

*Made in Carroll, Iowa*  
ESTD - 1974

THE WORLD'S FINEST RIMFIRE RIFLES AND PISTOLS









# CONTENTS

Stainless Steel Models .....	5
Lightweight Models .....	12
Rifle Specification Charts .....	20
The Art of Shooting - Katie Pavlich .....	24
Summit Bolt Action Rifles .....	26
Summit Rifle Specifications .....	29
Scorpion Pistol Models .....	32
Black Mamba Pistol Models .....	44
Pistol Holsters .....	50
Spending Time At The Range - Scott Volquartsen .....	54
Parts .....	57







## BUILD IT BETTER

“Build it Better” is more than a mantra. It is a lifestyle that is based on attitude, mindset, and discipline. You embrace it because you are determined to be better today than you were yesterday. You steadfastly pursue your passions and are humble in your pursuits. You are willing to hold yourself to a higher standard and tenaciously push forward with unwavering persistence.

You recognize that “handcrafted” doesn’t always mean “well-crafted,” and that “Made in the USA” doesn’t always equate to quality. You deserve firearms that are designed and engineered to the highest standards using only the best possible materials and technologies.

The word standard is not in your vocabulary. You never settle, and neither do we.



A man with glasses and a grey t-shirt is working on a precision machine in a workshop. He is focused on his work, with his hands near a rotating wheel. The machine is complex, with various adjustment knobs and a large flexible duct on the right side. The background shows a typical workshop environment with pipes and equipment.

## PRIDE & PRECISION

We manufacture every firearm and accessory using only the highest quality materials and production methods, ranging from time-honored hand tooling techniques to custom in-house CNC and EDM precision-built technology. Every gun we build is assembled from start to finish by a single technician who also test fires each gun before it's ready to ship. All of our firearms include a certificate of authenticity signed by the technician who assembled your gun. Each product is a promise - and we take that very seriously.

NOTICE  
PLEASE REGREASE 200LA  
GREASE (ABOUT PUSING  
THE GREASE GUN TEN  
TWENTY) THE GUIDE WAY  
EVERY MONTHS. PLEASE  
REFER TO 17 PAGE OF



## THE EVOLUTION OF THE WORLD'S MOST ACCURATE RIMFIRE RIFLE

It has always been our goal to achieve bolt-action accuracy from a semi-auto, and this begins with the barrel. Our stainless steel barrels feature match bore and chamber tolerances. These dimensions are proprietary to Volquartsen and have evolved from over 25 years of testing. Digital gauging equipment ensures that each barrel meets our stringent criteria.

Starting January 1, 2020, all Volquartsen Firearm barrels will undergo a unique laser hardening process. This will provide all the benefits of a hardened breech without compromising the barrel quality.







## STAINLESS STEEL MODELS: IF-5, SF-1, DELUXE, AND CLASSIC RIFLES



We offer four configurations of our stainless steel barrel, and all are very similar in terms of accuracy and performance. Each barrel features match tolerances in both the bores and chambers and are measured using the latest digital gauging equipment. All of our barrels are stress relieved multiple times throughout the manufacturing process. Once the rifling, chambering, and machine work are complete, our barrels undergo a machine honing and lapping treatment that not only helps in keeping the barrel clean, but also eliminates the need for a tedious break-in.

### Which Stainless Steel Barrel is right for you?

There is no wrong decision and it is entirely dependent upon individual shooting preferences. For example, are you shooting from a bench, prone, or off-hand position? Some shooters prefer the weight of a non-fluted barrel, where others prefer the balance of a lighter barrel, such as the I-Fluted model.



# STAINLESS STEEL MODELS



Shown with brown/gray Sporter Stock  
Multiple stock options available

## IF-5

The total package every shooter is looking for. The IF-5 is perfectly balanced and incredibly accurate, largely due to our signature I-fluted barrel. It reduces weight and creates more surface area than any other fluting designs, eliminating approximately 12 oz. of overall rifle weight.

Complete specification charts can be found starting on page 20.

AVAIL CALS:

17 WSM 17 HMR  
22 WMR 22 LR



Shown with brown/gray Thumbhole Stock  
Multiple stock options available

## SF-1

One of our most unique rifles, the SF-1 features our signature snake fluting design. This enables more heat dissipation than conventional straight flutes, but added rigidity over spiral flutes. The increased surface area helps cool the barrel during long, rapid-fire strings. Snake fluting reduces barrel weight by approximately 5 oz.

Complete specification charts can be found starting on page 20.

AVAIL CALS:

17 HMR  
22 WMR 22 LR





Shown with brown Sporter Stock  
Multiple stock options available

## DELUXE

The Deluxe model features a straight fluted stainless steel barrel and removable 32-hole compensator. This signature design gets you back on your second shot quicker, reduces weight, and helps dissipate heat for incredibly accurate shots, every time.

Complete specification charts can be found starting on page 20.

AVAIL CALS:

17 WSM 17 HMR  
22 WMR 22 LR



Shown with gray Sporter Stock  
Multiple stock options available

## CLASSIC

The Classic is the foundation of all our semi-auto rifles. Its sleek, clean features appeal to those seeking an updated take on the more traditional all-around rifle, yet looking for accuracy and performance.

Complete specification charts can be found starting on page 20.

AVAIL CALS:

17 WSM 17 HMR  
22 WMR 22 LR



















## LIGHTWEIGHT, SUPERLITE, AND ULTRALITE MODELS

Heavy bull barrel accuracy at less than half the weight

Is the balance of a rifle more important than the weight?

For many shooters, a heavier rifle that balances well can be easier to shoot than a lighter rifle where all the weight is on the muzzle.

Our Lightweight and Superlite rifles are designed for the uncompromising shooter aiming for balance and accuracy. The Lightweight and Superlite models utilize our original Lightweight THM Tension Barrel. This design is the original “lightweight bull barrel” and the four-piece design consists of a small diameter barrel with stainless steel end caps separated by a carbon fiber sleeve. This design creates an air space between the barrel and sleeve, allowing for better heat dissipation than other lightweight barrel designs.

The only difference between the Lightweight and Superlite is the receiver - stainless steel receiver on the Lightweight versus the Type III hard anodized aluminum receiver on the Superlite, results in an approximate 8 oz. difference.

