



HAMMR

Handgun Accurizing Mechanical Machine Rest

Universal Grip Casting Kit Instructions



Limited Warranty

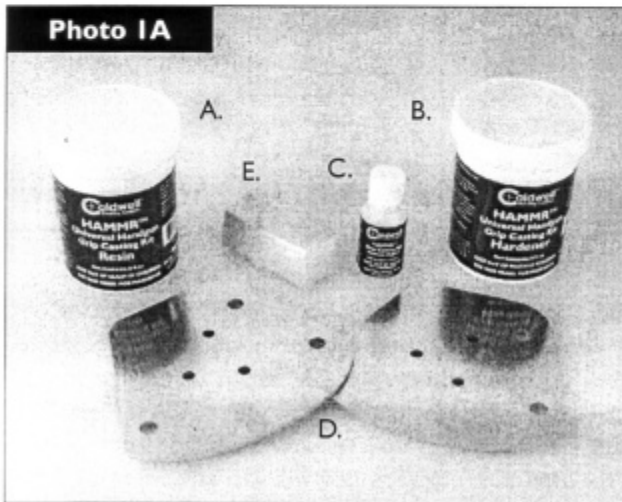
Every Caldwell product is warranted to be free of defects in materials and workmanship for a period of one (1) year from the date of original purchase. Caldwell will, at its option, repair or replace without charge, except for transportation costs, parts that fail under normal use and service when operated and maintained in accordance with our Instructions. This warranty does not apply to normal wear or to items whose life is dependent upon their use and care. This warranty is in lieu of all other warranties, expressed or implied and releases Caldwell, its affiliates, and its vendors from all other obligations and liabilities.

Instructions read top to bottom, left to right.

The HAMMR is a universal machine rest that is designed to test a wide variety of handguns. In addition to the 22 stock grip inserts that we sell, we offer this Universal Grip Casting Kit. This Universal Kit provides most of the tools necessary for you to create a set of grip inserts for virtually any handgun you may have.

THE CONTENTS OF THE UNIVERSAL GRIP CASTING KIT

Photo 1A



1. Please take a moment to locate all of the items in the Universal Grip Casting Kit. (See Photo 1A)

- A. 6 oz. container of resin
- B. 6 oz. container of hardener
- C. .5 oz. container of release agent
- D. (2) aluminum grip insert plates
- E. molding clay

In addition to the items included in the Universal Grip Casting Kit, you will also need to supply these items.

- A. the HAMMR
- B. plastic cling wrap
- C. roll of masking tape
- D. roll of paper towels
- E. pencil

2.

CREATING THE GRIP INSERTS

Photo 2A



2. Place one of the aluminum backing plates on the machine rest. Machine rest should be in the forward or "ready to fire" position. The height adjustment screw should be set halfway between the minimum and maximum adjustment. This will ensure that you will maintain flexibility in your height adjustment once your grips have been cast. (See Photo 2A)

3. Hold the handgun against the backing plate. Note the angle of the barrel. When making an insert it is important to ensure that the handgun is not canted down or up to such a degree that the elevation adjustment cannot be used to bring the gun on to the target.

4. Use a pencil to trace around the handgun grip frame on to the backing plate. Be careful that you do not position the handgun on the backing plate in such a way that the trigger lever cannot engage the trigger. Also, if the handgun uses a detachable magazine, be sure to position the frame to allow for removal and insertion of the magazine. (See Photo 4A)

