

AMERICAN PISTOLSMITH'S GUILD  
SINGLE ACTION REVOLVER  
CHECK SHEETS

This check list consists of four major sections:

- 1.) Action tuning
- 2.) Major component fitting
- 3.) Installation of accessories
- 4.) Finishing

Each check sheet item or modification cited is required unless otherwise noted. Although optional modifications are not required, they will add to the quality and appearance of the revolver and will, consequently, make a favorable impression on the examiners. In a formal inspection, field representatives will apply the following notations to the blanks provided at the left margin:

S: Satisfactory

U: Unsatisfactory

NA: Not applicable

These sheets were originally devised for the new Ruger Blackhawk revolvers, but are generally applicable to all makes and models. Feel free to contact Guild officers with any questions.

## I. ACTION TUNING

1.) Smooth action cycle: action should run smoothly, free of roughness, hitching and binding.

2.) Timing:

a.) Unlock timing: cylinder stop must drop clear of the cylinder notches before rotation starts.

b.) Carry up timing: cylinder bolting and hammer cocking should occur simultaneously. If the hammer cocking can be deliberately cocked without bolting, the timing is too slow.

c.) 1st and 2nd hooks on the hand should not be too close together and allow binding or hitching on the ratchet teeth.

3.) Trigger pull:

a.) Free of excessive creep.

b.) Free of backlash.

c.) Pull weight 2.5 to 4 pounds.

d.) Sufficient trigger return spring pressure to allow the trigger to return reliably.

e.) Sear engagement must be sufficient to preclude hammer pushoff.

f.) Trigger overtravel stop (optional):

i.) Trigger/sear surfaces clear halfcock notch on old style guns.

ii.) On Ruger New Models, sear surfaces must no 'bump' when hammer fall starts.

iii.) Installation attractive and unobtrusive.

4.) New Model Rugers or similar: transfer bar must function correctly. Firing pin should not move when the hammer is lowered with the trigger forward.

## II. MAJOR COMPONENT FITTING

1.) Cylinder:

a.) Endfloat not to exceed .0005" to .001".

b.) Cylinder should rotate freely on the basepin without binding.

c.) Receiver cylinder bearing areas reasonably smooth and square.

d.) Headspace correct for caliber chambered. .060" to .065" on standard cartridges.

e.) Cylinder stop notch free of damage and burrs.

f.) Front face of cylinder square.

2.) Barrel (custom barrel required)

a.) Cylinder gap maximum .004" to .005" on guns with standard cylinders.

b.) Cylinder must not drag on barrel extension during action cycling.

c.) Barrel to cylinder gap square.

d.) Forcing cone smooth, symmetric and of proper depth, checked with a plug

depth gauge.

e.) Front sight:

i) On straight

ii.) Silver solder cleaned well and free of gaps.

iii.) Sight should sit flush with the corner of the muzzle crown.

f.) Ejector housing:

i.) Should be pulled down to barrel and free of gaps.

ii.) Tube should be pulled up tight to the receiver face.

iii.) If installed on a short barrel, the end of the tube should be flush with the corner of the muzzle crown.

3.) Grip frame and receiver fit: Parts should align with no over or under lap.

Polishing should match and corners sharp when parts are separated.

### III. ACCESSORIES

\*\*\*Optional. Very few after-market accessories are available for single action revolvers. However, there are a few common ones that builders should be able to utilize.

1.) Scope mounts and bases: Installed as per the makers instructions. Mount should be on straight and square with properly drilled and tapped holes.

2.) Adjustable rear sights: Must have proper functioning and free of binding.

3.) Grips: Should be attractively shaped, well fitted with no gaps, and fitting flush with the grip frame.

#### IV.) FINISH

##### 1.) Metal preparation:

a.) Surfaces ripple free; corners sharp; screw holes crisp.

b.) Screw heads free of damage.

c.) Welding should not show hardness which effects bluing or plating. Should be free of pits and inclusions and be properly finished.

d.) Solder joints free of gaps and without excessive solder.

##### 2. Finish proper:

a.) Bluing and plating should be evenly applied, free of clouds, spots, and discoloration.

b.) Matte finishes should be even with no over-spray.

c.) If the receiver on Ruger revolvers are color case hardened, the firing pin bushing retaining pin should be finished and oriented properly.

##### 3.) Serration's and checkering (optional):

a.) Should be even with parallel lines and diamonds, sharp, and free of runovers and dents.

b.) There should be no overruns and the edges should be even.

FIELD INSPECTORS GENERAL REMARKS AND OBSERVATIONS: