



Pope Rifle Barrels

H. M. POPE

59 ASHLEY STREET HARTFORD CONNECTICUT



CATALOGUE AND PRICE LIST OF

Pope Rifle Barrels

POPE SPECIAL BULLET MOULDS

REAR WIND GAUGE SIGHTS : LUBRICATING PUMPS

DOUBLE LOADING FLASKS

MACHINE RESTS : ETC.



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59 ASHLEY STREET HARTFORD, CONNECTICUT, Mass.
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❖ PREFACE. ❖

IN presenting this catalogue to your attention, the writer, making no pretence to a literary character, asks your indulgence for any shortcomings of such a nature, but, understanding his subject well, asks also your careful attention to the points brought forward, and to descriptions of the various articles of his manufacture, which he has tried to describe as plainly as possible. These points of superiority have been demonstrated by infinite labor and experiment, and are, so far as known, absolutely true.

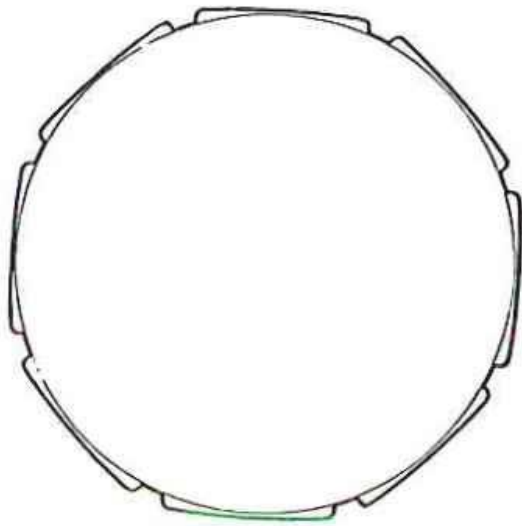
By profession, I am a mechanical engineer and a skillful workman; for recreation and by preference, a "rifle crank." I first made a barrel (entirely on a foot lathe) because I could not buy what I wanted; *i. e.*, a .25 cal., which I made in 1887, before this size was manufactured. My first charge was a straight shell holding 25 grs. powder and a 100 gr. bullet, then a shorter one with 20 or 21 grs. powder and 85 gr. bullet. Finding the making of a sufficient number of these shells on a foot lathe an arduous task, I rechambered and swaged down a 32-20 shell. I used this shell for some time, but on making my first muzzle loader, I swaged down a 38 ex. long c. f. holding 30 grs. and using bullets up to 120 grs. With this rifle I did my best shooting under N. R. A. rules. Being troubled with bursting shells, I finally swaged down 32-40 everlasting shells, using 35 grs. This did good work muzzle loading, but had passed the limit for accuracy for breech loading with black powder. In these shells you will find the prototype of nearly every .25 cal. shell now made. Shortly after this I accidentally injured my barrel and abandoned this rifle for a 13 lb. rifle with set trigger, the state of my pocketbook at prize matches giving an unanswerable argument that this gave better results than the lighter arm, and later experience fully bears this out,

and I find that I can still shoot a "practical" rifle with the rest, some "arms over your head" cranks to the contrary. (Proof, five dead deer with five cartridges, standing and running, all in thick woods at usual distances). The conditions of target shooting and field shooting bear no resemblance to one another, the most difficult change being not the change in arm, but the change from the deliberate aim at target to the snap shot at game. Therefore, *when you shoot at target use every refinement known to increase your scores*, as almost every refinement known for target use is impracticable in the field or woods.

During the period above mentioned I became interested in and thoroughly convinced that the so-called Schalke system, devised by Wm. Hayes and Geo. Schalke, possessed advantages for off-hand shooting that placed it far in advance of any other method of loading. This system I adopted, improving on Mr. Schalke's method of manufacture and altering somewhat the form of cut, though retaining the essential features. The above-mentioned heavy rifle, as well as the last .25 cal., were so made. Their performance was so good that I had to fit out my intimate shooting friends, and their improvement in shooting was so marked that I began to be besieged by outs'de parties to make barrels for them. This, for a long time, I refused to do, but finally these enquiries became so numerous, and Mr. Schalke's death occurring about this time, I consented, with the result that my barrels are now in the hands of the most expert off-hand shots in the country and are making scores that are unsurpassed, and *every man who shoots a Pope improves his scores*. Don't believe me, but watch the papers and see if this is not so.

The Pope System,

so-called, is, as previously stated, nearly the same as the Schalke, the difference being in the shape of the cut and that my barrels are cut to correct shape, while Mr. Schalke's were leaded. Mr. Schalke's rifling had eight flat grooves and eight narrow lands, with sharp corners to grooves. My rifling is shown here. It has eight wide grooves, which are on a radius about three times the radius of the bore, and has the corners rounded out, so dirt is easier removed, and it is cleaner in use. This groove is cut just deep enough to clean the bore in centre and gives a depth at corners of about .004", which is about one-half the depth of the Schalke, but which is of ample depth, and works cleaner, and leaves less to depend on on upset of bullet, and is therefore more reliable. The lands are very narrow (about one-fifth to one-sixth the groove).



