



S&W Pre-Drilled Front Sight Installation

You will need:

- 1/16th roll pin punch (tip pictured on right)
- Nylon punch
- Small hammer
- Degreaser (rubbing alcohol or gun scrubber)
- Pliers
- Q-tips
- Table
- Vice (Optional but highly recommended)
- Small file (not always necessary, but there is a chance of getting a tight-fitting tab)



Items provided with the kit:

- Thread locker
- Front sight
- 1/16th roll pin

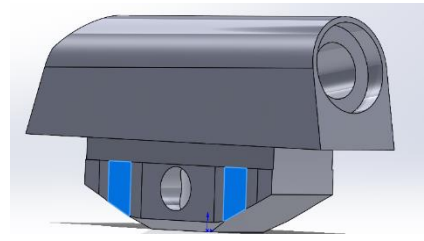
Before installing or adjusting your sights, unload and/or check to ensure the firearm is unloaded.

We recommend removing the cylinder completely, see owner's manual for instructions but be careful to not lose any of the components since some of them are held in place under spring tension.

1. Place the barrel/frame into a padded vice.
2. Using the 1/16th inch roll pin punch, begin striking the factory pin out to either side. (Roll pins conform to the area where they are installed so this can be tight.)
3. Once the pin is removed, remove the factory sight by taking the nylon punch and placing it on the face of the sight body and giving it a good strike forward, then move to the back of the sight and give it another good strike rearward. Repeat this process until the sight comes off.
4. Once removed there will be lint/fuzz/dust/dirt/carbon under the front sight. Degrease the front sight slot with Q-tips and degreaser.
5. Using the 1/16th roll pin punch, insert the tip into each side of the revolver sight base to determine which side it was drilled from at the factory (the drill starting side will be a looser tolerance than the opposing side.) The looser side should be the installation start side.
6. Once the installation start side is identified, test fit the front sight into the slot.

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7. If the sight does not fit into the slot, take some material off the tab with a small file. (Tab highlighted blue on the right.) Take caution to only allow the file to touch the tab of the front sight. File 1-2 times and repeat the exact amount of strokes on the opposing side, then check fitment. Continue test fitting and filing until the sight can seat fully into the slot.



8. Once the sight has been seated into the slot, verify that the holes are aligned using the 1/16th roll pin punch to ensure it will protrude on the other side of the revolver.
9. If you cannot insert the punch through both sides the holes are not aligned. If close, open the hole on the sight with a small rat tail file. If there is a big difference in the holes, contact our customer support team for an oversized version. Call (888)-744-4880 or email tech@xssights.com.
10. Once alignment is verified, remove the punch and sight and decrease the slot and tab of the front sight.
11. Next apply 4-5 drops of thread locker to the cross-pin location of the slot.
12. Seat the sight all the way into the slot and clean up the excess thread locker with a Q-tip. If no thread locker was squished out apply a couple more drops to ensure you have full coverage in the slot.
13. Use the roll pin punch to verify that the holes are aligned after the thread locker has been applied.
14. Now take the factory roll pin (or replacement pin) and install from the direction that was determined as the entry hole on **step 5**. The pin should go through with minimal resistance and should sit flush or just below flush.
15. Allow the thread locker to cure for 15 minutes then come back and wipe away the excess with a Q-tip. Allow a full cure time of 24 hours before handling or shooting.
16. Wipe sights down with protective oil in a light coating to prevent potential rust issues.

S&W Fixed Rear for K & L Frame Revolvers Installation

1. Remove the complete rear sight.
2. Assemble the rear blade onto the plate, but do not tighten attaching screw to full tightness yet.
3. Slide/drop, rear sight assembly into slot in frame top and check attaching screw hole alignment.
4. Apply a drop of blue thread locking compound onto each of the attaching screws threads.
5. Insert attaching screws into their holes in the plate and tighten to 12-15 INCH pounds. If you don't have an INCH pound torque tool, simply tighten until screws are fully seated and then no more than 1/8th of a turn more. The thread locking compound will prevent recoil from vibrating the screws loose better than attempting to over torque the screws which runs the risk of damaging the screw head slots.

6. Blade/Plate screw may now be tightened so pistol can be test fired for zero. The blade has a little play in it so very minor windage adjustment can be made if required. Once you are happy with things, we recommend loosening the blade/plate screw and flowing some blue thread locking compound around it and retightening screw to 10-12 INCH pounds or just 1/8th of a turn past screw being fully seated.
7. Set aside and let things sit for 20-30 minutes before doing any sort of clean up. This is to give the thread locking compound time to begin its curing process. Cleaning too soon or too aggressively you can end up removing much of the thread locking compound from the joint.
8. Clean up using only dry Q-tips.
9. Allow a full cure time of 24 hours before handling or shooting.
10. Wipe sights down with protective oil in a light coating to prevent potential rust issues.