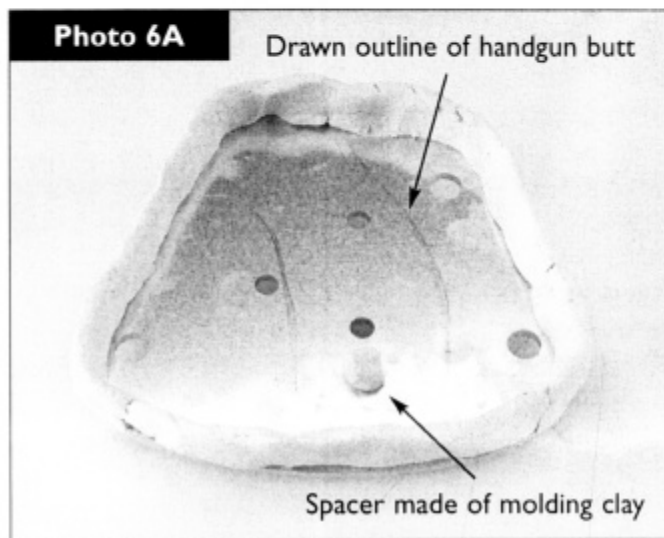
Photo 4A



Instructions 5 thru 12 continued on page 3. >>>>

5. With the outline of the frame on the backing plate, remove the backing plate from the machine rest.

6. Build a wall or "dam" of modeling clay around the circumference of the backing plate. The dam should be approximately 3/4" high above the surface of the backing plate. (This may vary dependent upon the design and width of the handgun.) It may be handy to place a "spacer" or "pillar" inside the dam to support the buttend of the handgun. This will serve to maintain at least a 1/4" gap between the gun and the backing plate so that the molding material can flow between the two. (See Photo 6A)

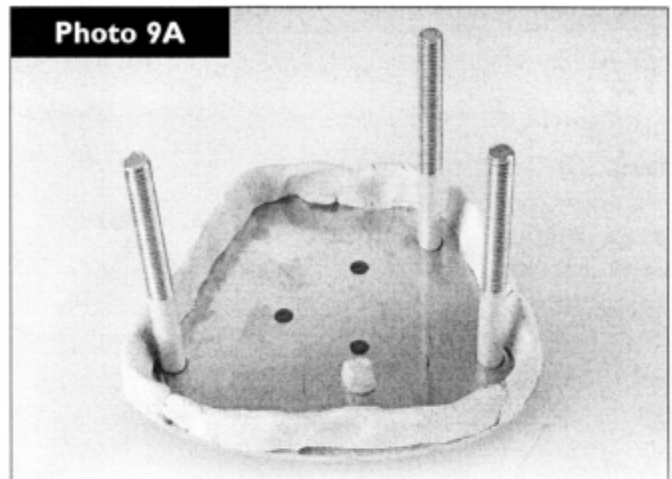


7. Remove the threaded studs from the machine rest and wrap tape over the threads up to 1.5" below the bolt head. This will allow the bolts to release from the cast grips once the molding material has fully cured.

8. Insert the bolts into the grip plate and apply tape over the heads of the threaded studs to prevent leakage of the mold material. On the backside of the grip plate, you will need to apply tape over the three smaller holes in the center of the plate. You will want the molding material to seep into the holes to provide a mechanical lock for the cured molded grips.

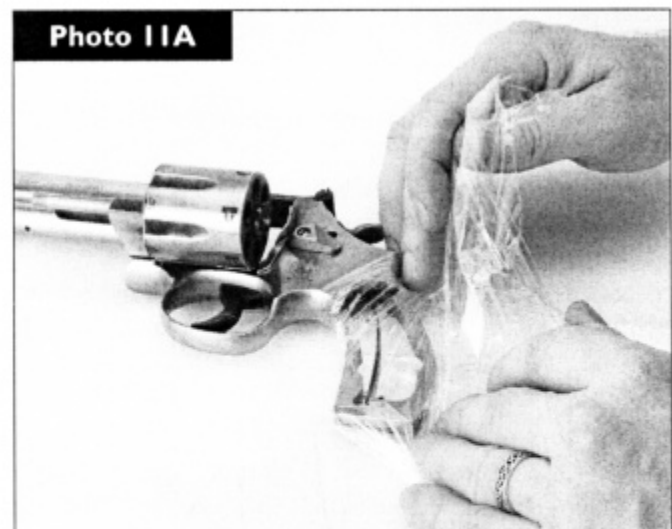
9. Place the backing plate and threaded studs on your bench with the shanks of the threaded studs UP. The stud heads should be on the surface of the bench. Coat the shanks of the studs with release agent (it is assumed that you are making a permanent set of inserts so the backing plate will not be coated with release agent). (See Photo 9A)

