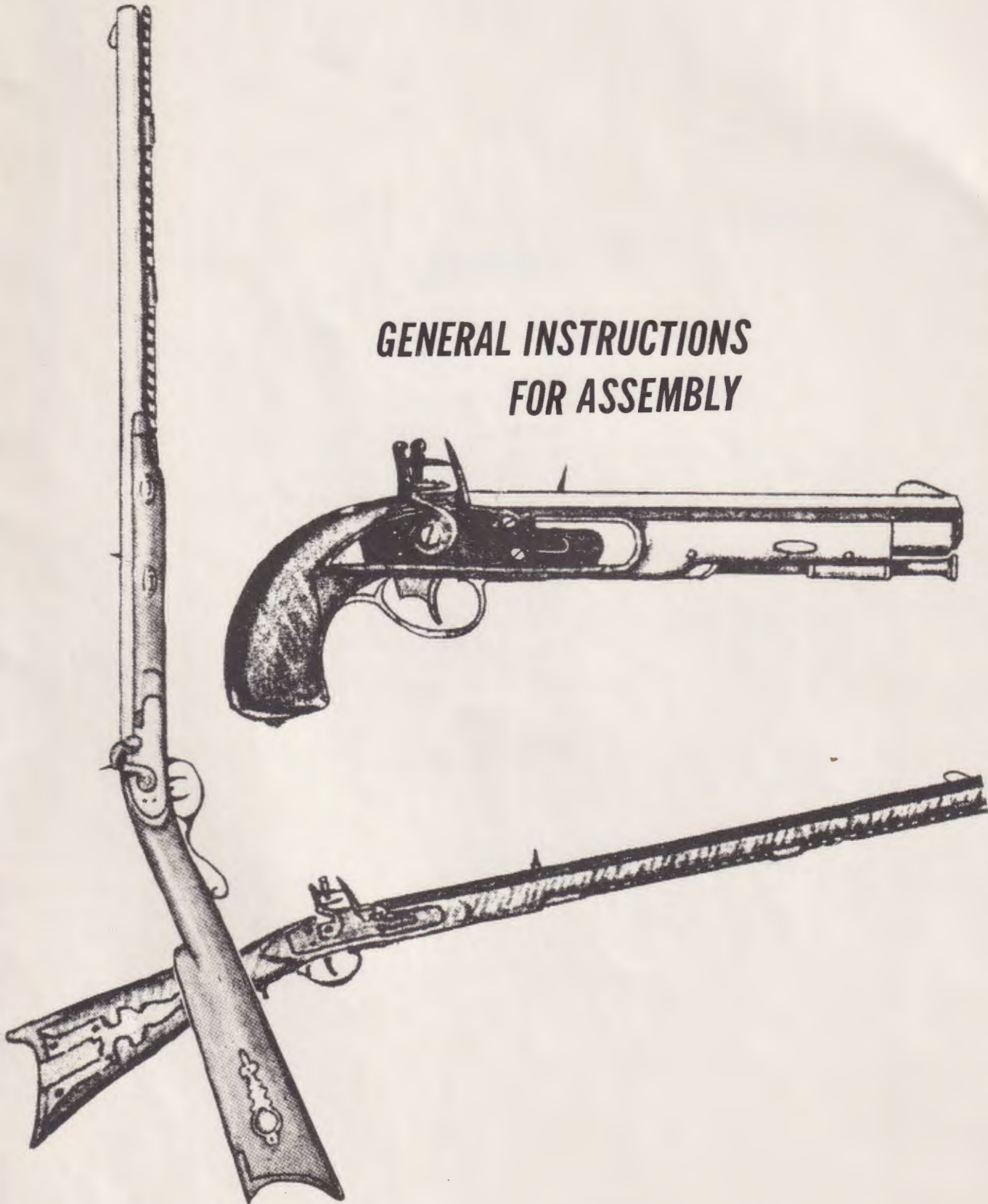


A Supplement of
North American
Correspondence Schools



**GENERAL INSTRUCTIONS
FOR ASSEMBLY**



Dixie Rifle Kit

GENERAL INSTRUCTIONS FOR ASSEMBLING THE DIXIE RIFLE KIT
(Dixie Gun Works, Inc., Union City, Tenn., 38261)

Congratulations. You are embarking on an adventure in gunsmithing that will, at the same time, give you pleasure in accomplishment, a fine firearm to shoot, and a bit of history to hold in your hand. The Kentucky rifle is truly the first American firearm. In the early 18th century, German settlers in Pennsylvania, using the principal rifling in the barrel which they brought from their homeland, made the first of these long full-stocked rifles. Because frontiersmen used them in their exploits into Kentucky territory, they acquired the name "Kentucky" rifles. They were better than any European musket because they could shoot farther and straighter and were easier to load. Many a settler bagged his meals and fought off Indian attacks with them. In the American Revolution, they surprised the British with their accuracy. British officers could be picked off before the main body of troops with muskets could get into firing range. And even into the 19th-20th centuries they have been prized as hunting weapons. But it is well to remember as you build your Kentucky rifle that the craftsmen who made the originals used great care and patience in their manufacture. So, to produce a Kentucky rifle of which you can be proud, take time to read and understand the instructions, and work on each step carefully.

Tools You'll Need

5/16" drill, 3/32" drill, No. 9 drill and No. 21 drill (use case hardened steel drills).

10/32" tap and die.

Hammer, screwdriver, wood saw and hacksaw.

A pair of metal shears.

A set of small files including triangular, rattail and half round as well as flat.

A set of wood carving tools, knives, gouges, etc.

Small straight and curved chisels.

An electric drill.

Sandpaper and 000 emery paper.

