

# BRUBAKER ARMS MANUFACTURING<sup>©</sup>

EST. 2009

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Brubaker Arms Manufacturing LLC is one of the largest Gunmaking / Gunsmithing / Firearm Maintenance and Classic Custom Sporting Rifles and Shotguns Manufacturing facility in PNW. With a shop floor area of almost 3700sqf (developed and / or in development) and 700 sqf of offices, our facility offers the greatest variety of gunsmithing services available in PNW. All our gunsmithing staff are licensed gunsmiths who have graduated from accredited USA institutions. Visit our offices for all your gunsmithing needs. From general maintenance to full custom builds, you will be satisfied with your choice.



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- your premier place for Classic Custom Sporting Rifles and Shotguns -

CUSTOM GUNSMITHING AND GENERAL FIREARM REPAIRS, YAKIMA WA

## COMMON GUNSMITHING SERVICES

\* This list is not a comprehensive list of the services we offer.

\* We are often requested to estimate the amount of fees and costs likely to be incurred in connection with a particular project. Whenever possible we will furnish such an estimate based upon our professional judgment, but always with a clear understanding that the estimate is not a maximum or fixed fee quotation. The ultimate charges may be more or less than the amount estimated.

\* Difficult / complicated brands require extra work; this includes but is not limited to anything with more than one barrel, all German brands, Remington M10, Buffalo Newton, Old firearms, obscure brands, home-made guns.

### SERVICES:

#### 01. FIREARM MAINTENANCE

	SERVICE	DETAILS
1	Quick Clean	Field strip gun + ultrasonic clean, oil & reassembly (no painted guns)
2	Diagnostic Clean (DCOA)	Complete disassembly, clean all parts, examine for wear / potential breakage; we will quote cost of replacement parts if they are necessary to bring the gun in A-1 condition We work on long guns, double guns, hand guns, etc.
3	Bead, sandblast or wire brush stainless steel*	*if firearm is oily and dirty, may be subjected to Diagnostic Clean (DCOA)
4	Drill & Tap	a. Drill & tap new holes for bbl, receiver, slide, etc., both for regular and hardened steel
		b. Plug hole with screw, re-drill and tap
		c. Remove broken screw
		d. Weld in old screw hole, redrill + tap; this WILL damage finish and will require refinishing.
5	Install scope	Mount and boresight scope
6	Bore sight	
7	Pattern shotgun	
8	Sight in scoped rifle	At 100 yards or custom
9	Check headspace	Gauges fees may apply
10	Chamber cast	Customer can keep the cast for an additional fee
11	Remove obstructions	a. Stuck case, if fired
		b. Stuck round, if live
		c. Other obstructions, including muzzleloaders (balls and broken ramrod); no guarantees about post condition; may not be salvageable.
		d. Remove fouling from barrel
12	Lap barrel	
13	Glass bedding barrel & action	a. Hunting Rifles
		b. Match Rifles, M-1 Garand, M1A
14	Pillar bedding barrel & action	Aluminium pillars bedded in glass bedding
15	Install recoil pad	Both wood and synthetic stocks (hallow synthetic stocks will require wood block bedding)
16	Make & install springs	Cost depends on the complexity of the spring
17	Re-solder rib	Will require refinishing, especially if silver soldering
18	Re-solder forend lug	Will require refinishing, especially if silver soldering
19	Raising dent in barrel	Might require refinish, depending on position and depth of dent
20	Straighten or adjust barrel	Might require refinish (shotguns only)
21	Refitting hinge pin lug	Might require refinish
22	Straighten crane on revolver	Might require refinish
23	Tighten slide	1911 auto

