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2018 Informational Booklet



**OVER 50 YEARS
EXPERIENCE APPLYING
ADVANCED FIREARM
COATINGS!**

Business Hours: 9 a.m. to 5 p.m. Monday – Friday
Saturday by appointment only
Closed Sunday's & Holidays

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Introduction:

The people at Craftguard would like to take this opportunity to welcome new customers and thank existing customers for their patronage! Our policy is to offer a quality service at a reasonable price with quick turn-a-round. Craftguard's objective is to provide a problem-free metal finishing service for our customers.

Craftguard was established in 1964 by William R. Iehl and operated until 1984 as a sole proprietorship, at which time Craftguard formed a partnership and our emphasis was changed from local gunsmithing services to mail order metal finishing. Effective January 1st, 1997, Craftguard became a limited liability company (LLC). Craftguard celebrated its "50th Anniversary" in 2014.

General Information:

Shipping Firearm by Public Carrier:(U.S. Post Office, UPS, Federal Express, etc.) " The Gun Control Act of 1968" allows the owner of a firearm to ship his or her weapon to a Federal Firearm Licensee for firearm maintenance. Also, any business possessing a valid Federal Firearms License (FFL) may ship their customer's firearm to Craftguard for metal finishing, gunsmithing, or stock work. Completed work may be returned to the owner's address or the address on the FFL. In compliance with BATF regulations, firearms shipped by public carriers must state "**Adult Signature Required**" on the shipping label. Shipping labels furnished upon request. **NOTE:** Firearms that are completely disassembled may be classified as gun parts for shipping purposes.

Normal Completion of Work: Craftguard's average turn-a-round time for disassembled firearms is two weeks. Turn-a-round time for non-disassembled firearms averages four to six weeks. Multiple finishes (such as electroless nickel plate receiver and "Guard-Coat" PLUS barrel), usually require an additional week. **NOTE:** Craftguard's business days are the same as United Parcel Service's working days. If completion of work is required by a specific date, (such as Christmas or birthday) or to be held until a specific date (customer vacation), please let us know and we will try to accommodate your needs. All work is subject to Craftguard's acceptance.

Craftguard's Guarantee: Craftguard's workmanship is of the highest quality. We offer an unconditional satisfaction guarantee. If you are not satisfied with Craftguard's work, notify Craftguard within thirty days from the invoice date and return firearm for rework. If a refund is requested the firearm must be returned and Craftguard will remove the finish and issue a refund. Customer will be responsible for shipping and insurance costs to Craftguard. Craftguard will pay for return postage (ground service) and insurance.

One Year Warranty: We offer a one-year warranty on metal finishing services for all firearms which have a manufacturer's serial number. Craftguard's warranty applies only to metal finishing services and does not include disassembly and reassembly, return postage, handling, or insurance. Warranty is valid for same type of finish and polish. One-year warranty is not valid for "Economical Customer Prepared Services."

What is a Disassembled Firearm? A disassembled firearm is a weapon that has been

completely dismantled. All screws, pins, wood, sights, plastic components, aluminum parts, springs, etc. have been removed from the firearm. Hexagonal or octagonal barrels should be removed from the receiver. Round barrel removal is usually not required unless the receiver or frame is made of an alloy. Identify and separate carbon steel parts, aluminum alloys, stainless steel and plastic parts. **NOTE:** All firearms must be disassembled prior to applying any metal finish.

Will Craftguard Disassemble and Reassemble? Craftguard can disassemble and reassemble firearms for an additional fee as listed on the "Price List". Craftguard will finish disassembling any firearm received partially disassembled and charge on a time basis. We have a minimum charge listed on the Price List for firearms received not completely disassembled. This includes the removal of sights, shotgun beads, and octagonal barrels. Gun stock removal prior to shipping to Craftguard will reduce postage and potential mail damage. Craftguard is not responsible for broken parts. Generally, parts break because they are old, worn, or rusted.