INLETTING THE BARREL

Using the semi-inletted and contoured Dixie stock blank, place the barrel into position in the stock and when the barrel fits into the stock far enough for the tang to rest on top of the stock, outline around the tang with a lead pencil. Then, with a sharp chisel about 1/2" wide, begin inletting. By carefully removing very little at a time, the barrel can be fitted to the stock so that it is in complete contact with the wood (Figure 1). It is always better to underestimate the amount of wood that you need to remove. The sides and bottom of the cut can always be smoothed and enlarged by using a small flat file. To make the deep channel for the tang, you can save time by using a drill to take out the first wood. Then use a small knife and small square file to cut the corners.

INLETTING THE BOLSTER

The percussion barrel presents an additional problem — inletting the bolster (Figure 2). Rough out the seat for the bolster with a rattail file until the bolster is within 1/32" of its final depth. Then switch to sandpaper wrapped around a dowel that is smaller than the bolster. Use this to finish the bolster seat and work it down until the barrel will seat tight in its channel.

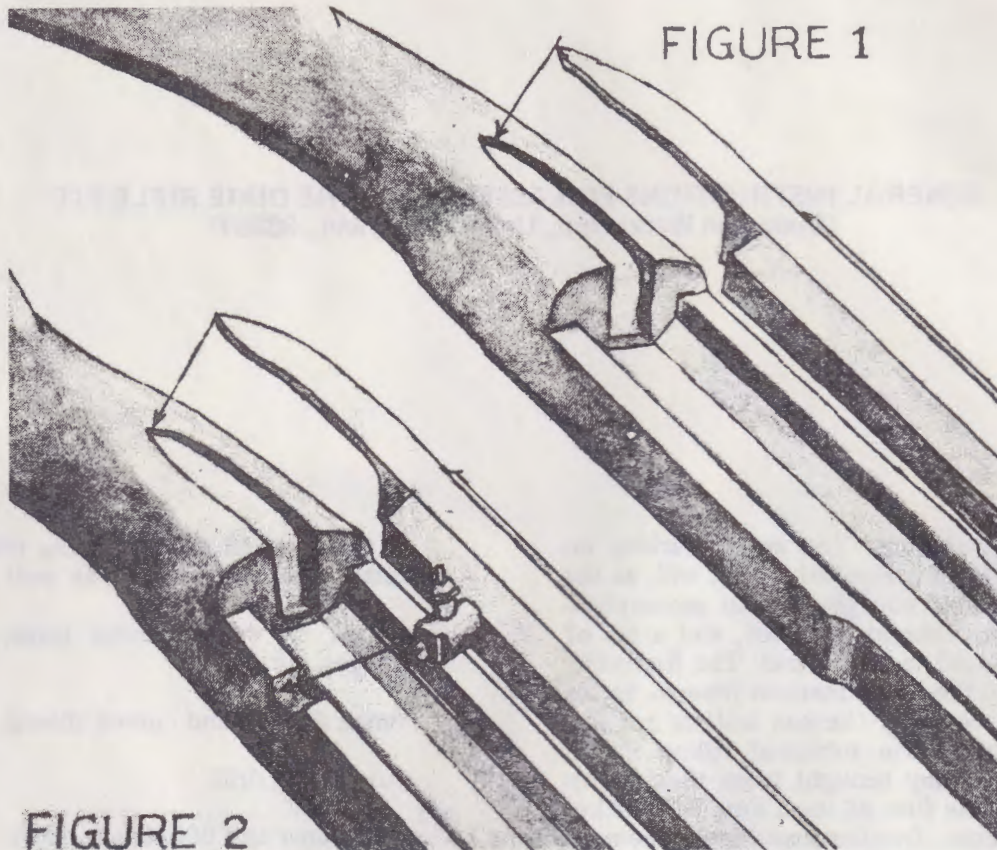


FIGURE 1

FIGURE 2

INSTALLING THE TENON AND SIGHTS

Since the tenons that hold the barrel, the stock, and both front and rear sights are installed the same way, they are included in the same instructions. Install the tenons first. Then when you have had practice, front and rear sights will be easier to put in and will look better. Mark off on the bottom of the barrel the width of the top of the dovetail slot. Make several hacksaw cuts as close as possible to the approximate depth of the slot (Figure 3). Carefully file the bottom of the slot smooth and flat. Be sure to keep it parallel with the top of the barrel. Undercut the ends of the slot using a slim tapered triangular file (Figure 4). Avoid cutting the slot oversize. File so the pinning tenon will be a good tight fit. Drive the tenon into the center of the slot, line it up straight with the barrel and secure it in place by making punch marks on each side of the tenon as close as possible.

