



To use these bushing stakers you will have to provide an appropriately sized punch that is long enough to fit through the bushing opposite the one being staked, a 4 oz. to 8 oz. ball peen hammer, and a support block sized to fit the grip bushing.



### 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

Grasp the staking tool by the handle and slide it into the magazine opening with the pointed end placed into the seat of the tightened bushing to be staked. On 1911 Autos, a  $\frac{1}{8}$ " pin punch is inserted through the opposite bushing and into the hole in the staking tool head. For the Beretta pistols, use a  $\frac{3}{32}$ " punch. Important: Use the proper size punch for the job! Do Not use an undersize punch. An undersize punch will damage the grip screw bushing it has been inserted through. A drop of Loctite™ on the grip bushing's threads during reassembly will help to prevent the bushing from loosening in use. Even a properly fitted and staked grip bushing can loosen if the grip screw is allowed to rust into the bushing.

Make sure the bushing to be staked is well supported, and the support is placed on a rigid, flat surface. A bench block with recesses cut for grip bushing staking like the **Brownells Bench Block (#080-632-000)** is ideal for this use.

#### Helpful Hint:

A suitable support for Colt bushings can be made by drilling a  $\frac{9}{32}$ " diameter, flat bottom hole, .157" deep in the center of a 2" x  $\frac{3}{4}$ " steel block approximately  $\frac{1}{2}$ " thick. Chamfer the  $\frac{9}{32}$ " hole  $\frac{3}{64}$ " with a countersink. For the Berettas, use a similarly sized piece of steel; drill a flat bottom hole with a "C" letter drill (.242" diameter) to a depth of .056". Chamfer the hole very lightly with a countersink. Important: You must provide adequate support for the frame when staking grip bushings in any auto pistol, especially when the pistol is equipped with an aluminum alloy frame. Failure to properly support the grip bushing and frame during staking can result in damage to the frame.

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® GRIP BUSHING STAKER

#080-644-000



READ & FOLLOW THESE  
**INSTRUCTIONS**

## BROWNELLS®

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