The bullet is made with a base large enough to fill grooves completely, and the body of practically the same diameter as the bore. This gives a form that is gas tight, loads very easily (being assisted in this by the narrow lands and choke bore) and on upset, instead of the body of bullet meeting only sharp lands and these cutting into the body more or less unequally, it is immediately held to place by the nearly flat centre of the broad grooves, and swells out into grooves equally and perfectly central; consequently it is accurate.

In this system a false muzzle and starter are used, and the lubricated bullet

seated from the muzzle, the shell with powder being afterward inserted in the ordinary way. In doing this the labor is very light, as the shooter has to handle nothing over a few ounces weight, the rifle standing in the loading stand. By the simple act of pushing the bullet home the sharp flat base of the bullet cuts the dirt down behind it, and does so *exactly alike*, each time giving a *uniformly clean barrel without the labor of cleaning*. The result of these things is that we attain *all the accuracy of patched bullets*, and in ordinary hands more, *without the labor of cleaning*. This is also less labor than the ordinary way of seating a greased bullet in the breech, having to invert the rifle and generally sustaining its weight while so doing.

Other things being equal, *the man who tires himself least does the best shooting* in the long run, and if this is accompanied by increased accuracy of the rifle, he has a great advantage over his fellows who do otherwise.

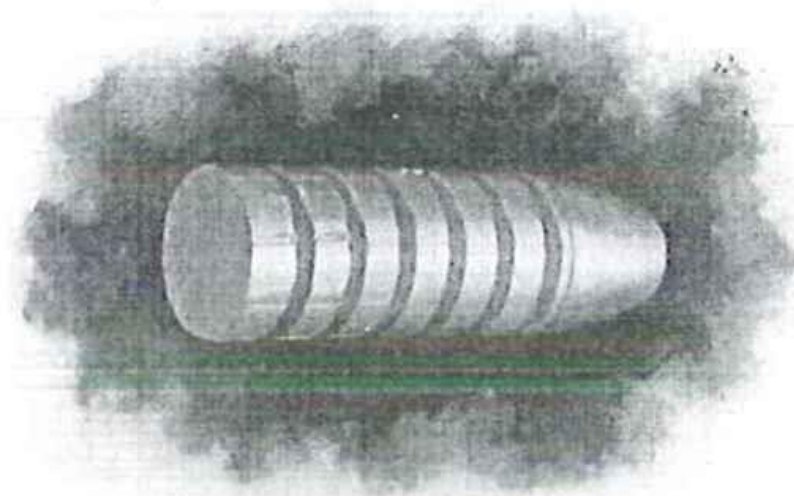
A properly made barrel, loaded in this way, will shoot 10 shot groups at 200 yards that will average about $1\frac{1}{4}$ or $1\frac{1}{2}$ inches less diameter than the same or an equally good barrel shot dirty, bullet seated from the breech, while one using bullets seated in the shell is so far out of the game as to have no chance whatever on a string of any considerable number of shots, if otherwise he is an even match for his competitors.

$1\frac{1}{4}$ to $1\frac{1}{2}$ inches does not sound much, but on the fine ringed targets now in use it means *points*. I have before me a good muzzle-loading group, .32 cal., 10 shots, 200 yards. On German ring target it counts 250. Another group shot breech-loading, bullet seated in breech, same load, is but 1 inch larger diameter and is the *best* group I ever saw shot under these conditions. It counts 245. On the

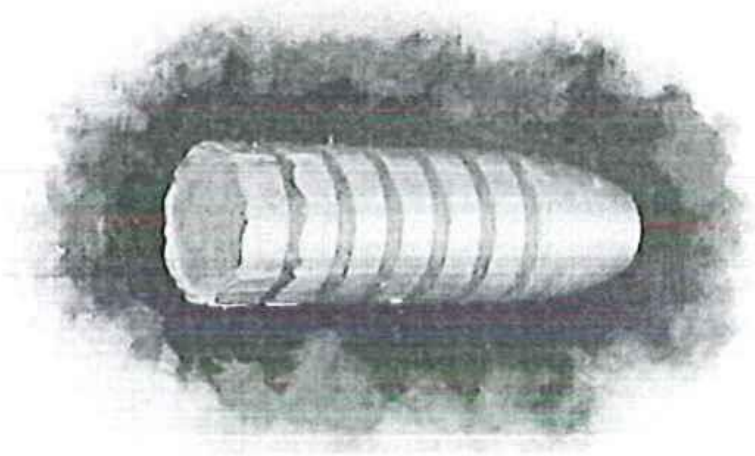
Columbia target the scores are respectively 12 and 21; on Standard American, 120 and 115. The difference between *average* groups is still more marked, averaging fully 7 or 8 points on German ring target. On this, no comment is necessary.

For steadiness of shooting, I have fired 130 consecutive shots in 10 shot strings, measuring from centres of groups 104", an average of exactly .8" per shot. The largest group was 3.75" across from centre to centre of outside shots, and measured $9\frac{1}{8}$ ". The smallest group was 1.8" across and measured 6". All but two of the shots would cut into a 3-inch circle.

