



Brownells Escutcheon Screw Counterbore is a combined drill and counterbore for use with Brownells Escutcheon Screws. The counterbore is designed to drill the clearance hole for the grip screw and counterbore the hole for the nut and escutcheon.



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

We recommend that all layout and inletting for new handgun grips be done on the rough grip blank before the hole is located for the grip screw. Any minor shifting of the grips while inletting could cause clearance problems for the grip screw with the internal parts of the firearm. Make certain that the location chosen for the new grip screw will not cause it to interfere with any moving parts through the full cycle of the action.

Mark the location for the grip screw on the inside of one grip panel. Secure that grip panel in a drill press vise, marked side facing up. Make certain that the grip panel is square with the drill press, so the grip screw hole will be drilled at right angles to the inside surface of the grips. Secure the escutcheon screw counterbore in the drill press chuck. Lower the drill press downfeed and check to see that the spade drill tip of the counterbore centers on the mark. Turn on the drill press and drill the grip panel. **IMPORTANT: DO NOT** allow the counterbore section to contact the inside surface of the grip panel. Turn the grip panel over so the outside surface of the grip panel is up. Run the counterbore into the drilled hole deep enough to counterbore for the escutcheon, but no deeper. Remove the grip from the drill press vise and place both grips onto the grip frame of the gun. Temporarily hold them in place with masking tape or a rubber band. Remove the escutcheon screw counterbore from the drill press. Carefully insert it into the drilled grip panel. Make sure that it is aligned straight through the grip panel. Gently turn the counterbore by hand to mark the opposite grip panel. Remove the grip panels from the grip frame of the gun and secure the non-drilled grip panel in the drill press vise. Follow the same procedures to drill the second grip panel that were used to drill the first. When both grip panels have been drilled, insert the nut and escutcheon into the grip panels and seat both parts into the counterbored holes.

BROWNELLS[®] ESCUTCHEON[®] SCREW COUNTERBORE

#080-034-600



READ & FOLLOW THESE
INSTRUCTIONS

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After the escutcheon and nut have been seated into the grip panels, place the panels on the firearm, insert the grips screws and tighten until the screw head is seated fully into the escutcheon. Use a dial caliper to measure the amount of grip screw threads that protrude from the nut. Write this measurement down. Remove the grip screw from the grip panels. Mark the cut-off measurement on the end of the grip screw and clamp the screw in the bench vise by the "waste" end. Cut off the grip screw at the mark, use a file to dress off the cut end and lightly bevel the screw at the thread origin. Clean off all chips and waste from the screw and make certain the threads are undamaged. Turn the grip screw into the nut, through the escutcheon, and tighten. The grip panels are now ready for final shape, fit and finish.

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.