Missing or Damaged Parts: If Craftguard loses a part during the metal finishing process and can determine which part is missing, we will order the part and apply the appropriate finish. If we cannot determine the missing part, we will return the firearm to the customer and request customer tell us the name of the missing part. Craftguard will then order the part, apply appropriate finish and return to customer. If customer receives a firearm from Craftguard and the part count does not match or a part is damaged, customer must notify Craftguard within ten days of the invoice date. After ten days, Craftguard is not responsible for replacing any parts. Due to high temperatures involved with some processes and the different types of metals or alloy metals used in firearms, Craftguard is not responsible for any heat damage. **Note:** Completing the "Parts List" on the "Work Order Form" is important.

Terms and Conditions:

- * Payment in full due upon completion of work.
- * Any overpayment will be refunded and enclosed with return order. Underpayment may delay shipment.
- * Make check or money order payable to "Craftguard."
- * Customer is responsible for any and all banking fees associated with a non-sufficient funds notice for a payment made to Craftguard in addition to the cost of metal finishing service.
- * Credit card order will be billed the day the order is packaged for shipment or picked up by customer and subject to a processing fee.
- * All prices are subject to change without notice.
- * Firearm must be completely disassembled before metal finish can be applied. Removing stock from weapon is NOT completely disassembling firearm.
- * Craftguard is not responsible for broken or worn parts when disassembling and reassembling a firearm.

- * Customer assumes full responsibility when having Craftguard apply a metal coating to alloy metals.
- * Craftguard is not responsible for heat damage.
- * Payments made on-line requires Craftguard to inform the customer of the invoice total by email. Upon payment verification, the completed work on the firearm will be returned to customer.
- * Craftguard offers a customer satisfaction guarantee. If, for any reason within 30 days after the invoice date the customer is not completely satisfied with the work performed, return the work to Craftguard for either rework or refund of money. If money is refunded, the finish will be removed and the weapon protected with gun oil. Customer pays shipping costs to Craftguard. Craftguard pays for return postage and insurance by UPS ground service.
- * Craftguard can remove old plating at the customer's request however; given the corrosiveness of the process, Craftguard is not responsible for any damage, including but not limited to pitting, caused as a result of the plating removal process.
- * Work is subject to Craftguard's acceptance.
- * Any and all unresolved claims must be litigated in Black Hawk County, Iowa.

Sending work to Craftguard indicates agreement by customer to ALL of Craftguard's terms and conditions.

Customer Classification:

Retail Customer: (non dealer) Any person who does not possess a valid Federal Firearms License (FFL). Please request Craftguard's "Retail Work Order Form."

Craftguard's Definition of a Dealer: Any business or individual possessing a valid Federal Firearms License (FFL). A copy of Craftguard's FFL will be supplied to all dealers. **NOTE:** A copy of dealer's FFL is required for dealer discount. Completed work will be returned to address on the Federal Firearms License. Law Enforcement is also eligible for dealer discount upon verification on Department Letterhead.

Metal Finishes and Coatings Available:

Salt Blue: Salt blueing (also known as hot blue, caustic blue or black oxide), is a process where properly prepared steel parts are suspended in a boiling bath of salts. The oxidation that forms on the surface of the steel is known as blueing and acts as a medium for oil to penetrate and prevent rust. The color of the blue will be a shade of black (from flat black to glossy black) depending on the degree of polish. Craftguard makes their own blueing salts solution. All polishes are available. Finish protected with Birchwood Casey's "Sheath." Meets military specifications Mil-C-13924C.

Rust Blue: Our rust blue process involves placing properly prepared steel parts in boiling distilled water to bring the metal surfaces up to temperature. We apply a thin coat of rust blueing solution on the dry hot metal surface and suspend the part back in the hot water to harden the rust blue. Craftguard then uses a carding method which removes all rust blueing solution not adhering to the metal. We place a minimum of eight coats on every part. Rust blueing will not harm soft solder or precious metals such as gold or silver. Craftguard rust blues all soft soldered double barrels. If Craftguard can not determine if the firearm is soft soldered or silver soldered, the weapon is rust blueed. Deluxe polish is the highest luster Craftguard will polish on Rust blueing. The finish is protected with Birchwood Casey's "Sheath."