An advantage a bullet loaded from the muzzle will always have over one loaded from the breech is shown in this cut. This is an enlarged view of a .32 cal. bullet seated from the muzzle. Notice the perfect base, as the lands *cutting forward* into the bullet left it nearly perfect. Contrast it with a bullet seated in breech with a bullet seater in the ordinary way (see cut, next page). Here the lands *cutting backward* into the bullet *drag out burrs behind, leaving an uneven and serrated base*. If this bullet



is not perfectly centred these burrs will be *longer on one side* than on the other. As these burrs leave the muzzle, the gas escapes first from the short side, tipping the bullet to the opposite side, in which it is assisted by the longer burrs holding the



bullet back; the result is an uneven, wobbling flight. *The greatest essential for perfect shooting is to deliver the bullet perfectly from the muzzle;* that being done, atmospheric conditions and gravity alone govern its flight; the result is accurate shooting. To so deliver the bullet, it must have a perfect base, and be perfectly centred, and have uniform velocity.

To illustrate, a group was shot at 200 yards, machine rest, with as perfect bullets as I could select, another on same holding with bullets very badly mutilated at the point; these two grouped closely, a 3-inch circle holding all. Another group was then shot with bullets very slightly filed on one edge of the base, but otherwise perfect; this caused imperfect delivery, and the group was *8 inches* in diameter. Weather conditions were good.

The base band of my bullets is broad and sharp, and of full size; the starter

centres it perfectly, and fits it to rifling with a perfect base; the shape of grooves holds it central on upset, and it delivers perfectly from the muzzle. No other method will do this.

My barrels are all (unless specially ordered) cut with a gain twist, and are so bored and rifled as to have a slight, but gradual, taper from breech to muzzle. This, beside keeping bullet perfectly under control, in connection with the narrow lands (which cut through the bullet easily), makes loading very easy, and very materially increases accuracy. A bullet pushed through from the breech is tight all the way, there are *no loose places*, and this result is attained by close, careful workmanship, no emery being used; the result is a barrel with a long life. Wherever practicable I chamber and make all crosscuts before rifling; I then fit a bushing to chamber and bore and rifle it with the barrel and false muzzle. As the rifling is then the last cut made in the barrel, I am *absolutely certain* that there can be no burrs across the grooves, a very common fault.

The advantages of the gain twist are two: 1st—The twist being less at the breech, gives less friction to the bullet; it therefore starts easier and quicker, giving the powder less time to burn on in front of chamber, which therefore fouls less than in a barrel of uniform twist at the same necessary muzzle pitch. 2nd—The slight change in angle of rifling, in connection with choke boring, effectually shuts off any escape of gas and prevents gas cutting, which is another cause of imperfect delivery.

The Advantages of the Pope System

are briefly summed up as follows :

1—Accuracy. 2—Light labor. 3—Seating the bullet centrally without deforming the base, and fitting it perfectly to the bore. 4—The shape of the grooves holding bullet centrally on upset. 5—Non-burning on qualities of the gain twist. 6—Perfect workmanship. 7—Ability to load from either breech or muzzle, and to clean and inspect from the breech. 8—The ability to shoot any charge desired by inserting shell first and loading both powder and bullet from the muzzle.

Workmanship.

To produce the quality of work that I do, the methods employed in factories producing work in large quantities are impossible; that is to say, that this method of interchangeable parts must leave some leeway for slight inaccuracies, to insure parts assembling. In my work such looseness of fit would be fatal to the results attained. False muzzles, for instance, it is utterly impossible to make *perfectly* interchangeable, neither is it possible for automatic machinery to produce the same quality of work as a skilled workman with *brains* behind. The automatic machine does more, and does it cheaper, but the quality is not there. Therefore I do *all nice work by hand*, in the very best manner I know how. Nothing is slighted. This is slow work and takes expensive men. Naturally I can not compete with factory work in price, but, *quality considered*, my price is very low. The half tones I show you give but a faint idea of the quality of the work; this must be seen and handled to be appreciated.

The Pope Muzzle-Loading Outfit

consists of barrel, false muzzle, starter, ramrod, Pope special muzzle-loading mould, and lubricating pump. A cut of false muzzle and starter is here shown (cuts of the



mould and pump will be found later with descriptions of these articles). Barrels will be furnished of almost any weight and length, within about 3 to 6 oz. limit of variation up to about 8 lbs. 2 oz. for a 32 inch, No. 4 oct., .32 cal. barrel; longer or heavier barrels, also barrels to exact weight specified, at special prices. I consider for offhand 200 yard work, a barrel of about 7 $\frac{3}{4}$ lbs., 30 inch, oct., as the best adapted. This I consider my standard, and recommend it as giving the best average results. For calibre for offhand work I prefer a .28, .32 or .33.

The price for this outfit includes fitting the barrel to your action, and fitting to it your extractor, forearm and sights, where they can be used. If new ones are necessary, they will be charged at cost.

