

Banded Front Ramp Installation Tips:

Our banded ramps can be fit and installed in a variety of ways mostly depending on the budget of the job and the ability of the installer.

First we start with a banded ramp whose straight interior diameter is slightly undersize of the finished dimension by a minimum of .001" to .002" up to .025". If a band needs to be stretched further than say .020" to .025" we would strongly suggest that the band be annealed first before stretching.

To stretch a banded sight we use an older barrel / mandrel which taper resembles that of the barrel we are fitting too. With the banded ramp seated on the mandrel we strike the band of the sight with a polished face of a ballpeen hammer. With repeated hits in a line along the top edge of the band close to the base of the ramp to start with. We then rotate and continue to strike in repeated fashion until we reach the other side of the band all the while applying pressure to the front of the ramp forcing back on to the barrels taper. (Please note that some smiths will set up their lathe and bore out the inside of the band to achieve the taper and diameter they need. This is perfectly fine to do if you have the equipment.)

Periodically check the ramps position on the barrel we wish to fit the sight too. Depending on the degree of the taper will determine how far you will be able to drive the ramp on for the final seating or positioning. We generally use .125" as a rough rule of thumb. We typically position the ramp 3/8" to 1/2" back from the muzzle. We have many reasons for this. One by setting it back that far should the muzzle be damaged and need to be re-crowned the ramp would not need to be moved. Second on heavy recoiling rifles some customers later add a muzzlebrake and again with the sight set back the sight will not need to be moved as the barrel would be simply threaded for the brake. Third reason, we just like the look.

Once the ramp is sized for final fitting. We belt grind and hand polish the facets off the band caused by the peening. We will then polish or bead blast as needed to match the finish on the gun we are installing it on if we are to simply epoxy or glue the ramp in place. Soldering would require the entire re-bluing or refinishing of the metal. Which brings us to how to permanently attach the ramp. If installing on a finished gun we would blue or finish to match and during the final assembly use "271 Loc-tite" or Brownell's "Acra-glas" epoxy inside the band. (CAUTION MUST BE TAKEN AS THE RAMP IS DRIVEN ONTO THE BARREL AS IN SOME CASES THE RAMP WILL SIMPLY STOP AS THE LOC-TITE SETS UP AND IF IT IS NOT LEVEL IT WILL CAUSE AN ISSUE TRYING TO CORRECT THE TILT.) We prefer to solder on the ramps and for this we use Force 44 lead free solder from Brownell's and tin both the barrels surface as well as all interior surfaces of the band and ramp. Drive ramp on under heat and one the ramp is confirmed to be level continue heating the ramp and barrel area until the solder successfully flows around the edge or seam of the sight.

Clean up the solder by using a sharpened and polished scribe, or a brass chisel and then the use of aluminum oxide cloth, files or a bead blaster to remove the excess solder in preparation for the final metal polish and finish.