Front and Rear Sights

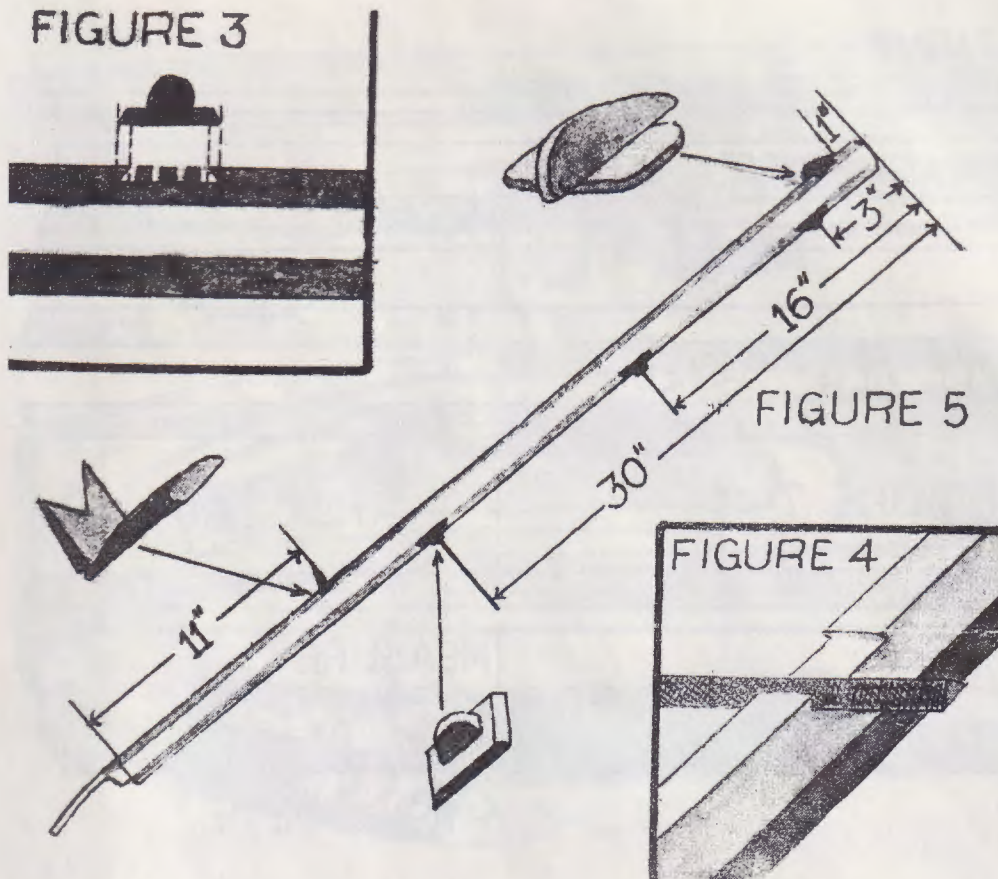
Front and rear sights are installed the same way. The rough cast brass front sight will have to be prepared by filing a dovetail in front and back of the base with a triangular file. Once front and rear sights are in place in the center of the barrel top, file off protruding

sides to be smooth with the flat surfaces of the barrel. As to proper position for each piece: (Figure 5) 3 tenons are placed 3", 16", and 30" from the muzzle. The front sight is placed 1" from the muzzle. The rear sight is placed 11" from the breech.

PINNING THE STOCK TO THE BARREL

First, the tenons must be inleted at the bottom of the stock's barrel inlet (Figure 6). Exact position for the tenon slots can be determined by using oil and lampblack on the tenon tip and pressing the barrel into its place in the stock. With a small knife, remove just enough wood at the lampblack mark to allow both tenons and barrel to fit snugly into the stock.

To pin the barrel to the stock (Figure 7), measure the distance from the muzzle to the center of the tenon. Draw a vertical line through this point on the right side of the stock. Then measure the distance from the top of the barrel to the center of the tenon. Draw a horizontal line on the right side of the stock at this point. The intersection of the two lines is the center of the barrel tenon hole. Repeat this operation for each of the 3 tenons. Hold the barrel firmly in the stock with clamps. It helps to cut a guide hole first with a drill, so a check can be made after drilling to be sure the hole is dead center in the



ling to be sure the hole is dead center in the tenon. Drill slowly to avoid springing the drill. Then to finish the hole, drill an enlargement with any necessary corrections using a 3/32" drill completely through the stock and tenon. Make barrel pins from number 6 finishing nails and drive the pins in from right to left.

FITTING THE PERCUSSION LOCK

The Dixie percussion lock is so constructed that the internal parts are interchangeable with the flintlock. However, if your Kentucky rifle is to be percussion, one extra step is necessary. The lock plate must be notched on the top edge ahead of the hammer to admit the drum (Figure 8).

Before making the notch, hold the lock with the hammer fully forward, against the drum end and adjust the lock's position so the hammer is centered over the nipple and the plate is in line with the upper edge of the stock. Next, scribe a line on each side of the drum on the upper edge of the lock plate. Then, using a rattail file, cut a rounded notch on the lock plate between the two lines. Stop and check the progress of your filing occasionally to be sure the hammer is centered over the nipple as shown in the illustration. Continue filing until a close fit of the drum to the lock plate is achieved.

INLETTING THE LOCK

Before inletting the lock, either flintlock or percussion, remove all internal parts and hold the lock plate against the side of the stock to get proper positioning. The flintlock pan guard should fit tight against the surface of the stock where the barrel breech begins and should, when inletting is done, fit tight against the barrel (Figure 9).

For percussion, the lock plate should fit against the under curve of the drum and should be inletted just enough to permit the hammer to be centered over the nipple. Scribe a line around the lock plate. Cut around this outline with a sharp chisel to the proposed depth of the lock plate and remove inner wood with a small chisel or gouge. For round ends, use a round edge chisel. The area cut out can be smoothed with small files and chisels. When the flintlock plate is in place, it will be noted that a small piece of the stock must be removed above the plate to permit the hammer to move freely (Figure 9). Remove only enough wood to expose 1" of the top surface of the lock plate. Next, replace the internal parts and continue inletting. Best results are obtained by inletting parts in order of the distance they protrude. Mark their position on the stock using oil and lampblack (Figure 9).

