

Under Ribs, for halfstock guns



#RIB-1803
Harper's Ferry rib
web thickness .265
\$27.99



#RIB-NW-16
Milled rib
web thickness .240
\$24.99



#RIB-SG
Concave rib
web thickness .235
\$27.99

Ribs, milled solid steel, with overlapping edges:

Our milled steel ribs have overlapping edges, to center the rib, conceal the joint, and make your first installation look perfect.

Underrib, milled steel, 24" length:

- #RIB-NW-13** rib, milled, overlapping edges, 24" for 13/16"
- #RIB-NW-14** rib, milled, overlapping edges, 24" for 7/8"
- #RIB-NW-15** rib, milled, overlapping edges, 24" for 15/16"
- #RIB-NW-16** rib, milled, overlapping edges, 24" for 1"
- #RIB-NW-18** rib, milled, overlapping edges, 24" for 1-1/8"
- #Rib-NW-##** underrib, milled, 24 " length **only \$24.99**

Concave underrib, milled steel, 24" length, for round barrels:

- #RIB-NW-SG** rib, overlapping edges, 24" for round barrel
- #RIB-1803** rib, overlapping edges, 24" for US 1803 & 1814
- #Rib-##** concave underrib, milled, 24 " length **only \$27.99**



This nice quality unplated #5-40 flat head screw is made for mounting a rib, or for mounting any Hawken or English trigger-guard which lacks a threaded stud, to a triggerplate. A bit smaller diameter than our #6-40 rib screw, that larger screw can easily be used to replace a worn #5-40 rib screw, when a worn or damaged oversize hole is retapped to #6-40.

#Screw-5-40-R steel machine screw, #5-40 thread **only \$ 1.29**

Unplated #6-40 flat head screw, for mounting rib, or mounting a Hawken or English guard without threaded stud, to a triggerplate.

#Screw-6-40-R steel machine screw, #6-40 thread **only \$ 1.29**



This nice quality unplated #6-48 screw is made for mounting a Thompson Center underrib. This is a popular gunsmithing screw thread size is often used on modern telescope mounts, T/C rifle ribs, most InvestArm rifle ribs and Lyman Great Plains rifle ribs

The screw has a overall length of .3" with a .186" diamter head, .055" thick.

#Screw-6-48-R T/C rib screw, #6-48 thread **only \$ 1.29**

We offer gunsmith quality carbon steel plug taps, bottom taps, tap drills, and clearance drills, for easy installation of this screw, at low cost.

The underrib fits under the forward end of the barrel on halfstock rifles, shotguns, and pistols. It is attached with screws or solder. Ribs must be attached to thin wall barrels with solder.

We prefer our StayBrite Solder. To prevent flux and solder from wetting visible edges, clamp your rib to your barrel, and draw around the joint with our Birchwood Casey Presto® Instant Blue Pen. Solder will not wet a blued area. Bluing is easily removed during polishing.

To "sweat solder" your rib to the barrel, wipe a thin coat of flux on the mating surfaces of the rib and the barrel. Warm these surfaces until solder will flow, and "tin" each surface with a thin film of solder. Use a cheap tin handled "solder brush", available at most hardware stores, to move the molten solder, until the area is tinned. Wipe away excess solder, while molten, with steel wool. Leave only a thin film of solder covering each surface. Do not overheat and scorch the flux!

When cool, clamp the two pieces in correct position, and gently warm the joint. Tinned surfaces will bond together, when the solder melts. Remove excess solder from the edges of the joint, while the solder is still molten. Quickly wipe away any excess molten solder using 0000 steel wool.

Or drill and tap blind holes in the bottom of a heavy wall barrel, and attach the rib with screws. We recommend using our 5-40R screws. Clamp the barrel and rib together, and drill them together, using a drill press and rigid vise. Use a tapping jig, or chuck the tap in your drill press, with the belt removed. Tap at least three threads, using a plug tap, then a bottom tap, feeling the torque, as you cut threads. Don't flex the tap or apply too much torque, else the tap will break. Use lard oil or resulphurized thread cutting oil. Back-off tap every half turn.