The price of above, untested, is.....	\$35.00
The same, but tested at 200 yards from machine rest, I guaranteeing to furnish a 10 shot group on 3-inch circle, or closer, is.....	40.00
The same, but 2 $\frac{1}{2}$ -inch group, or closer, guaranteed.....	45.00

In these there is absolutely no difference in the quality of barrels or workmanship. I have a long trip to make to test, and in my guarantee have to make allowance for adverse weather conditions, sometimes having to make several trips to secure the desired results. I never alter a barrel in testing, it is a matter of ammunition wholly. If tested, you see what has actually been accomplished with fine appliances and know exactly what load did it. If untested, you, unless very expert, can hardly expect to equal at once the results of my machine rest, and may have to do some experimenting (when you become accustomed to the system, not before), to determine the best temper of bullets, etc. You are as liable to get as close a group on one guarantee as on another, as it is largely a matter of weather conditions. If weather is good, I get close groups; if weather is cold and wind tricky, they are not so good. It is perfectly obvious that I can not guarantee to furnish as close a group as the barrel is capable of shooting, though I might happen to do so. I believe all my barrels are capable of shooting closer than 2-inch groups, with favorable conditions.

Recutting to Pope System.

I recut rifles of other makes to larger sizes with the same outfit and guarantees as for a new barrel.

Price, untested.....	\$25.00
“ 3-inch guarantee.....	30.00
“ 2½-inch “	35.00

CALIBRES AND WEIGHTS.

CALIBRE.	POWDER.	M. L. BULLET.	B. L. BULLET.	200 YD. GUARANTEE.
.25	26 grs.	98 grs.	86 grs.	3½ and 3
.28	30 "	118 and 138 "	108 "	3 " 2½
.32	47 "	180 " 200 "	165 or 185 "	"
.33	47 "	195 " 218 "		"
.38	55 "	277 " 330 "	255 "	"
.39	55 "	265 " 343 "		"

The weight of powder charges are the drawn shell full. This can be decreased by the use of everlasting or special shells, or by using less powder and an air space. Weights of B. L. bullets are those intended to seat in shell. Barrels are cut with a pitch correct for the bullet they are intended to use. Shorter bullets can be used in a barrel cut for the long one, but not the reverse. It is oftentimes better to use the lighter bullet. Unless specially ordered I shall use my own judgment in cutting the barrel.

Breech-Loading Barrels.

I cut barrels for breech loading in the same style as for muzzle loading. A mould for same bullet is recommended as giving better results than the ordinary B. L. bullet. The price for new barrel of same sizes and weights as given under the Muzzle-Loading Outfit, fitted to your action and to your extractor, forearm and sights, is \$16.00. Recutting, \$10.00.

Testing and guaranteeing same prices as there given, but the size of group guaranteed is 1¼ inches larger.

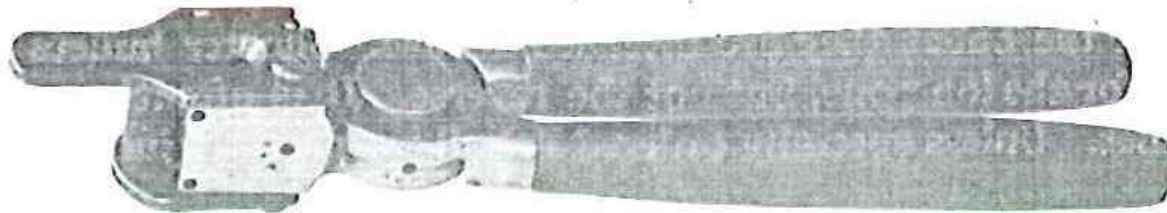
.22 Calibre Barrels.

I am now prepared to furnish .22 cal. barrels, with the same quality of workmanship used on my muzzle loaders. These can be furnished for .22 short or long rifle cartridges, up to 30-inch, No. 3 oct., weight about 6 to 6¼ lbs.

Price, fitted to your action, etc., and tested at 25 yards, ~~\$18.00.~~ 20 00

Pope Special Muzzle-Loading Mould.

As previously shown, a bullet with a perfect base is essential for the finest work. To meet this requisite the mould shown above was designed. It differs from all



others in having a cut-off with a bottom plate rigidly connected to it and swinging with it. These plates, with the joint pin and dowels, hold the two halves of mould perfectly in position; bullets from it average within .0005" of being round, which is practically perfect. No other mould does such work. The bullet is poured from the point, bringing imperfections to this end. When sprue is cut off, both plates swing entirely clear of bullet, which easily falls out. Great pains are taken to have each half of mould of equal depth, to avoid sticking. This mould is part

of the muzzle-loading outfit. It is also recommended as being the best for breech-loading work, shooting dirty with bullet seated in the barrel.

Moulds can be ventilated, if desired. This consists of cutting air passages from each groove and from point and base in the mould to allow air to escape freely. It is a little advantage where one works so slowly that mould is apt to be too cool, but not otherwise.

