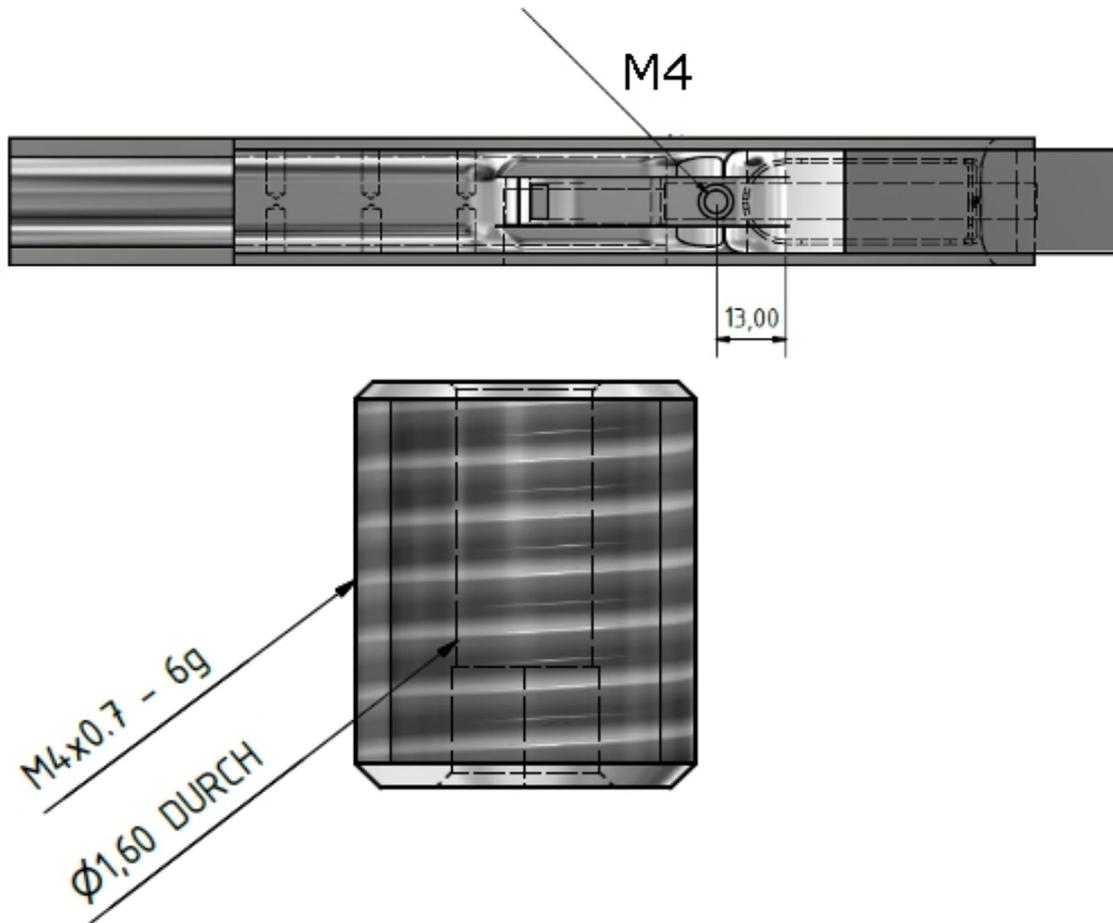


1911 X- Line Installation instruction for gunsmith

1. Put a M4 thread in the frame of the 1911 grip

For this the position of the center of the M4 thread must be marked on the bottom of the trigger guard.



2. Insert and fix the trigger-beam into the frame

At first disassemble the delivered trigger system. While fitting the trigger-beam into the frame you need to note, that you may just work on the left and right and on the bottom of the trigger-beam.

