

## Fiber Optic Front Sight Instructions

1. Remove old front sight.
2. Mill a flat slightly wider than the sight back about .625" from front of slide. This flat can be from .125 wide to as much as .250. Use this opportunity to change this height if you want your gun to shoot higher or lower than before. It is easier to sink the sight deeper now, than it would be to cut the top of the sight down later. Keep in mind that the top of 1911 slides are machined at about a one degree angle. The craftsman holds the top of his slide level in the machine vise.
3. Measure height of the dovetail base from the bottom of the sight. This is the depth of the dovetail cut you must make. We usually add about .002 to this dimension to make sure the bottom of the dovetail will slightly clear, and the bottom of the sight will fit flush to the slide. Rough out this cut with a 1/4" end mill with its centerline back .325 from the face of the slide.
4. Just touch the bottom of your roughed out dovetail cut with a .330X65 degree dovetail cutter. Its centerline should also be .325 back from the front of the slide and make a single thru pass. A rigid set up is necessary for success. Do not try this job on a drill press, use a milling machine only.
5. Before fitting, deburr the sight and slide. Usually only a slight amount of hand fitting is necessary if you have done a good job machining. After the sight is installed and centered on the slide, drill a 1/16th inch hole through sight and slide.
6. Press the 1/16X1/4 inch roll pin through sight and slide to secure the installation. It should be flush with the inside of the slide when fitted properly.
7. Install fiber rod through sight, and carefully apply flame (from a lighter) to melt the end of the rod into a bulb. After it cools, pull it gently to seat it into the sight. Trim the excess from the opposite end, leaving about 1/16" sticking out, then apply flame to this side until it forms a bulb. To replace an old rod, cut rod in middle and pull out from each end of sight. If you need more explanation, do an internet search for installing fiber optic sights and you'll find several videos demonstrating the process.