



Brownells 1911 Auto Lug Iron was designed by noted gunsmith and author Jerry Kuhnhausen and the gang at Brownells. This tool enables the pistolsmith to quickly and easily remove burrs or raised metal near the locking lug recesses inside the slide of Colt, 1911 Autos, and pistols of similar design. Used slides, because of the effects of force and friction, develop wear ridges or flanges at the edge of the lug recesses. New slides can exhibit machine marks or burrs on the interior surfaces. Both can interfere with proper functioning and lug engagement. The Lug Iron will help the pistolsmith give the inside surface of both new and used slides a finished, smooth appearance.



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

Remove the slide assembly. Strip the slide of all parts except the sights which, under normal conditions, are not removed. Be sure to follow the manufacturer's instructions or those described in a good manual such as *The NRA Guide to Pistols and Revolvers Vol. IV*, or *The Colt .45 Automatic - A Shop Manual* by Jerry Kuhnhausen. Clean the interior of the slide thoroughly to remove all grease, oil, carbon, etc. Secure the slide in a padded vise with the bottom, or "open" portion, facing up. It is important to have unrestricted access to the slide's interior and to be able to closely monitor the progress of your work.

Loosen the socket head screw securing the clamping bar to the end of the Lug Iron. Wrap a 2" long x 1" wide piece of abrasive paper around the head and tuck the two ends of the strip under the clamping bar. Retighten the socket head screw to secure the abrasive paper. The abrasive paper should be fitted snugly around the Lug Iron head. If loose, it may tear, or prevent entry of the Lug Iron into the slide.

The condition of the interior of the slide will determine the initial grit of the abrasive paper used. Normally, 320 grit works well. Depending upon the job requirements, you can also work on through finer grits to the point that you have an almost "mirror" polish inside the slide.

Carefully measure the depth of the locking lug slots before and during the polishing process. The depth of the locking lug recesses must NEVER BE LESS THAN .055". **PLEASE NOTE:** (It is necessary to remove only the burrs or raised metal around the locking lug recesses.) Normally you will only need to remove about .002". Do not remove any more metal from around the Locking Lug area than is absolutely necessary.

The area from the front edge of the slide to within .250" in front of the first locking lug recess can also be polished. Do not remove more than a few thousandths of an inch. Excessive metal removal at the front of the slide may result in a loose fitting barrel bushing.

When the interior of the slide has been polished, clean the slide carefully to remove all traces of abrasive.

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.

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1911 AUTO LUG IRON

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READ & FOLLOW THESE
INSTRUCTIONS

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