The Ultralite is our lightest rifle, originally designed specifically for rimfire steel shooters. It's based on our carbon fiber tension barrel design but features a smaller barrel diameter resulting in our lightest configuration, making it perfect for transitions from plate to plate in a rimfire challenge event. It also features the Type III hard anodized aluminum receiver.







Shown with Hogue® stock  
Multiple stock options available

## LIGHTWEIGHT

True to its name in stature only, this rifle is a heavy-duty performer ideal for plinking, hunting, and all-around shooting. Our signature lightweight match grade barrel with tensioned sleeve creates a rigid, accurate, lightweight barrel which offers all the accuracy of heavier barrels, without the weight.

Complete specification charts can be found starting on page 20.

AVAIL CALS:

17 WSM 17 HMR  
22 WMR 22 LR



Shown with Hogue® stock  
Multiple stock options available | Multiple barrel color options available

## SUPERLITE

Our Superlite is a breeze to carry and shoot. It is incredibly lightweight, but also extremely tough. Featuring our robust CNC-machined aluminum hard anodized receiver and our Lightweight THM tension barrel, the Superlite packs on the performance - just not the pounds.

Complete specification charts can be found starting on page 20.

AVAIL CALS:

17 HMR  
22 WMR 22 LR



## LIGHTWEIGHT MODELS



Shown with McMillan® Sporter stock  
Multiple stock options available

### ULTRALITE

The Ultralite is built on our aftermarket receiver. It is still CNC-machined; however, it uses a more conventional wedge-locking block to secure the barrel as opposed to a threaded receiver. The Picatinny rail on this model is also removable, allowing for the receiver to be drilled and tapped for a specific mount or red dot optic.

Complete specification charts can be found starting on page 20.

AVAIL CALS:

22 LR























Standard with Magpul® X-22 Hunter stock  
Stock available in multiple color options

## VM-22

The VM-22 combines our Superlite barreled action with the Magpul® X-22 Hunter stock, resulting in a performance match that's made in heaven. This combination makes it an extremely accurate, well-balanced, and lightweight all-around rifle that's comfortable to shoot off-hand or from a benchrest.

Complete specification charts can be found starting on page 20.

AVAIL CALS:

22 LR



Standard with Magpul® X-22 Hunter stock  
Stock available in multiple color options

## OPEN-SIGHT

We've taken the popular Hi-Viz® fiber optic front sight and paired it with an XS Sights® adjustable rear ghost ring, making it the perfect combination for any lighting conditions. This set-up provides quick acquisition for rimfire steel competitors, as well as pinpoint accuracy for target shooters and hunters.

Complete specification charts can be found starting on page 20.

AVAIL CALS:

22 LR



# 22 LR RIFLE SPECIFICATIONS

RIFLE MODELS 22 LR	WEIGHT	BARREL LENGTH	RECEIVER MATERIAL		THREADED IN BARREL	LOCKING BLOCK SYSTEM	PICATINNY RAIL	
			STAINLESS STEEL	TYPE III HARD ANODIZED ALUMINUM			INTEGRAL	REMOVABLE
IF-5	4 lb. 15 oz.	20.5"	✓		✓		✓	
SF-1	5 lb. 4 oz.	20.5"	✓		✓		✓	
CLASSIC	5 lb. 5 oz.	18.5"	✓		✓		✓	
DELUXE	5 lb. 3 oz.	20"	✓		✓		✓	
LIGHTWEIGHT	3 lb. 5 oz.	18.375"	✓		✓		✓	
SUPERLITE	2 lb. 14 oz.	18.375"		✓	✓		✓	
ULTRALITE	2 lb. 8 oz.	18.375"		✓		✓		✓
OPEN SIGHT	3 lb. 11 oz.	16.5"	✓			✓	✓	
VM-22	2 lb. 14 oz.	18.375"		✓	✓		✓	

\*Weight shown is barreled action only \*Barrel length includes comp if applicable

## GENERAL SPECIFICATIONS

- + Magazine Capacity: 10-round
- + Barrel Twist Rate: 1:16"
- + Action: Direct Blowback Semi-Auto
- + Trigger: TG2000 with 2.25 lb. trigger pull

## COMPATIBLE STOCKS

- + McMillan Sporter (ambidextrous) - 1 lb. 13 oz.
- + Hogue Overmold - 2 lb.
- + Magpul - 2 lb 8 oz.
- + Laminated Wood Sporter - 2 lb. 5 oz.
- + Laminated Wood Thumbhole Silhouette - 2 lb. 14 oz.
- + Laminated Wood Lightweight Thumbhole - 2 lb. 2 oz.
- + Laminated Wood AS-1 Ambidextrous - 2 lb. 14 oz.
- + Inferno (ambidextrous) - 5 lb. 5 oz.



## 22 WMR RIFLE SPECIFICATIONS

RIFLE MODELS 22 WMR	WEIGHT	BARREL LENGTH	RECEIVER MATERIAL		THREADED IN BARREL	PICATINNY RAIL	
			STAINLESS STEEL	TYPE III HARD ANODIZED ALUMINUM		INTEGRAL	REMOVABLE
IF-5	5 lb. 8 oz.	20.5"	✓		✓	✓	
SF-1	5 lb. 15 oz.	20.5"	✓		✓	✓	
CLASSIC	6 lb.	18.5"	✓		✓	✓	
DELUXE	5 lb. 15 oz.	20"	✓		✓	✓	
LIGHTWEIGHT	4 lb. 5 oz.	18.375"	✓		✓	✓	
SUPERLITE	3 lb. 7 oz.	18.375"		✓	✓	✓	

\*Weight shown is barreled action only \*Barrel length includes comp if applicable

### GENERAL SPECIFICATIONS

- + Magazine Capacity: 9-round
- + Barrel Twist Rate: 1:16"
- + Action: Direct Blowback Semi-Auto
- + Trigger: TG2000 with 2.25 lb. trigger pull

### COMPATIBLE STOCKS

- + McMillan Sporter (ambidextrous) - 1 lb. 14 oz.
- + Hogue Overmold - 1 lb. 15 oz.
- + Laminated Wood Sporter - 2 lb. 7 oz.
- + Laminated Wood Thumbhole Silhouette - 2 lb. 12 oz.
- + Laminated Wood Lightweight Thumbhole - 1 lb. 13 oz.
- + Inferno (ambidextrous) - 5 lb. 5 oz.



