DUAL-CRIMP INSTALLATION TOOL—INSTRUCTIONS

Tool Kit Contents

- Application tool
- Drill jig
  - Assembly sleeve
  - Assembly bolt (Colt-type installations)
  - Assembly nut
- 3/16'' cobalt drill
- 3/16'' carbide drill
- Carbide reverse countersink
- Slide bushings
  - Colt
  - Browning
  - S&W
  - Colt/Browning assy. screw
  - S&W
- File guide
- Plastic box

Tools Needed

- Drill press
- Drill vise
- File (mill)
- Masking tape
- Tweezers (or needlenose pliers)
- Cold blue
- Vise-Grip pliers
- Small punch
- Hammer
- Soft-nose hammer or mallet
- Open-end adjustable wrench
- C-clamp (Browning installation)

WARNING
CHECK GUN—MAKE SURE IT IS UNLOADED.

Instructions

1. Strip slide.
2. Remove front sight. Colt-type factory front sights twist off easily with Vise-Grips; or place front sight in vise and twist slide to break off sight. Remove portion of sight left in slide with small punch so it does not jam drill.
   S&W, Detonics, and other front sights with one-piece slide and front sight, will have to be milled or filed down flush with the top of slide.
   To remove with a file, it is best to first grind the front off close to the slide, then file square and flat to top of slide.
   The file guide supplied can be used to protect the slide by clamping it with a C-clamp against the rear of the front sight. This will help to make an even square pad for the aproned front sight.
3. Clamp the drill jig, with the correct slide bushing, into the muzzle end of the slide. Be sure muzzle of slide is square to sides; if not, use shim under drill jig to true up (photo 1).
   For S&W and Colt-type guns, the clamp bolts can be used through the slide plunger hole. Use the appropriate clamp bolt. On guns without plunger hole (Browning Hi-Power), use C-clamp to hold drill jig to slide.
4. Clamp slide and jig in drill vise. Use masking tape or safe jaws to protect slide. Use block or a short bolt and nut between rails of slide to keep slide from collapsing.
5. Check drill jig for tightness. (Use open-end wrench.) Check for squareness of slide to drill press and drill jig.
6. Place 3/16'' drill in drill chuck.
7. Align drill with guide hole in drill jig.
8. Drill holes in slide. Use care in starting holes so that drill jig is not moved. Drill all the way through the slide.

WARNING
WEAR SAFETY GLASSES DURING ALL DRILLING/COUNTERSINKING OPERATIONS.

9. Remove drill jig without moving slide in vise. This will maintain alignment with last hole drilled.
10. Using tweezers or needlenose pliers, slip reverse countersink into the last hole drilled and tighten shank of countersink in drill-press chuck (photo 2).

CAUTION
Use slowest speed setting for countersinking to prevent chipping.

11. Pull up on quill handle as you turn the drill press on and off (pulse the motor) so that you will not go too deep with the countersink cut. Do not allow countersink to dwell, as this will work-harden the slide and make countersinking more difficult. (See photo 3.)
12. Depth of countersinking is determined by the thickness of the slide: the thicker the slide, the greater the depth of cut. As a rule, the cut should be about half to one-third the thickness of the slide, leaving a .025'' minimum land after filing the flat for the apron. (See illustration A.)
13. Remove reverse countersink.

NOTE
If slide does not have a flat surface equal to the length of the Millett front sight, it will be necessary to file a flat, using the file guide to protect the surface of the slide. If slide has a flat, skip steps 14 and 15.

14. With slide clamped in vise, place Dual-Crimp front sight into drilled holes, sight facing properly. (Do not crimp yet.) Place file guide with flat end flush against face of sight. C-clamp to slide and remove sight (photo 4).
15. Using a safe-edged mill file, file a flat from file guide to end of slide. Flat should be approximately 1/32'' per side wider than the hole. Be sure to keep file flat and square to slide so sight will seat properly (photo 5).
16. Cold-blue the flat if the gun has been blued.
17. Place front sight in holes. Check alignment of sight with sides of slide. If sight is not aligned properly as you crimp with the Application Tool, apply pressure in the direction necessary to straighten the sight (photo 6).
18. Crimp the sight with the Application Tool, using enough force to flare the hollow dowels on the sight.

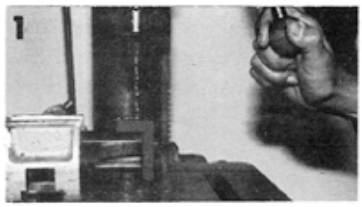
NOTE
When crimping the rear hole, place a piece of cardboard under the jaw of the Application Tool at the rear edge. This will protect the slide when releasing the tool.

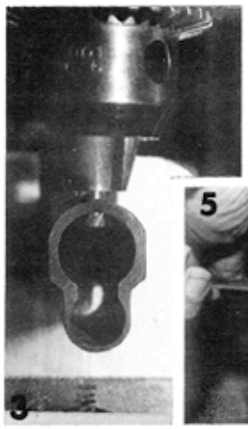
19. After firmly crimping both rivets, check the alignment of the sight. If not straight, use the Application Tool to square up the sight. Retighten the Dual-Crimp Tool and crimp again.

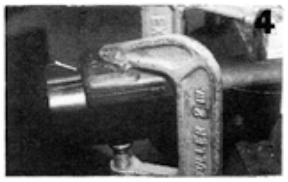
Removing a Dual-Crimp Front Sight

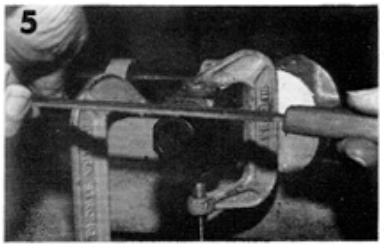
Place the sight in a vise, bottom side of slide up, and tap up with a soft-nosed hammer on the slide to loosen crimp. Pull up on slide, using a rocking action, until sight releases. New sight can be reinstalled following steps 17, 18, and 19.

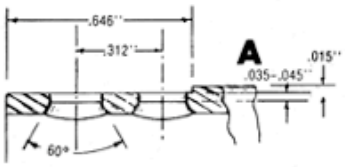
CAUTION
Browning slides are very soft, and sight must be removed with care. If seat and holes are distorted, pean back to shape with a punch and hammer—don't use a file.











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