Instructions 13 thru 18 continued on page 4. >>>>



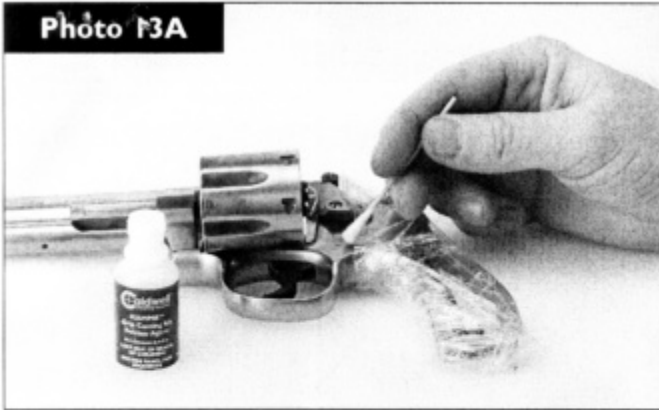
10. Prepare the handgun for casting the holding inserts. Some handguns will require removal of the grips, others will not. Some will require extensive disassembly of the frame, others will not. For example, the Nagant revolver is designed and constructed in such a way that the grips must be left on when casting the inserts and when firing it in the machine rest. The Colt 1911, on the other hand, should have the grip panels removed when casting inserts. Since there are thousands of different handguns, it will be up to the user to determine how far the handgun should be disassembled when casting inserts.

11. Wrap the grip frame with a thin plastic sheeting such as plastic cling wrap or electrical tape. (See Photo 11A)



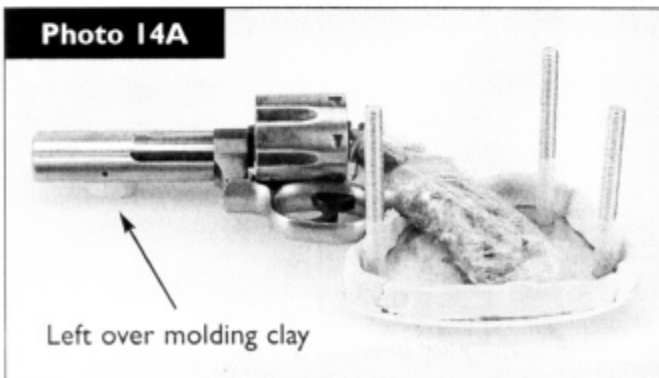
12. Make sure there are no machined slots, holes, or under cuts that might trap the molding compound and lock the frame into the insert.

Photo 13A



13. Apply release agent to the frame and any tape or covering that has been applied to the frame. (See **Photo 13A**)

Photo 14A



14. Place the handgun over the outline of the frame drawn on the backing plate. Press the handgun down compressing the modeling clay dam until the frame is at least $\frac{1}{4}$ " or more above the surface of the backing plate. You will most likely need to make additional supports for the front of the handgun or frame. If you have any molding clay left over, you may use this for supporting the front of the handgun. The frame should be parallel to the backing plate. Don't allow it to be canted or at an angle. (See **Photo 14A**)

Photo 14B shows how the dam should continue right up to the point where it meets the gun. You will want to check for probable leaks around the handgun before pouring the molding material into the grip plate.

Photo 14B



15. Mix 1 part hardener with 1 part resin to form the molding material and allow it to set for 20 minutes.

Then pour the molding material into the grip plate making sure it flows under the handgun frame. Check for leaks in the clay dam and repair as necessary. The molding material should extend to approximately $\frac{1}{16}$ " below the midpoint or halfway mark on the handgun frame.

16. Allow 24 hours for the molding material to fully cure. Remove clay dam from around molding material.

17. Remove the handgun from the insert.

18. Repeat the process for the other half of the frame insert. Use the first insert as a guide to help position the frame in the other backing plate. Don't forget to also place the attaching studs through the backing plates and make sure there is tape around the stud holes in the backing plate to prevent the escape of molding material.

A **Battenfeld** Product
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