

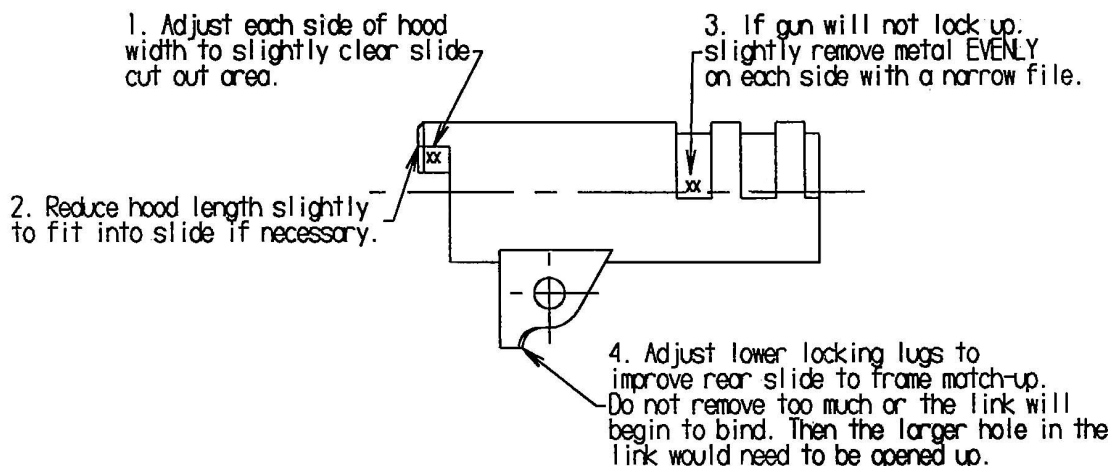
Drop-In Barrel

1. Slip barrel into the slide and check barrel hood sides. They should clear on each side when lower locking lugs are true up and down.
2. Check barrel hood length. Approximately 1.315"-.010 to the first top lock groove is correct. Trial assemble the barrel to see if it will fit up into the slide locking recesses. Remove a small amount of length if it will not.
3. Install barrel, with link, link pin and bushing, and trial assemble slide, barrel and frame. A properly fitted barrel will hit hard on the back of the hood, hard on the lower locking lugs, and evenly on each side of the top locking grooves. It should NOT touch any place else except the bushing. You should now be able to press the gun into locked position with only thumb pressure, but the barrel will have very little, if any, movement in any direction.

If you can not press the gun into the locked position, determine where it is tight, and remove a tiny amount of metal only at the point of interference. These are called out on the drawing with an XX. It is very unusual to find metal that will need to be removed any other places. Never,

under any circumstances, remove any metal from the diameter of the barrel itself.

4. The barrel is locked at zero at the lower locking lug, and its further movement wedges everything in position, except the link, when the gun is locked. Notice a flat between the slide stop pin lower locking area, and the front radius on the lower locking lugs. This measures about .030 and is necessary for proper operation. However, this .030 can be increased to as much as .060 to help the slide be more flush with the rear of the frame, if desired. Just remove metal from the rear of the locking lug with a 3/16" rat tail file or milling machine with a 3/16" end mill. This action will allow the slide stop pin to lock the barrel slightly further to the rear. Keep in mind that if the .030" is increased, the link pin lower hole will most likely have to be opened up to prevent binding.



5. Once you are satisfied with the fit of the barrel, slide and frame assembly, install the link and link pin and check for link pin interference. **IMPORTANT:** With the slide upside down in your hand and the barrel installed, you should still be able to move the link slightly while the slide stop is pressed firmly to the rear. If not, open up the slide stop pin hole in the link slightly on the bottom side.

6. Finish the chamber with a 45 ACP finish reamer to 0.898" up to 0.910" measured from the end of the hood. This may not be necessary if only a small amount of hood material was removed during fitting. Finish the chamber with a 9mm finish reamer to 0.754" up to 0.776" measured from the end of the hood. Finish with a 38 Super finish reamer to .890" up to .900" measured from the end of the hood.

DO NOT USE A LONG LINK - A long link also causes an extremely long arc for the barrel to travel during the locking process. A longer travel means an increased chance for malfunction. They also cause the barrel to sit too high in the gun, making the firing pin hit off center and the gun to shoot low. Use only standard length links.

DO NOT CUT THE FEED RAMP ANY DEEPER - Our Drop-In Match Grade Barrel is finished chambered, cut to size and is throated for SWC ammo. Do not cut the feed ramp any deeper. If you desire, the feed ramp may be polished slightly and a TINY radius may be polished at the junction of the feed ramp and the chamber.

SUPPRESSOR READY BARREL

Please note we do not deal in suppressors; we make the barrel you will need to make the 1911 "suppressor ready". You must procure the suppressor from another vendor, and be aware that states have different laws regarding suppressors.

A suppressor equipped with a Nielsen device is **REQUIRED** for reliability in a 1911 device. This is also referred to as a booster, kicker, or Linear Inertial Decoupler. We use and recommend the Black Reign .45 ACP suppressor by Elite Iron, <http://www.eliteiron.com>. Thread size on the Ed Brown 45 ACP suppressor ready barrel is 0.578 x 28 tpi RH, and 1/2 x 28 tpi RH on the 9mm suppressor ready barrel.

DISCLAIMER

Our Drop-In Match Grade Barrel is intended for sale to pistolsmiths to save them time while doing rebuilds, or offering a closer fitted barrel than what most factories supply. If you decide to install this product yourself, you assume all responsibility for its safe installation and use.

Do not attempt to install this product unless you are sure you can do so. Modified parts may not be returned for credit or replacement.

This product is sold as is, and without any warranty. No liability for damage or injury which may result from the improper installation or use of this product. For the safe operation of this product, we strongly recommend that its installation be checked by a professional pistolsmith.

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