



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

Disassemble the pistol and remove the sear and hammer components. If you do not know how to disassemble our pistol, we have reference manuals available. #924-200-045, *The Colt .45 Shop Manual*, a CD-Rom 1911 Bench reference, #087-000-002, or several others listed in the catalog.

- 1) Place the sear into the jig with the nose up and the flat on the sear against the setscrew. Use the sear pin from your pistol to hold the sear in place. The setscrew is set to a height of .074 of an inch, for the proper angle on the primary face.
- 2) Refer to the illustrations on sear angles and hammer hook depth before you start.
- 3) Place the jig in a vise to hold it securely and place the .020" shim on top of the jig. If the nose on your sear does not extend above the .020" shim it is too short and you must use a new sear.
- 4) Use finger pressure to hold the sear against the setscrew and with a medium cut India stone, 6" x 1/2" x 1/2" (#657-246-146) on top of the .020" shim. Stone the primary angle of the sear until it is just even across its face. Use light pressure and check the sear face often.
- 5) Now use a Ceramic stone 6" x 1/2" x 1/2" (#080-721-601) and stone the sear primary face to a mirror finish.
- 6) Remove the sear from the jig and now you can stone in the secondary or relief angle on the sear, see the reference chart.
- 7) To do this, place the sear nose down on your India stone and the .020" shim under the sear flat at the rear. This will raise up the sear at the rear and help in stoning in the 45° angle for the relief or secondary angle. Be sure to keep it even across its face.
- 8) The secondary angle should be about .020" wide or about 1/3 as wide as the primary angle surface. With that done, you will have a sharp edge where the two angles meet on the top of the sear nose.
- 9) Use your Ceramic stone and very slightly bevel that sharp edge to a slight radius, don't remove too much material. Just a small radius on that sharp edge only.

PREPPING THE HAMMER:

- 1) Clamp the hammer in a padded vise with the hooks up, and level. Use a Hammer Squaring File (#080-811-011) to lower the hammer hooks down to .020" in height.
- 2) With the .020" shim resting on the hammer and the hooks above the shim, file the hooks down until the file just touches the .020" shim.

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1911 SEAR FIXTURE

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READ & FOLLOW THESE
INSTRUCTIONS

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Use your Ceramic or India stone to take them down completely and smooth up the tops.

- 3) Use the Hammer Squaring File, and very lightly file the face of the hammer hooks to be sure they are 90° square. Then use a ceramic stone to polish the face of the hooks to a mirror finish. Make sure your stone is 90° square and the edge is sharp.
- 4) Assemble only the trigger components back into your frame. Leave out the grip safety at this time.

HINT: Replacing the factory 23 lb. mainspring with a 19 lb. mainspring will help lighten the trigger pull weight.

- 5) Check the trigger pull weight with a trigger pull gauge. You can bend the sear spring leaves backward to reduce the trigger pull. The sear spring has three leaves on it, the left leaf rides on the sear, the center leaf rides on the disconnector, and the right leaf operates the grip safety.
- 6) You can also straighten out the curvature of the spring on the lower end to help lighten the pull. Do not change the sharp 90° bend on the very bottom.
- 7) Bend the leaves a little at a time and check your pull weight, 3.5 lbs. to 4 lbs. is a good safe pull weight.
- 8) Never go below 3 lbs. as your trigger will be unreliable and unsafe.
- 9) The left leaf with the 90° bend at the top rides against the sear and should always be in front of the center leaf, when viewed from the side of the sear spring.
- 10) The center leaf should always have enough tension on it to push the disconnector up into place and to return the trigger forward.

THUMB SAFETY CHECK - VERY IMPORTANT!

When performing a trigger job on a 1911 pistol, you have changed the position of the sear from where it was originally and sometimes the thumb safety will not work correctly.

With the pistol unloaded and completely reassembled, cock the hammer and engage the thumb safety up into the on position.

Pull the trigger, the hammer should not move any, nor should the sear. Push the thumb safety down to the off position, the hammer should not fall down.

If either of these conditions exists you must replace the thumb safety and refit the new safety to your pistol.

Once you have performed the basic function/safety checks, you are ready to go to the range.

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.

REFERENCE CHART

