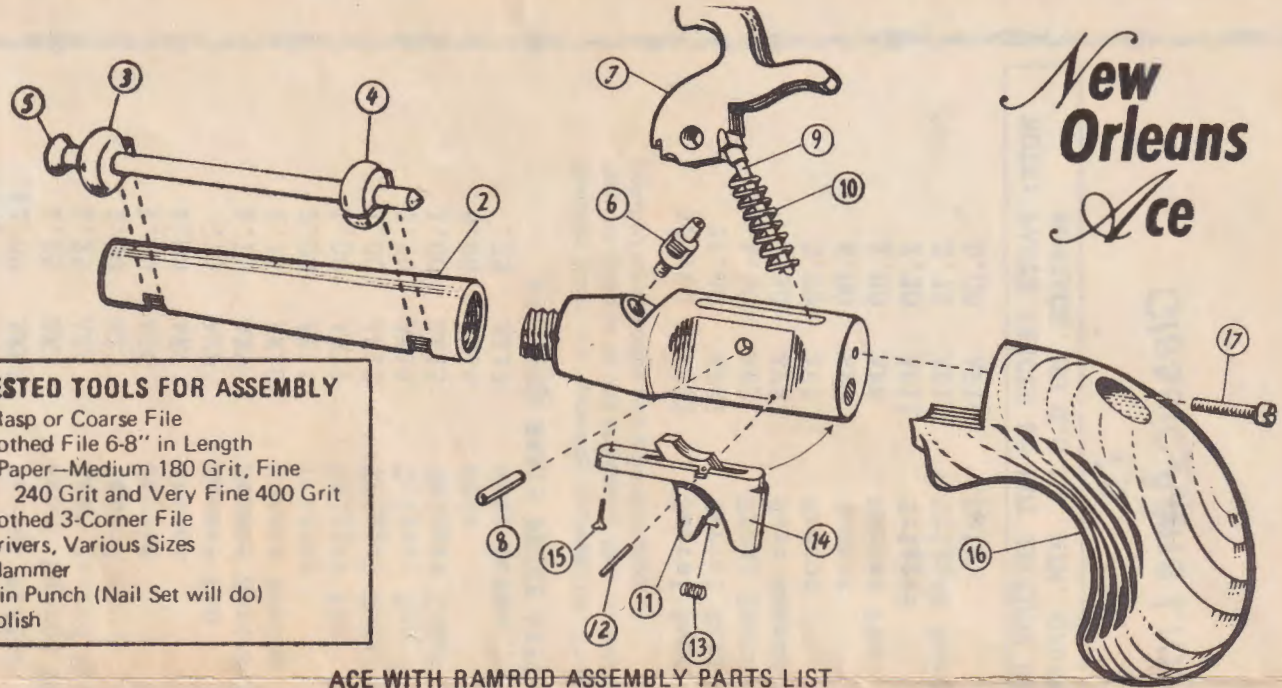


New Orleans Ace



SUGGESTED TOOLS FOR ASSEMBLY
 Wood Rasp or Coarse File
 Fine-toothed File 6-8" in Length
 Emery Paper—Medium 180 Grit, Fine 240 Grit and Very Fine 400 Grit
 Fine-toothed 3-Corner File
 Screwdrivers, Various Sizes
 Small Hammer
 Small Pin Punch (Nail Set will do)
 Brass Polish

ACE WITH RAMROD ASSEMBLY PARTS LIST

1. Receiver	5. Ramrod	9. Hammer Spring Retainer	13. Trigger Spring
2. Barrel	6. Nipple	10. Hammer Spring	14. Trigger Guard
3. Front Ramrod Mount	7. Hammer	11. Trigger	15. Trigger Guard Screw
4. Rear Ramrod Mount	8. Hammer Pin	12. Trigger Pin	16. Grip
			17. Grip Screw

BUILDING A MUZZLE-LOADING GUN HAS PROVEN TO BE AN EXTREMELY POPULAR AND FASCINATING PASTIME. THE BASIC ELEMENTS ARE HERE TO COMPLETE A TRULY FINE DISPLAY OR SHOOTING PIECE AND WITH MOST OF THE DIFFICULT WORK DONE. THIS KIT CAN BE ASSEMBLED BY THE REASONABLY ADEPT DO-IT-YOURSELFER WITH JUST THE TOOLS IN HIS WORKSHOP.

