

Sear Jig

1. Disassemble gun completely to remove the sear. If you don't know how to completely disassemble the gun and remove the sear, we suggest our 1911 Bench Reference to guide you. Order here: <https://www.edbrown.com/product/1911-bench-reference-2nd-edition/>
2. Install the sear into the jig as is shown in the drawing on the back of this page. Use the sear pin out of your gun to hold it in place. If the sear doesn't come up above the height of the .020 shim, it is too short to use. Replace it with a new one. It needs to stick up above the shim to start with, but it does NOT have to be stoned down to the shim's level.
3. Hold the jig in your palm and place your index finger over the front of the sear in the area of the jig that is cut on an angle to hold it back against the adjusting screw as shown in the drawing.
4. Set the .020 shim about the center of the flat on top of the jig. It can be loosely held in place between the thumb and little finger.
5. Use a medium cut India stone, 1/2 x 1/2 x 6 (or your favorite) and gently stone the top of the sear. Check the cut right away. Most sears will need a slightly different angle stoned on them than the one that is done from the factory to achieve the trigger pull you want. We have adjusted the sear angle screw to suit the way we do triggers, but if you prefer a different way, then the screw will have to be readjusted. Note that it is set in place with Loctite.
6. Continue to stone the top of the sear until the top is evenly cut all the way across. The .020 shim will assist you in keeping the stone flat on top of the sear, as well as keep any wear off of the jig.
7. Finish the top of the sear with a 1/2 x 1/2 x 6 fine cut ceramic stone, or your favorite. Use quite a bit of pressure and stop only when a mirror finish appears all across the top of the sear contact area.
8. Remove the sear from the jig and hand stone a bit of relief on the back similar to the lower drawing. Use the medium cut India stone. This relief does not require a jig as it is only relief. It does affect the creep that the final trigger job will have, so try to get it just like the drawing. A four or six power eye loop is handy for this job. What you want to do is to stone away approximately 1/3 of the rear of the engagement surface. See the enlarged drawing of a sear for clarification.
9. Now take the ceramic stone and stone a SLIGHT radius between the original angle finished on the jig, and the one you just stoned. Just barely eliminate any sharp junction point with a few light swipes.

10. Use the ceramic stone to smooth up the hammer hooks on your hammer. They should be ninety degrees when you start, and ninety degrees when you finish. The hooks should be no more or less than .020 high. Use your .020 shim and your medium cut India stone to establish this height. Use the ceramic stone to make sure there are no burrs on the sharp edge you just stoned. Your stone needs to have a sharp, ninety degree corner to get this right.

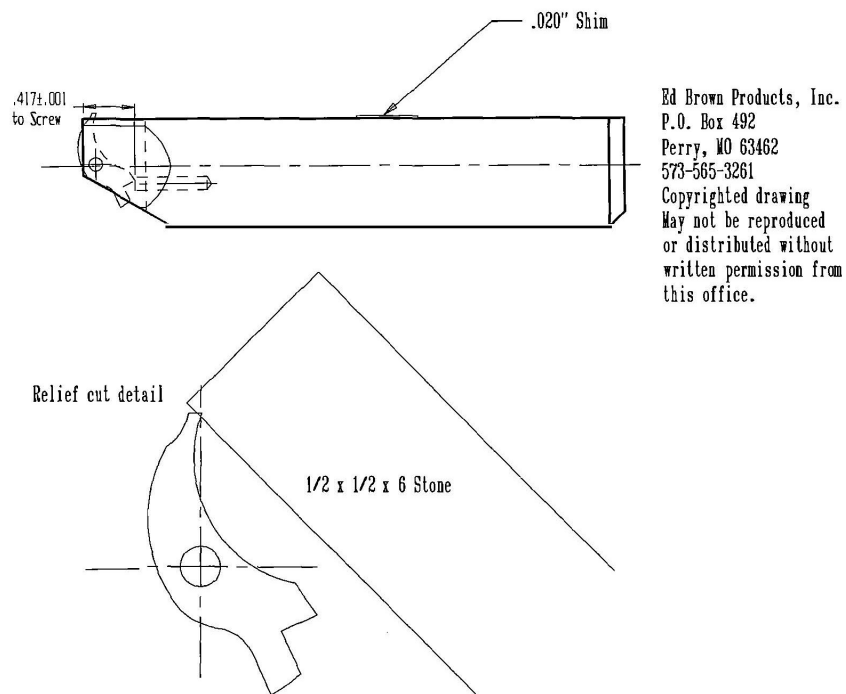
11. Now you should have a nice crisp trigger pull. Assemble only the parts necessary to check the pull into the gun. Don't bother installing the grip safety. If the pull is too heavy, bend the sear spring leaves slightly backward to lighten the pull. Don't bother to change the one that contacts the grip safety. I like to keep both the sear and disconnecter leaves approximately equal when viewed from the side.

WARNING:

NEVER UNDER ANY CIRCUMSTANCES SHOULD THE TRIGGER PULL WEIGHT BE LESS THAN THREE POUNDS. THIS MEANS THAT THE TRIGGER SHOULD PICK UP A THREE POUND WEIGHT WHEN ALL SAFETY DEVICES ARE DISCONNECTED! ATTEMPTING TO REDUCE A 1911 TRIGGER PULL BELOW THREE POUNDS IS UNSAFE AND UNRELIABLE.

12. If the pull has more creep than you like, pull the sear back out of the gun and stone just a tiny bit more from the relief area to reduce the amount of contact the sear has with the hammer.

13. This last step is the most important! Since you have changed the trigger/sear engagement surfaces, you need to check the thumb safety to see if it will still engage the sear properly, and block it from firing when in the safe position. **MAKE SURE YOU DO THIS.** If the sear will move ANY with the thumb safety engaged, the safety needs to be refit, or replaced.



Other helpful hints:

Our 19# mainspring (#919) will reduce the trigger pull without losing any reliability of ignition or function. For the finest, longest lasting trigger pulls, use our specially designed parts like our hammer (#896 (blue) #897 (stainless)) and sear (#874). They are made from tool steel, heat treated clear through, and have specially designed geometry to make your final trigger pull more reliable and longer lasting.

Brownell's, 515-623-5401, India Medium Cut Stone #657-246-146, Ceramic Stone Fine Cut #080-721-601, Ruby Stone #348-221-001. This stone is a smaller version, made from pure ruby. It really leaves a beautiful finish, but is fairly expensive. You be the judge .