wood Rasp or Coarse File
- Fine Toothed File 6-8in In Length
- Emery Paper
- Screwdrivers, Various Sizes
- Small Hammer
- Small Pin Punch
- Brass Polish

Pepperbox Firing Instructions

- 1) WILL NOT FIRE CARTRIDGE BULLETS. DO NOT USE SMOKELESS POWDER.
- 2) NOTE: Follow safety procedures at all times, shooting glasses also recommended.
- 3) Use No. 11 percussion cap over nipple to ignite powder, 12 grains grade FFFG black powder only into each barrel, with 350cal. solid lead round ball and .015 oiled patch.
- 4) Load each barrel taking precaution that only one specific load per barrel is used, place oiled patch around ball and holding ramrod between fingers (not into palm of hand) tamp ball down barrel. **FIRMLY SEATING IT AGAINST POWDER. DO NOT** leave air space between ball and powder - dangerous combustion may result.
- 5) Do not put ball into unloaded barrel, it will be very difficult to extract. Make sure all excess powder is removed from around muzzle before firing.
- 6) To maintain and preserve your firing piece and prevent corrosion, thoroughly clean after each use.

CAUTION

NEVER FIRE A MUZZLELOADING FIREARM UNLESS THE BALL OR MINIEBALL 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.