

# 1911 Sear jig

## Instruction

This process requires highly skilled operators.



### Recommended tools:

- Grinding stones\*
- Hallen key set

\*You can find the proper stones on our website, check in tools division (code: TOKITLA5).



Abrasive stone

### Instruction:

1. Setting up the sear in the jig , consisting of putting the sear in place, rotating it clockwise until the lower legs are stopped by the screw on the left, then locking it in place. The left-hand screw defines the steepness of the primary sear angle, which must be set before locking things up (check fig.A)

2. Once the sear is positioned correctly, the stones are used to first shape, then smooth the metal surface. Although the jig is mostly a block of aluminum, the roller is steel to ensure it isn't chewed to bits by the stones as they roll over it. Force must be applied evenly and consistently.

Reshaping the primary angle requires frequent checks for evenness and the progression of the reshaping. As the new surface takes form, the line of filed metal will move toward the base of the sear nose; when it hits that base, it's time to stop filing. (check fig.B)

3. The secondary sear angle is determined only by the shape of the sear itself when using this jig: Unclamping the sear lets it rotate back until it's stopped by a fixed bar. (check fig.C)



Fig.A

Lock screw



Fig.B

Pin - sear second angle

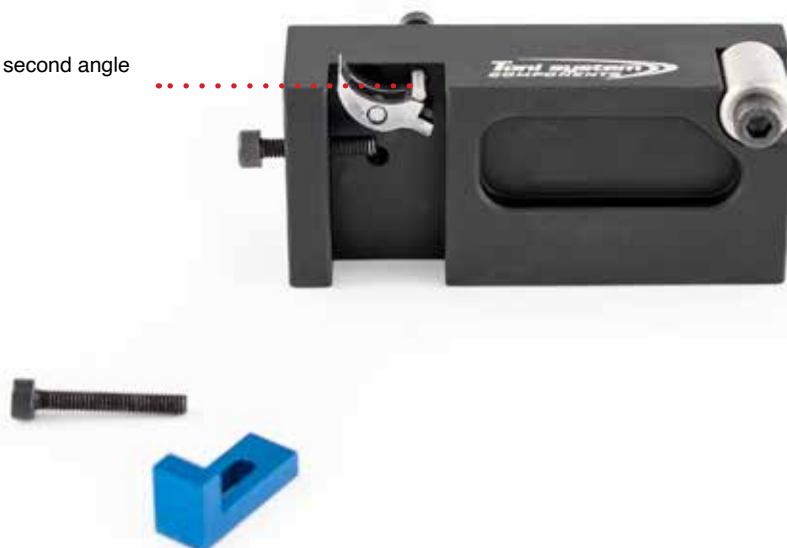


Fig.C



Fig.D

**Warnings.** Handle with care, open carefully. Assembly of some products may require specialized personnel with suitable equipment. Do not modify or tamper the parts. If you encounter difficulties in assembly, contact the company.