#### 02. METAL WORK

	SERVICE	DETAILS
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24	Stripping nickel	
25	Draw filing	
26	Bevel Magazine well	for 1911 Auto
27	Open and modify ejection port	for 1911 Auto slide
28	Throat, polish chamber and feed ramp	for 1911 Auto - feeding issues and general improvement of functioning
29	Open bolt face	For larger cartridges
30	Mill bolt for M16 style extractor	
31	Lap in bolt lugs	
32	Welding on new bolt handle - will require polishing and finishing or coating - might require polishing and refinish and inlet stock for new bolt handle / knob; finishing, coating and inlet quoted separately.	
33	Forging bolt handle - will require polishing and finishing or coating - might require polishing and refinish and inlet stock for new bolt handle / knob; finishing, coating and inlet quoted separately.	
34	Threading bolt handle for knob - might require polishing and refinish and inlet stock for new bolt handle / knob	
35	Inlet stock for new bolt handle	
36	Installing aftermarket safeties / safety modifications; all safety installs will require refinishing	
37	Install crane lock for revolvers	
38	Remove / modify revolver hammer spur	
39	Fit & Install barrel bushing on 1911 Auto	
40	Fit custom hammer	
41	Sight ordering fee	applies especially to rifles, where precise measurement is required
42	Milling slide for red dot sight	
43	Milling dovetail slot	
44	Solder on front ramp	will require refinish
45	Screw-on front ramp	drill & tap – regular and hardened steel
46	Swap sights	- for standard guns - difficult brands Sig, Beretta, M&P Shields, Kimber and other
47	Install front sights	- stake-on - fiber optic (existing dovetail or new cut dovetails)
48	Install rear sight	existing dovetail, or new cut dovetail
49	Install insert in pistol sight	includes insert
50	Install fiber optic	includes fiber optic
51	Flatten rear sight	existing dovetail, or new cut dovetail
52	Cut slide for BO-MAR sight	usually for 1911's
53	Cut slide for Novak rear sight	usually for 1911's
54	Installation or adjustment of trigger	including trigger jobs for rifles and shotguns, for the following – but not limited to: - Shilen, Timney, Dayton-Traister, Moyer type - double sets - single sets - 1911s - ARs
55	Action job	clean, smooth action - revolvers - semi-auto pistols
56	Threading barrels	cut, crown & thread barrel thread muzzle for muzzle brake or suppressor (does not include muzzle installation or thread protecting cap) pin & weld muzzle brake to barrel
57	Muzzle brakes – Brubaker Arms TriCircle 'Brake	- thread barrel, make & install custom in-house made muzzle, flush to the bbl and matching the profile and the finish of the bbl – (barrel needs to be at least .650"+dia or needs to be cut down up to that dia.), timed - if the barrel is threaded, make & install custom in-house made muzzle, flush to the bbl and matching the profile and the finish of the bbl – (barrel needs to be at least .650"+dia or needs to be cut down up



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		to that dia.), timed
58	Brubaker Arms ManuFacturing 'Brake	- thread barrel, make & install custom in-house made muzzle, flush to the bbl and matching the profile and the finish of the bbl – BAMF 'Brake: Brubaker Arms ManuFacturing 'Brake: Larger ports than our TriCircle 'Brake, with 4 .125" ports 60* off top Centerline (30* each side), timed - if the barrel is threaded, make & install custom in-house made muzzle, flush to the bbl and matching the profile and the finish of the bbl – BAMF 'Brake: Brubaker Arms ManuFacturing 'Brake: Larger ports than our TriCircle 'Brake, with 4 .125" ports 60* off top Centerline (30* each side), times
59	Custom thread protecting cap	Matches barrel diameter and finish
60	Custom adapter	1/2 – 28 to 5/8 – 24 adapter
61	Install barrel band swivel	Silver solder – comes with certification that the soldering has been made with high temp silver solder that will withstand the temp of the caustic salt tanks; non-silver soldering would limit the future bluing options.
62	Lengthen forcing cone	Non-plated bores Plated bores
63	Install liner in the barrel	Starting at
64	Cut down and crown barrel	Rifles and Shotguns / Handguns, may need refinishing
65	Rebarreling	- if barrel is blank (chamber and fit barrel to action) - if barrel is pre-threaded and chambered – simple barrel swap - revolvers - 1911s, non-Ramped Barrel, drop in - 1911s, non-Ramped Barrel, full fit - 1911s, Ramped Barrel, drop in - 1911s, Ramped Barrel, full fit - AR barrel – subject to "home builder fee"
66	Re-chambering	basic, starting at
67	Back-boring	non-plated bores only
68	Open / modify chokes	per barrel or tube, non-plated bores only
69	Install screw-in choke	- single barrels, non-plated bore - single barrels, plated bores - double barrels, non-plated bores - double barrels, plated bores
70	Port barrel	shotguns only

### 03. AR WORK

*\*all AR fees are subject to the "home builder fee"*

	SERVICE	DETAILS
71	Install aftermarket trigger	Trigger not included
72	Install aftermarket forend / free float	Forend not included
73	Assemble	- Complete upper - Complete lower - Complete rifle
74	Install flash hinder	- on pre-threaded barrel
75	Install / replace	- gas block - AR barrel - buttstock & buffertube
76	Open gas port for functioning	
77	AR action jobs	



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## 04. AK WORK

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\* prices include machine and bench time only; metal finishes not included