Unpack contents of the kit and inspect parts using exploded view drawing and assembly part list. It is suggested that reader read through the instructions before starting in order to become familiar with the assembly. At this time remove any unnecessary burrs from the parts and polish to your liking.

A GRIP-16 Using GRIP SCREW-17, attach unfinished grip to RECEIVER-1 and carefully scribe a ring on the grip around the receiver. Remove grip screw and grip. Use a sanding belt, file or sandpaper attached to a block, and shape the front of the grip to match the contours of the receiver. Remove all extra wood until the grip has the contours of the grip in the drawing. Assemble grip to receiver to be sure the fit is proper. Again remove and finish WITH the grain of the wood until a very smooth surface is obtained. You are now ready to apply a finish of your choice, perhaps linseed or Birchwood Casey Tru-Oil—stain unnecessary. Put grip aside to dry and proceed to complete the rest of the "ACE".

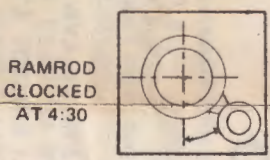
B HAMMER-7 Note! Necessary parts have been precision heat treated (hardened) for your convenience. **DO NOT ALTER** the grooves and machined surfaces at the **BOTTOM** of the hammer.

C TRIGGER-11 DO NOT FILE OR ALTER in any way the part of the trigger that will come in contact with the HAMMER.

D HAMMER & TRIGGER POLISHING Polish the trigger and hammer, and if a

high bright polish is preferred, buff the FINGER SURFACE of the trigger and all of the top of the hammer using a cloth buffing wheel and buffing compound.

E REAR RAMROD MOUNT-4 Assemble ramrod mount into the dovetail slot at the rear of the barrel. **FRONT RAMROD MOUNT-3** should then be assembled into dovetail slot at front of barrel. It may be necessary to file a small lead on the ramrod mount dovetails so they will start into barrel dovetail slots more readily.



FINAL ASSEMBLY OF THE ACE to follow after all finishing coats have been applied to grip and the grip is dry.

F Assemble NIPPLE-6 by screwing same into receiver.

G Slip HAMMER SPRING-10 over the HAMMER SPRING RETAINER-9. Insert the pointed end of the spring retainer into the angled hole in the LOWER inside of receiver. Hold this assembly in place with your left hand while placing the hammer

in place and force hammer against the spring until the hole in the hammer lines up with the hole in the receiver — at which time **HAMMER PIVOT PIN-8** must be inserted into the LEFT side of receiver. Once again, taper end of pivot pin must be inserted into the receiver first. Pivot pin will have to be tapped into place with a punch, being careful not to scratch the receiver. Do not let hammer fall onto the nipple without a percussion cap.

H Assemble TRIGGER-11 into receiver, inserting TRIGGER PIVOT PIN-12 from the LEFT side of the receiver as shown on diagram. Look at PIVOT PIN carefully. One end is chamfered or has a slight taper to allow it to assemble easily. Tap pivot pin through trigger into right-hand side of receiver.

I Assemble TRIGGER SPRING-13 into blind hole inside trigger guard.

J Assemble TRIGGER GUARD-14 into receiver using TRIGGER GUARD SCREW-15, 4-40 x 1/4 flathead screw.

K Screw barrel into place.

L Assemble GRIP-16 to receiver with GRIP SCREW-17. Your ACE is now complete! We suggest wiping off all finger prints and applying a light coat of oil to prevent rusting. If the ACE is going to be fired, a drop of oil on the trigger pivot pin and hammer pivot pin is recommended as well as on the end of the spring retainer where it comes in contact with the hammer.