FIGURE 6

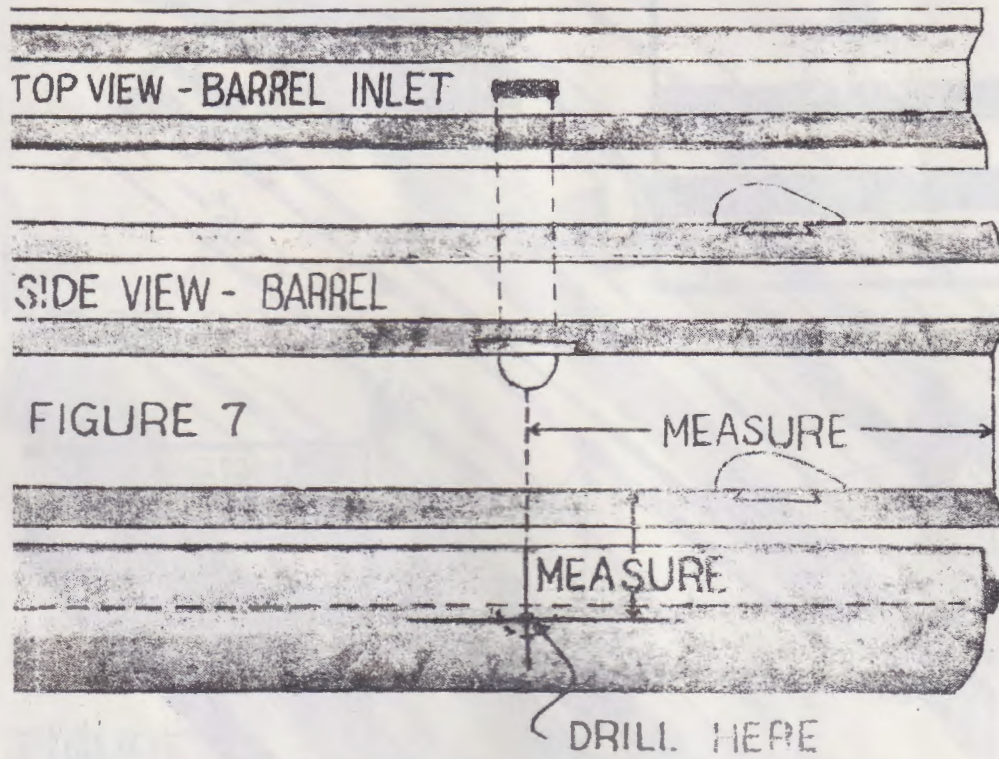
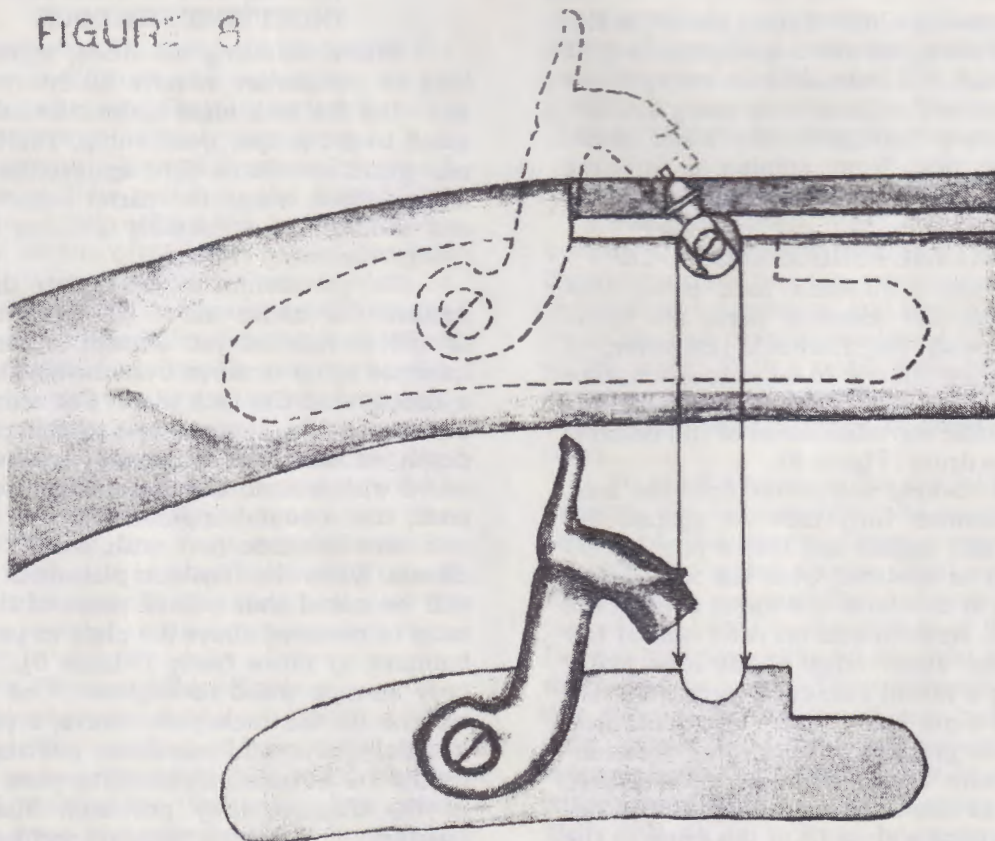