All moulds are broken in ready for use. Keep them dry and use no oil. Wax joints in use when necessary to keep them free.

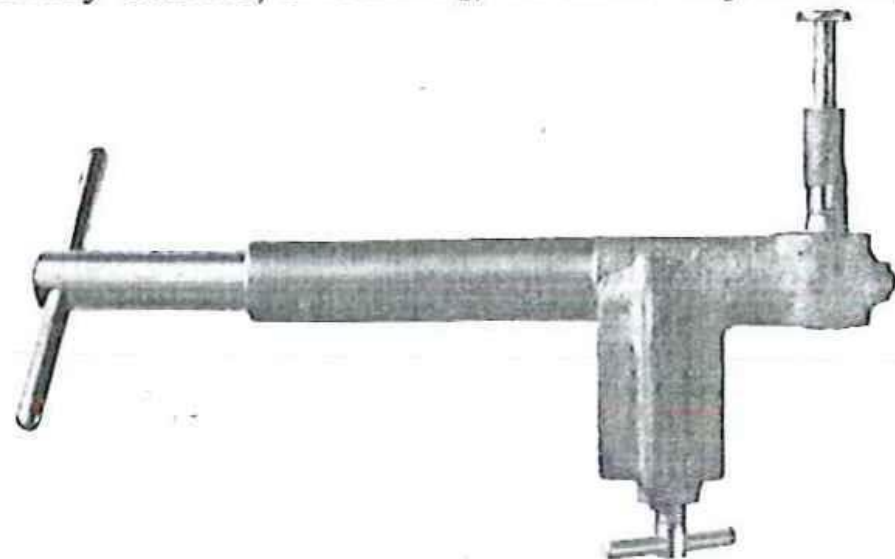
I have a large number of cherries of various sizes and styles. Moulds can be made from any of these at regular prices. I make special sizes, to order, at \$3.00 extra, retaining the cherry as my own property.

Price of Pope Special mould.....	\$3.50
“ Moulds cutting off at base.....	1.50
“ Ventilating, extra.....	.50
“ Double mould, extra.....	.50

The Pope Lubricating Pump.

The construction is clearly shown in cut. It holds enough to grease 180 to 300 of my bullets, according to size. By its use, using grease cold, one greases bullets

perfectly as fast as fifteen to twenty-five per minute, according to skill; rightly used, it just fills the grooves and no more, leaving the bands bare. This is essential for fine work, for if there be more grease on one side of bullet than on the other, it displaces that bulk of lead on upset, throwing the bullet out of balance. If the mould is round, as mine are, no wiping of bullet is necessary. Dies are made



interchangeable, so any number of different ones may be had, each bullet requiring a different die.

It is used as follows. It is best filled by removing forcing screw and pouring in melted lubricant; this excludes air better than by other methods of filling, and makes it work better. Do this some time before you want to use it, so grease will be cold; preferably fill it immediately after use, so it will be ready for next time. Grease can be jammed in cold if so desired, but the operation is not so good. Clamp pump onto corner of table, or onto a projecting stick fastened to bench or held in a vice, insert a bullet, hold it firmly in, turn forcing screw just enough to fill grooves (a very little practice will enable you to do this accurately), turn screw

back about one-fourth turn to relieve pressure on grease and prevent its oozing out, and expel bullet with plunger.

This is an indispensable tool for the nicest work; it forms part of the muzzle-loading outfit.

In ordering, send several samples of each size bullet it is intended to grease, and pack these carefully, so they can not be bruised in transportation.

Price.....	\$3.00
Extra Dies, each.....	.75

The Pope Rear Wind Gauge and Elevating Sight.

The cut shows this plainly. I claim it to be the neatest, safest, most convenient and accurate sight made. Wind and elevating movements are entirely separate, so moving one can not also disturb the other. One hole movement of either elevating nuts or wind screw equals *1 inch on 200 yard target*. The two elevating nuts are operated by the small lever pin, which can be carried in the head of sight as shown, or worn upon the watch chain, as preferred. These nuts bind against *opposite* sides of the solid frame, therefore looseness of fit from wear *can not affect the accuracy* of adjustment. These nuts are usually set firmly, so they can not be accidentally moved, but may be left so as to move with the fingers if desired. The wind screw differs from the ordinary construction by passing through a bearing at both ends of frame and



by having a shoulder on one end and a jam nut on the other; when wear occurs, all that is necessary to correct it is to screw the nut up a little firmer, filing off a trifle from end of screw if necessary.

The key to the operation of this sight is found in the following: "Turn your sight the way you want your shot to go." To shoot to the *right*, turn wind screw to the *right*, and *vice versa*. One hole or one-fourth turn of screw equals 1 inch; one turn or one graduation equals 4 inches on 200 yard target. To shoot *higher*, first move the *upper* nut the required amount, then tighten the lower one, turning from you (holding muzzle to left, sight folded). You can not turn these the wrong way if you put pin in the correct nut, as that tightens the nut instead of loosening it. To shoot *lower*, first move *lower* nut, then tighten upper one, turning both toward you.

