



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 Sights with Test Post

Tools Needed: non-marring punch (brass, delrin, nylon), Q-Tips, alcohol

1. Place the gun 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. Once the height is confirmed, test the steel 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 sight until it will enter the dovetail halfway. (See Figure 1) Check the dovetail tips; if sharp, dull them. 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 7; otherwise, skip to step 8.

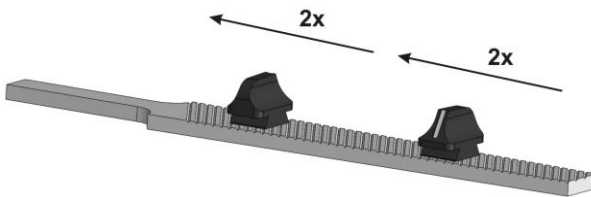


Figure 1

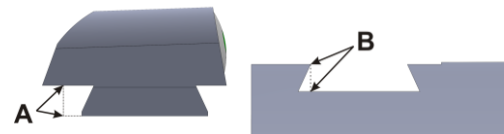


Figure 2

6. Using an angled dovetail file, file on one of the angled faces of the dovetailed portion of the sight until the sight enters halfway.
 - 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.



XS Ghost-Ring Sights with Protective Wings

1. Place the gun in a padded vise.
2. Remove the plug screw(s) from the rear scope base holes.
3. Drill and tap 8-40 holes in receiver
 - a. **Remington:** two holes required. Position the sight on the receiver so that the ghost-ring is perpendicular to the sight plane. The rear edge of the sight should be located one inch forward of where the stock meets the receiver. If needed, e-mail Tech@xssights.com for a drawing of the installation position.
 - b. **Mossberg Shotguns with factory Ghost Ring Sights:** one additional hole for a total of two holes required.
 - c. **Other applications:** two 8-40 holes required.
4. Degrease the sight and receiver.
5. Apply a small amount of red threadlocker to the bottom of the base and spread it around so a thin layer covers approximately 80% of the base. Too much compound can crawl into the action, locking up critical moving parts. Place the base on the receiver so that the mounting holes align.
6. Apply a small amount of red threadlocker to the bottom of the sight and spread it around so a thin layer covers approximately 80% of the base. Place the rear sight assembly into the Wings. Mount the sight so that the aperture is closest to the shooter's eye (if applicable). If screws of varying length are provided, the long screw will be used in the rear hole.
7. Apply a very small amount of red threadlocker to the screw threads up near the head and tighten.

To Change the Aperture:

1. Back off one windage screw three full turns.
2. Remove the aperture by turning it counterclockwise.
3. Install the new aperture by turning it in clockwise until it bottoms out. Then unscrew 3 full turns to achieve the aperture's basic starting position.
4. Tighten the windage screw and rezero the rifle.

Note:

At times, an alternate height front sight might be needed to zero. If so, contact our tech staff with the distance shot and measured point of impact shift, and we'll exchange your front sight (U.S. customers only).