# 17 HMR RIFLE SPECIFICATIONS

RIFLE MODELS 17 HMR	WEIGHT	BARREL LENGTH	RECEIVER MATERIAL		THREADED IN BARREL	PICATINNY RAIL	
			STAINLESS STEEL	TYPE III HARD ANODIZED ALUMINUM		INTEGRAL	REMOVABLE
IF-5	5 lb. 8 oz.	20.5"	✓		✓	✓	
SF-1	5 lb. 15 oz.	20.5"	✓		✓	✓	
CLASSIC	6 lb.	18.5"	✓		✓	✓	
DELUXE	5 lb. 15 oz.	20"	✓		✓	✓	
LIGHTWEIGHT	4 lb. 5 oz.	18.375"	✓		✓	✓	
SUPERLITE	3 lb. 7 oz.	18.375"		✓	✓	✓	

\*Weight shown is barreled action only \*Barrel length includes comp if applicable

## GENERAL SPECIFICATIONS

- + Magazine Capacity: 9-round
- + Barrel Twist Rate: 1:9"
- + Action: Direct Blowback Semi-Auto
- + Trigger: TG2000 with 2.25 lb. trigger pull

## COMPATIBLE STOCKS

- + McMillan Sporter (ambidextrous) - 1 lb. 14 oz.
- + Hogue Overmold - 1 lb. 15 oz.
- + Laminated Wood Sporter - 2 lb. 7 oz.
- + Laminated Wood Thumbhole Silhouette - 2 lb. 12 oz.
- + Laminated Wood Lightweight Thumbhole - 1 lb. 13 oz.
- + Inferno (ambidextrous) - 5 lb. 5 oz.



# 17 WSM RIFLE SPECIFICATIONS

RIFLE MODELS 17 WSM	WEIGHT	BARREL LENGTH	RECEIVER MATERIAL		THREADED IN BARREL	PICATINNY RAIL	
			STAINLESS STEEL	TYPE III HARD ANODIZED ALUMINUM		INTEGRAL	REMOVABLE
IF-5	6 lb. 13 oz.	22"	✓		✓	✓	
CLASSIC	7 lb. 4 oz.	20"	✓		✓	✓	
DELUXE	7 lb. 1 oz.	21.5"	✓		✓	✓	
LIGHTWEIGHT	5 lb. 14 oz.	22"	✓		✓	✓	

\*Weight shown is barreled action only \*Barrel length includes comp if applicable

## GENERAL SPECIFICATIONS

- + Magazine Capacity: 8-round
- + Barrel Twist Rate: 1:9"
- + Action: Direct Blowback Semi-Auto
- + Trigger: WSM TG2000 with 3 lb. trigger pull

## COMPATIBLE STOCKS

- + McMillan Sporter (right hand only) - 1 lb. 11 oz.
- + Laminated Wood Sporter - 2 lb. 7 oz.
- + Ambidextrous Wood Thumbhole - 2 lb. 10 oz.



A woman with long blonde hair, wearing a grey hoodie and blue jeans, is smiling and holding a long-barreled rifle. She is standing in front of a dark grey wall. On the wall, to her left, is a large white logo that reads "VOLQUARTS FIRE" with a stylized flame icon. The woman's hoodie also features a smaller version of the "VOLQUARTS FIRE" logo.

# VOLQUARTS FIRE

## THE ART OF SHOOTING

KATIE PAVLICH

The 2nd Amendment maven, Fox News contributor, and best-selling author on protecting and preserving the art of shooting.



“As we continue to advance in our own relationship with the sport, we have an obligation to share it. The American shooting tradition is one that must be protected...”

The art of shooting is a thrilling and individual one. Performance requires focus, patience, and the management of a tool being used to accomplish a downrange goal. Improvement takes discipline, perseverance, and dedication. The contour and weight of a handgun feels different for everyone. The stock of a rifle or shotgun is unique for each shoulder. And when you pull the trigger, whether standing, kneeling, or prone, you are in charge.

But while shooting as a sport ultimately comes down to personal skill and an individual relationship with a firearm, sharing this pastime and the constitutional right to keep and bear arms with friends or new shooters is tremendously rewarding. This is especially true given the sport naturally exudes curiosity.

I often get requests to “go shooting” from people who are unfamiliar with the sport. Those who show up for the first time are often optimistically cautious and tepid, but leave educated and empowered. They want to come back, work on their new skill set and ultimately pass their experience onto others.

The survival of the Second Amendment can be credited to those dedicated to its tradition. It has been proudly shared in a parallel way with peers and passed down for generations. Whether it's Olympians representing the United States on the global stage, shooters competing in local matches, fathers proudly passing down their rifles to sons and daughters, mothers arming themselves to protect their families, grandparents buying firearms for holidays and birthdays, or friends taking curious observers to shoot for the first time. Memories at the range and the time spent are priceless, and we all wish we had more of both.

Every August, shooters from around the country officially celebrate National Shooting Sports Month. Over the course of 31 days, the experienced and inexperienced are encouraged to get out to the range and to bring a friend or someone new. Whether it's outside or inside, long- or short-range target practice, the occasion is a reviving practice that encourages us to work on our shooting goals.

As we continue to advance in our own relationship with the sport, we have an obligation to share it. The American shooting tradition is one that must be protected and passed on to others, who will eventually feel the need to do the same.





# THE SUMMIT : REDEFINED



The Summit straight-pull bolt action is based on a concept originally developed by PWS – the Summit T3. The Volquartsen Summit represents the combination of their innovative design, our 40+ years' rimfire experience, and our mindset to “Build it Better.”

Designed for both competition shooting as well as small game hunting, this unique rifle is a straight-pull bolt action inspired by the 10/22 style platform. The CNC-machined receiver features an integral 20 MOA Picatinny Rail, making it the perfect rifle for any rimfire long-range shooting.

The Summit is available with either a stainless steel or aluminum action – lightweight or stainless steel bull barrel – easily configurable for any shooter. Barrels feature ½ x 28 muzzle threads, making it the perfect companion for your favorite suppressor.

