

Assembly Instructions for the Howell 1851 Gated Conversion Kit

The redesigned gated ring makes installation a breeze!

Before you begin converting your Pietta or Uberti percussion revolver, first ensure the weapon is **UNLOADED**, and is in good working order. The Howell Arm's Kit consists of precisely made parts that are designed to fit most revolvers. Some modifications are required, see details below. Replace any worn components for the best results.

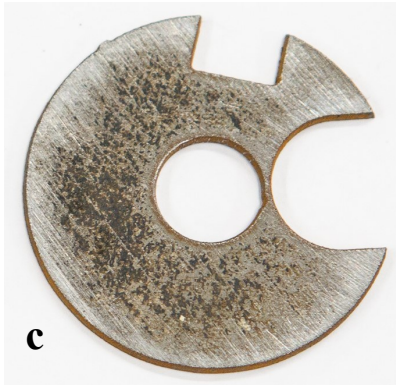
Warning: DO NOT USE A BRASS FRAME REVOLVER. DO NOT DRY FIRE.

What's Included: Gated Ring (a), 6 Shot cylinder (b), Loading Port template (c)

a



b



c



What do I need:

- Dremel, 3/8" Sanding Drum (Coarse & Fine).
- File
- Sandpaper (400 Grit)
- Liquid Gun Blue
- Vise (not necessary but makes Life easier)
- Dykem/nail polish

2. Prepare to cut the **Loading Port:** (Fig. 2)

- a. Apply Dykem (or nail polish) to the face of the frame. Wrap tape around backstrap or use rubber pads to protect it while clamped in a vise.
- b. Place the port template in the frame and use the hammer nose to maintain orientation. Scribe a line to mark the port location as seen in Fig 2. The template does not need to be removed when grinding.

Fig. 2 Before



Fig. 3 After



3. **Cut the loading port:** Using a Dremel with a **Course** sanding drum, carefully grind the loading port. Stop occasionally so that you do not overheat the frame. Always wear eye protection when grinding!

- a. Change to a **Fine** sanding drum before you reach the scribed line or the template.
- b. Once the material is removed, re-install cylinder and test fit for loading and unloading cartridges. If the cartridge hangs up, remove the cylinder, and very slowly grind a more material from the port. Repeat this process until the brass can easily be removed , then begin final polish.
- c. Use 400 grit sandpaper or a rubberized polish wheel to polish the loading port and carefully remove all sharp edges. Apply liquid gun blue to the exposed metal and let it dry. Fig. 3
- d. Lower the hammer and scribe a line on the hammer where it extends beyond the face of the frame. Fig 4. Remove the extra material from the hammer face with a file or grinder. Modified hammer shown in Fig. 5
- e. Hold the conversion ring in place and lower the hammer against the ring and check for clearance between the bottom of the sight nose and top of the conversion ring near the firing pin. **Fig. 6.** If the bottom of sight nose hits the ring, remove excess material to create clearance.

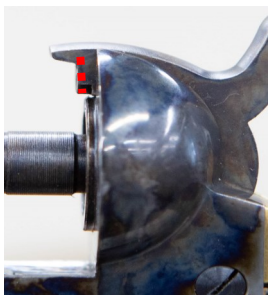


Fig. 4



Fig. 5

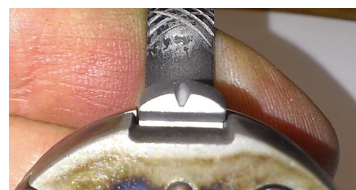


Fig. 6



Milled and Welded Hammer

4. Fit the Ring: Fig. 7 shows a properly fitted ring. It is flat to face of the frame and squarely in the corner. The ring should Not rotate when fitted correctly. See Fig 8, 9 & 10 for fitting requirements. The feet on the ring keeps the ring positioned properly. Remove small amounts of material and continually check the fit. Assemble your revolver and check for proper function.

5. Ferrule Relief Cut: Make a shallow cut as shown to create clearance for the ferrule, see Fig. 10 & 11

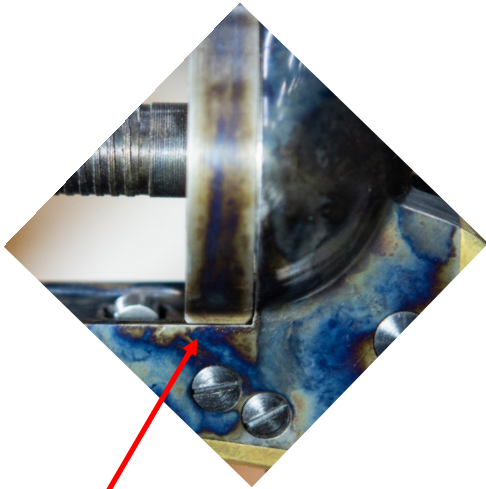


Fig 7



Fig.8 FEET

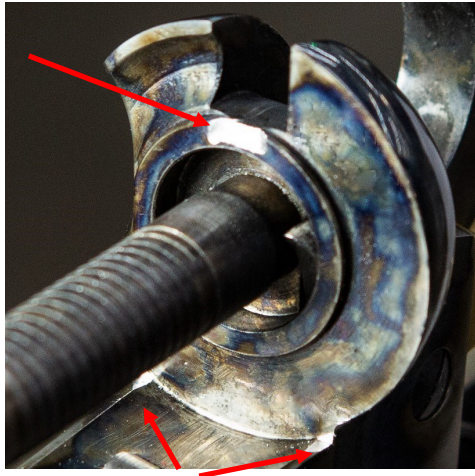


Fig. 9 File used to create flat pads for the feet



Fig 10

Fig. 11 Ferrule relief cut



Flat created for the feet of the ring

****If your Pietta cylinder does not index completely, the hand may need to be bent slightly towards the cylinder pin.****

Note: If you have a problem during the conversion process, STOP and call 608.563.0974 or e-mail Howell at info@howellarms.com for technical assistance.