FIGURE 8



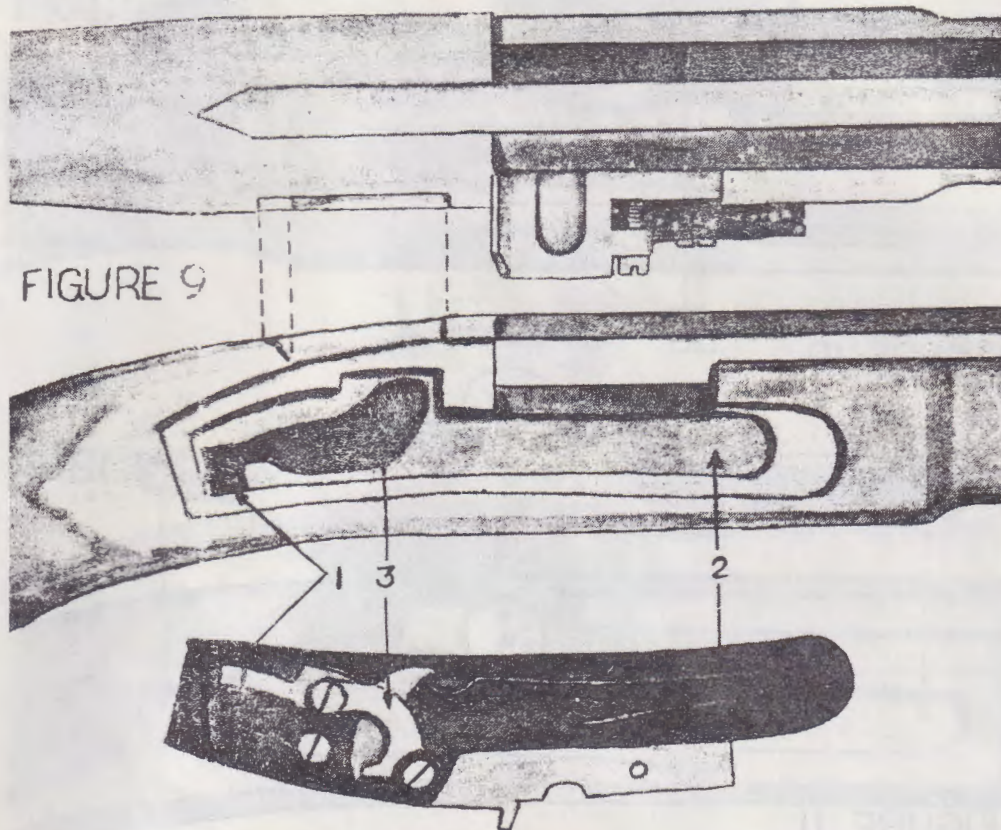


FIGURE 9

To inlet the sear arm (No. 1), use a 1/4" drill and drill 1/8" deeper than the length of the arm and enlarge for up and down motion. Continue to cut and fit (No. 2) the main-spring and (No. 3) the tumbler and sear spring mechanism. Take out only enough wood to allow the parts to work freely.

INSTALLING LOCK BOLT, SIDE PLATE AND NAME PLATE

Use the Dixie Bolt Blank with the head shown in Figure 10. Locate the position of the hole to be drilled by outlining the position of the side plate on the left side of the stock (Figure 11). Then mark the position of the bolt head so that it is fairly well centered in the upper curved tab of the side plate. The hole when drilled should pass through the stock, cut a niche in the tang reinforcement and come out through the upper reinforced portion of the lock plate.

Remove the hammer and center punch the lock plate at spot opposite the bolt mark on the left side. Carefully drill from the right side through the lock plate, stock and tang reinforcement with a No. 21 drill. The lock plate hole will act as a guide. Remove the lock plate and ream out the hole in stock and tang reinforcement with a No. 9 drill so the lock

bolt will pass through the stock. Thread the bolt blank with a 10-32 die for 3/4" and cut a slot in the head with a hacksaw. Then tap the hole in the lock plate with a 10-32 tap.

Now inlet the side plate on the left side of the stock. Bevel the edges slightly toward the underside and use lampblack and oil to assure a good fit. Drill with a No. 9 drill through the side plate using the same hole as for the lock plate. Put the lock in place, put in the lock bolt and tighten. Cut the bolt to length so that the end will be flush with the lock plate. The name plate should be 3/8" from the end of the tang and centered on the wrist (Figure 10). Trace the design of the plate and inlet with a small knife so that the plate will be flush with the wood when driven into place.

INSTALLING TRIGGER AND TANG SCREW

First, locate the spot at which the trigger arm slot should be cut. With the lock removed, draw a line across under side of the stock which corresponds to the rear of the sear arm hole. Draw a line down the middle of the underside of the stock. With a 1/16" drill, work out the narrow slot starting where the lines cross and working forward the length of the trigger arm. The slot should be about 1/4"

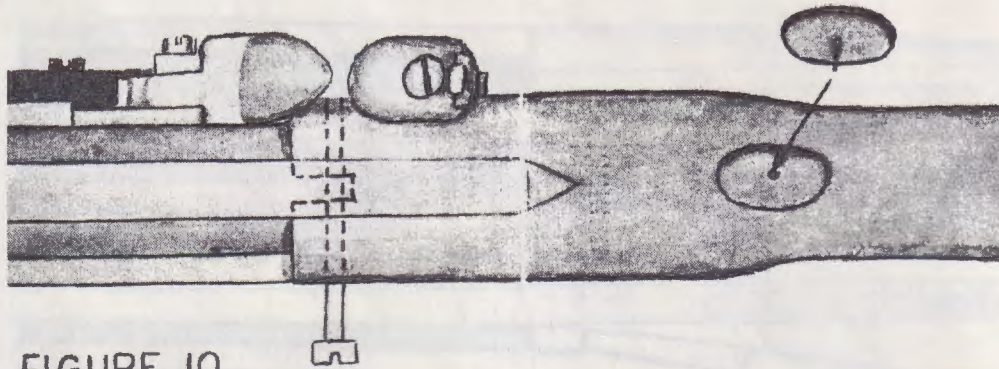


FIGURE 10

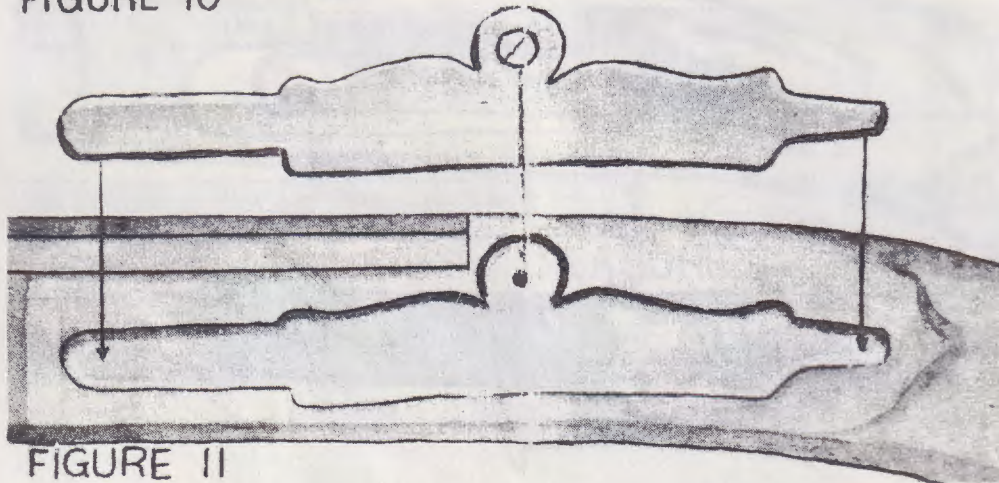


FIGURE 11

deeper than the height of the trigger arm to allow play. When the trigger arm can be inserted in the slot, mark off the trigger plate and continue inletting with a small chisel until the trigger plate is flush with the stock. A wood screw can be installed at the back of the trigger to hold it in place (Figure 12).

