

Grand Masters, L.L.C.

D.B.A. as Power Custom

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Power Custom bench Mounted Barrel/Action vise

CNC manufactured from billet steel for a lifetime of service.

Designed to be used in conjunction with the Power Custom Frame wrench Handles and interchangeable inserts, but can be used as a stand-alone barrel/action vise.

Aluminum vise jaws compress or expand to give a superior grip to steel, while providing a non-marring working surface.

Jaws are available in a wide variety of diameters, contours, and tapers to fit the most popular barrels and actions including:

Remington 700 Action

Taper #1-Remington 700 sporter taper barrel

M1A/M14/M1 Garand Action

1.25" O.D. Barrel - for most custom barrels

1.1" O.D. Barrel - fits M1A/M14/M1 Garand service contour barrels

Winchester Model 70 Featherweight Contour barrel

Winchester Model 70, Ruger M77, Mauser Action

1.150" O.D. Barrel Fits older win. M70 sporter barrels

1.05" O.D. Barrel -fits Savage barrels

S & W Action wrench inserts

Also, call 573-372-5684 for custom contours!

Installation instructions:

- 1.) Using the base of the barrel vise (with 4 holes), mark location holes on your bench according to the center of the holes.
- 2.) with a 1/2" diameter bit, drill all the way through your bench for the two outer, non-threaded holes, and at least 1" deep for the inner threaded holes.
- 3.) Insert one of the included 1/2" bolts in each of the outside vise holes, through your bench, and thread into the base plate. Tighten heartily with supplied Allen wrench.
- 4.) Place desired aluminum action/barrel inserts between the vise base and steel backing plate. Insert bolts through entire assembly and thread into vise.

POWER BLOCKS
POWER BLOCKS-RSA- RUGER SINGLE ACTION (LARGE FRAME)POWER BLOCKS-CSA—COLT SINGLE ACTION ARMY (clones)

Material—Black Delrin-Precision machined by CNC process. Provides the ultimate support of the frame for most custom alterations that may be performed on single action Rugers, Colts and CSAs. Allows access to screws, pins, etc..Holds the frame securely when doing alterations requiring the frame to be held solid.

INSTRUCTIONS - To use Power Blocks, it is necessary to remove the cylinder from the frame. The block with large relief is the one that goes on the right side of the frame (The side with the ejector rod shroud support). Put the blocks on each side of the frame. The blocks will not fit on the wrong side. The frame is now sandwiched between the blocks, which can now hold the frame securely when placed in a vice. Most alterations may now be performed, including removing and replacing the back strap/trigger guard, all internal parts, base pin, base pin latch assy., rear sight, ejector rod/shroud assy., barrel, and even the firing pin bushing, cross pin/firing pin assembly. NOTE—If it is necessary to mill a relief or drill a straight line of holes on the top strap, the top strap will not be perfectly straight with the outside of the blocks. It is necessary to adjust the vice on the rotary base and dial in the center of the rear of the top strap (Rear sight notch) to the center line of the bore (muzzle, front sight) or center of the front of the frame bore, this type of alteration is usually done by advanced gunsmiths that are opening up the rear sight notch or installing sights or bases on the frame.

UNIVERSAL FRAME/BARREL WRENCH HANDLE With CLAMP ASSY. AND SINGLE ACTION BARREL BLOCKS

INSTRUCTIONS—To remove and install single action barrels, it is best to place the Power Blocks on the frame and place vertically in a heavy vice. Remove the Ejector rod shroud. Place the single action barrel blocks on the wrench handle BETWEEN the 1/2" thick plate and the handle. The plate has to be used to prevent damage to the alum. barrel blocks. Align the holes then place the 1/2" socket screws through the steel plate, alum barrel blocks and into the threaded holes in the handle. NOTE-The radius in the barrel blocks are for .750" diameter barrels. Place the barrel blocks over the barrel to where the .750 diameter fits. (Usually on the colts, it is next to the frame and on Ruger it is approx. 2 inches in front of the frame.) Align the space between the barrel blocks with the front sight. Tighten the socket cap screws with Allen wrench (tight). With every thing tight, the barrel now may be removed. Alterations may be made and this same method is used to screw the barrel back in the frame. The reason the front sight is aligned with the space between the barrel blocks is to aid in alignment of front sight with frame when replacing the barrel. The same may be accomplished with out the use of a heavy vice by replacing the vice with a additional Frame Wrench used to hold the Power Blocks.

GRIP FRAME PLATE

3/16s inch thick steel plate with socket head cap and Allen wrench

GRIP FRAME PLATE (On the side of the frame wrench handle) is used to hold the grip frame and frame assembly when fitting grip frames to the revolver frame. Place the Frame Wrench Handle in a vice with grip frame plate side up. With grips removed, sandwich the grip frame between the 3/16" thick plate and the handle of the Frame Wench, install the socket head cap screw and tighten with enclosed Allen wrench. Alterations may now made to the side of the revolver. To access the other side, Remove and turn the revolver over in the frame clamp assembly. NOTE—If your POWER BLOCKS are too tight on your factory frame, They may be altered with a sharp knife/chisel or a Dremel tool with a small cutter. There is a large variation in the shape and size of factory frames POWER BLOCKS are manufactured by CNC machining and fit the factory frames that we have in the shop. They may not fit your frame with out minor alteration.