This innovative design is built for everyone from the junior just getting into shooting to the accomplished competitor.

Available in multiple calibers and configurations with more to come!





Shown with Magpul® X-22 Hunter stock  
Multiple stock options available



## SUMMIT

All Summit models feature an integral 20 MOA Picatinny rail, TGS Trigger Group with a 1.75 lb. trigger pull. The action is available as a stand-alone product for 22 LR or 17 Mach 2 builds in your choice of stainless steel or Type III hard anodized aluminum. The 17 WSM is available only as a complete rifle with a stainless steel action. All barrels are suppressor-ready and threaded 1/2 x 28, with the exception of the tapered barrel. Summit models utilize a locking block system to secure the barrel to the receiver.

AVAIL CALS:

17 MACH 2  
17 WSM 22 LR







# SUMMIT STRAIGHT-PULL BOLT ACTION



Summit Aluminum Action - 1 lb. 11 oz.



Summit Stainless Steel Action - 2 lb. 13 oz.



SS Summit 22 LR w/ SS tapered barrel  
Brown/Gray AS-1 Ambi Stock



Summit 17 Mach 2  
Blue Laminated Wood Thumbhole Silhouette



**NEW FOR 2020**

Summit 17 WSM  
Gray Laminated Wood Sporter Stock

## Summit Specs – 22 LR

Barrel Twist: 1:16"

Magazine Capacity: 10-round

AL barreled action w/ lightweight barrel: 3 lb. 3 oz.

SS barreled action w/ lightweight barrel: 4 lb. 5 oz.

SS barreled action w/ ss tapered barrel: 5 lb. 9 oz.

## Compatible Stocks:

+ McMillan Sporter (ambidextrous) - 1 lb. 13 oz.

+ Hogue Overmold - 2 lb.

+ Magpul - 2 lb 8 oz.

+ Laminated Wood Sporter - 2 lb. 5 oz.

+ Laminated Wood Thumbhole Silhouette - 2 lb. 14 oz.

+ Laminated Wood Lightweight Thumbhole - 2 lb. 2 oz.

+ Laminated Wood AS-1 Ambidextrous - 2 lb. 14 oz.

+ Inferno (ambidextrous) - 5 lb. 5 oz.

## Summit Specs – 17 Mach 2

Barrel Twist: 1:9"

Barrel Length: 16.5"

Magazine Capacity: 10-round

AL Barreled Action Weight: 3 lb. 3 oz

## Compatible Stocks:

+ McMillan Sporter (ambidextrous) - 1 lb. 13 oz.

+ Hogue Overmold - 2 lb.

+ Magpul - 2 lb 8 oz.

+ Laminated Wood Sporter - 2 lb. 5 oz.

+ Laminated Wood Thumbhole Silhouette - 2 lb. 14 oz.

+ Laminated Wood Lightweight Thumbhole - 2 lb. 2 oz.

+ Laminated Wood AS-1 Ambidextrous - 2 lb. 14 oz.

+ Inferno (ambidextrous) - 5 lb. 5 oz.

## Summit Specs – 17 WSM

Barrel Twist: 1:8.25"

Barrel Length: 20"

Magazine Capacity: 6-round

Available only with SS action

Lightweight Rifle Weight: 5 lb. 3 oz.

IF-5 Rifle Weight: 6 lb. 3 oz.

## Compatible Stocks:

+ Laminated Wood Sporter Stock - 2lb. 9 oz.











# SCORPION 22 LR: THE CHOICE OF WORLD CHAMPIONS

Kolby Pavlock  
4X Rimfire World  
Overall Champion



The Scorpion 22 LR is the product of over 40 years of continual innovation, engineering, and vision. It offers unbeatable accuracy and balance and is extremely lightweight, with models weighing under 2 lb. Our proprietary, signature crisp 2.25 lb. trigger pull provides uncompromising quality. With the Scorpion, you can pick your poison – with different configurations for your frame, grip, barrel, and accessories to build your own customized set-up.



Cole Busch  
RCSA Junior Limited and Open  
World Champion



#### SCORPION 22 LR FEATURES:

- CNC-machined stainless steel barrel
- Stainless steel breech
- Type III hard anodized aluminum uppers
- Competition bolt standard
- Choose a 1911 style or Target style frame
- 4.5" or 6" upper
- Muzzle threaded 1/2 x 28
- Choose from Multi-port compensator, Single-port compensator, or a thread protector
- Integral Picatinny rail
- Configure your own at [Volquartsen.com](http://Volquartsen.com)



# SCORPION 22 LR MODELS



## 6" Scorpion, 1911

- 6" black aluminum upper
- 1911 black aluminum frame
- Hi-Viz® front, and target rear sights
- Hogue® grips

LENGTH: 11.5"

BARREL: 6"

WEIGHT: 2 lb. 1 oz.



## 4.5" Scorpion, 1911

- 4.5" black aluminum upper
- 1911 black aluminum frame
- Hogue® grips
- Multi-Port compensator

LENGTH: 10.4"

BARREL: 4.5"

WEIGHT: 1 lb. 14 oz.



## 6" Scorpion, Target

- 6" black aluminum upper
- Target style black aluminum frame
- Hi-Viz® front, and target rear sights
- Volthane grips

LENGTH: 11.5"

BARREL: 6"

WEIGHT: 2 lb. 6 oz.



## 4.5" Scorpion, Target

- 4.5" black aluminum upper
- Target style black aluminum frame
- Volthane grips
- Multi-Port compensator

LENGTH: 10.4"

BARREL: 4.5"

WEIGHT: 2 lb. 3 oz.



## SCORPION 22 LR FTV MODELS



### Black FTV, 6"

- 6" black aluminum flat top upper
- 1911 black aluminum frame
- Vortex Venom optic, 3 MOA dot
- Hogue® grips
- Multi-Port compensator

LENGTH: 11.5"

BARREL: 6"

WEIGHT: 2 lb. 3 oz.



### Black FTV, 4.5"

- 4.5" black aluminum flat top upper
- 1911 black aluminum frame
- Vortex Venom optic, 3 MOA dot
- Hogue® grips
- Multi-Port compensator

LENGTH: 10.4"

BARREL: 4.5"

WEIGHT: 2 lb.

