



# WARNING!

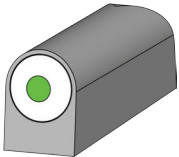
**Gunsmith Installation Only**

*“Customers should be fully aware that installation of this sight requires milling off the original factory front sight from the barrel. Returning a pistol to the original condition will require the original manufacturer installing a new barrel.”*

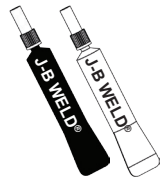
**Before installing or adjusting your sights, unload and/or check to ensure the firearm is unloaded.**

### Included

Front Sight



Gel/Putty Epoxy  
(J-B WELD)



File



### Need to Grab

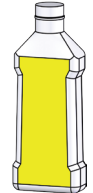
Q-tips  
(5-10)



Cold Blue



Alcohol



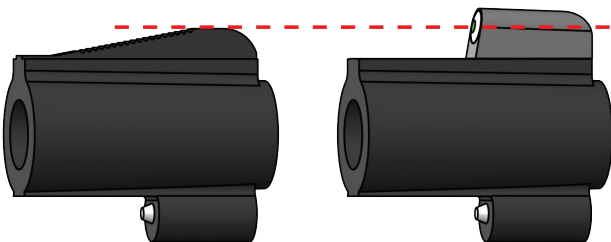
Acetone, Gunscrubber, etc.



## Gun Model Info

*“This sight is designed to be installed on the current series (1985+) of S&W “J” frame revolvers which have a front sight width of 0.100” or wider. While it is possible to install on the older thin blade front sights, much care must be taken for front sight to be installed straight. Barrels for these older models may not be available from the factory.”*

### 1 Installation (only Barrel shown)



*“Intent: When the sight is installed according to these directions, the center of the tritium dot will be at the same height as the top of the original front sight.”*

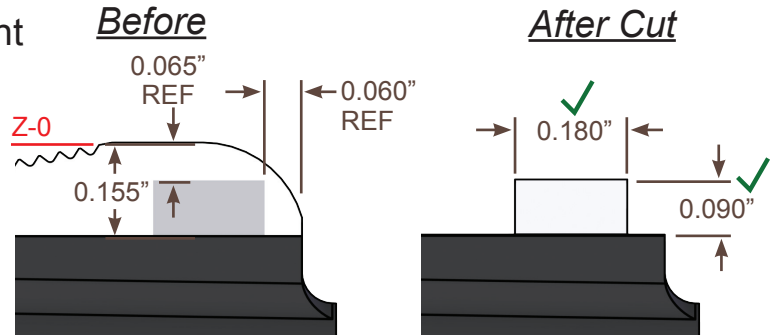
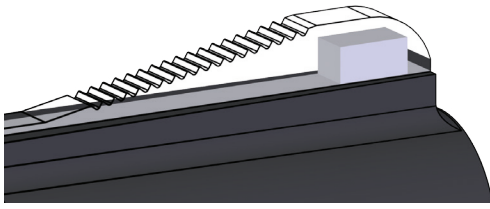
### 2 Disassemble Pistol

1. Disassemble pistol and remove grips and cylinder.
2. Remove side plate and internal parts.
3. Press side plate back onto frame and tap it down until it is back flush with the frame.
4. Do not install the side plate screws.

### 3 Prep for Machining

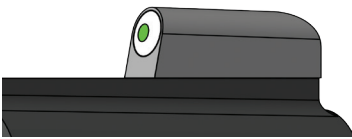
1. Chuck frame into mill vise and level across top of frame.
2. Install a sharp, carbide end mill ( $\varnothing 0.250$ "- $0.375$ " ) into the mill.

### 4 Machine Stub from Original Front Sight



1. Bring the end mill down until you touch off on the top of the original front sight and zero your "Z"
2. Cut down the top of the front sight down until it is 0.065" below the initial zero.
3. Come down another 0.090" (0.155" from initial zero) and bring tool around until it just touches the front of the front sight blade. Cut the front sight back 0.060" and bring the tool out and around to cut away the back portion of the front right until you have a stub that is 0.180" long.
4. After milling you should be left with a small stub 0.180" long x 0.090" tall above the original rib. The front will be 0.060" back from the front edge of the rib.

### 5 Check Fit, File as Necessary



"With a small file, cut away the corners of the stub until the new front sight will sit down leaving little to no gap between the bottom of the sight and top of rib."

### 6 Deburr All Edges & Cold Blue

1. Deburr all edges
2. Cold blue any surfaces requiring finish
3. Clean all surfaces of stub & XS<sup>®</sup> Sight bottom in preparation of gluing sight over stub.

### 7 Install Sight with Putty Epoxy

1. Mix a small amount of a putty epoxy (like J-B Weld)
2. Apply to bottom of sight.
3. Press sight down over stub.
4. Wipe off excess putty with clean Q-tips.

### 8 Check Alignment & Let Cure.

1. Double check to ensure sight is straight.
2. Set aside for 5 hours for epoxy to cure before shooting.
3. Wipe sights down with protective oil in a light coating to prevent potential rust issues.

Questions or Problems? Ask the XS Tech Team: (888) 744-4880 | [tech@xssights.com](mailto:tech@xssights.com) | 8:30am-5:00pm CT