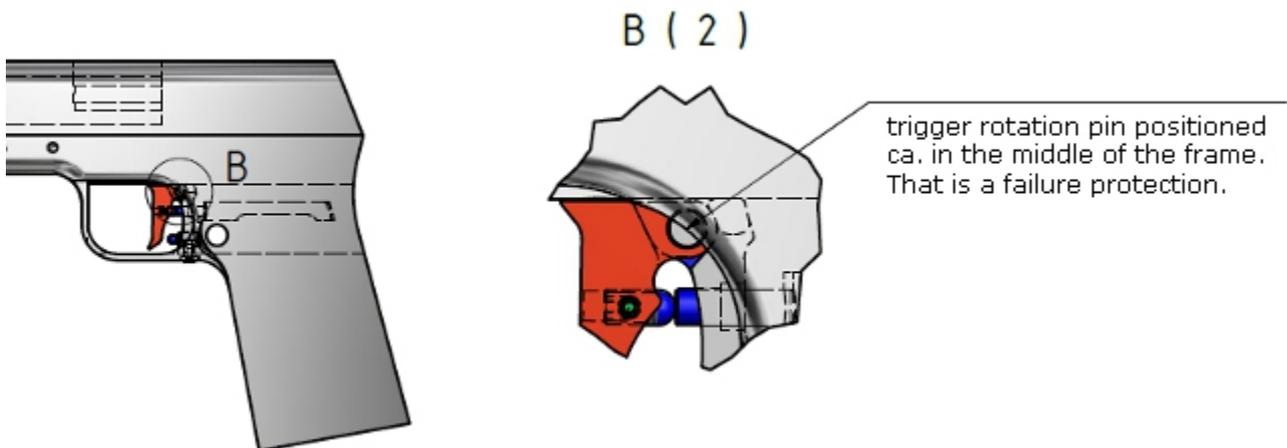
!Attention! Do not take material away from the top of the trigger-beam.

Advantageous is an exactly fit in of the trigger-beam into the frame without big tolerances. If the trigger-beam fits well and slides through the front by the frame, the steel-beam can be fixed with the M4 copy threaded pin through the frame.

Therefore put the trigger-beam with the center of the hole of the rotation axis ca. at the center of the frame and then slightly tighten the M4 copy threaded pin from below in order to fix the trigger-beam.

Pic.1

trigger-beam rotation pin positioned near the middle of the frame



3. Fit the trigger-bow with the push-rod into the frame

Therefore the trigger-bow has to be pushed into the backside of the frame. The pushrod has to slide smooth through the trigger-beam's hole.

If that is not the case, take a small round file and work gentle a bit material out of the hole at the point where it is necessary. Also the sheet metal could be touch up a bit. If you need to touch up the hole into the trigger-beam just untie the M4 copy thread pin and take out the trigger-beam to the front of the pistol frame. Now touch up the hole with a small round file and put it back into the last position into the frame.

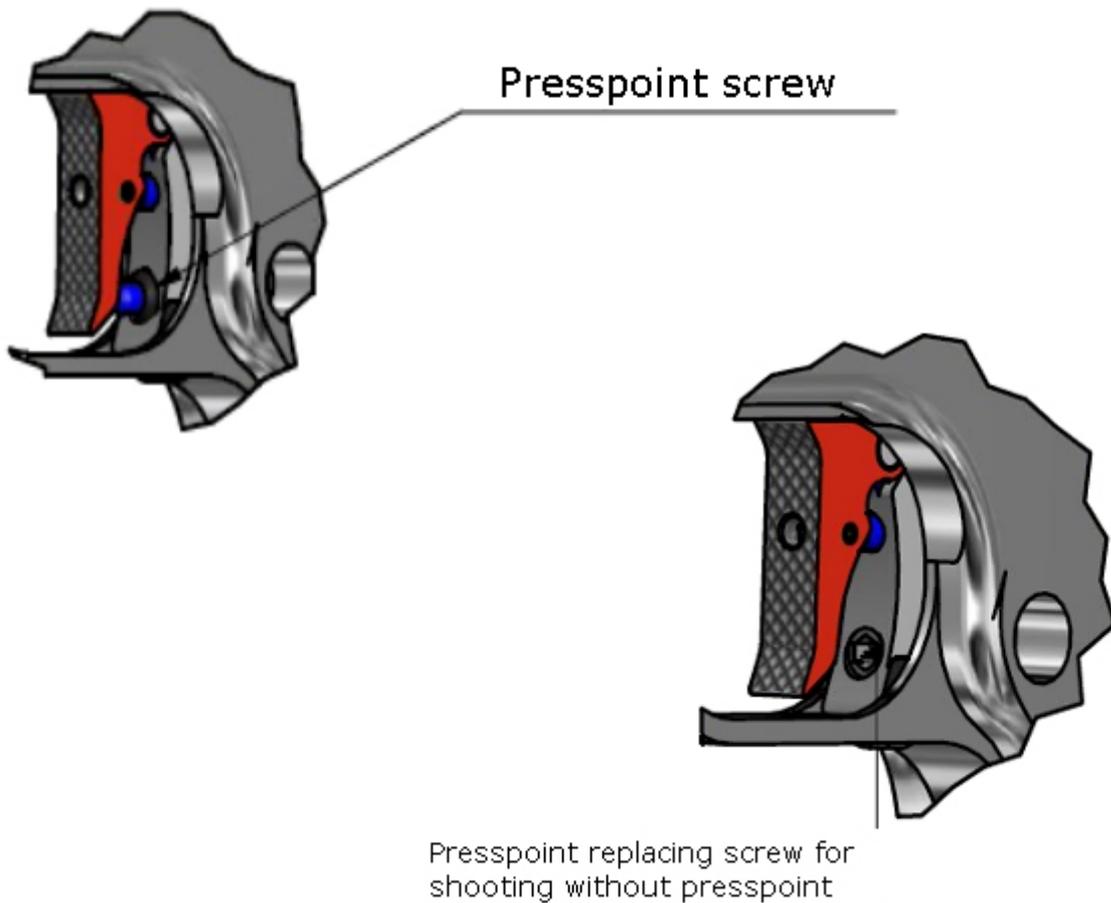
Tighten up the M4 copy threaded pin easy again. If the steel metal slides smoothly and easily with the rod through the frame and the trigger-beam hole, you are ready for now and you can take the trigger-beam out of the frame to the front again.