	SERVICE	DETAILS
78	Complete assembly	Under folder model, price starting at AKM model
79	Modifications	Galliel style charging handle – weld on bolt handle Side mount scope Bore gas port Populate barrel – rear sight base, gas block, front sight pressed on to the bbl and pinned in place Press in bbl + adjust headspace Bore bbl cross pin hole + install pin AK flat bending to serialized receiver – this is considered manufacturing according to ATF + we must serialize + report creation of firearm Barrel swap – press off old barrel, install Front sight gas block – cut, thread + crown (require correct metric dye), includes boring out gas port to function with shorter dowel time Make safety bolt hold open

## 05. METAL ART WORK

	SERVICE	DETAILS
80	Custom slide profiling	- will require refinish
82	Convert revolver from square butt to round butt	- if the wood handles don't need to be modified; - will require metal refinish; - if the wood handles do need to be modified as well; - will require metal refinish;
83	Jeweling / engine turning	- bolt or small parts
84	Re-contour front or rear receiving ring	
85	Dehorn and break edges for carry	- will require refinish
86	Full melt down bevelling	- will require refinish
87	Checker front strap of frame on 1911 auto	- will require refinish
88	Hand Engraving	
89	Laser Engraving	

## 06. METAL TEXTURE

	SERVICE	DETAILS
90	DIP	<p>If you chose to prepare the metal yourself, you are welcome to do so. We will do the bluing exclusively, based on a liability release form that you sign.</p> <p><i>If you are sending your project in for a "dip", we do not do any metal preparation for you. It must arrive in the shop completely rust-free and polished to your satisfaction. Please do not send any rusty parts for a dip – no matter how light the rust, bluing will not eliminate it. Preparation should include stripping old bluing, then bead blasting with an abrasive (e.g. glass bead or aluminum oxide) to remove rust, followed by polishing from lower to higher grits. It is important that you properly oil and package your prepared metal, as surface rust can form in a very short period of time, especially in transit environments.</i></p> <p><i>When we receive your firearm, we will evaluate it to be sure there is no rust present, and then run it through the bluing tanks in the next bluing session. If rust is present we will contact you regarding your options.</i></p> <p><i>If you have aluminum parts that accompany your dip, we can Cerakote those parts for an extra fee.</i></p>



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91	MATTE	Abrasive / bead blast / wire wheel followed with all screw holes and corners protected and square.
92	SATIN	Abrasive / bead blast / wire wheel followed with all screw holes and corners protected and square. Finished with Scotch-Brite.
93	SEMI-GLOSS	Polished to #320 grit polish with all screw holes and corners protected and square. Finished with Scotch-Brite.
94	HIGH-GLOSS	Polished to #600 grit polish with all screw holes and corners protected and square. Finished with Scotch-Brite.
95	MIRROR	Polished to #1500 grit polish with all screw holes and corners protected and square; all polishing marks removed, no ripples, and finished with #1500 polish to a mirror finish. Finished with Scotch-Brite.

## 07. METAL FINISHES – include bead blasting only:

	SERVICE	DETAILS
96	CAUSTIC SALT BLUING / HOT BLUING / OXYNATE® 7 REBLUING	Handgun Long gun
97	BELGIAN BLUING / EXPRESS BLUE	Handgun Long gun
98	SLOW RUST BLUING	
98	SLOW RUST BROWNING	
99	NitreBlue™ / FIRE BLUING	Offered for small parts / accessories only, one basket of parts
100	ANODIZING	Aluminum only
101	COLOR CASE HARDENING	full rifle, less barrels - starting at, does not include metal preparation one part - starting at, does not include metal preparation
102	CHARCOAL BLUING	Pair with mirror polish to replicate the Traditional Colt Blue.

## 06. METAL COATINGS

	SERVICE	DETAILS
103	CERAKOTE	
104	DURACOAT	
105	PARKERIZING	Steel only

## 07. WOOD / STOCK WORK

	SERVICE	DETAILS
106	Install adjustable butt plate	
107	Install sling swivels – standard and quick detach	
108	Install stock cross bolt	– will require refinish
109	Install recoil reducer	– simple installation in synthetic buttstock – Hydraulic buttplate-style (Gra-Coil or Counter Coil®) – Drill Stock & Install Recoil Reducer
110	Inletting and finishing of semi-finished stock	- starting price, not including checkering, recoil pad, special butt plate, grip cap or other attachments (includes lacquer / varnish on stock)
111	Fit, bed and finish fiberglass stock blank	
112	Prefinished synthetic stock	– fit and install barrelled action
113	Install adjustable comb hardware	- might require refinish
114	Cut synthetic stock + bed wood internal section for re-attaching recoil pad	- when the synthetic stock is cut and is empty on the inside
115	Fit recoil pad	
116	Repair cracked stock	