## SCORPION 22 LR CUSTOM FINISHES



### American Flag Edition

- Patriotism Cerakote®
- 4.5" or 6" upper with compensator
- 1911 style aluminum frame
- Hogue® grips
- Accessory rail
- Target sights

LENGTH: 11.5"

BARREL: 6"

WEIGHT: 2 lb. 3 oz.



### Battleworn

- Proprietary NIB Battleworn® finish
- 4.5" or 6" aluminum upper with compensator
- 1911 style aluminum frame
- Hogue® grips
- Accessory rail
- Target sights

LENGTH: 11.5"

BARREL: 6"

WEIGHT: 2 lb. 5 oz.



Nate Gibson  
2019 RCSA Overall World Champion

















# SCORPION 22 WMR: A NEW BREED - SETTING THE STANDARD



The Scorpion 22 Mag is built using only the highest quality materials and production processes available, so you get better ballistics than the 22 LR, yet maintain the same level of accuracy and performance found in all our guns. It's a new breed of pistol for small game and varmint control.



# SCORPION 22 WMR MODELS



## Predator Green

- 6" stainless upper
- Completely CNC-machined from stainless steel
- Tungsten alloy bolt
- VZ® composite grips, Predator Green
- 9 round magazine capacity

LENGTH: 11.5"

BARREL: 6"

WEIGHT: 4 lb. 2 oz.



## Black on Black

- 6" stainless upper
- Completely CNC-machined from stainless steel
- Tungsten alloy bolt
- VZ® composite grips, black
- 9 round magazine capacity

LENGTH: 10.4"

BARREL: 6"

WEIGHT: 4 lb. 2 oz.



## Black Nitride

- 6" stainless upper, black nitride finish
- Completely CNC-machined from stainless steel
- Tungsten alloy bolt
- VZ® composite grips, black
- 9 round magazine capacity

LENGTH: 11.5"

BARREL: 6"

WEIGHT: 4 lb. 2 oz.



## American Flag Edition

- 6" stainless upper, Patriotism Cerakote®
- Completely CNC-machined from stainless steel
- Tungsten alloy bolt
- VZ® composite grips, black
- 9 round magazine capacity

LENGTH: 11.5"

BARREL: 6"

WEIGHT: 4 lb. 2 oz.











# BLACK MAMBA 22 LR: STRIKE WITH SPEED & AGILITY



Competition ready in an easy takedown configuration - the Black Mamba is everything you are looking for and more whether you are a backyard plinker, looking to win your local matches, or hitting the national competition scene.

The Black Mamba combines features from our Scorpion 22 LR pistol along with the push-button takedown functionality of the Ruger® MK IV™ platform.

The Black Mamba build utilizes a Ruger® MK IV™ frame that has been retrofitted with our Accurizing Kit providing a crisp, clean 2.25 lb. trigger pull. The frame has also been fitted with our magazine release that, when used in conjunction with our magazine base pads (included standard), eliminates feeding issues. This is accomplished by raising the magazine's position in the frame, allowing the bolt to more positively engage each round as it feeds.





#### BLACK MAMBA 22 LR FEATURES:

- CNC-machined stainless steel barrel with stainless steel breech
- Type III hard anodized aluminum uppers
- Our Accurizing Kit for a 2.25 lb. trigger pull
- Competition Bolt with DLC coating standard
- Choose a Ruger® MK IV™ 22/45™ or Ruger® MK IV™ Target style frame
- Integral Picatinny rail
- Muzzle threaded 1/2 x 28
- Single-port compensator
- Models in 4.5" or 6" barrel lengths
- Custom configurations available – build your own at [Volquartsen.com](http://Volquartsen.com)



# BLACK MAMBA 22 LR MODELS



**Black Mamba**

- 4.5" or 6" black aluminum upper
- Ruger® Mark IV™ 22/45™ polymer frame
- Volquartsen Accurizing Kit with 2.25 lb. trigger pull
- Volquartsen Competition Bolt with DLC coating
- Hi-Viz® front or Target front sight available
- Hogue® grips

LENGTH: 11.5"	BARREL: 6"	WEIGHT: 2 lb. 1 oz.
---------------	------------	---------------------



**Black Mamba**

- 4.5" or 6" black aluminum upper
- Ruger® Mark IV™ 22/45™ polymer frame
- Volquartsen Accurizing Kit with 2.25 lb. trigger pull
- Volquartsen Competition Bolt with DLC coating
- Hi-Viz® front or Target front sight available
- Hogue® grips

LENGTH: 11.5"	BARREL: 6"	WEIGHT: 2 lb. 1 oz.
---------------	------------	---------------------



**Black Mamba**

- 4.5" or 6" black aluminum upper
- Ruger® Mark IV™ 22/45™ polymer frame
- Volquartsen Accurizing Kit with 2.25 lb. trigger pull
- Volquartsen Competition Bolt with DLC coating
- Hi-Viz® front or Target front sight available
- Hogue® grips

LENGTH: 11.5"	BARREL: 6"	WEIGHT: 2 lb. 1 oz.
---------------	------------	---------------------



**Black Mamba**

- 4.5" or 6" black aluminum upper
- Ruger® Mark IV™ 22/45™ polymer frame
- Volquartsen Accurizing Kit with 2.25 lb. trigger pull
- Volquartsen Competition Bolt with DLC coating
- Hi-Viz® front or Target front sight available
- Hogue® grips

LENGTH: 11.5"	BARREL: 6"	WEIGHT: 2 lb. 1 oz.
---------------	------------	---------------------















## SCORPION HOLSTER



Safariland UBL



Blade-Tech TEK-LOK

- Currently compatible with 1911 style and Target 22 style frames
- Approximately 4 oz.
- Safariland UBL and Blade-Tech TEK-LOK set-ups available
- Compatible with most red-dot sights
- Open bottom design will work with thin suppressors (1" diameter or smaller)
- Keep your Scorpion safe and secure
- Made in the USA







## BLACK MAMBA HOLSTER



Safariland UBL



Blade-Tech TEK-LOK

- Currently compatible with 22/45™ frames
- Adjustable retention
- Safariland UBL and Blade-Tech TEK-LOK set-ups available
- Compatible with most red-dot sights
- Open bottom design will work with thin suppressors (1" diameter or smaller)
- Keep your Black Mamba safe and secure
- Made in the USA







A photograph of two men at a shooting range. One man is sitting in a folding chair on the left, wearing a blue t-shirt with a 'VOLQUARTSEN FIREARMS' logo, a white and black baseball cap, and sunglasses. The other man is standing on the right, wearing a dark t-shirt with the same logo, blue jeans, and sunglasses. They are both smiling. In the background, there is a large white building and a grassy field. A semi-transparent text box is overlaid on the right side of the image.