4. Now you have to make the important decision, if you want to use the presspoint- screw or if you don't!

If the presspoint should be in operation for Bullseye for example, it is necessary to work and polish another angle at the sear. That is very important and necessary for the safety for the triggersystem.

For explanation: Should the shooter think about to stop shooting, but did already push the aluminum trigger to the presspoint, it must be guaranteed, that the sear slides always complete back into the hammer notch. If the sear and the hammer notch are adapted together there should be no problem.

- In case the presspoint is not required, the M5 pin-screw can be replaced for the presspoint-screw into the trigger-beam. So if you make this decision you do not have to work at the sear.



5. Settings of the setting-screw into the Aluminum Trigger

You can assemble the frame with the trigger-bow, but without thumb safety and beaver tail. The trigger-beam and the aluminum trigger can be pinned and assembled now, too. The roundhead screw in the aluminum trigger needs to look out of the aluminum trigger backside about 2mm. That is important to make some fine adjustments later.



6. Fixing the location of the triggersystem in the frame

Now clamp the pistol with the slide into a vice. The grip-opening has to show up.

Now spinning the hammer and the Trigger beam with the pinned aluminum trigger will be pushed into the frame from the frontside. Now work very gentle and precise.

Push the trigger-beam into the frame as long as the curve of the M3 screw that is installed into the aluminum trigger touches the triggerbow's push rod.

When the trigger bow's push rod touches the M3 screw-curve, push the trigger-beam very slow and gentle as far as the hammer falls into the frame. At the point where the hammer falls, the position to mark the trigger beam through the M4 copy threaded pin with a small drill is found. You can repeat this process a few times if you wish to be sure you do the mark at the right position.

7. Adjustment of the trigger-system

Adjustment of the release of the trigger before and after the finish-screw.

The release of the trigger or the disconnector is set with the M3 set screw, which is screwed in front of the trigger. The function is tested by triggering the trigger, holding and then repeating the slide again. Then release the trigger and check whether the trigger is released.

- **If the trigger is not released:**

the M3 set screw must be so far rotated counterclockwise until the trigger locks.

- **If the trigger is released but you still feel a overrunning:**

you have to turn the M3 set screw clockwise

This is adjusted so that no overrunning of the trigger can be felt anymore and so that the trigger is released again when released.

8. Copying of the center point of the copy threaded pin in the bottom of the steel beam

Is everything set so far, the exact position of the trigger system in the breakthrough of the frame should be known. Now the end fitting of the trigger system is prepared.

To mount this screw, the 1.6mm hole which exists in the copy M4 threaded pin, has to be projected onto the steel beam bottom. Please unscrew the presspoint screw if it is still installed. Now drill with a 1.6mm drill through the copy threaded pin in the beam bottom until the drilling crosses the M5 thread in the steel beam.

