

Machined Ambidextrous Thumb Safety

To properly install the ambidextrous thumb safety, the entire gun must be disassembled and one must be familiar with the internal workings of the 1911 handgun design, particularly with respect to the way the safety blocks the movement of the sear. If you are not certain you are qualified to install this part, we highly recommend installation by a qualified gunsmith.

We offer this service for a very reasonable charge if there is no one in your area capable of this installation. Please visit the Service section on our website for pricing and to schedule shipment of your firearm.

The following instructions are merely a guide to a qualified gunsmith, not intended as a “how-to” project for the amateur. Safety issues are involved and serious injury or death could occur if done improperly.

1. Remove magazine fully and unload chamber. Look into the chamber to insure empty.
2. Remove the slide and barrel assembly from the frame.
3. Remove the old thumb safety and thumb safety plunger spring assembly.
4. Hold on to the hammer and let it down gently by pulling the trigger.
5. Remove the grip safety. (Remove the mainspring housing if necessary to accomplish this by removing it's retainer pin.
6. Replace the mainspring housing temporarily over the sear spring and secure it with its pin.
7. Re-cock the hammer.
8. Re-Install the original thumb safety and observe how it blocks the sear from movement when the trigger is pulled. This is easily visible with the grip safety out of the way.
9. Now install the new thumb safety left hand side and with a sharp scribe, mark the point where contact is made with the sear.
10. Remove the new thumb safety and remove metal in small amounts until the safety installs flush with the frame and works freely. Use the old thumb safety as a pattern to what the new should look like.
11. Make CERTAIN the sear cannot move at all when the trigger is pulled with the thumb safety in the safe (fully up) position.

12. Once you are certain the safety is correctly operational, you may disassemble the new thumb safety and remove both the mainspring housing and hammer.

13. Now re-install the hammer with the longer, grooved pin.

14. Install the right hand side of the ambidextrous safety temporarily and check it for free operation over the new grooved pin. Just rotate it over the pin.

15. Remove the right hand side once you are satisfied and re-install the parts in the gun as you normally would during any re-assembly. Sear spring, mainspring housing, grip safety, mainspring housing pin.

16. Install the new right hand side of the ambi-safety and rotate it over the hammer pin.

17. Cock the hammer to install the new left hand side of the ambi-safety and do a final check for proper installation with the plunger spring assembly installed. Neither the sear or hammer should move when the trigger is pulled.

18. Reinstall the upper assembly of the slide and barrel.

Tip: For easier removal of the left hand side ambi-safety lever, grasp it firmly and pull up while wiggling it up and down in a motion identical to putting the safety on and pushing it off.