

Breech Plugs



This fine Jaeger Rifle was created from our parts, by the noted gun maker, Michael Hayes.



Flared Tang Plug:

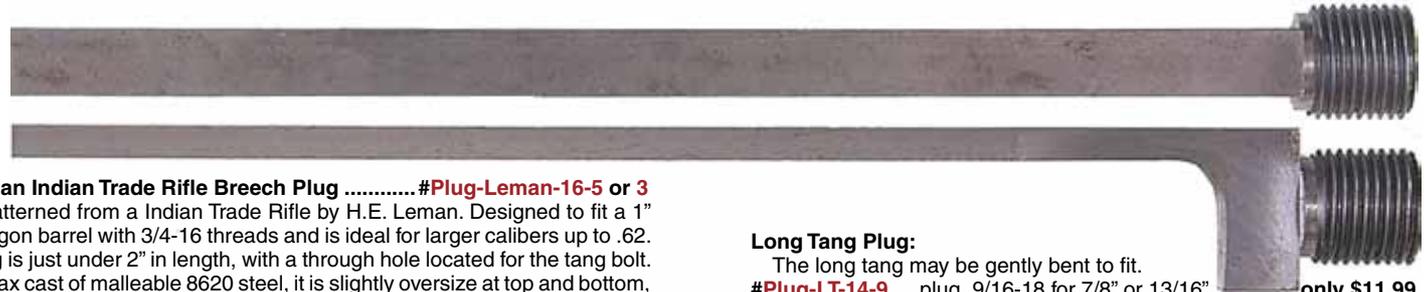
Early flint breech plug, with flared tang. Select correct thread and octagon size. Trim the threaded journal to the exact same length as thread depth.

- #Plug-FT-14-9** plug, 9/16-18 for 7/8", file to fit 13/16" **only \$ 8.99**
- #Plug-FT-14-5** plug, 5/8-18 for 7/8", file to fit 13/16" **only \$ 8.99**
- #Plug-FT-16-9** plug, 9/16-18 for 1", file to fit 15/16" **only \$11.99**
- #Plug-FT-16-5** plug, 5/8-18 for 1", file to fit 15/16" **only \$ 9.99**
- #Plug-FT-16-3** plug, 3/4-16 for 1", file to fit 15/16" **only \$ 9.99**
- #Plug-FT-18-3** plug, 3/4-16 for 1-1/8" octagon **only \$11.99**
- #Plug-Bess-1** plug, 7/8-14 for Brown Bess barrel **only \$25.99**

Straight Tang Plug:

Select correct thread and octagon size. Bottom tap your barrel to fit.

- #Plug-ST-14-9** plug, 9/16-18 for 7/8", file to fit 13/16" **only \$ 7.99**
- #Plug-ST-14-5** plug, 5/8-18 for 7/8", file to fit 13/16" **only \$ 7.99**
- #Plug-ST-16-9** plug, 9/16-18 for 1", file to fit 15/16" **only \$ 9.99**
- #Plug-ST-16-5** plug, 5/8-18 for 1", file to fit 15/16" **only \$ 9.99**
- #Plug-ST-16-3** plug, 3/4-16 for 1", file to fit 15/16" **only \$ 9.99**
- #Plug-ST-18-3** plug, 3/4-16 for 1-1/8" octagon **only \$10.99**
- #Plug-ST-18-7** plug, 7/8-14 for 1-1/8" octagon **only \$10.99**



Leman Indian Trade Rifle Breech Plug#Plug-Leman-16-5 or 3

Patterned from a Indian Trade Rifle by H.E. Leman. Designed to fit a 1" octagon barrel with 3/4-16 threads and is ideal for larger calibers up to .62. Tang is just under 2" in length, with a through hole located for the tang bolt.

Wax cast of malleable 8620 steel, it is slightly oversize at top and bottom, to allow draw-file polishing to match your barrel. Sides have tapered "draft" to simplify hand inletting.

Threaded for a 3/4-16 breech, exactly .550" length, to fit Colerain or Rice barrels. Green Mountain barrels are threaded slightly deeper to allow trimming the barrel's breech only, normal gunsmithing practice.

This .550" thread journal solves lock placement problems, clearing the vent. Original plug faces were nearly always grooved to clear the drum, or vent liner.

This plug has no thread relief, front or rear. All 8 threads are good. Thus, it is necessary to chamfer the breech end of the barrel, slightly, to allow the turned tang faces to fit the breech end snugly. Failure to chamfer the breech end may cause thread galling, if the plug is removed.

Dope all threads with anti-seize lube before first trial fitting, to prevent galling the threads.

Adjust the thread length to seat the plug face snugly against the inside shoulder of the thread cavity. No need to over-torque a breech plug.

Measure the number of flats or the fraction of a turn needed to "index" the plug to align with the top flat. For instance, if the error is one flat (1/8 turn) for this plug with 16 threads per inch, then each full turn is 1/16" or .062" per turn. Each octagon flat is 1/8 of .062" or .007" per flat.

Trim the thread length, and matching breech depth, until the plug aligns with the top flat. When "indexed" to the top flat, match-mark the bottom flat with a sharp chisel mark across the draw-filed smooth joint.

- #Plug-Leman-16-5** 5/8-18 thread for 1", file to fit 15/16" **only \$20.99**
- #Plug-Leman-16-3** 3/4-16 thread for 1", file to fit 15/16" **only \$20.99**

Long Tang Plug:

The long tang may be gently bent to fit.

- #Plug-LT-14-9** plug, 9/16-18 for 7/8" or 13/16" **only \$11.99**
- #Plug-LT-14-5** plug, 5/8-18 for 7/8", file to fit 13/16" **only \$11.99**
- #Plug-LT-16-5** plug, 5/8-18 for 1", file to fit 15/16" **only \$13.99**
- #Plug-LT-16-3** plug, 3/4-16 for 1", file to fit 15/16" **only \$13.99**
- #Plug-LT-18-3** plug, 3/4-16 for 1-1/8" octagon **only \$13.99**

Our long tangs are malleable. Bend one to match your stock's profile. Tangs may be shortened, shaped, or modified to accept a tang sight. Long tangs are found on Tennessee and Southern Mountain rifles.



#Plug-Leman-16-5
5/8-18 thread
or
#Plug-Leman-16-3
3/4-16 thread