



Brownells 1911 Auto Front Sight Staker will help the gunsmith properly secure front sight blades to most models of the 1911 Auto pistol. The vertical offset design of the Staker makes it easier to hold and transfer the full force of the hammer blow directly to the sight's tenon. The Front Sight Staker is equipped with a hardened, replaceable staking anvil that will easilypeen both the old-style narrow tenon as well as the new-style wide tenons. Staking is the most common technique used to secure a front sight blade; is very durable and should not separate or loosen from the slide. Staking the front sight allows the gunsmith to replace or change the sight without the risk of potential damage to the slide or its finish. Other methods of front sight attachment, such as soldering or brazing, can discolor the slide or cause heat warpage and loss of temper.



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

REMOVING THE OLD SIGHT - Secure the slide in a padded bench vise with the bottom of the slide facing up. Use a small, abrasive stone point in a Dremel Tool to remove the excess sight tenon material around the tenon slot on the **inside** of the slide. Removing this material will make it easier to pry the existing sight from its tenon slot. Be very careful, grind away only enough material to expose the end of the sight tenon and no more. Loosen the bench vise, turn the slide over so the top of the slide is facing up and secure the slide in the bench vise. Grasp and lock onto the sides of the existing sight with a pair of vise grips. Gently rock the vise grips side-to-side until the front sight begins to loosen in the tenon slot. The sight material is softer than the slide. Rocking the sight will deform the tenon and cause it to loosen in its slot. When the sight is sufficiently loose, place a small block of soft wood underneath the bottom side of the vise grips and gently push downward on the vise grips. If the sight is loose enough, the downward pressure will lift the sight from its slot. **CAUTION:** Do not let the vise grips come in direct contact with the slide. If rocking the sight blade causes it to break away from the tenon, simply remove the remaining tenon by gently pushing it downward, through the tenon slot, into the slide with a small diameter punch or awl. **CAUTION: DO NOT** strike the tenon or deform the tenon slot. Before proceeding, make sure the tenon slot is clear of any obstructions or remnants of the existing tenon.

Before you use Brownells 1911 Auto Front Sight Staker, carefully examine the tenon slot and determine if it is "wide" or "narrow". Colt has manufactured slides with both dimensions. Earlier A1 and 70 Series pistols have a tenon slot width that measures approximately .055". Later Series 80 pistols have a tenon slot width that measures approximately .125". The wider tenon provides more support for the newer style; higher profile sights. Also, after-market sights equipped with the wide tenon, if properly staked, are stronger than the narrow tenon sights. Other manufacturers of 1911 Auto pistols have followed Colt in this design change, some have not. Before

attempting to install any sight, measure the tenon slot and determine its width. **NOTE:** Make sure the tenon width of the front sight you intend to install matches the width of the tenon slot in the slide. **DO NOT** attempt to install a wide tenon sight in a narrow tenon slot or a narrow tenon sight in a wide tenon slot. The tenon **MUST** fit the tenon slot snugly. Newer Series 80 pistols have a machined flat on the top of the slide directly over the tenon slot. If the sight base is longer than the machined flat, alter the base of the sight until it sits flush against the slide with no gaps showing at the front, rear, or along the sides of the sight. Make all your alterations to the sight - **Remember**, it's the cheaper part.

STAKING THE SIGHT - Secure the slide upside down in a padded machinist's vise so you have access to the inside front portion of the slide. **IMPORTANT:** Use lead shims to pad the jaws of the vise. In addition, place a leather pad underneath the slide to prevent damaging the finish of the slide. Closely examine the tenon slot inside the slide to see if the edges on either side of the slot have been relieved. If the slot has not been previously relieved, cut a 1/32" relief bevel on either side of the tenon slot with a .125" diameter round ball cutter mounted in a Dremel Tool. The purpose of relieving these edges is to create more surface area and leave more tenon material after peening and grinding. More tenon material means a stronger, more durable front sight. After the relief bevel has been cut, remove the slide from the machinist's vise and check the fit of the sight and the tenon in the slide tenon slot. It must fit snugly. If the tenon is too small or too narrow, replace it with another sight. Clean and fully degrease the front sight and tenon slot. Place the front sight in the tenon slot and secure the slide in the padded machinist's vise. Because front sights are made from relatively soft material, the sight blade must be fully supported and aligned (not canted) during staking or the blade will be damaged. Place a drop of Loctite™ #271 or #640 on the cleaned tenon to help fill any voids between the slide and the sight and increase the strength of the installation. Place the Point of the Sight Staker on the tip of the tenon that protrudes through to the inside of the slide. Begin striking the Sight Staker with light strokes using a four or eight ounce ballpeen hammer. Hold the Sight Staker lightly and move the Point of the Staker side-to-side and continue to tap until the tenon is flattened evenly against the inside surface

BROWNELLS®

1911 AUTO FRONT SIGHT STAKER

#080-817-000



READ & FOLLOW THESE
INSTRUCTIONS

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of the slide. Go slowly and do not attempt to rush the staking of the tenon. The tenon must be flattened evenly and uniformly to achieve the strongest installation. Allow the Loctite adequate time to cure before proceeding to the next step. After the tenon has been staked and the Loctite is fully set, use a Dremel Tool with a fine cut grinding point to remove any excess peened material from the tenon. Remove only enough material to permit installation of the barrel bushing.

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.

REPLACEMENT OF SIGHT STAKER POINT - The hardened staker Point can be easily replaced if it becomes excessively worn or broken. Order part #080-870-213 from Brownells. If the anvil of the Point breaks off, the remainder of the shaft can be driven out through the mounting hole in the Staker with a small punch. If the anvil is worn but not broken from the shaft, carefully grind off the anvil portion of the Point, then remove the shaft as detailed above. Do not remove any metal from the body of the Staker. Place a drop of #242 Loctite on the shaft of the new Staker Point and insert it into the mounting hole.