With the trigger installed, mark the trigger arm at the lowest spot of the sear arm hole. Remove the trigger mechanism from the stock and remove that part of the arm that blocks insertion of the sear arm. With a hacksaw cut down to within $1/32''$ of the mark on the trigger arm. File down the lower edge of the trigger arm until it does not trip the sear until the trigger is pulled.

Drill the tang screw hole from the tang on the barrel through the stock through the trigger plate. Use a No. 21 drill, which is smaller than the Dixie bolt blank, so as not to drill the hole in the trigger plate too large to cut threads for the bolt. The bolt should be threaded for $3/4''$ with 10-32 die and the trigger plate tapped with a 10-32 tap. Notch the head of the bolt blank with a hacksaw.

With the trigger plate out, ream the hole in the stock and tang with a No. 9 drill. Then, countersink the tang hole so the head of the bolt when screwed in place will be flush with the tang top (Figure 13).

INSTALLING THE TRIGGER GUARD AND BUTT PLATE

Excess metal of rough casting on trigger guard or butt plate should be removed by filing before these steps begin.

Inlet the trigger guard by first outlining and removing wood as was done for other parts (Figure 14). When the guard fits flush in the stock, clamp it in place and drill through the stock and the pinning loops on the guard with a $3/32''$ drill. Then, make trigger guard pins from No. 6 finishing nails and drive them into place. Never use wood screws to hold a Kentucky guard in place. To do so indicates second quality work.

To install the butt plate (Figure 15), begin by inletting the butt plate arm at the top of the stock. Be careful in cutting the stock to assure tight fit of metal to wood. Then, drill a hole in the arm of the butt plate the size of a steel wood screw to be used in fastening. Replace the butt plate on the stock and using the hole in the arm as a guide, drill the stock to take the steel screw. After countersinking the screw, fasten the butt plate at the top. The other steel screw should be installed the same way. With the butt plate in place, outline its shape on the stock with a pencil. Then, with the butt plate removed, use a rasp or file