Rust Brown: The browning process is similar to rust blueing except an oven is used instead of hot water. A thin coat of rust brown solution is applied to the warm, properly prepared metal part. Once again Craftguard uses a carding process to remove all solution not adhering to the metal. We continue to apply coats until the brown color is deep and uniform. The finish is protected with Birchwood Casey's "Sheath."

Rust Gray: This finish is recommended on any firearm the customer desires an old or worn appearance. The finish is gray to light black in color, thin in texture, and usually not even with dark and light areas. Application is similar to our rust blueing process. The finish is protected with Birchwood Casey's "Sheath."

Damascus Rust Blue: This finish is recommended on all Damascus barrels. This finish is designed to truly show and bring out the Damascus pattern. It will be uneven in color and is similar to the Rust Gray process. The finish is protected with Birchwood Casey's "Sheath."

NitreBlue (FireBlue): This is a process of blueing that will color virtually all carbon steel. Unlike conventional hot salt blueing, NitreBlue can produce a wide variety of colors from a "straw" color to a deep black blue. The most common appearance of NitreBlue is to achieve a "bright peacock" or "fire" blue. It can be used to closely match the blue on Colt and Smith & Wesson revolvers of the 1850's through the 1930's. Currently, this finish is only available on miscellaneous smaller parts such as triggers, hammers, screws, etc., and is not available on a complete firearm.

Parkerizing (gray, black, gray/green): Originally developed by the Parker Company for the military, parkerizing is a process where properly prepared parts are submerged in a warm phosphate solution for a period of time ranging from five to twenty-five minutes. Parkerizing will etch the surface of the metal and produce a coarse build-up. Bore and chamber are protected and not parkerized. Only carbon steel and cast iron can be parkerized. We can apply a bake-on product on non-steel parts that will closely match our parkerizing in color, texture and durability. Hunter polish is the only polish available for parkerizing. The finish is protected with Birchwood Casey's "Dry Touch Plus". Meets military specifications Mil-P-16232.

"Guard-Coat": Using "Advanced Teflons", this process is a low temperature bake-on finish for exterior surfaces of the firearm. The colors available are: Non-reflective matte black or dull silver. Prior to coating the weapon, Craftguard parkerizes the firearm to produce an excellent

base for the Teflon coatings to adhere. Bore and chamber are protected and not coated. The finish is protected with Birchwood Casey's "Sheath". Meets military specifications STD-171.

"Guard-Coat" PLUS: Developed for law enforcement, "Guard-Coat" PLUS is a high temperature thermal elastomer metal coating which is extremely durable and has a low coefficient of friction. Dry film thickness is approximately 0.5 mil. Pencil hardness is between 2H and 3H. Color is non-reflective flat black. The texture is similar to "Teflon" and slightly smoother than parkerizing. "Guard-Coat" PLUS is applied to the exterior surfaces of the weapon. Internal surfaces such as bore and chamber are not coated. Gun oils, gun solvents (including bore cleaners), humid salt air, gasoline, human sweat, and blood will not harm the finish. Passes 90 degree bend test without flaking. Process can be applied on carbon steel, cast iron, stainless steel, and aluminum. The process may not be applied to plastic components, pot metals, or firearms with soft soldered parts or ribs. "Guard-Coat" PLUS is maintenance free. Firearm bore and chamber are protected with Birchwood Casey's "Sheath". Meets military specifications Mil-M-24519B (EC).

