



Stippling is a random pattern of impressions designed to provide a non-slip surface on wooden pistol grips, fore ends or handgun grips. It can be applied in far less time than traditional checkering yet, when properly done, it can be attractive as well as functional. Until now there were no commercially available tools specifically designed for gunsmiths for use on stocks. The Brownell tools were designed to meet that need.



### WARNING



Never attempt to disassemble or reassemble a firearm unless you are absolutely certain that it is empty and unloaded. Visually inspect the chamber, the magazine and firing mechanism to be absolutely certain that no ammunition remains in the firearm. Disassembly and reassembly should follow the manufacturer's instructions. If such instructions are not immediately available, contact the manufacturer to see if they are available. If they are not available at all, then you should consult other reference sources such as reference books or persons with sufficient knowledge. If such alternative sources are not available and you have a need to disassemble or reassemble the firearm, you should proceed basing your procedures on common sense and experience with similarly constructed firearms.

With regard to the use of these tools, the advice of Brownells Incorporated is general. If there is any question as to a specific application it would be best to seek out specific advice from other sources and not solely rely on the general advice and warnings given.

### HOW TO USE

The Brownell Wood Stippling Punches are made of Fatigue-Proof steel. While more than adequate for use on wood, these punches are NOT designed for use on any metal surface. **DO NOT USE THESE PUNCHES ON METAL!** If you need to stipple a metal surface, use the Brownell Metal Stippling Punches Set (#808-717-000).

The Wood Stippling Punches are provided in coarse, medium and fine texture. The coarse punch has 60° diamonds that are 12 lines per inch; medium is 16 lines per inch; and fine, 20 lines per inch. In general, you will want to use the coarser punch for applications where maximum surface roughness is required. It is also important to note that the quality and density of the wood being stippled should also influence your choice of punches. Open grained, porous, average grade walnut should be stippled with the coarse punch. Harder, denser wood can be stippled with the finer punches.

Prior to attempting to stipple a valuable stock, practice on a scrap piece of wood of approximately the same hardness and density. The more you practice, the more professional and attractive your finished product will be. Stippling can be done to unfinished wood, it can also be done over most finishes. In the case of polyurethane finishes or other thick, epoxy-like finishes, the best results are obtained if you remove the finish in the areas to be stippled.

We normally use a small (4 or 6 oz.) ballpeen hammer for striking the Stippling Punch. It is NOT NECESSARY to use a heavy hammer or to strike the punch with great force. It is always much better to use repeated blows with light, even force. Always wear eye protection when using impact tools for protection in case of tool failure.

Secure the stock, handgun grip or piece of wood being stippled in a padded bench vise. Stippling requires you to use both hands so it is essential that the workpiece be secured without movement. In addition, the workpiece must be positioned so you have unrestricted access to it with the Stippling Punch.

A stippled area on a stock can be borderless, it can have a "V" border cut around the stippling or the stippled area can be slightly recessed below the surface of the rest of the stock. There are no hard and fast rules about how it should or should not be done. As you practice and experiment with these punches you will determine what is most attractive and suitable for our needs. Regardless of the type of border you use, you will find it helpful to mark the outside edge of the area to be stippled. The Brownells Mark-On-Anything Pencils may be used to lay out your pattern. It is VERY IMPORTANT to be extremely careful when stippling near this line. If you accidentally stipple beyond the line of the border, the only practical way to disguise this is

# BROWNELLS® WOOD STIPLING PUNCHES

READ & FOLLOW THESE  
INSTRUCTIONS

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to extend the stippled area beyond the accidental mark. It can be extremely difficult to remove a deep stippled mark.

If you are working near a border you may wish to alter the shape of the face of the punch. You can easily grind a portion of the round face away to form a straight edge or one that has a more gentle or gradual radius. You can even alter it so the face is in the shape of a "V" to get into a tight corner of a pattern. You are limited only by the pattern layout and your own imagination!

When using the Stippling Punch, the punch should be held with only the thumb and forefinger of the left hand (if you are right handed). Hold the punch securely but with a "light" touch. The hammer should be held in your right hand. Position the punch so the face of the punch is held just above the surface of the workpiece, approximately .050". When struck, allow the punch to "bounce" and position itself at random (inside your border of course!) for the next stroke. The texture and appearance of the stippled surface can be varied by utilizing the different punches. We often use all three within a given area to provide a more attractive appearance.

Work slowly and do not become impatient. If, after your first pass over an area with a Stippling Punch, you notice areas where the stippling is uneven, spend a bit more time with the punch to achieve a nice, even, uniform appearance. When the stippling has been completed, you may wish to use a very, very thin sealer to protect the wood surface. DO NOT use any finish or sealer that will fill or clog the stippling. This would defeat the reason for stippling and also tend to destroy the effectiveness of the stippling.

Reassemble the firearm according to the manufacturer's instructions. Check for proper functioning using **ACTION PROVING DUMMIES**. Make sure **ALL SAFETY MECHANISMS** are fully functional as designed and approved by the manufacturer. If these tests prove satisfactory, test-fire the firearm with live ammunition in a **SAFE and APPROPRIATE** manner. **IMPORTANT!** Start the live ammunition tests by first loading an **ACTION PROVING DUMMY**, then a live round, into the magazine. Only after several tests have been conducted in this manner should additional rounds be placed in the magazine and fired.