FIGURE 12

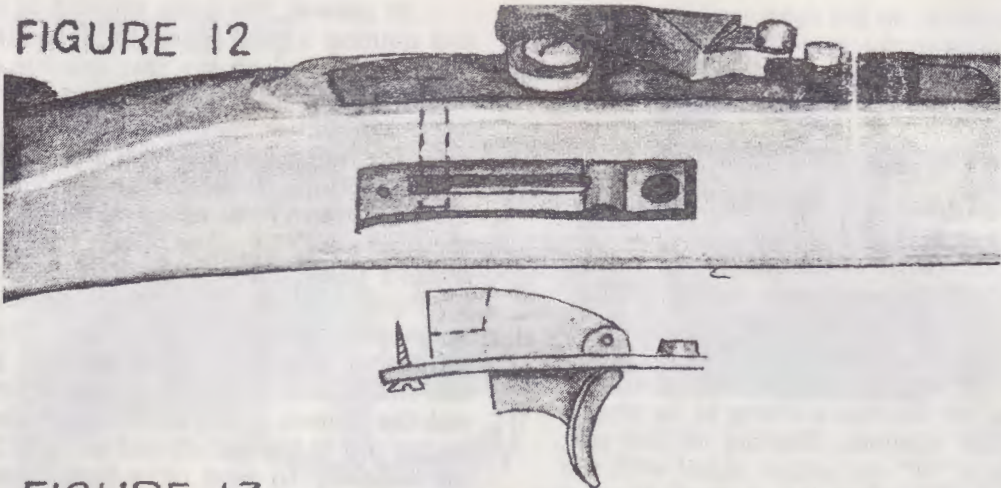


FIGURE 13

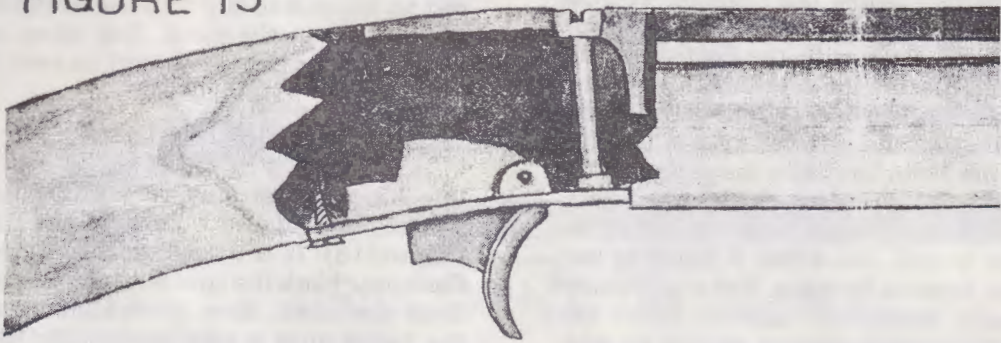


FIGURE 14

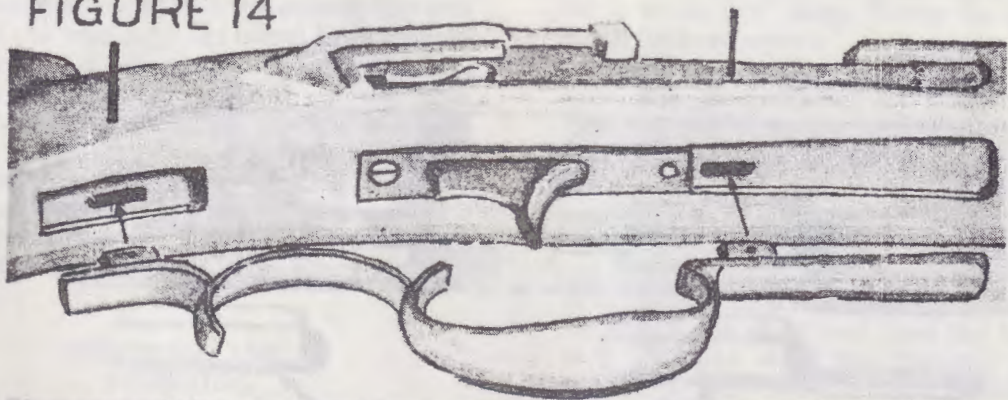
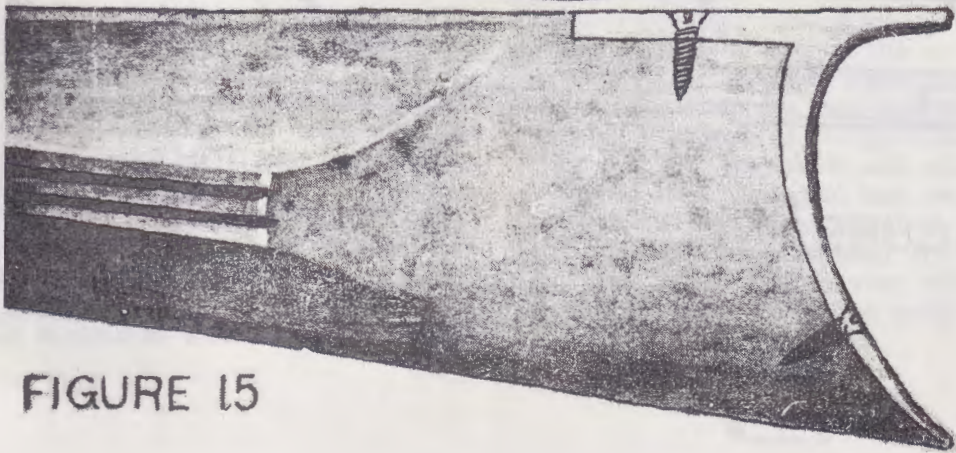


FIGURE 15



to shape the wood so the contours of the butt plate will blend perfectly with the contours of the stock. Both trigger guard and butt plate can be smoothed by rubbing with No. 000 emery paper.

INSTALLING THIMBLES AND RAMROD

The Dixie Rifle Stock Blank has a channel and hole for the ramrod already drilled. Position the forward thimble 4" from the front of the stock (Figure 16). Measure width and length of the forward thimble and draw its position on the stock sitting at its proper place on the channel. Starting at the side lines, make a "V" cut with a chisel with the point of the "V" below the channel. The cut may have to be deepened to permit the thimble inside to be flush with the bottom of the rod channel. Measure the depth of the slot and on the right side of the stock, make a line corresponding to the position of the thimble flanges in the hole. Opposite the center of the thimble and $\frac{3}{32}$ " below the marked line, drill a nail hole through stock and thimble flange with a drill. Use a No. 6 finishing nail to hold the thimble in place. The rear thimble is positioned where the ramrod enters the hole and the second thimble should be midway between the upper and lower thimbles, or about 14".

In general, the same method of inletting and pinning is used for all thimbles. However, the concave tail on the rear thimble after inletting can be made to grip the inner sides of the cut by flattening with a hammer.

The hickory ramrod has a larger diameter than the drilled hole in the stock, although the brass worm to be fitted on the rod end fits the hole perfectly. First, file a tongue on the ramrod that fits into the hole in the worm mechanism (Figure 17). Use an epoxy glue to fasten the worm on the tongue. Then, with sandpaper wrapped around the rod, graduate the rod to the diameter of the worm. Next, put the ramrod in the barrel and make a mark on the rod at the muzzle and cut it off. It may be necessary to sand off a little more of the rod to allow it to slip into the complete depth of the hole in the stock. But when installed, the end of the ramrod should be even with the muzzle.

DRILLING THE VENT

This applies only to the flintlock. Note the position of the hole with the frizzen up (Figure 18). It is located at the bottom of the flash pan. Mark the spot and remove the barrel from the stock. Now, push a small dowel into the barrel until it rests against the barrel plug and make a pencil mark on the dowel at the muzzle.