Electroless Nickel Plate: Craftguard can electroless nickel plate carbon steel and cast iron. We cannot electroless nickel plate aluminum, stainless steel, brass, or copper. We offer two different types of Electroless Nickel Plating; 100 Series which is a bright nickel and 300 series which is a dull nickel with a stainless appearance. Electroless nickel has an outstanding resistance to petroleum distillates of all types including gun solvents and has a salt resistance tolerance exceeding 240 continuous hours per one-mil of thickness. Unlike conventional electroplating where the plating build-up is not uniform (thick on the edges and thin in the middle), electroless nickel plating is uniform on all metal surfaces (inside and out, edges and flats). Expansion and contraction from heat does not result in cracks or peeling. With a Rockwell rating of C56 in hardness, it is 0.10 tougher than hard chrome on the Tabor Wear Index. Plating thickness ranges from one-quarter mil. (0.00025 inches) to one mil. (0.001 inches) with three-eighths mil. (0.000375 inches) optimum for firearms. The finish is protected with Birchwood Casey's "Dry Touch Plus."

"DuPont® Teflon®" Coatings: This particular Teflon® is applied to all cast iron parts, aluminum parts, and stainless parts in which the remainder of the firearm has been blued. **Note:** This service replaces the Iron Plating Method Craftguard has used for many years. The color will be either semi-gloss black or matte black, depending on what type of polish you requested with the blueing. You may also request this finish for a complete firearm. When requesting this finish on a complete firearm, the colors available are semi-gloss black or semi-gloss gray. Additional colors available upon request. The finish is protected with a water displacing oil. Meets military specifications STD 171.

Cerakote®: Cerakote® is a ceramic based finish that can be applied to metals, plastics, polymers and wood. The unique formulation used for Cerakote ceramic coating enhances a number of physical performance properties including abrasion/wear resistance, corrosion resistance, chemical resistance, impact strength, and hardness. Each of these properties is rigorously tested to guarantee that Cerakote products remain at the forefront of the ceramic coatings market. Cerakote ceramic coatings utilize state-of-the-art technology to out-perform any competitive coating in both laboratory settings and real world applications. Specify Cerakote color and identifying sku under "Special Instructions" on the Work Order Form. Please contact us for more information about Cerakote®.

DuraCoat® DuraCoat® can be applied to ferrous metals, alloys, stainless steel, synthetics, wood, etc. It is available in over 250 colors and is available via airdry for metals or other material that cannot take heat or bake-on methods. Specify DuraCoat color and identifying sku under "Special Instructions" on the Work Order Form. Please contact us for more information about DuraCoat®.

Polish Only (Do Not Apply Any Metal Finish): Craftguard will polish firearm parts and return without applying any metal finish. An example of this would be to bead blast a stainless-steel firearm only. The finish is protected with water displacing oil.

Combination Finishes: Many customers request combination finishes because they prefer contrast on their firearms. Craftguard can apply two or more finishes on the same firearm. A few examples of this are as follows: (1) Rust blue double barrel shotgun barrels, and salt blue the receiver and parts. (2) Salt blue handgun slide and electroless nickel plate the frame and parts. (3) Salt blue carbon steel action and parts, and "Guard-Coat" PLUS stainless-steel barrel. Additional time required to complete combination finishes. Most combinations are available. Contact Craftguard for price estimates.

Gold Plate Small Parts: Craftguard can gold plate small parts such as triggers, screws, and hammers. All polishes are available. Refer to "Work Order Form" for additional charges.

Metal Polishes Available:

Match Factory: Craftguard will duplicate factory polish as close as possible. No extra charge for hunter, matte, satin, carded, coarse, standard or deluxe polishes, except hexagonal or octagonal barrels. High gloss, and mirror polishes are additional charges as listed on the "Work Order Form". The purpose of this option is to allow Craftguard to decide the polish for the customer not sure which polish to request. We prefer to have the customer specify polish desired.

Hunter: Craftguard blasts with silica sand resulting in the lowest glare of all polishes. Texture is the most coarse. Recommended on firearms with severe pitting. All parkerizing has hunter as final polish.

Matte: Craftguard glass bead blasts with number six glass beads. Better finish than satin on pitted firearms.

