



The single most critical factor when checkering 1911 front straps is making sure that the guide or master lines are laid out properly. Once this is done, it is a relatively simple matter to complete a pattern.



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

After making absolutely sure the pistol is not loaded, remove the magazine and separate the barrel and slide from the frame. The only parts that normally need to be removed from the frame are the two grip panels. Of course, if you are planning to reblue the frame you will want to completely strip it of all components.

The frame should be secured in a padded vise so the front strap is "up" and easily accessible. Make sure the position of the frame in the vise does not interfere with the placement of the Checkering Guide. The guide can now be clamped to the frame using the Allen head screw along with the rectangular clamping pad. The head, or top portion, of the Checkering Guide should rest evenly and securely on the top of the front strap with the angular point of the Guide's head at about the mid-point of the width of the front strap. Because of its design, the Checkering Guide can be clamped on either side of the frame as well as at virtually any point along the length of the front strap. The milled slot in the body of the guide allows it to be positioned over the grip screw studs eliminating the need to remove them.

If you wish to cut a series of parallel lines across the front strap you can use either side of the Checkering Guide Head since the sides are at a 90° angle to the front strap. If you wish to actually checker the front strap, the 60° angle on the front of the guide's head will position the master lines properly for well proportioned diamonds.

DO NOT attempt to actually checker with the guide in place! The purpose of the guide is only to ensure that the master lines are true and straight. After positioning the guide, make a long, contour-following stroke across the front strap with a checkering file. One edge of the file should be held securely against the side of the guide throughout the stroke. Next, remove the guide, move the checkering file over a few lines and make another long stroke. By resting several rows of the checkering file teeth in previously cut grooves, the file can be guided properly. Repeat this process until you have covered as much of the front strap as desired.

Reinstall the Checkering Guide so you can cut another series of lines that

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will cross the first set of lines at a 60° angle. When you have completed this you will have a series of diamonds outlined in the front strap. However, these diamonds are flat and do not aid in making the shooter's grip more secure. To "top-off" the diamonds, use a 60° triangular file to deepen these shallow lines. Go over each line carefully and repeatedly until the lines are so deep their edges touch. When this occurs the diamonds will be "topped-off". Be **VERY CAREFUL** that you do not rock the triangular file from side to side. If you do, the lines or grooves will be of varying widths and depths which will mean that the diamonds will not be properly shaped or spaced.

After the diamonds are completed, burnish or brush the checkered area with a Brownells stainless steel toothbrush to remove any burrs. Reblue entirely using Oxynate No. 7™, or finish using one of the Brownells aerosol finishes like Baking Lacquer, Teflon Moly, GunKote, etc.

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.