FIGURE 16

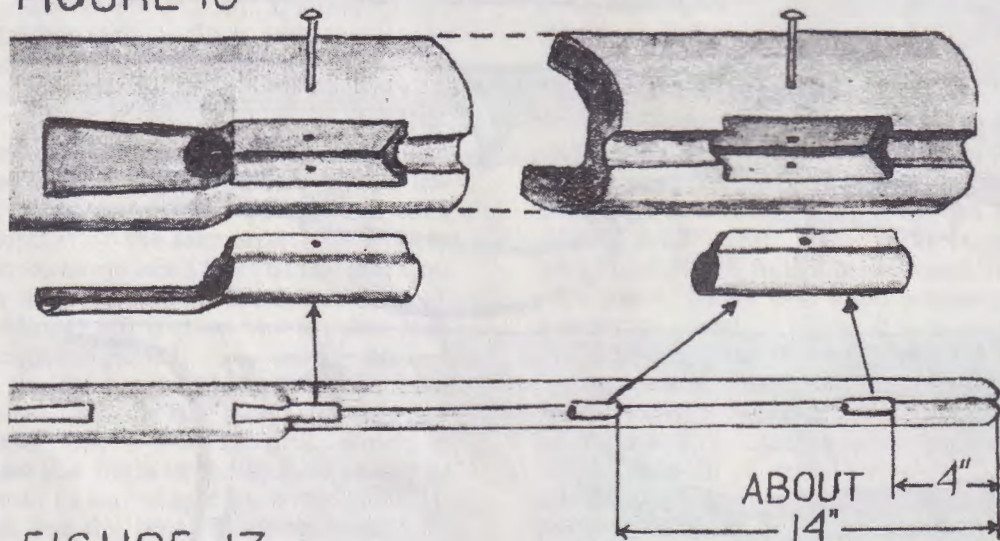
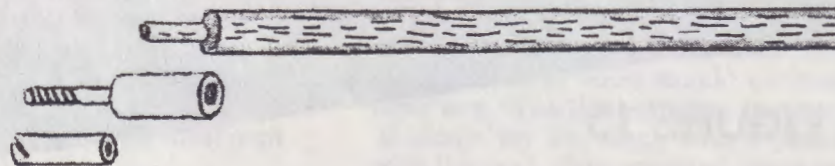
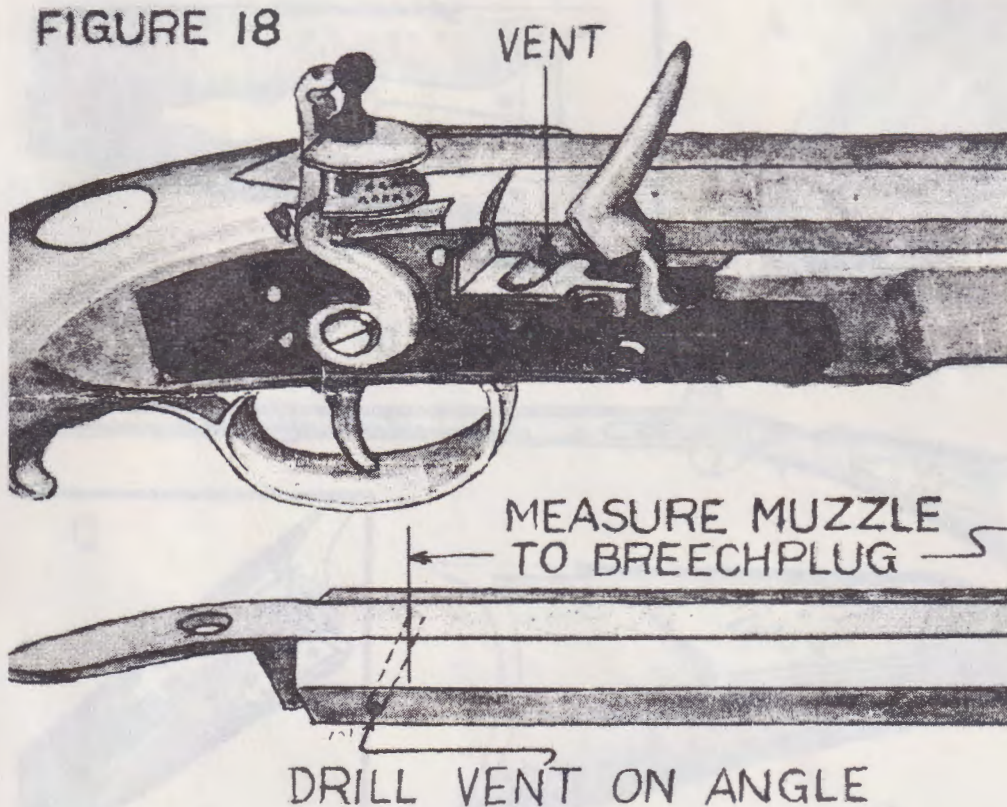


FIGURE 17





After removing the dowel from inside the barrel, place it against the outside flat and mark off the true depth of barrel from muzzle to breech plug. As shown in the drawing, this line is somewhat forward of vent hole mark. It will be necessary to drill the vent hole on a slight angle so the flash will reach the powder charge. After marking the vent hole spot with a metal punch, use a 3/32" drill to bore through. Use the line on the outside of the barrel to help you aim your drill properly.

DRESSING AND FINISHING

Figure 19 makes some suggestions on dressing up your Kentucky rifle which involve more parts than the basic kit.

(A) A nose cap may be purchased from Dixie and installed as shown, with a small screw from the bottom of the barrel inlet threaded through the cap.

(B) A spring brass or silver patch box is another Dixie item that can be installed on the right rear of the buttstock. The plate is inletted flush with the wood surface and the butt plate is notched with a half round file

to permit lifting the lid. The cavity under the lid is about 5/8" deep. Fasten the plate with small flathead screws.

(C) An eight pointed star cheekrest inlay may also be purchased at Dixie as well as other inlays. They are inletted flush with the surface and driven in place with already fixed pins or fastened with a countersunk flathead screw.

(D) A Dixie toe plate may also be installed to protect the lower tip of the buttstock. It too should be inletted flush with the under-surface of the stock and meet the butt plate. It is fastened with two flathead screws as shown. A dark spiral on the ramrod can be burned in while turning the rod before a torch flame. The finishing of the stock may be of your choice. Antique stock stain is available from Dixie, or you may wish to handrub the stock after each of 3-5 applications of boiled linseed oil. The barrel and other steel parts should be browned to help protect surfaces from rust and eliminate glare. Browning solution may be purchased from Dixie Gun Works. Accessories for your rifle may also be selected from the Dixie catalog. Let your imagination be your guide.



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PR3120 Pedersoli Kentucky Rifle .45 Caliber Percussion

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This Kentucky .45 caliber percussion rifle evolved from the German hunting rifles and was a major rival of the Brown Bess Musket. A typical firearm in use in the American Colonies and one of the most popular American rifles. This is a fullstock with American walnut and a 13 1/2" trigger pull. Barrel is blued, Octagon, 35 1/16" length with a 1 in 48" twist. Front sight is blued steel base and blade while the rear sight is blued steel open style. Features brass furniture color casehardened lock, single trigger. Overall length is 50" and weighs 6 1/2 lbs. Manufactured by Pedersoli/Italy.

THIS PRODUCT CANNOT BE SHIPPED TO CANADA.

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