## SPENDING TIME AT THE RANGE

SCOTT VOLQUARTSEN

The President of Volquartsen Firearms discusses the importance of spending time at the range and having fun while you're there.



“For many of us, the range is a form of therapy, an escape from the office, or simply a break from the daily grind. It’s the one place that you can leave all the daily stressors behind.”

Do you remember your first shooting experience? Was it as a young kid with a parent, grandparent, or an older sibling? Or maybe you have just recently been introduced to shooting?

Either way, I’m betting you can recall that first time with a firearm. There’s something unique, something memorable about that first shot going downrange. Don’t believe me? Watch a new shooter’s reaction - it’s usually all smiles followed by something like, “I want to do that again!”

For many of us, the range is a form of therapy, an escape from the office, or simply a break from the daily grind. It’s the one place that you can leave all the daily stressors behind and be fully present in what you are doing. Whether it be with family, friends, or by yourself - putting rounds downrange is therapeutic.

I feel fortunate to have what I consider one of the best jobs in the world, but over the years, it was hard to distinguish between fun range time and work range time. Range time was testing new products, troubleshooting existing ones, or simply test firing completed firearms. Being on the range is something I started to take for granted and not fully appreciate.

If you’re a competitive shooter, maybe work on the range for you looks like repeating drills or stages trying to improve those times. Maybe your focus is more tactical or EDC, and the range has become all about situations and scenarios.

Let me be clear, I don’t want to take anything away from putting in work and honing your firearm skills at the range. My point is, it’s ok to take a step back and shoot for the pure enjoyment of shooting.

This past year I told myself I need to set aside more “fun” range time versus “work” range time. It’s always easy to say, “I don’t have time,” but many times that is an excuse we tell ourselves. I get it, it seems everybody is busier than ever between work, kids’ activities, chores around the house, and everything in between. I would argue that in our busy lives it’s even more important to prioritize time to get away and decompress.

I consider myself fortunate that I get to spend time on the range with people from all walks of life. It could be world champion shooters one weekend and busy CEOs the next. It’s always a privilege watching competitive shooters showcase their ability on the range but there’s almost something sacred about watching what the range can do for so many of us. The more shooters I visit with on the range the more I have come to realize there’s always a common theme - the word “reset.”

Spending time on the range with like-minded individuals, shooting for nothing more than fun, can be what we all need. The perfect reset.





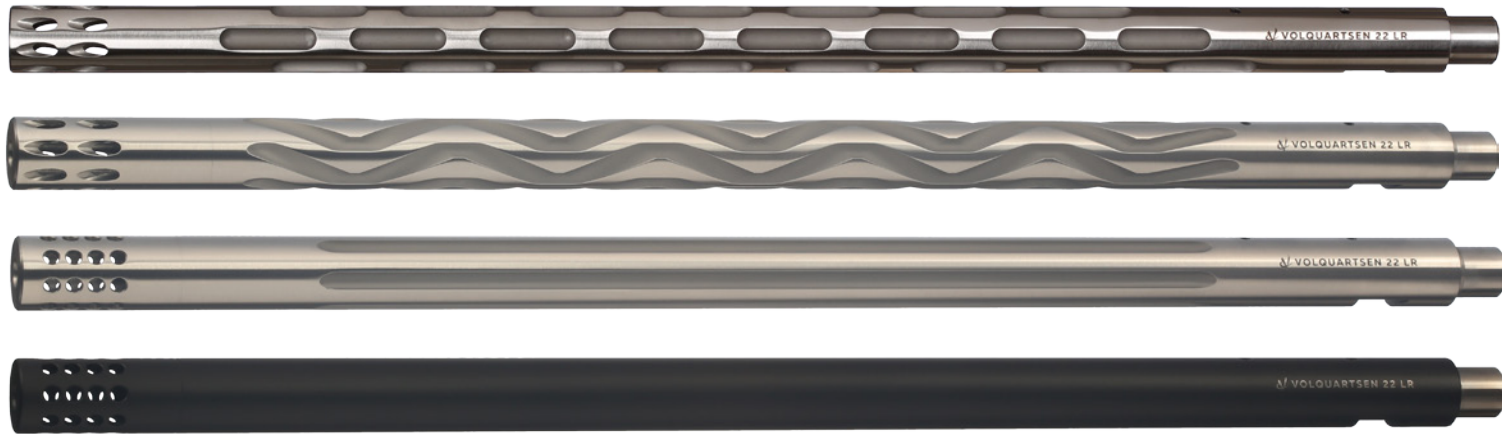




THE FINEST UPGRADES FOR YOUR GUN  
OUR COMPLETE LINE OF PARTS CAN BE FOUND AT  
[VOLQUARTSEN.COM](http://VOLQUARTSEN.COM)



# RIFLE BARRELS



**Stainless Steel Match .920" bull barrels**



**Lightweight Barrels for Ruger® 10/22® and 10/22 Takedown®**

## SUPERIOR FUNCTION & OPTIMAL ACCURACY

Our drop-in .920" bull barrels set the standard in accuracy and performance for rimfire barrels. Each barrel is digitally measured and inspected. We've developed our unique chamber to provide optimal accuracy but also superior function. Several fluting options are available.

Our lightweight barrels are no exception. The THM tension barrel consists of a special taper honed match barrel and chamber. It features a sleeve that is used to create tension on the barrel itself. This unique design eliminates issues typically found in smaller barrel profiles.

Our complete line of barrels can be found at [volquartsen.com](http://volquartsen.com).