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SATISFACTION GUARANTEED: This pistol kit is guaranteed against breakage and defects in our workmanship and materials. Upon inspection, before any work is started, return damaged parts for replacement. Any work done on a part before it is returned voids guarantee.
 see other side

KIT PARTS PRICE LIST

Price	Part #	Description
\$10.00	AKS2	Barrel Smoothbore
12.00	AKR2	Barrel Rifled
1.25	AK3	Front Ramrod Mount
1.25	AK4	Rear Ramrod Mount
2.50	AK5	Ramrod
1.00	AK6	Nipple
4.00	AK7	Hammer
.75	AK8	Hammer Pin
1.75	AK9	Hammer Spring Retainer
1.75	AK10	Hammer Spring
2.00	AK11	Trigger
1.00	AK12	Trigger Pin
1.00	AK13	Trigger Spring
2.50	AK14	Trigger Guard
1.00	AK15	Trigger Guard Screw
6.00	AK16	Grip
.75	AK17	Grip Screw

POLISHED PARTS PRICE LIST

Polished parts are generally ordered for finished guns, but may be ordered by kit builders if they so desire. Each part is polished for assembly into a finished product.

\$20.00	APS2	Barrel Smoothbore
22.00	APR2	Barrel Rifled
1.50	AP3	Front Ramrod Mount
1.50	AP4	Rear Ramrod Mount
3.50	AP5	Ramrod
6.00	AP7	Hammer
1.00	AP8	Hammer Pin
2.50	AP11	Trigger
3.75	AP14	Trigger Guard
9.00	AP16	Grip

NOTE: PARTS PRICES DO NOT INCLUDE HANDLING & POSTAGE. NO C.O.D. MIN. ORDER \$2.50

Classic Arms Ltd.

New Orleans Ace-Firing Instructions

- 1) WILL NOT FIRE CARTRIDGE BULLETS. DO NOT USE SMOKELESS POWDER OR ANY COMBINATION THEREOF. FIRES BLACK POWDER ONLY.
- 2) NOTE: Follow safety procedures at all times when loading & firing any firearm . . . shooting glasses also recommended. Widely recognized 235 pg. guide to black powder shooting, "Lyman's Black Powder Handbook" may be obtained by sending **7.95** to Spare Parts Department.
- 3) Use No. 11 percussion cap over nipple to ignite powder, 18 grains grade FFFG black powder only into barrel, with recommended solid lead ball sizes & patches:

	Rifled
Smoothbore (no rifling inside bbl)	.440 round ball/.010 patch
.424 round ball/.015 patch	.450229 minie (conical)/no patch
- 4) Place oiled patch around ball and holding ramrod between fingers (not in palm of hand), tamp ball down barrel. Firm pressure necessary when starting ball into rifled barrel — ball starter may be used to start ball in. If minie or conical ball is used with no patch, Hodgdon's Spit Ball or similar lubricant is recommended around ball. Tamp ball down barrel **FIRMLY SEATING IT AGAINST POWDER. DO NOT LEAVE AIR SPACE BETWEEN BALL AND POWDER. DANGEROUS COMBUSTION MAY RESULT.**
- 5) Place percussion cap over nipple, aim & fire. To maintain & preserve your firing piece, and prevent corrosion & fouling from black powder residue, thoroughly clean with suitable cleaning solvents after each use. Hoppes 9+ or similar lubricant may be used for oiling patches as well as later cleaning your firearm.

CAUTION

NEVER FIRE A MUZZLE-LOADING FIREARM UNLESS THE BALL OR MINIEBALL IS FIRMLY SEATED AGAINST THE POWDER CHARGE

Do not overload the bbl with excessive amounts of black powder. The best velocity creating the lowest, safest pressures will be obtained using recommended charges of black powder. Increasing the pressures in the barrel will not increase accuracy. Unreasonably heavy charges of black powder can be dangerous.

Do not attempt to shoot a stuck ball free from the barrel. If due to powder fouling or other circumstances, the projectile becomes lodged part way down the barrel then the firearm must be disassembled and the charge & ball removed. This is extremely important for, under such a condition, the stuck ball is acting as a bore obstruction. Firing will cause damage to the firearm and possible injury to the shooter.

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