Satin: Our most popular of all the blasted finishes. Craftguard blasts with number eight glass beads. Texture is the finest of all our blasted finishes.

Standard: Craftguard polishes to number 400 grit. This polish is our most requested buff. This polish is offered upon request with no additional fees except on octagonal or hexagonal barrels. **Note:** Refer to "Work Order Form" for additional fees on octagonal or hexagonal barrels.

Deluxe: Craftguard polishes to number 600 grit greaseless fine compound. Buff marks are visible. This is a higher luster (or shine) than our standard polish. Recommended minimum

polish on most Brownings, Colts, Smith & Wesson, and Weatherby's. This finish is now offered upon request with no additional fees except on octagonal or hexagonal barrels.

Note: Refer to "Work Order Form" for additional fees on octagonal or hexagonal barrels.

High Gloss: Craftguard polishes with a grease compound to produce a high luster finish. Most visible buff marks removed. Refer to "Work Order Form" for additional charge. See note under mirror polish below for more information.

Mirror: Craftguard polishes using a chrome plating grease compound to produce a mirror finish. All visible buff marks are removed. Charge for mirror polish available after inspection of firearm. **Note:** High gloss or mirror polishes are not recommended for firearms with deep pitting around number, letters, edges, or engraving because not all pitting will be removed. It's important to realize that pitting that cannot be removed is magnified. High gloss and mirror polishes are available for "polish only parts," "salt blueing," and "NitroBlue" only. Refer to "Work Order Form" for additional charge.

Carded: Craftguard polishes with a fine wire wheel. Excellent polish for preserving markings on weapons such as "Broomhandle" Mausers or Damascus barrels. Carding will not remove any pitting. Same charge for carded polish as standard polish.

Coarse: Craftguard polishes to # 120 grit. If firearm is extremely pitted and customer does not desire a hunter, matte, or satin polish, this polish will cover or hide some of the pitting.

Polish (and Draw File) Octagonal or Hexagonal Barrel: Service required on all hexagonal or octagonal barrels in order to keep the flats smooth (no waves) and the corners sharp. This service is optional on round barrels. **Note:** Hexagonal and octagonal barrels must be removed from the receiver. See "Work Order Form" for additional cost.

No Polish (Economical Prepared Service): Craftguard will apply metal finish over surface as prepared by owner, dealer, or gunsmith. Craftguard will clean parts (using ultrasonic cleaner). No polishing will be performed by Craftguard. Parts received rusty or scratched will be returned to customer for re-polishing. **Note:** "No polish" service is not available on "Guard-Coat" PLUS. Also note, Craftguard will not provide the free Electroless Nickel Plating of bolts, triggers, hammers, etc, on "Economically Prepared" firearms.

Gunsmithing Services:

Dent Removal: Craftguard can push up dents in 20, 16, and 12 gauge shotgun barrels and magazine tubes. Gouges may not always be completely repaired, depending on the degree of damage. Craftguard considers dent removal as part of our metal preparation and we do not charge extra for the service. **Note:** Not available for economical customer prepared services.

Jeweling (Engine Turning): Metal finishing destroys jeweling. Craftguard can re-jewel bolts, carriers, etc. on most firearms. Refer to "Work Order Form" for additional cost.

Removal of Old Plating: Craftguard can electrically remove old plating. Craftguard is not responsible for any damage caused as a result of the plating removal process. Old plating must be removed prior to applying any new finish or coating. Refer to "Price List" for additional

cost.

Electroless Nickel Plating: When Craftguard provides a metal finishing service on a complete firearm, Craftguard will electroless nickel plate bolt assembly, bolt handle, bolt body, shotgun carrier, extractors, ejectors, or triggers at no additional charge (six part maximum). **Note:** Service must be requested in the "Special Instructions" section on the "Work Order Form". This does not apply to economical customer prepared services. This may increase wait time for completing your order.