Carbon fiber lightweight barrel and  
I-Fluted barrel with compensator for the SW22 Victory®



LLV Competition Uppers for the  
Ruger® MKII™, MKIII™, and MK IV™

## BALANCE, VERSATILITY, ACCURACY

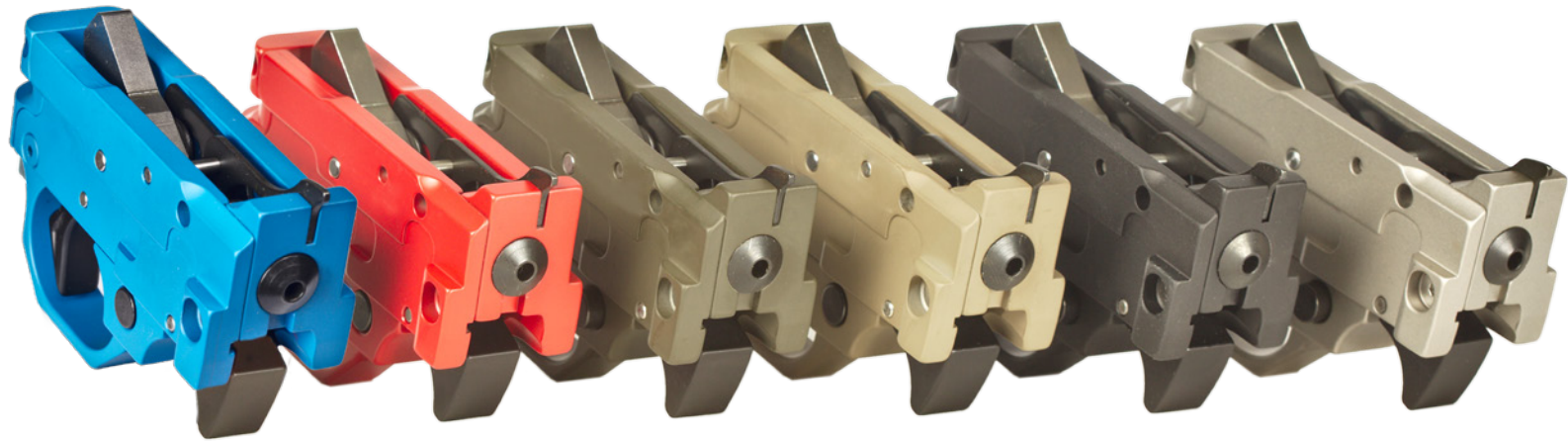
Designed to withstand years of use, whether you're a serious hobbyist or a competition shooter. Our uppers feature a stainless steel breech and are precision-machined from a single piece of aluminum billet. An integral Picatinny rail is machined into the top of the upper. A contoured barrel reduces weight without sacrificing accuracy.

Our barrels feature easy, drop-in installation and reduce weight while increasing accuracy. We can help you choose the correct one for your application.

Our complete line of barrels and uppers can be found at [volquartsen.com](http://volquartsen.com).



## TRIGGERS AND FRAMES



**TG2000**



**Target 22 Style Frame**



**1911 Style Frame**

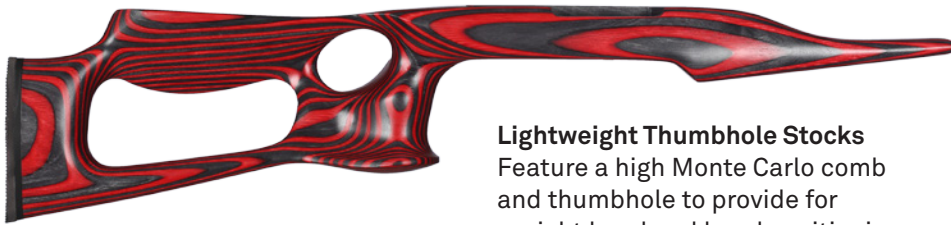
## SETTING THE STANDARD

The TG2000 is the drop-in replacement trigger guard that sets the standard for the Ruger® 10/22® rifle. It is machined from aluminum billet, and with precision wire-EDM cut internal components provides a crisp, clean 2.25 lb. trigger pull. Pretravel and overtravel adjustments can be set to your preference. The trigger is reset internally to eliminate any dragging or inconsistencies caused by a conventional trigger plunger.

Complete CNC-machined pistol frames with our Accurizing Kit pre-installed are also available. These frames feature a 2.25 lb. trigger pull.



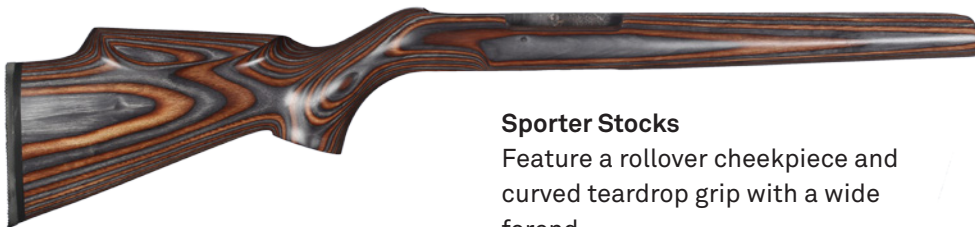
# STOCKS & GRIPS



**Lightweight Thumbhole Stocks**  
Feature a high Monte Carlo comb and thumbhole to provide for upright head and hand positioning.



**Thumbhole Silhouette Stocks**  
Feature a high Monte Carlo comb and thumbhole to provide for upright head and hand positioning.

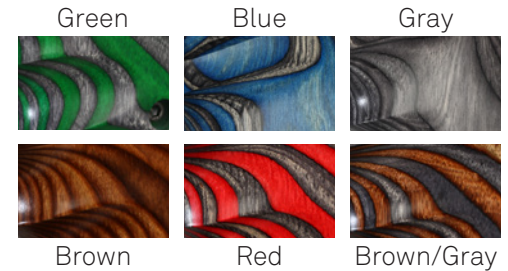


**Sporter Stocks**  
Feature a rollover cheekpiece and curved teardrop grip with a wide forend.



**AS-1 Ambi Stock**  
The most versatile stock we offer. Designed to fit our semi-auto 22 LR rifles, as well as our Summit action, and all Ruger® 10/22® rifles. Available in gray, brown, or brown/gray only.