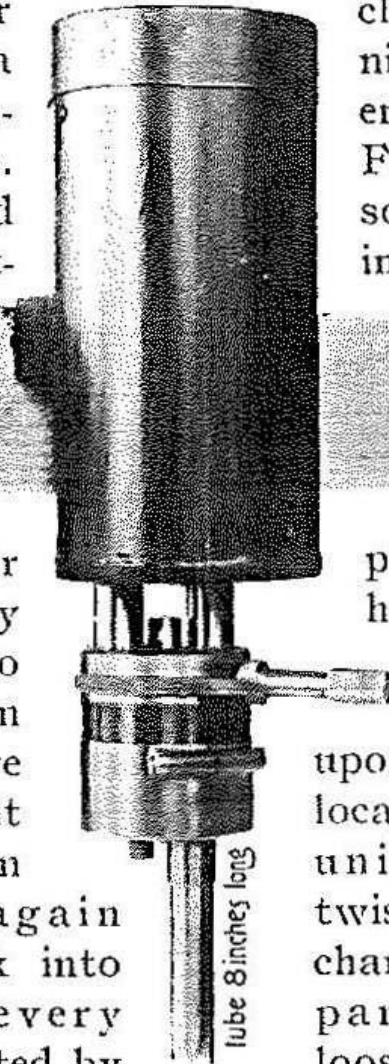
In ordering, send me your old sights if practicable, set on 200 yards elevation; give make of rifle, and, if old sights are not sent, state height of present front sight above top of barrel to centre of disc, also diameter of muzzle.

The advantages of this sight are its *safety*, convenience and accuracy; also, one does not have to remove front sight to carry rifle in case; the result is that the sights are always on the rifle, and you do not go to the range and forget your wind gauge. Who has not done this?

Price, without base, fitted to any base sent me.....	\$5.00
Price, with base, complete.....	6.50
Globe Sight, with interchangeable disc.....	1.00

The Pope Loading Flask.

This is an improvement on my previous flask in several ways, the principal one being that it is adjustable for change the charger. It loads a a full charge of black at one op- the most accurate flask made. supporting bar on back is slotted permanently placed on a project- a wall timber; this room and brings it height. Where this is supported in the small metal spider can be screwed into the wall or essary); this gives the necessary ble, does not enlarge the flask so large to carry. The operation lever has a loose knurled sleeve forward stop and twisting it and shakes the powder down pushed to back stop and again shell, and settles the black into ward and rattled, emptying every Changing the charge is effected by

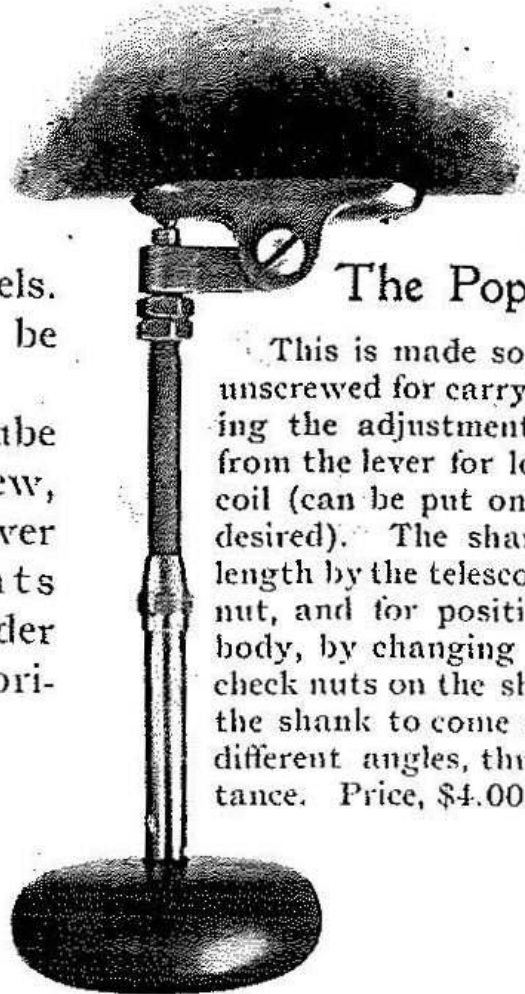


charge, without having to ex- nitro priming and black body or eration, and is very quick and For use in a regular place, the so it can be slid over two screws ing bar, such as the rod rack or gives plenty of hand to a convenient is not convenient, it same way from a (not shown) which post (no screw driver being nec- hand room and, being remova- as to make it unnecessarily is very simple. The operating upon it; holding this against the locates the nitro charger properly uniformly into it; lever is then twisted; this empties the nitro into charger, which is then drawn for- particle of black into the shell. loosening the clampscrew on lower

body, then turning this up or down, setting the slot to line and reclamping. One turn equals one grain of black powder. The flask holds enough for about 125 charges of 47 grs. The charge varies from 28 grs. bulk to 60 grs. where nitro priming is used, and from 22 grs. to 60 grs. using all one kind, or by using double or treble charges of one kind any required amount may be loaded. This flask covers all charges used regularly in my barrels. Special size for smaller charges will be made to order.

