



Brownells 1911 Auto Barrel Lug Cutter is a time-saving tool that will remove most of the excess material located on the bottom lugs of an oversized, aftermarket 1911 Auto Barrel. This specially manufactured, carbide cutter and handle assembly will leave the bottom lugs with a smoothly cut surface, ready for final hand fitting. The Barrel Lug Cutter is available in .186" and .195" diameter. You should always use the .186" diameter cutter first and check for proper fit before using the .195" diameter cutter. Once too much material has been removed from the bottom lug it is impossible to get a true, slide stop pin to bottom lug lockup without rewelding the lug. However, you can still achieve what is called "link lockup" which is the standard lockup for most factory guns.



### 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

Before cutting the 1911 Auto Barrel lugs; the barrel hood, upper lugs, barrel and bushing must be completely fitted and the slide must fit onto the frame without interference. The slide can fit the frame tightly but it must be able to move on the frame with only light, finger pressure.

Insert the fitted barrel into the slide and position Brownells Barrel Alignment Block (#080-000-041) in the slide around the barrel lugs and square the barrel. Insert Brownells Auto Barrel Holder (#080-711-100) into the slide spring tunnel and tighten the Barrel Holder's screw to hold the barrel fully locked-up in the slide. Remove the Barrel Alignment Block. Make sure the bottom lugs of the barrel are centered and set squarely in the slide. If the barrel is not square and centered, repeat the process with the Barrel Holder, and make corrections to the top lug or barrel hood to ensure the proper relationship between the barrel lugs and the slide are maintained during the cutting operation. If the barrel lugs are not held squarely in the slide, the lugs will not be cut evenly and improper lockup will result.

Install the slide and barrel assembly onto the frame so the barrel lugs are located to the rear of the slide stop pin hole. Do not push the slide/barrel assembly all the way forward at this time. Install the Lug Cutter pilot bushing into the slide stop pin hole located on the ejection port side of the frame. Apply a small amount of grease on the cutter. This will both lubricate it and catch the metal shavings as the lugs are being cut. Assemble the Lug Cutter onto its handle and install the Lug Cutter from the plunger tube side of the frame. Make sure the pilot on the end of the cutter is engaged onto the hole in the center of the bushing. Push the slide forward until you feel the barrel lugs come in contact with the Lug Cutter. Turn the lug cutter slowly, in a clockwise direction, while applying pressure to the rear of the slide. As you begin to remove material from the barrels lugs the slide/barrel assembly will begin to move forward and the metal chips will begin to clog the cutter. Remove the Lug Cutter and handle assembly from the frame frequently and clean the chips out of the cutter; then re-grease.

Continue cutting the barrel lugs carefully, until the thumb safety will swing into the slide's safety notch freely and without drag. There is another way to make certain the lugs are cut correctly. Install the disconnecter cor-

rectly and cut the lugs until the disconnecter rises properly into its clearance cut in the slide and the thumb safety swings into its slide notch freely. Do not be concerned if the back of the frame and slide do not line up after cutting the lugs. These areas can be recontoured to blend properly after all slide/frame and barrel fitting has been completed.

The standard .186" diameter cutter will leave enough material for final handfitting with a round, fine-cut  $\frac{3}{16}$ " diameter file. Using the .195" cutter will remove more material and in some pistols this may be too much. We strongly recommend that you start small, cut carefully and check your work often. Both cutters will require some hand fitting to be done to the lugs after the cutting process is finished. The lockup should be firm but not bind.

Once the lugs are cut, you must choose the proper barrel link. Measure the distance (Distance 1) from the bottom of the barrel link hole to the lug surface where it will contact the slide stop pin when the barrel is locked into battery. Next, measure the distance between the two holes in a barrel link (Distance 2). Find a link where Distance 2 is equal to, or slightly longer than, Distance 1.

Paint the sides of the barrel lugs with a permanent marker and lay a link on the outside of the lugs using a link pin to hold the link in place. Position a sharp scribe in the slide stop hole of the link and rotate the link thru it's arc scribing a line on both sides of the barrel lugs. This will show you how much to remove off of the front of the barrel lugs to allow the link to swing freely throughout it's movement as the barrel cycles in and out of battery. The flats on the lugs should be as long as possible to lock on the slide stop pin for best accuracy. Install the link and pin into the barrel and hand cycle to check functioning.

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®

## 1911 AUTO BARREL LUG CUTTER



READ & FOLLOW THESE  
**INSTRUCTIONS**

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