

1911 LCI Installation Procedure

Return Spring Steps 1-5

Step 1: Install T-nut into your slide as if you were assembling your slide on your frame.



Step 2: Insert slide on Jig with the breach face against center post, tighten the two 10-24 screws to secure slide to fixture.



Step 3: Stand fixture up vertically in vise with the slides right side facing the operator.



Step 4: Using an edge finder, locate the back jaw of the vice and the right side of the fixture, and set zero for both axes. Then dial the X-axis from zero to 1.775. Dial the Y-axis from zero to .5000.

Step 5: Insert the long 7/64 drill into drill chuck (with spindle off) lower the drill into the fixture guide hole until it touches the breach face of the slide. Set a zero, turn on spindle and then proceed to drill the return spring hole to a depth of .7000. You are now done with the return spring hole.

Pivot Pin Steps 6-8

Step 6: With the pivot pin block removed, insert fixture in to your vise with the right side of the slide up and against a machinist stop on the right side of fixture. With your edge finder, locate the right side of the fixture, and the solid jaw of your vise, and set zeros. Dial the X-axis from zero to 2.9375. dial the Y-axis from zero to 1.9230.

Step 7: Insert a 1/16 end mill and make a spot face to a full diameter. Remove fixture from vise and install the pivot pin block and tighten 10-24 screw to secure block. Reinsert fixture into vise.

Step 8: Insert a 1/16 drill into the spindle and drill thru the slide (peck the drill up and down many times to clear the chips from the drill. Small drills tend to break easily). You are now done with the pivot pinhole.



LCI Slot Steps 9-13

Step 9: Insert your fixture into your vise; slide up right with the rear part of the slide to your right. With your edge finder, locate the right side (X-axis) of the fixture and solid jaw of your vise (Y-axis) and set zeros. Dial your X-axis from zero to 3.0625 and your Y-axis to 1.0000. Reset both axes to zero.



Step 10: Insert a stubby 1/8 end mill into spindle. With spindle off, touch the top of the Return spring Block and set a Z-axis zero. Lower your Z-axis .2800 and reset your Z-axis zero.

Step 11: With your Z-axis lowered to your new zero, dial (slowly) your X-axis to .2000, and then dial the opposite way to clear end mill from the slot. Then move your Y-axis +.002 towards the back jaw of vise, and then dial your X-axis to .200. Move your Y-axis towards the operator -.002 and dial your X-axis the opposite way to clear end mill out from the slot.

Step 12: Raise your Z-axis to .125, dial (slowly) your X-axis to .350, and then dial the opposite way to clear end mill from the slot. Then move your Y-axis +.002 towards the back jaw of vise, and then dial your X-axis to .350. Move your Y-axis towards the operator -.002 and dial your X-axis the opposite way to clear end mill out from the slot. You have now finished the rework to your slide.

Step 13: Insert the LIC (with out return spring) and use your 1/16 drill as a temporary pivot pin, check to see how much of the LIC protrudes above the top of slide. File the top of the LIC close to the top of your slide, when close remove the 1/16 drill and LIC and finish filing until flush. Replete if necessary (If done with care refinishing of slide is not necessary).

Step 14: Insert return spring in the 7/64 hole you drill first.

Step 15: Insert the LIC and 1/16 roll pin into the 1/16 hole you drill second. You have now finished the complete installation of your LIC.