



# Sporter Barrel Threading Info/Worksheet

## ( $\frac{5}{8}$ " x 24 TPI)



Precision Rifle Concepts (the consumer gunsmithing division of Ultimate Reloader, LLC) is pleased to offer a proprietary muzzle threading service to customers specifically for thin-profile sporter contour barrels that would not normally be threadable. You can [read about this process on Ultimate Reloader HERE](#) (including video). This process consists of threading the barrel back further than normal, adding a shoulder nut, and corresponding finishing work. The resultant shoulder is 0.800" in diameter providing plenty of shoulder seating surface area for muzzle brakes and suppressors.

### **In order to perform this service, your rifle will need to satisfy the following: (this is for $\frac{5}{8}$ "x24 only)**

1. At least \*0.650" minimum diameter at the end of the muzzle. We can cut your barrel down at additional charge if you have sufficient taper and corresponding finished barrel length. (see diagram below)
2. 30 caliber or smaller bore (0.308" or 0.312") - please inquire about larger bore diameters.

\*Please reach out to us with specific questions if there is any doubt about these guidelines. In some cases we can do this type of threading with as little as 0.625" - 0.630" muzzle diameter, this may depend on taper.

### **Checklist**

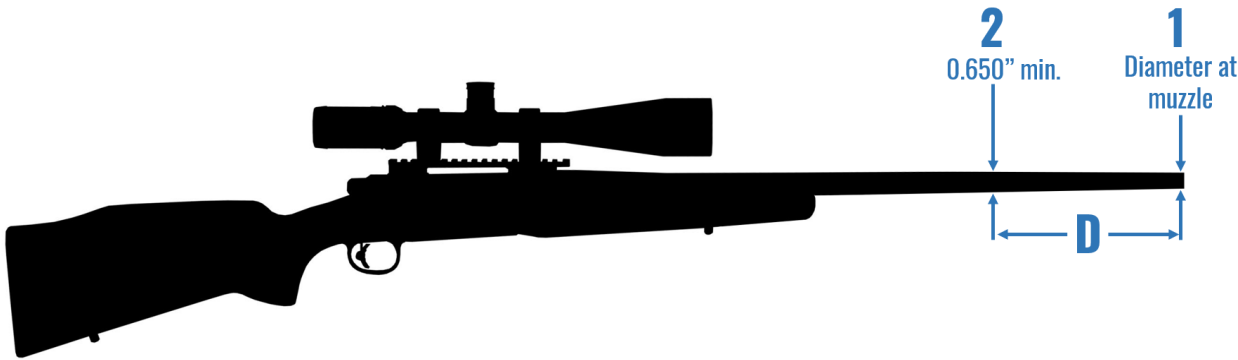
1. Verify with Precision Rifle Concepts that we are ready to receive your rifle: (your position in the queue has come up). For inquiries on queue position: [sales@ultimatereloader.com](mailto:sales@ultimatereloader.com)
2. Remove your scope and send the rifle (you can also send just the barrel, or just the barreled action) to the address below.
3. Print out and complete all fields in this form, sign this form, and include a full copy with your shipment.

# Pricing Schedule (check boxes as appropriate)

|                                                                                                                                                                                                                        |                |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|
| Sporter Threading, including removing barreled action from stock, threading muzzle, installing shoulder nut, cold blueing (chromoly) or polishing (stainless) of shoulder nut, re-installing barreled action in stock. | [ X ] \$200.00 |
| [as appropriate] Barrel cut down, <b>required</b> if muzzle diameter is less than 0.650"                                                                                                                               | [   ] \$25.00  |
| [optional add-on, as appropriate] Remove and re-install scope (with precision leveling)                                                                                                                                | [   ] \$30.00  |
| [optional add-on, as appropriate] Re-crown muzzle                                                                                                                                                                      | [   ] \$30.00  |
| (please fill in) <b>Total:</b>                                                                                                                                                                                         |                |

\*Tax will be added as appropriate with Federal and State laws, return shipping will be added as well.

## About My Rifle



Please take any measurements using the diagram above carefully with a micrometer (preferred) or digital calipers.

|                                                                             |                                                        |
|-----------------------------------------------------------------------------|--------------------------------------------------------|
| Make and Model                                                              |                                                        |
| 1: Diameter at Muzzle                                                       | _____ inches                                           |
| 2: Distance from muzzle for 0.650" diameter (if less than 0.650" at muzzle) | _____ inches                                           |
| Optional if cut down, cut-down length                                       | _____ inches ( <b>how much to remove from barrel</b> ) |
| Desired Shoulder Nut Material/Finish                                        | [   ] Blued (chromoly)   [   ] Bare Stainless          |

## Notes and Terms

- We have shoulder nuts in chromoly (regular steel) that will be blued, or stainless steel which will be polished or sanded to look similar to the factory barrel finish as appropriate.
- The finish on the shoulder nut may not match your rifle barrel's existing finish. If you are interested in Cerakote services at Precision Rifle Concepts as a part of this job, please reach out to [sales@ultimatereloader.com](mailto:sales@ultimatereloader.com).
- Customer is responsible for shipping both ways (with insurance), we will charge you for return shipping as a part of your invoice. Rifles will not be shipped until services + shipping are paid for. If directions in this document were not followed (muzzle can't be threaded with this process), the customer is still responsible for shipping both ways.
- Precision Rifle Concepts is not responsible for customer measurements that are in error.
- You can drop off and pick up your rifle at our store to avoid shipping costs (limited store hours)
- Your rifle's finish on the barrel may have very slight marks on it (marring) after the sporter threading process is finished. There may be a visible transition between the shoulder nut and existing barrel surface.

Shipping Address:

**ULTIMATE RELOADER, LLC**  
**FFL 07 Manufacturer, SOT**  
5745 Sunset HWY  
Cashmere, WA, 98815

## Customer Return Address and Contact Information

|                        |  |
|------------------------|--|
| Name:                  |  |
| First Line of Address: |  |
| City:                  |  |
| State:                 |  |
| Zip Code:              |  |
| Phone #:               |  |
| Email Address:         |  |

Please see full shipping instructions here: [placeholder]

# Customer Agreement

Check this box: [ ☐ ] I have read the terms and conditions in this document and agree. I agree to pay the amount listed in "Pricing Schedule" (total), plus return shipping with insurance (calculated when the rifle is shipped back to the customer).

**Date:**     \_\_\_\_/\_\_\_\_/\_\_\_\_

**Full Name:**     \_\_\_\_\_

**Signature:**     \_\_\_\_\_