In carrying the flask, the loading tube is unscrewed, and the small thumb screw, shown behind it, screwed up, the lever being in front position. This prevents charger turning and spilling powder through it, when being carried in a horizontal position.

Price, complete, \$5.00.

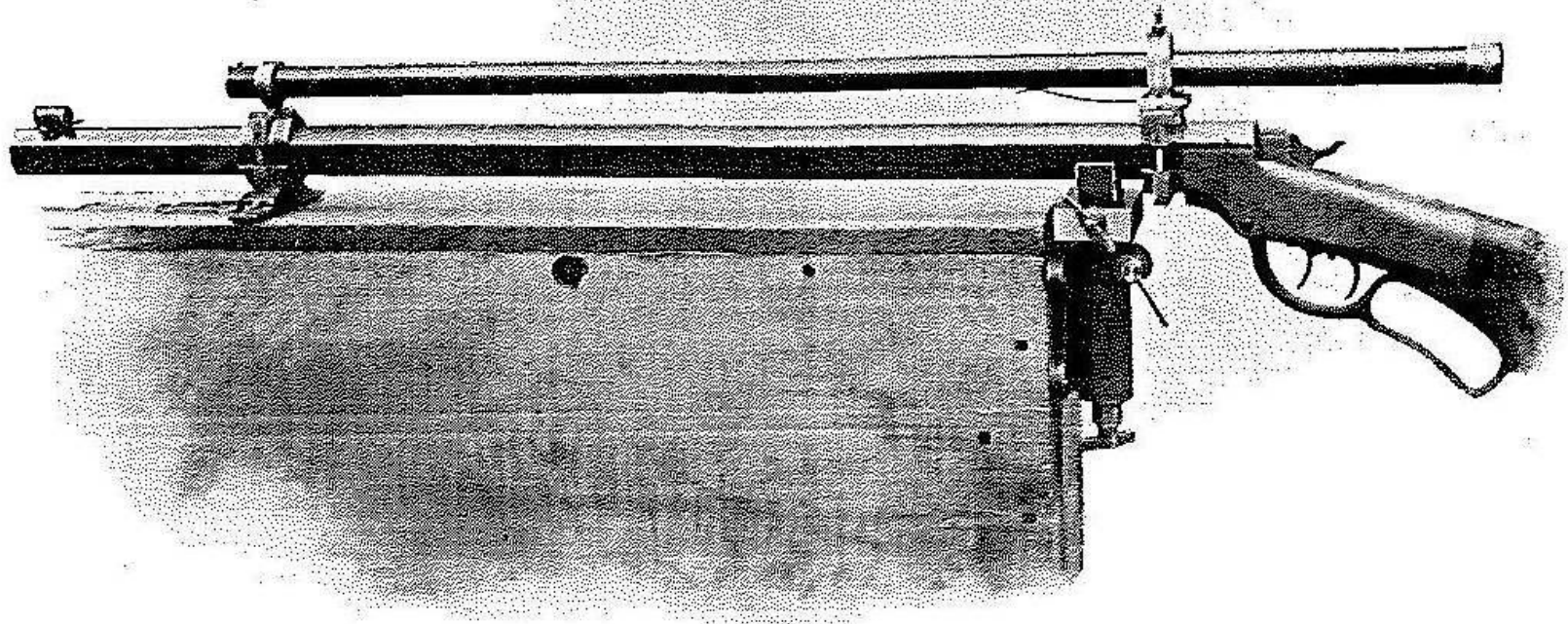


The Pope Palm Rest.

This is made so the shank is easily unscrewed for carrying, without changing the adjustment. It swings away from the lever for loading, and from recoil (can be put on the reverse way, if desired). The shank is adjustable for length by the telescoping tube and taper nut, and for position to or from the body, by changing the position of the check nuts on the shank, so as to allow the shank to come against the stop at different angles, thus affecting the distance. Price, \$4.00.

The Pope Double or Machine Rest.

Shown complete in cut, with all attachments, should be owned by every club



for testing purposes. More information can be derived from its use in a few hours, than can be had by ordinary rest shooting by an ordinary shooter in as many

weeks, as, if at all carefully used, it has no *human errors* of holding and pulling. The results, therefore, are those due to rifle, ammunition and weather; the man is out of it, except so far as his loading of the rifle and judgment of wind are concerned.

This rest is made in various styles. That shown is the best and consists of the No. 1 rear rest, No. 3 front rest, with sliding telescope mountings, stop, and telescope sight. These mounts are all adjustable and clamp to the barrel, no screw holes or marring of barrel being necessary; they take barrels of all ordinary sizes, without change. Forearm is removed while testing.

