



Metal Checkering Files are designed as layout files. Use them to obtain the proper line spacing on mild, chrome moly and stainless steels. The spaced lines may then need to be cut to their full depth with a 3-square, fine cut needle file.

The "life expectancy" of these files will depend on the hardness/toughness of the metal being checkered, and the amount of area being checkered. Use of these files on chrome or nickel plated surfaces or on hardened surfaces will ruin the teeth - dulling them almost immediately.

FILE PREPARATION - FULL WIDTH FILES

Since the full width files are standard production items cut to a nominal width of 1/2", the edge rows of teeth are not always cut to full form. To properly prepare the file for use, these partial rows of teeth will have to be ground away so the outside rows are "full form". We recommend the use of a belt sander with a sharp, fresh 220 or 320 grit belt to cut away the partial rows of teeth.



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 area to be checkered should be painted with a layout fluid, such as Dykem, and the checkering pattern marked in pencil. Determine the angle that lines are to be cut for diamonds (usually 60°) or the angle for serrations to be cut (usually 90° to the gun's vertical axis). Scribe a "master" layout line in each direction needed for checkering diamonds (usually 60°) or serrations (usually 90° to the gun's vertical axis).

A pattern of metal checkering that has become popular with gunsmiths building custom 1911 Colt-type pistols uses vertical-horizontal lines cut into the front strap of the grip and the mainspring housing. In laying out this type of checkering, be very careful to have the vertical lines parallel to the sides of the pistol's frame, with the crossing lines at exactly 90° to them. The upper border of this type of checkering on the front strap usually stops abruptly, with the metal of the frame cut away to the depth of the checkering, and "sculpted into" the curve leading into the trigger guard. We recommend that you study illustrations of this type of work as shown in many current gun magazines, or better yet, study examples of other pistolsmith's checkering, before starting.

Using a fine-cut, 3-square file, carefully cut the master guide lines along the scribed line. Note: The care taken in laying out and cutting master guide lines will determine the overall quality of the finished job. The master guide line should be cut to about half the depth of the finished checkering.

An alternate method of cutting the master guide lines uses the left or right row of teeth of the checkering file itself, rather than a 3-square file.

Lay the Checkering File on the metal surface and slide it sideways until one row of teeth "catches" in the master guide line. Apply only moderate

pressure downward when cutting with the Checkering File to prevent the "guide" side from slipping out of the guide line. At the end of the stroke, raise the file slightly from the surface and return it to the starting point for each stroke. Do not draw the file backwards...the teeth are designed to cut only on the forward stroke. When the new line has been cut to about half its finished depth, move the file's "guide" side to the newly cut line. The file can cut parallel lines going either to the left or right, depending on the shape of the part being worked on, or the gunsmith's preference.

When the pattern is completed, there will be a series of diamonds outlined on the part. However, these diamonds are flat and do not aid in making the shooter's grip more secure. To "top-off" the diamonds, use a 60°, 3-square file to deepen these shallow lines. Go over these lines repeatedly and carefully, until they are so deep their edges touch. At this point, the diamonds will be "topped-off". Be VERY CAREFUL, do not rock the 3-square file from side-to-side while deepening the lines. Doing so will cause the lines or grooves to be of varying widths and depths, and not properly shaped or spaced.

After the diamonds are completed, brush the checkered area with a Brownells Stainless Steel Toothbrush or a wire wheel to remove any burrs. Touch up with Oxpho-Blue™ or reblue entirely using Oxynate #7™.

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.

BROWNELLS® CHECKERING FILES

READ & FOLLOW THESE
INSTRUCTIONS

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