## 08. STOCK DUPLICATING

	SERVICE	DETAILS
117	Make custom pattern for client, fitted to arm,	



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	shoulder, face physiology	
118	Return pattern fee, if client brings his own pattern and wants it	- this covers the time necessary to fit the pattern into the duplicator and return it to original condition
119	Duplicating stock, inlet to about 95%	- first stock, average complexity
		- additional stock, average complexity
		- first stock, higher level of complexity
		- additional stock, higher level of complexity
120	Hand inletting by the hour	

## 09. WOOD / STOCK ARTWORK

	SERVICE	DETAILS
121	Recutting Checkering	
122	New Checkering	
123	Custom Checkering - 1 of a kind art	

## 10. WOOD FINISHES

	SERVICE	DETAILS
124	Total stock restoration	strip to bare wood, raise marginal dings & scratches, seal wood pores, recut checkering, rubbed oil to desired finish: matte, gloss, high gloss
125	Stock Refinish	- only for varnished / lacquered stocks: strip to bare wood, steam, sand, spray for STANDARD stock
		- only for varnished / lacquered stocks: strip to bare wood, steam, sand, spray for COMPLICATED stock
126	Stock Refresh	- knock-down, re-spray / oil for STANDARD stock
		- knock-down, re-spray / oil for COMPLICATED stock

## 11. WOOD COATINGS

	SERVICE	DETAILS
127	Weatherby Finish	two part epoxy varnish

## 12. PACKAGES - Save 15%-20% when purchasing a package vs. purchasing the services individually.

	SERVICE	DETAILS
128	Accurizing package	- True bolt face
		- True receiver face (and recoil lug on Remington type actions)
129	Accurizing package	- Lap bolt and inner lugs and recoil lug
		- Chamber to minimum head space
130	Full restoration	- Bed action to stock and free float barrel – GLASS BEDDING
		- Set trigger to 3lb or otherwise specified
128	Accurizing package	- True bolt face
		- True receiver face (and recoil lug on Remington type actions)
129	Accurizing package	- Lap bolt and inner lugs and recoil lug
		- Chamber to minimum head space
130	Full restoration	- Bed action to stock and free float barrel – PILLAR BEDDING
		- Set trigger to 3lb or otherwise specified
130	Full restoration	Rifle:
		- full stock restoration (includes steaming)
130	Full restoration	- checkering restoration
		- hot bluing restoration
130	Full restoration	- polishing
		- install rails for scope
130	Full restoration	- install recoil pad
		- DCOA
130	Full restoration	Shotgun:
		- full stock restoration (includes steaming)
130	Full restoration	- checkering restoration



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		<ul style="list-style-type: none"> <li>- slow rust bluing</li> <li>- polishing</li> <li>- install recoil pad</li> <li>- DCOA</li> </ul>
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### 13. WRITTEN APPRAISALS

	SERVICE	DETAILS
131	Appraisals for insurance companies (fire / water / smoke damage)	<p>Firearms collections can constitute a valuable loss in case of fire hazards. Our company can assist you with minimizing your loss by providing you with a written appraisal on a letterhead document. Our written appraisals packages include the following, but we can customize your package as requested by your insurance company:</p> <ul style="list-style-type: none"> <li>- close inspection of each firearm;</li> <li>- establishing the market value of the firearm prior to the fire hazard and after;</li> <li>- when the firearm is a collectible item that had been conserved in original finish: loss of collectible value</li> <li>- list of services needed for bringing the firearms back to the original value, with quotes at our shop rates</li> </ul>
132	Appraisals for manufacturing companies	<p>Although most manufacturers provide a high-standard quality control, sometimes firearms present function faults from manufacturing. If your firearm is still covered by warranty, it is cheaper for our customers to ship the firearm back to the original manufacturer rather than covering the repair cost. In that case, we will provide you with a written appraisal to ship with your firearm to the manufacturers.</p> <p>Our written appraisals usually include:</p> <ul style="list-style-type: none"> <li>- close inspection of the firearm;</li> <li>- function testing;</li> <li>- proof of malfunction from production.</li> </ul>

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509-367-6614

2107 E Mead Avenue Yakima WA 98903

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