



**REMEMBER:**

Before installing or adjusting your sights, unload and/or check to ensure the firearm is unloaded.  
**WARNING:** Use of a sight press for installation is not recommended as it can cause damage to sights/slide.

**Dovetail Front Sight**

**Needed Tools:** non-marring punch (brass, delrin, or nylon), Q-tips, fine file or emery paper, vise, alcohol

1. Place the slide in a padded vise.
2. Drive out the existing sight using a brass or steel punch.
3. Clean the factory dovetail until smooth (Q-tip, toothbrush, file as necessary).
4. Slide the sight into the dovetail. Entry side does not matter; test both sides to find the best fit. If it goes in at least half way, or loosely slides through, skip to 7. **Friction fit is not necessary.**
5. Using a fine file or emery paper on a flat surface, remove steel from the bottom of the Express Sight until it will enter the dovetail halfway. (See Figure 1) Do not file the dovetail (A) shorter than the depth (B) noted in Figure 2. If the sight still does not fit, but you have reached the minimum height, move to step 6; otherwise, skip to step 7.

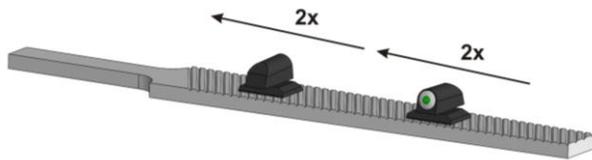
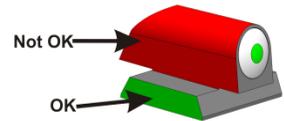


Figure 1

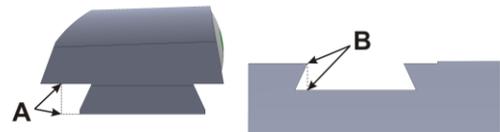
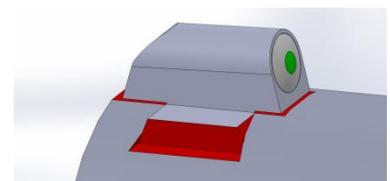


Figure 2

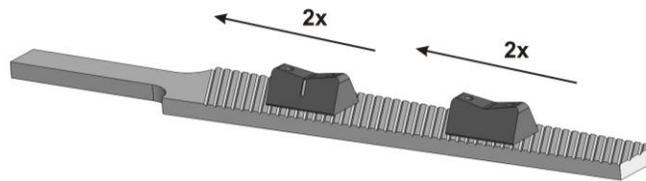
6. Using an angled dovetail file, file on the angled faces of the dovetailed portion of the sight until the sight enters halfway. (file info should be a footnote)
  - a. 65° 1911 Dovetail Type Slot Straight Base file 080-648-265WB
  - b. 60° Dovetail Slot sight base file 080-648-260WB
7. Remove the sight. Degrease the slot and the sight.
8. Apply red threadlocking compound to all mating surfaces.  
*\*Red threadlocker is a necessary component of our sight installation process - sights can fall off without the use of red threadlocker.*
9. Install the sight using a non-marring punch.
10. Let sit for 10 minutes, and then lightly remove the excess clumps of red threadlocking compound with a Q-tip. In this initial clean-up, do not clean aggressively, as you will remove the compound from the joint. Let it set for 3 hours.





#### EXPRESS SIGHT ADJUSTABLE REAR SIGHTS

1. Place the slide in a padded vise.
2. Remove elevation screw from existing rear sight. Lift up the 'T' section. Remove setscrews (if applicable) and elevation spring; store in a safe place. Drive out the existing sight using a brass punch.
3. On the XS Adjustable Rear Sight, remove the sight elevation screw. Unscrew the hex setscrew so that it is not protruding below the bottom of the dovetail.
4. Slide the sight into the dovetail. If it goes at least halfway, or fits without resistance, skip to step 6. **Friction fit is not necessary.**
5. Using a fine file or emery paper, remove steel from the bottom of the Express Sight until it will enter the dovetail halfway.



6. Center the sight in the dovetail and finger tighten the setscrew.
7. Apply red threadlocking compound around the edges of the dovetail to ensure a solid installation.
8. Reinstall the elevation screw.
9. Wipe sights down with protective oil in a light coating to prevent potential rust issues.