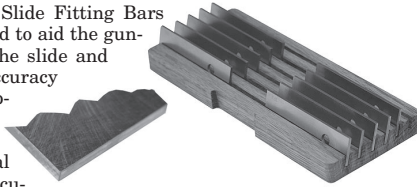


**WARNING**

Parts critical to the safe and correct functioning of the 1911 Government Model pistol, its variations and copies, including (but not limited to) the Barrel, Barrel Link and Disconnecter, are affected by the fit of the firearm's Slid to the Frame. Refitting the Slide and Frame using the Slide Fitting Bars will affect the relationship of these critical components. These Slide Fitting Bar Instructions cover **ONLY** suggested techniques for use of the Slide Fitting Bars. **ONLY** those person knowledgeable in the theory and procedures for repairing and rebuilding the 1911 Government Model Pistol, its variations and copies should use the Slide Fitting Bars and then **ONLY** as a part of a complete refitting involving all critical parts.

Brownells 1911 Auto Slide Fitting Bars were specifically designed to aid the gunsmith in the fitting of the slide and frame for maximum accuracy and uniformity. For optimum accuracy, the slide must fit the frame snugly with no horizontal or vertical movement. Accuracy is directly related to the uniformity with which the components within the pistol lock up at the moment of firing. If the slide is loose, it will be in a slightly different position each time it moves forward and locks into the barrel, causing the point of impact to vary.

Current production Slide Fitting Bars are manufactured with a 1/4" diameter hole located about 1" from one end of the bar. This hole enables two Slide Fitting Bars to be held on the frame with Brownells Slide Fitting Bar Holding Fixture. (Note: If you have Slide Fitting Bars without the hole, they can **NOT** be drilled to use with the Holding Fixture...they are heat treated to a level that makes it virtually impossible to drill or alter without destroying the tooling or the bar itself.

**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**

Following the manufacturer's recommended procedures, completely disassemble the pistol. Ideally, you should be working with a fully stripped frame and slide. Not only will this make firing easier, it will avoid the possibility of damage to smaller components.

Note: There are slots or "ways" near the top of the frame which match corresponding rails in the bottom of the slide. Ideally, the height, or thickness, of the slide rails should be approximately .001" less than the height of the frame "ways". If the heights of the slide rails are equal to, or greater than, the heights of the frame "ways", the slide will fit the frame so tightly it cannot cycle back and forth, or it will not go onto the frame at all! If the slide rails are more than .001" less than the frame "way" height, the slide will fit the frame too loosely.

The slide must be properly prepared prior to beginning the actual fitting process. Turn the slide upside down and secure it in a padded vise so you have complete access to the slide rails. Using appropriate files and emery paper, smooth up and polish the bottom of the slide rails on the underside of the slide. Ideally, you will want to have a smooth, dead, flat surface on the bottom of the slide rails. Also, flatten the sides of the slide rails on the inside of the slide at this time. Do **NOT** assume that the surfaces of the slide rails are true! Variations in rail height and slight bends in the rails are fairly common, especially on older, wartime production slides.

After the slide rails are smooth, we suggest that you remove an additional two to three thousandths (.002" - .003") of slide rail height in the area from the disassembly notch, forward. This will permit the smooth and easy movement of the slide to the rear after the barrel initially unlocks. Again, the metal should only be removed from the disassembly notch, FORWARD.

In order to select the correct Slide Fitting Bar, the height of the slide rails from the disassembly notch to the rear must be accurately measured. Using the Brownells Slide Rail Micrometer (#827-561-730). If the height of the slide rail is .115", use the .116" Slide Fitting Bar as the spacer for tightening

# BROWNELLS®

## 1911 AUTO SLIDE FITTING BARS

READ & FOLLOW THESE  
**INSTRUCTIONS**

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the frame "ways". REMEMBER: The height of the frame "ways" should be .001" larger than the slide rail height.

Secure the frame in a padded vise so you have complete access to the frame "ways" and the top of the frame. Always use a Magazine Well Filler when clamping the frame to avoid damage to the magazine well. Also, take care that the stock screw escutcheons are not damaged by the vise jaws.

Place the edge of the appropriate Slide Fitting Bar in the frame "way" and, using a machinist hammer with a polished, flat face, gently tap the top edge of the frame "way" downward. Exercise great care in doing this. **DO NOT USE EXCESSIVE FORCE!** Try to move the metal of the frame "ways" down evenly. Be extremely careful in working the metal around the magazine well. There is less metal in this area and it is possible to crack the frame.

When the Slide Fitting Bar is a snug fit on one side of the frame, repeat the process on the other side. Note that as the metal on the frame is swaged downward to tighten the "ways", it is also moved outward. This outward movement of the metal helps eliminate sideways movement of the slide.

After use of the Slide Fitting Bar is completed, place the slide on the frame. Final fitting should include lapping the slide to the frame with an appropriate lapping compound.

Once fitting of the slide has been completed and all related components have also been refitted, 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.

Please note the steps outlined here are but a few of the operations that should be considered in fitting a slide. The amount of work to be done depends upon the initial fit of the slide to the frame and the skill, experience and motivation of the individual doing the work. For more extensive information about tuning a 1911 Auto, we would urge you to consult the various fine gunsmithing books, such as the *NRA Gunsmithing Guide-Updated*, *Hallock's .45 Auto Handbook* and *Kuhnhausen's The Colt .45 Automatic, A Shop Manual*.