Unscrew the copy threaded pin. You don't need it anymore.

Then pull the drilled trigger-system out of the frame to the front to work on the steel-beam again.

9. Mounting the finish-screw/ drilling the M4 thread to diameter 4,2mm to get a through-hole.

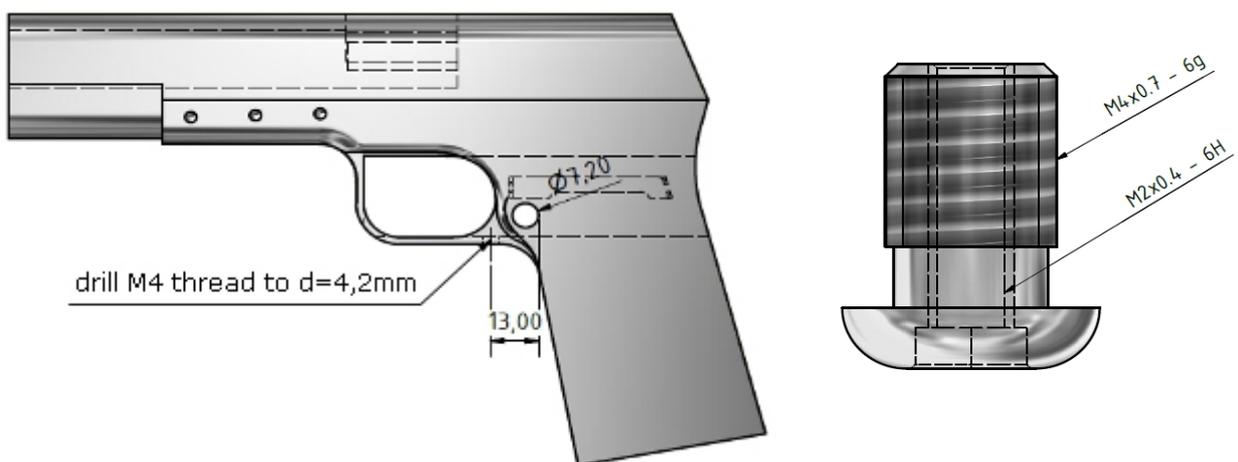
The M4 thread in the frame gets drilled to a diameter of 4,2mm.

Drill a 3,2mm hole in the trigger beam at the drilled marking until the hole crosses the thread of the presspoint screw. Now cut the M4 thread at that position.

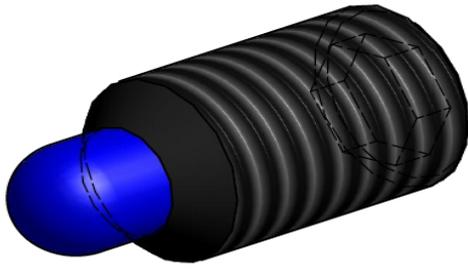
If everything is drilled so far and the thread is cut, it is important that the passage of the M4 thread to the M5 thread is accurate and without any ridge.

Now put the trigger-system back into the frame from the front and screw the finish-screw together with the beam through the frame.

If the length is adjusted, the presspoint screw can be screwed and the fine tuning of the system can be performed. In the finish screw is still a M2 threaded pin to secure the setting of the presspoint screw. Therefore a 0.9mm Allen key is included in the delivery.



10. Setting of the presspoint screw



The aim of adjusting the presspoint screw is to divide the trigger weight.

Assuming an overall trigger weight of about 1200 grams, then the goal should be to have about 900 grams to the preference and about 300 grams on the presspoint to trigger the shot.

!!!! If the presspoint is adjusted with the presspoint screw this has a direct impact on the way of the sear in the hammer notch and the release of the shot !!!

11. Secure all relevant parts

If the system is set, all the screws should be secured with thread lock, so that the trigger system can not be adjusted by the impulse of the shot.

Because a thread has to be drilled into the grip of the 1911er gun and the setting of this system have a great effect on the function and the characteristic of firing the shot, the installation of this trigger-system should be done by a qualified gunsmith.

The angle of the sear must be sanded that if the shooter terminates the firing process the sear falls back to the initial position of the hammer notch.

When installing this trigger system, the fishing catch the hammer can be overridden.

You are ready now!

