



XS Sights DIY-Series™ / Gunsmith-Series™ - Inline Rear Sight Tool – Glock® Instructions

The XS Inline Sight tool for Glock pistols fits all OEM Glock models. Always follow [the four rules of gun safety](#) and ensure the firearm is unloaded before working on the pistol.

Rear Sight Installation

1. Apply oil to the bolt threads before every use.
2. Place the sight tool on a flat surface and position the bolt on your dominant-hand side.
3. Place the slide against the inside wall and align the brass bit into the dovetail.
 - a. If installing sights on a GLOCK 42, see special instructions at the bottom of the page.
4. Insert the locking wedge to create a tight seal between the wedge and the slide.
5. Insert the handle into the bolt and rotate the bolt until it touches the brass bit and creates tension.
6. Make sure the brass isn't touching the sides of the dovetail and the slide hasn't canted.
7. Rotate the bolt clockwise and drive the rear sight out.
8. Once the sight is removed, turn the bolt counterclockwise until the brass can slide to the rear of the tool.
9. New Rear Sight Preparation
 - Preferred Method: Degrease the bottom of the sight and slide the dovetail. While this method creates the strongest surface area connection for increased retention strength, installation requires the most effort. The threadlocker requires a minimum rest of 15-minutes before cleaning the excess liquid.
 - Acceptable Method: Wipe the bottom of the sight and the dovetail with a cleaning cloth. Then insert sight without degreasing. While this method offers the easiest installation, the threadlocker requires the longest rest time of 30 to 60 minutes before cleaning the excess liquid.
 - For installation force expectations, see the troubleshooting section.
10. Insert the new sight into the dovetail and press it in as far as it can without canting the sight.
11. Slide the brass bit against the side of the sight and rotate the bolt clockwise until it contacts the brass.
12. Double-check the brass and sight one more time for proper alignment.
13. Rotate the bolt clockwise and drive the sight into place.
14. Once you believe you have centered the sight, rotate the bolt counterclockwise until the brass can slide to the rear of the tool and remove the locking wedge.
15. Pin the slide in place with your hand and slide the brass bit with your finger until it travels through the dovetail and connects with the sight body.
16. Identify which hash mark on the brass bit is closest to the white etched line on the sight tool.
17. Turn the slide 180 degrees and repeat steps 15 and 16. The marker on the brass bit should be the same for a properly centered set of sights.
18. If the sight needs to be moved, lock the slide back into the tool and adjust as needed.
 - Adjustment Tip
 - 1 Hash mark difference equals 1 1/2 bolt rotations (0.0625" / 0.0416")
 - ½ Hash mark difference equals 3/4 bolt rotation ((0.0625" /2) / 0.0416")
 - Brass Bit Scale 1/16 inch (0.0625") | One Bolt Rotation Distance 1/24 inch (0.0416")
19. Apply threadlocker to the rear sight according to the sight preparation method chosen in step 9. Choose application method A or B.
 - A. Mechanical Zero: After centering the sights apply threadlocker to the sight according to the installation method used in step 9. If windage adjustments are later needed, use the sight tool to drift the sight and reapply threadlocker.
 - B. Windage Adjustments Before Applying Threadlocker: Fire 3 to 5 rounds and make windage adjustments as needed. Once satisfied, apply threadlocker to the sight according to the installation method used in step 9.
 - Follow the range safety rules for handling firearms and shoot the defensive load you plan to carry.
20. Once the resting time has passed, clean the excess liquid off the slide and sight. The threadlocker requires a full 24 hours to cure. After the cure period, lightly re-oil the sight and slide.

Glock 42 Instructions

- A. Place the foam in the slide channel on the inside wall.
- B. Place the slide against the flat wall and slide the brass bit into the dovetail.
- C. Return to step 4 above.

Front Sight Installation

1. Use the included Glock front sight tool to unscrew the factory screw.
2. Remove the front sight from the slide and place the original parts away from the working space.
3. Use the front sight tool to remove the screw from the new Glock front sight.
4. Degrease the new front sight and the threads on the screw.
5. Degrease both the top and bottom of the slide where the new sight will touch.
6. Insert the screw into the front sight tool and rest the tool vertically on the working space.
7. Apply a medium-sized drop of red threadlocker to the screw threads.
8. Excessively apply the red threadlocker to the bottom of the new front sight.
9. Insert the front sight into the hole on the slide. Ensure the sight face is directed towards the rear of the slide.
10. Make sure the front sight is straight.
11. Grip the top of the slide with your weak hand and use your index finger to keep downward pressure on the front sight.
12. Rotate the slide upside down, ensuring pressure is still being applied to the front sight.
13. Use your dominant hand and pick up the Glock front sight tool and insert the screw into the sight body.
14. Turn the tool clockwise until the screw is finger-tight.
15. DO NOT OVER-TIGHTEN THE SCREW.
16. Let the liquid threadlocker rest for 15-minutes before wiping away the excess liquid.
17. Reassemble the pistol per the manufacturer's manual.
18. The threadlocker requires a full 24 hours to cure. After the cure period, lightly re-oil the sight and slide.

Rear Sight Tool Troubleshooting

XS's easy-use rear sight tool is designed to remove many brands of sights and install XS handgun sights into Glock OEM slides. Aftermarket Glock slides require an average of 50% more force than OEM slides. Non-XS handgun sights require an average of 100% more force than XS Sights. The aluminum base is engineered to flex but may not recover if the inch-pound forces are in the red. This can easily be identified using the shims provided. If the tool is flexing, slide a shim under the slide channel in the following order. If you are in the orange range and have not successfully installed the sight, stop, relieve pressure on the brass, and contact XS customer service for support.

Difficulty of Installation and Sight Tool Recovery After Use Color Scale



Tool Inch Pound Rating

Slide Type & Sight Type (Oiled/Degreased)	Inch Pounds Rating	DIY-Series™	GUNSMITH-Series™
Glock OEM Slide - Oiled w/ XS Sights	25 - 40	Green	Green
Glock OEM Slide - Degreased w/ XS Sights	41 - 59	Green	Green
Aftermarket Slide - Oiled w/ XS Sights	60 - 79	Yellow	Green
Aftermarket Slide - Degreased w/ XS Sights	80 - 99	Yellow	Green
Competitor Sights - Not Recommended	100 - 124	Orange	Yellow
Competitor Sights - Not Recommended	125 - 149	Red	Orange
Not Rated - STOP!	150 - 200	Red	Red

Warranty

XS Sights function tests each unit and warrants each tool to be free from defects upon receipt. This warranty applies only to the original purchaser. If this product is found to be defective, the manufacturer's only obligation is to replace the product at the manufacturer's discretion, provided that the product has not been damaged through misuse, modifications, neglect, or mishandling. This warranty shall not apply to the finish on any portion of the products such as surface and/or weathering, as this is considered normal wear and tear. XS warrants that the sight installation tool can install XS handgun sights when installing sights in approved pistol slides. XS does not warrant damages to slides or sights. The bolt and brass bit are wear parts replacements may be purchased at XSSights.com.

To file a warranty claim, please contact XS Sights at (888)-744-4880 or tech@xssights.com.