Underlug Staples

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 staple location.

Precisely place the double punch along the centerline, with the double punch, to locate the holes for the staples.

Underlug Staples are period correct, very easy to install.