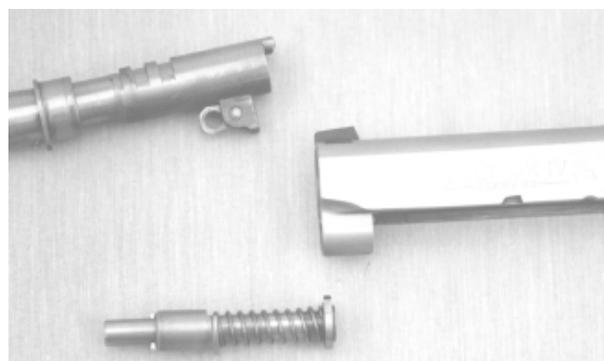


You will need a place to work, a tool bench, or suitable substitute. A padded bench vise, a vertical mill would be nice, but a file complete with elbow grease will do, and enough knowledge to disassemble the top half of the gun.

1. Unload gun and remove slide. Of course we only work on unloaded guns. Don't just drop the mag and jack the slide. LOOK inside the chamber. Once you are certain no ammo exists, remove the slide and top half of the gun. Go ahead and strip the slide of the barrel and bushing, but there is no need to disassemble further.



Now you should be able to see how the factory recoil spring plug fits into the small tab on the bottom of the slide. Notice how it protrudes far enough forward to block the barrel bushing from rotation. Grab the replacement recoil spring plug and examine the differences. The first thing you should notice is the shoulder on the back. The design is intended to replace the small tab with a shoulder that will absorb the pounding better. So you need to remove metal from the slide equal to the thickness of the shoulder. In other words, the shoulder has to go somewhere, you can't just let it stick out the back of the slide.



The reverse plug is furnished in stainless steel only and is intended for gunsmith fitting to the Colt Officer's Model.



2. The slide should be cut off on the rear of the plug area an amount equal to the thickness of the shoulder. The plugs are furnished with a .062 thick shoulder. I usually cut about .065 off of the slide to make sure that the plug shoulder will clear slightly and not contact the frame during firing. Remove metal from the rear of the slide spring area equal to the thickness of the shoulder on the new recoil plug. This is where the vertical mill would be handy. You could simply clamp up the slide upside down in a mill vise, and make a straight cut across the back equal to the thickness of the shoulder. Assuming the vise was mounted on the mill, five minutes max. However, if you are a bench workman without a mill, never fear. You can do just as good a job, it will just take a little longer.

Using what ever measuring device you have, mark the slide an amount equal to the thickness of the shoulder so you will have a line to file up to. Clamp the slide in a vise padded with cardboard or leather. If I have to do any filing, I prefer to press down, rather than any other way, so I suggest clamping only the muzzle of the slide in the vise, allowing the rest to stick straight up.

File carefully and be sure to keep the rear end square in all directions. If you have done a good job laying out your guide line, this should be no problem. Don't forget, you can always use the new recoil spring as a check gauge by trying its fit often. Once you get very close, you will begin to notice a slight interference with the radius between the body of the recoil plug and its shoulder.

3. Round off the inside of this area so that no sharp corner can cut into the radius in the recoil plug shoulder area. The radius on the recoil plug needs to be there, so the slide needs to have a slightly larger radius cut on it for clearance. This is best done with a small hand grinder and about a 1/8" to 3/8" grinding wheel. Try to make it even all the way around, and do not grind away all of your square area. Properly done, there is a small flat left all the way around the back of the slide.

4. Make sure the plug fits flush without binding and will lock the bushing in place. I can't say much more about this line other than not to be afraid to tap on the back of the bushing shoulder with a plastic hammer to make sure it is seated fully. You could also reinstall the bushing and make sure the new plug will lock the bushing in the vertical position.

5. Assemble the spring on the rod and the plug on the spring. The closed end of the spring goes on the rod first. Don't put it on backwards, it is the sign of a real amateur.

6. Compress the plug and spring down and hold in place with the take down pin. There is an easy way to do this. Put the recoil spring in the slide backwards, and place the assembled rod and spring in backwards. Now you can use the slide as a handle and press the head of the guide rod into your work bench. As you do this, check out one important point. Make sure the recoil spring will collapse FULLY into the recoil spring plug. More than one gun has been tied up, or broken by the shooter using an oversize recoil spring that will not collapse into the recoil plug. Upon firing, the force usually pushes the front out of the recoil plug and ruins it. Once satisfied that there is actually room for the spring, insert the take down pin into the guide rod and let the pressure off the assembly. If the take down pin is centered, you should be able to remove the assembly from the front of the gun.

7. Assemble barrel, bushing, and slide, and insert guide assembly in place. Now you can reinstall the barrel and bushing in the slide. You will notice that there is just room to install the new guide assembly underneath the barrel.

8. Assemble complete top half on frame of gun and reinstall slide stop. Self explanatory, but pay attention for this last step. It is most important!

9. Make sure recoil plug is fully seated into the slide, then pull back slide to release take down pin. By now you are familiar with the recoil shoulder on the new recoil plug. It is most important that this shoulder be seated fully home. It is easy to check, because the barrel bushing will not be locked, and there will be a large gap where the shoulder should be. **MAKE SURE THE SHOULDER IS SEATED FULLY.** If you fire the gun with the shoulder unseated, the force of the slide will seat the plug for sure. Of course it won't be lined up and will cut a neat divot in the side ruining it for good. If the worst does happen, don't forget we sell replacement plugs. Now that the installation is complete, you can shoot in complete confidence and enjoy a bit of additional muzzle weight. You should also notice that the action of the gun is a good bit smoother due to the fact that the short recoil spring is not binding inside the slide any more.