In use, two stout posts are set deeply in the ground, the firmer the better; these are braced together, and a smooth, level plank fastened on top; both posts are firmly braced in two directions, stop is fastened on top plank in proper position and rear rest to rear post so as to give approximately the correct elevation. Front rest and scope mountings are clamped to barrel, the same loaded and slid gently to stop; to sight on, I prefer four black pasters placed at the corners of a square about $2\frac{1}{2}$ inches on a side; adjust your rest or telescope or perhaps both, so gun points where you wish, cross hairs being between each pair of pasters; let the rifle rest naturally, hold right hand about 6 inches behind the butt, touch set trigger with left hand and catch the rifle on recoil. If the gun has a heavy pull, pinch the trigger and guard with thumb and forefinger so as not to disturb the rifle in the rest. In setting up, it is often convenient to set the rest, so the rifle will point on the target before the telescope is mounted, using the ordinary sights, then mount the scope and adjust it to your pasters, and shoot your group, then move rest a fair amount, that depending on how close the gun will shoot, then bring your scope again to the pasters and shoot again. It very seldom pays to try to

get the rifle to shoot at any given spot in testing. Hold in one spot, and get your group wherever it happens to fall.

A telescope sight is not a necessity in double rest shooting, though it is a great convenience. With it you can shoot from a bench that is not firm, as the sight gives you a chance to correct the aim each time; for all that an absolutely firm bench is best, and if you shoot from double rest without a scope, it is an absolute necessity. "Shooting and Fishing," Aug. 25, 1898, contains an illustrated article on double rests. Price of complete double rest and scope, as shown, \$25.00.

No. 1 rear rest is the best and most compact, has a collar screw for elevating and depressing, giving a positive movement both ways; shank is securely fastened by the clamp screw and lever. The wind adjustment is by two tension screws operating against each other, permitting the most exact adjustment and locking firmly. Price, \$8.50.

No. 2 rear rest is the same as No. 1, except that the three adjusting screws are set screws. These necessarily project much further than in No. 1, and are therefore a little more likely to accidental movement, also elevation depends wholly on the weight of rifle following up the movement of the screw, taking, therefore, a little more care in handling. This construction avoids the necessity of careful lining up of parts, and makes fewer parts necessary, thus cheapening its construction. Price, \$6.00.

No. 3 rear rest has no adjusting screws at all; the elevation is held by the clamp, as in Nos. 1 and 2, the cross movement by a set screw and shoe against the V block. It is all right for group shooting on one setting, but does not permit of adjustment for wind or close setting. Price, \$4.00.

No. 1 front rest. This is the simplest and lightest possible; it consists of the lower part of front rest shown in cut. It is fastened to the barrel by one screw, tapped into it. It is the best for permanent double rest work, but not so convenient for various arms, as all barrels used with it must have a screw hole in them. Price, with stop, \$1.00.

No. 2 front rest. This has a cap and clamp screws. Its size is such that it takes barrels of all ordinary dimensions without necessity of screw holes. Price, with stop, \$1.50.

No. 3 front rest is the same as No. 2, with the addition of front mounting for sliding telescope sight. With this is also included the rear telescope mounting, also clamping to barrel, and with adjustments for both wind and elevation. Price of all, \$6.50.

Telescope sight. I have a special sight made for me by John W. Sidle for this work. It is $\frac{3}{4}$ " diameter, 28" long, steel tube, browned, 14 power, fine cross hairs, with cross hairs and object glass both adjustable for focus. Price, \$10.00.

Set of castings and blue print for double rest for those who wish to make their own rest, \$1.50.

Rifles.

I do not make complete rifles, but can furnish any standard make at reasonable prices. These I can generally have come to me unrifled, when I can bore, rifle and fit my outfit to them at the price given for reboring. This gives the slight advantage of standard sizes on these arms, and the ability to use factory ammunition in them if desired. It takes usually three or four weeks to get such a rifle from the factory, before I can do much work on it. Write for prices.

Winchester barrels are interchangeable, and are the only ones, to my knowledge, that are so. To any one wishing such, and who will give me the necessary time, as given above for rifles, I can furnish a blank barrel from them at same discount I give on rifles, and charge, beside, my price for recutting. I can buy these blanks as cheaply as I can make a new barrel; and as I save myself the work of fitting to action, slotting, etc., I am thus enabled to furnish a barrel at a little less than my regular price. This applies to *no* other make and to these only where the necessary time is given me. I also do not, on this, need your action to fit to and test from.

Read This.

From all parties having new barrels fitted, I require the old barrel where possible, as well as the action, as this is of much assistance to me in fitting the new barrel. Make the case you ship in large enough to contain both barrels, together with the new outfit. Prepay express charges and mark box plainly, Paid. I will not waste my time, as I have done, in rectifying express company's mistakes; where collections are made on both ends (in one case it took me six months and cost me in time nearly \$10 to collect a double charge of \$1.35), if box is not plainly marked, and the express company charge me, I charge you, and you pay the bill. If I succeed in collecting the bill, I will remit to you; otherwise not. Therefore prepay the express and mark it PAID.

Terms.

My terms from parties unknown to me are 25 per cent. with order, the balance upon notification of completion of work, or C. O. D. and return charges. I consider a rifle sent to be recut or for other work equivalent to a deposit.

Prices are subject to change without notice.



String, One Inch.

