

# Underlug Staples



#Tool-105-S  
staking staple tool



#Tool-105-P  
double punch for staple



#UL-104-A  
for thick key



#UL-104-B  
for thin key



#UL-104-C  
solid for pin

## Underlug Staples, for thick keys, thin keys, or barrel pins:

Drill holes about .120" diameter (#34 or 1/8") for these staples. Our UL-104-A staples are made for keys up to .125" thick. The .430" slot width allows for barrel expansion when hot, without pinching the barrel, changing point of impact. This larger staple works well with our tempered steel 3/32" dowel pin, too.

Ideal for Hawken and similar Plains rifles using full size keys. It may be seated deeper for thinner keys. Malleable steel.

#UL-104-A staple for thick key **only \$2.50**  
#Drill-34 drill bit, #34, HSS, 135° split point **only \$1.99**

## Underlug Staples, for thin keys, thin keys, or barrel pins:

Our UL-104-B staples are made for thin keys, up to about .090" thick. The .425" slot width allows expansion of the barrel when hot, to avoid pinching the barrel, changing point of impact. May be used with our steel 3/32" barrel pin, in thin wall barrels. Drill .109" (7/64").

Recommended for fullstock longrifles, fullstock Hawken rifles, and light halfstocks using thin keys. Malleable steel.

#UL-104-B staple for thin key, **only \$2.50**  
#Drill-34 drill bit, #34", HSS, 135° split point **only \$1.99**

## Underlug Staples for barrel pins:

Our UL-104-C staples are solid, for use with barrel pins, or to support swivel screws up to about .150" diameter. The bottom of this solid staple should seat firmly against the barrel. Use a #34 drill bit, to make holes .073" deep, or a tiny bit deeper. After drilling for barrel pin, consider elongating the hole, to allow barrel expansion when hot. Always leave .100" barrel wall thickness.

We recommend this solid staple for fullstock and halfstock rifles using our 3/32" barrel pins. Malleable steel, virtually unbreakable.

#UL-104-C staple, solid for pin **only \$2.50**  
#Drill-34 drill bit, #34, HSS, 135° split point **only \$1.99**



## Steel dowel pin 3/32" for barrel lugs, rod pipes, triggerguards:

Caution: unless you are highly skilled, drilling tiny 1/16" pin holes can cause problems! This size is often recommended in gunmaking books, to our amazement. Small pins are hard to buy, hard to use, and easily bent. Broken drill bits (especially when breaking through the lug), bent drills, misaligned holes, and drill run-out are common problems with small pins. Original antique guns rarely used these, and most measure .080 - .095.

Our 3/32" tempered steel barrel pins solve these problems. They are ideal for pinning barrels, triggerguards, ramrod pipes, and other parts. Gunmakers use pins to avoid screws when possible. Our dowel pins are .094" diameter, 1-1/2" length, tempered, chamfered ends.

#Pin-3-32 dowel pin, 3/32 x 1-1/2", each **only \$ .50**  
#Drill-3/32 drill bit, 3/32", HSS, 135° split point **only \$1.99**

## Gunsmith Tools to install staples for keys, pins, or swivels:

Underlug staples are authentic, stronger, easier to install, and they remove less metal than dovetail lugs. Not suitable for thin walled barrels. Staples work well for keys, pins, or supporting a sling swivel.

## Double punch, for locating Track's underlug staples:

Align our double punch with a centerline drawn on the bottom flat of your octagon barrel. Strike it to prick punch the exact spacing for our staples. Very handy for quick and accurate staple location.

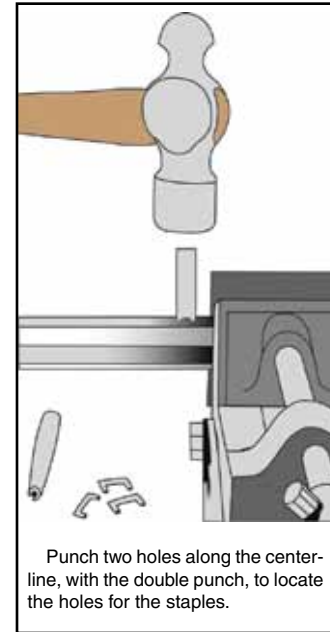
Lay your key or pin in the open staple. Measure the staple leg extending above your key or pin. Drill your holes exactly that deep. Select a drill bit to match the staple foot diameter (about 7/64"). We recommend using a drill press. Set a quill stop to avoid drilling too deep. Hole depth is determines key slot thickness.

#Tool-105-P double punch, for staple **only \$7.99**

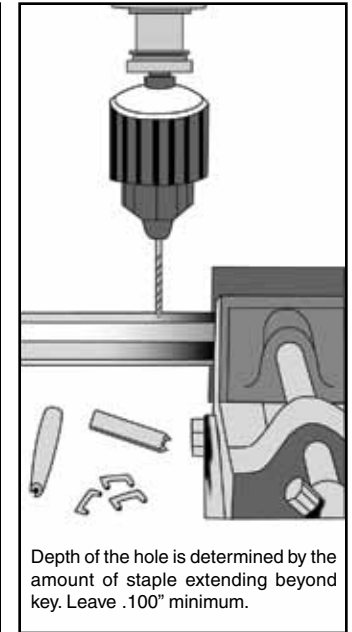
## Staking tool, for securely staking staples, permanently:

Insert one end of our staple into your hole, and seat it with a light hammer blow. Place the semicircular slotted end of this tool around the staple's seated end. Strike it with firm blows, to stake the staple permanently in place. Seat the opposite end, and stake it. Malleable staples allow bending. Stake one end securely, before attempting to seat the other end. Straighten after staking.

#Tool-105-S staking tool, for staple **only \$7.99**

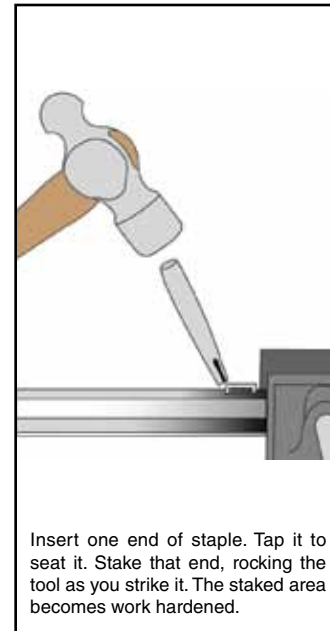


Punch two holes along the centerline, with the double punch, to locate the holes for the staples.

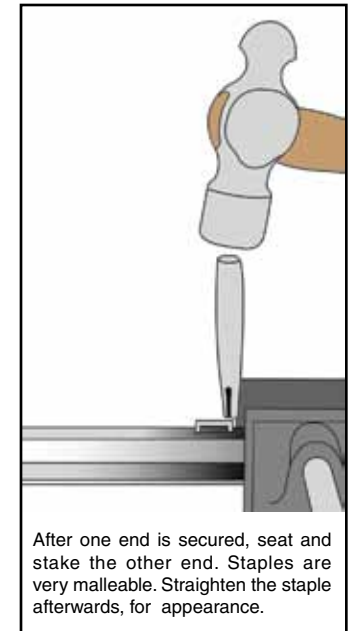


Depth of the hole is determined by the amount of staple extending beyond key. Leave .100" minimum.

## Underlug Staples are period correct, very easy to install.



Insert one end of staple. Tap it to seat it. Stake that end, rocking the tool as you strike it. The staked area becomes work hardened.



After one end is secured, seat and stake the other end. Staples are very malleable. Straighten the staple afterwards, for appearance.