Barrel Removal From Action/Receiver: Barrel removal from action is required in order to properly polish hexagonal or octagonal barrels. Round barrel removal is usually not required unless action is an alloy or for combination finishes. **Note:** Barrel removal is required for the heating processes of Teflon, "Guard-Coat" or "Guard-Coat" PLUS if the overall length of the barrel and action exceeds 37 inches. Refer to "Work Order Form" for additional cost.

Other Gunsmithing Services: Craftguard offers a variety of gunsmithing services. Not all of Craftguard's gunsmithing services are listed. Please contact Craftguard with any questions regarding our gunsmithing services.

Gunsmithing services offered by Federal Firearm Licensed (FFL) gunsmiths throughout the United States listed on Craftguard.com: Any questions concerning gunsmithing services listed on this webpage should be directed to the Federal Firearm Licensee offering the gunsmithing service. In addition to providing specific gunsmithing services, each gunsmith listed may be used for disassembly, reassembly, and for shipping your firearm to Craftguard to have a metal finish applied. NOTE: Craftguard makes no guarantee, provides no warrantee, and accepts no legal responsibility for any of the gunsmithing services provided from the Federal Firearm Licensee gunsmiths listed on Craftguard.com.

Firearm or Parts Received Damaged By Carrier:

Package Torn Open or Crushed: If package is received with a hole in the box or crushed, notify the carrier upon delivery of the package and check package for missing or damaged arts. If you need to file a claim, notify Craftguard and we will initiate a claim following carriers' or third party insurer (such as U-PIC) instructions.

Package Received With No Visual Damage: If firearm or parts are damaged upon opening shipping container, first notify carrier or third party insurer if applicable, then Craftguard. We will do all we can to expedite any claim.

Tracking UPS and Federal Express: Craftguard can track UPS and FedEx online. Time required for tracking is three to five minutes. You may also request tracking numbers via email for your convenience.

Care and Maintenance Of New Metal Finish:

External Surfaces of Firearm: Do not clean the outside of the weapon with harsh bore

cleaners or solvents and never use fuels such as gasoline or kerosene! Protect chamber(s) and bore with gun oil. Craftguard does not use any corrosion inhibitors that are harmful to metal or gunstock finishes. Periodically (every month or so) or after each handling of the firearm, wipe off all exposed metal surfaces to remove moisture and finger prints to prevent rusting. Excess water displacing oil (such as "Sheath") may be wiped off with a silicone gun cleaning cloth or clean cotton rag. Exterior maintenance not necessary for finishes such as "Guard-Coat" PLUS or Dupont's® "Teflon®."

Internal Surfaces of Firearm: Bore and chamber should be cleaned and oiled after each hunting trip or target shooting session for all metal finishes. Internal parts should be oiled with water displacing oil periodically.

Craftguard's History of Metal Finishing Services:

Craftguard is a small family owned and operated business. My late grandfather, William R. lehl, performed gunsmithing services for several local gun shops and in 1964 set up our **Hot Salt Blueing** process to service local gun shops. One year later he expanded the service to include **Rust Blueing**. In 1988, **Parkerizing** was added in gray, black, and gray/green. Two years later (1990), the rust blue line was expanded to include **Rust Brown** followed by **Rust Gray** in 1992. **Electroless nickel plating** of handguns was introduced in 1991 and expanded to include long firearms in 1997. **Gold plating** of small parts (such as hammers or triggers) was first offered in 1992. "**Guard-Coat**" in matte black color was introduced in 1996 and expanded to include matte silver in 1998. "**Guard-Coat**" **PLUS** metal coating service was offered in the fall of 1997. In the spring of 1998, **DuPont® "Teflon®"** metal coating in semi-gloss black color was introduced. **Damascus Rust Blue** was introduced in 2001 and is excellent for bringing out the Damascus pattern. **Nitre Blueing** was offered in January 2002 and closely matches Colt and Smith & Wesson revolvers of the 1850's through the 1930's. In 2016, Craftguard added Cerakote® and DuraCoat® to our metal finishing lineup.

Respectfully,



Bryan lehl
Manager/General Partner