

Beavertail Jig

1. Disassemble the lower half of the gun completely so that all you have to work with at this time is the bare frame.
2. Assemble the jig into the safety pin hole with one button on each side.
3. With a sharp pointed tool, scribe around the back of the jig on each side so as to lay out the cut lines.
4. Remove the jig from the frame. If you have a pedestal grinder or milling machine, you can rough away most of the stock up to the scribed line.
5. Reassemble the jig into the frame with a button on each side and C clamp in place. Then close the frame up in a bench vise snugly, but do not crush it. Be sure to use some thin cardboard to protect the frame from the vise jaws.
6. With a medium sized file, take the frame right down to the jig buttons.
7. Check the foot that contacts the trigger for length. We make it too long purposely so it will work with all types of frames and triggers. Shorten it so it will just fit into your frame and keep the angles the same. Keep trying to assemble the thumb safety into the frame and look for high spots to file off. You should be within a few thousandths now, so go carefully. Watch the flats underneath the jig where the beavertail fits into the gun. They may need to be filed off a bit.
8. Once the grip safety and thumb safety will fit into the frame freely, you can see all the additional metal that must come off the gun in the area where the web of your hand must go. This is what sets the gun deeper into your hand for more control. Blend the frame, grip safety and thumb safety together by grinding or filing. Do not remove any more metal than necessary from the grip safety. It is very thin in places.
9. Drop the trigger you intend to use in place and check the foot on the grip safety. You will probably have to remove a tiny bit more metal for this to work properly. If you get confused about how it is supposed to work, replace the original grip safety in the gun and study it. As soon as you are satisfied of the fit and proper function, replace the mainspring housing and check it for clearance. Then reassemble the entire gun and recheck all safeties for function. Don't forget to thin the grip safety foot if you are working on a Colt Series '80'. Make it look just like the original part. When you are satisfied that everything is fitted correctly, disassemble and reblue.