Our old fashioned "carbon steel" gunsmithing taps are inexpensive, and they are best for this type of work. If broken, they can be crushed and removed, using a drift punch. If a #5-40 tapped hole becomes enlarged or damaged, it can be re-tapped to the larger #6-40 thread, salvaging the job. Likewise, you may enlarge a damaged #8-32 hole to #10-32 thread size.

Expert Gunsmithing

Our expert gunsmith can mount our rib to your barrel, after fitting the breech plug, at extra cost.

Our gunsmithing work is limited to installing the breech plug, installing sights, underlugs, ribs, and soldering ramrod pipes to notches that we mill in your underrib.

We can often complete and ship your order within three to seven days shop time. Change orders are not accepted, once the gunsmith begins his work. Returns are not accepted, for items cut to your order. Plan your work carefully, and specify any desired dimensions. Or allow our gunsmith to select the best location for sights, rib, and lugs. We do this frequently.

Our gunsmith is not tooled to hand inlet parts, assemble partially finished kits, repair guns, nor restore antique guns.



#RIB-TR-16
Smooth drawn rib
web thickness .220
available in 20", 22", 24" and 30" lengths
from **\$19.99**

Ribs, smooth die drawn steel, for octagon barrels:

Our die drawn steel ribs have very smooth surfaces, ready for final polishing and installation. A typical halfstock rifle has a 14 to 16" forend. Our ribs are available in 20", 22", 24" and 30" lengths, to fit various lengths of barrels.

Rib, smooth die drawn steel, 20" length:

- #RIB-TR-13-20** rib, smooth die drawn steel, 20" for 13/16"
- #RIB-TR-14-20** rib, smooth die drawn steel, 20" for 7/8"
- #RIB-TR-15-20** rib, smooth die drawn steel, 20" for 15/16"
- #RIB-TR-16-20** rib, smooth die drawn steel, 20" for 1"
- #Rib-TR-##-20** underrib, 20 " length **only \$19.99**

Rib, smooth die drawn steel, 22" length:

- #RIB-TR-13-22** rib, smooth die drawn steel, 22" for 13/16"
- #RIB-TR-14-22** rib, smooth die drawn steel, 22" for 7/8"
- #RIB-TR-15-22** rib, smooth die drawn steel, 22" for 15/16"
- #RIB-TR-16-22** rib, smooth die drawn steel, 22" for 1"
- #Rib-TR-##-22** underrib, 22 " length **only \$21.99**

Rib, smooth die drawn steel, 24" length:

- #RIB-TR-13-24** rib, smooth die drawn steel, 24" for 13/16"
- #RIB-TR-14-24** rib, smooth die drawn steel, 24" for 7/8"
- #RIB-TR-15-24** rib, smooth die drawn steel, 24" for 15/16"
- #RIB-TR-16-24** rib, smooth die drawn steel, 24" for 1"
- #RIB-TR-18-24** rib, smooth die drawn steel, 24" for 1-1/8"
- #Rib-TR-##-24** underrib, 24 " length **only \$23.99**

Rib, smooth die drawn steel, 30" extra long:

Our 30" die drawn ribs are made for longer barrels. To fit a tapered barrel, the rib must match the octagon size at muzzle.

- #RIB-TR-13-30** rib, smooth die drawn steel, 30" for 13/16"
- #RIB-TR-14-30** rib, smooth die drawn steel, 30" for 7/8"
- #RIB-TR-15-30** rib, smooth die drawn steel, 30" for 15/16"
- #RIB-TR-16-30** rib, smooth die drawn steel, 30" for 1"
- #Rib-TR-##-30** underrib, 30" length **only \$29.99**

StayBrite Solder and Flux..... **#Solder-SB**

A premium solder for all metals except aluminum. It flows freely and smoothly and is five times stronger than ordinary solder. Melts and flows at 430° F, providing strength without distortion. Includes a 1/2 oz. coil of solder and 1/2 bottle of flux.

StayBright solder is a lead free alloy of tin and silver. Use our Birchwood Casey's Blue Pen to mask off solder free borders.

- #Solder-SB** Stay Bright Solder and Flux, **only \$29.99**
- #BC-PSP** Instant gun blue in a felt tip pen **only \$ 6.79**