All laminated wood stocks & grips available in these colors



Stock weights can be found with rifle specs beginning on page 20.



**Inferno Stock - Fully Adjustable - Ambidextrous**  
The Volquartsen Inferno Stock is a fully adjustable stock that is completely CNC machined from an aluminum billet. This is like no other stock on the market.



4 oz. weight

**Volthane Grips**  
Added comfort and control. These grips have been a staple for nearly 30 years.



3 oz. weight

**Ruger® MK III™ & MK IV™ Grips**  
Feature thumb rest, heel rest, and finger grooves. Designed to provide a relaxed, steadier hold.





**Competition Bolt for  
Ruger® 10/22®**



**Replacement Receiver for Ruger® 10/22®**



3 oz. weight

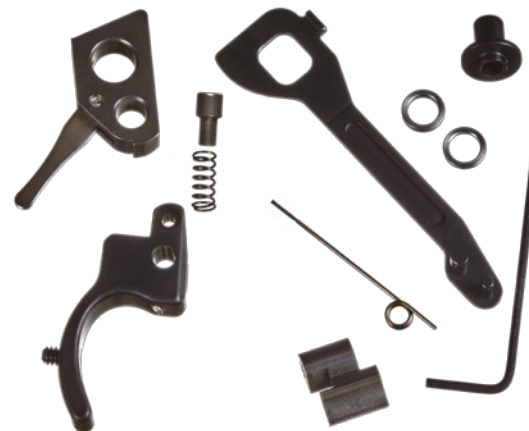
**32-Hole and Forward Blow Compensators**



5 oz. base weight

**Competition Bolts for the Ruger® MK II™, MK III™  
or MK IV™**

Eliminate stovepipes, failures to fire, and improve overall performance. Features an Exact Edge Extractor as well as the SureStrike Firing Pin. Diamond Like Carbon (DLC) Coated.



**Accurizing Kit for the Ruger® MK IV™  
(also available for MKII™ & MKIII™)**

Complete drop-in kit includes Target Hammer, Target Sear, Target Trigger, Extended Bolt Release, and Trigger Return Spring with Polished Plunger. All the internal components needed for the crisp, clean 2.25 lb. trigger pull. No stoning or fitting required.

## COMPETITION GRADE

Did you know our Competition Bolt for the Ruger® 10/22® was the first aftermarket bolt available for the 10/22®? It eliminated the need to rework the factory bolt. No more having to square the bolt face, reduce the headspace, or replace the internal parts on the factory bolt. The DLC coating has been tested through the rigors of competition and has proven itself time and time again. You get improved cycling, less lubrication, and very minimal cleaning. Just wipe it down, and you're good to go.



# ***GEAR/APPAREL***

AVAILABLE AT [VOLQUARTSEN.COM](http://VOLQUARTSEN.COM)

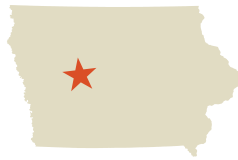




# THANK YOU

Here's to our shooters, hunters, competitors, dealers, ranchers, fathers, mothers, sons, daughters, plinkers, teachers, enthusiasts, supporters, collaborators, champions—and everyone in between. We're honored to see our work bring people together, and we couldn't be more grateful for your continued enthusiasm and support. – The Volquartsen Family

Volquartsen Firearms  
24276 240th Street  
Carroll, Iowa 51401  
712.792.4238  
info@volquartsen.com



@volquartsen\_firearms



@volquartsen



@volquartsenguns

## U.S.A. and INTERNATIONAL STOCKING DEALER PROGRAM

Become a Stocking Dealer and enjoy all the benefits of the program:

- Stocking Dealer pricing on rifles, pistols, and accessories
- Discounts on Volquartsen accessories
- Free Volquartsen apparel / merchandise
- Promotional material for your store
- Advertising & marketing support
- Listing on our Dealer Locator

For more information, call 712-792-4238 or email [info@volquartsen.com](mailto:info@volquartsen.com)

—  
PROUD SPONSOR  
OF THE  
RCSA  
**RIMFIRE  
CHALLENGE**  
AND THE  
SHOOTING SPORTS  
—

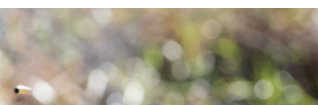
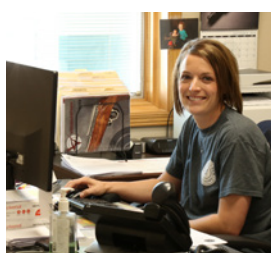
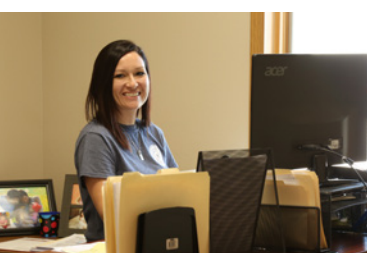
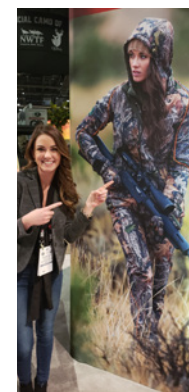
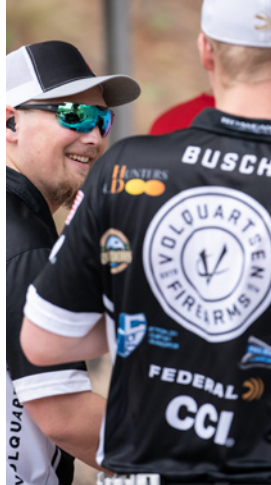


---

## THE INDUSTRY'S BEST WARRANTY

When you buy Volquartsen, you buy one of the finest names in firearms—as well as peace of mind. What does the industry's best warranty mean? Basically if you have a problem with anything that has been manufactured by Volquartsen and it hasn't been altered or modified, we will take care of it. For more warranty information, visit [Volquartsen.com/warranty](http://Volquartsen.com/warranty)







*Made in Carroll, Iowa*  
ESTD - 1974

BUILD IT BETTER



Volquartsen Firearms  
712.792.4238  
info@volquartsen.com  
© 2020 Volquartsen Firearms

[volquartsen.com](http://volquartsen.com)