

ANDERSON

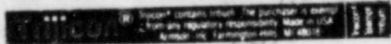
GUNSMITHING

July 25, 1986

Donald N. Mackenzie
United States
Nuclear Regulatory Commission
Washington, DC 20555

RE: Control No. 019613

Dear Mr. Mackenzie:



The above label will be attached to the frame under the grips
of each gun.

Attached is a copy of the installation instructions.

Sincerely,

A handwritten signature in cursive script that reads "David Anderson".

David Anderson
ANDERSON GUNSMITHING
Owner

DA/njd

8610150512 860725
NMSS LIC30
04-23594-01E PDR

ANDERSON

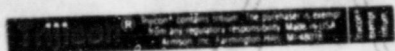
GUNSMITHING

July 25, 1986

Donald N. Mackenzie
United States
Nuclear Regulatory Commission
Washington, DC 20555

RE: Control No. 019613

Dear Mr. Mackenzie:



The above label will be attached to the frame under the grips of each gun.

Attached is a copy of the installation instructions.

Sincerely,

A handwritten signature in cursive script that reads "David Anderson".

David Anderson
ANDERSON GUNSMITHING
Owner

DA/njd

GUNSMITHING INSTRUCTIONS

TRIJICON INSERTS

The insert assembly is a miniature glass lamp containing pressurized hydrogen gas and phosphor. It is shock mounted in silicone rubber, inside an aluminum cylinder with a diameter of as little as 1/16 of an inch. The insert is fragile until installed in the sight blade and the adhesive has set.

All drilled holes (see specifications on back page) must be "through" holes. OR a hole must be drilled from the side to vent the hole. This is essential! Putting an insert into a blind or unvented hole almost guarantees failure of the insert. Also, be sure the drilled hole is deep enough to accommodate the entire length of the insert. Under no circumstances can you trim any aluminum from either end of the insert.

After drilling, the hole must be thoroughly cleaned with a strong solvent like toluene. Wrap a very small piece of kleenex around a thin toothpick and swab the hole several times with toluene. Wipe away excess toluene and allow to air dry for five minutes. At this point some cold blue can be applied to the area of the hole that will not be covered by the insert. Allow the cold blue surface to air dry for about 10 minutes and then clean up again with toluene.

The inserts are clean as supplied. They must not be immersed in strong solvents like toluene. It will swell the silicone rubber which crushes the glass capsule and the lamp will go out in a matter of days or weeks. If you get oil on the insert, wipe the outside with a tissue moistened with toluene, not wet.

Use only Loctite Black Max as adhesive. This is a cyanoacrylate base super glue type of adhesive. It is available from us if you cannot locate an industrial source near you. Do not experiment with other adhesives as we have already done so without success. Use a hypodermic size plastic nozzle (.035" OD, .017" ID Loctite #999310) with the bottle of Black Max. Insert the tip of the plastic hypo into the drilled hole and gently squeeze out a small drop about 1/16 inch diameter to just fill the hole from the top and down about 1/16 inch. Excess causes too much cleanup afterwards. Grip the insert from the sapphire end with a pair of tweezers and apply a small bead of Black Max to the other end, just wetting the end and back about 1/16 inch. Push the insert into the hole with a smooth motion, and use a clean toothpick to seat it flush with the outer surface of the sight. Remember, the Black Max sets up in a few seconds, after which there is no repositioning. Use Loctite X-NMS clean up solvent if you get any Black Max on the sapphire. Allow the inserts to set overnight.

A gun with Trijicon inserts installed **MUST NOT** be soaked or immersed in solvents for cleaning. It can be cleaned with powder solvents and wiped off without causing a problem. Light gun oil is also not a problem.

SPECIAL SITUATIONS

S&W. An S&W with adjustable rear blade may require a .142 flat bottom drilling to properly fit our replacement blade (in some cases it may be larger or smaller than .142). A new screw and nut (spring and plunger too if these parts pop out) will also be required. Very shallow ramp S&W front blades should be drilled from the muzzle end with the drill being supported as it breaks out. Front red ramp blades are drilled right through without any problem.

COLT. The front blade on a Colt must be staked before drilling it. For the rear blade, we are providing about .010 inches of material to be removed to fit a factory new Colt. If we made the blade to perfectly fit a new Colt, it would be too loose on older guns where the dovetail has been widened. Our Colt rear blade is .325 inches high and equals the height of the Colt Officers model. A correspondingly higher front is needed, usually .180 high, but can vary depending on the ammo and bbl length being used. Drill the hole for a D insert at .065 below the top of the finished height of the front.

OTHER FIXED SIGHT AUTOMATICS. See note above referring to fit of rear blade on Colt.

BERETTA. The front blade is hard. We find that a carbide drill is best at a 15 degree angle to the barrel to follow the shape, .050 inches below the top to the centerline of the hole.

STEYR GB. The Steyr GB hole follows the 6 degree slope of the front blade, centerline .072 below the top.

SIG. Our SIG rear blade is .235 inches high. Be aware of a possible variance in the height measurement of your SIG.

H&K P-7. The standard plastic inserts must first be removed. If they do not come out easily by sticking the sharp point of an Xacto knife into them and prying them out, then do the following: Heat the end of a paper clip or pin with a match flame for a few seconds, push into the plastic and allow to cool. Then pull out the pin with the plastic insert. Take a #49 drill and use it with the fingers to scrape the old glue out of the hole until it comes clean. Before gluing, you must check that the hole is deep enough for the insert. A few P-7 have been found with incomplete holes. If necessary, drill hole to proper depth. Clean the hole with toluene as above. All H&K P-7 have vent holes drilled from below.

Label provided with inserts must, by law, be affixed to your gun—usually inside grip or frame.

GUNSMITHING INSTRUCTIONS

TRIJICON INSERTS

The insert assembly is a miniature glass lamp containing pressurized hydrogen gas and phosphor. It is shock mounted in silicone rubber, inside an aluminum cylinder with a diameter of as little as 1/16 of an inch. The insert is fragile until installed in the sight blade and the adhesive has set.

All drilled holes (see specifications on back page) must be "through" holes OR a hole must be drilled from the side to vent the hole. This is essential! Putting an insert into a blind or unvented hole almost guarantees failure of the insert. Also, be sure the drilled hole is deep enough to accommodate the entire length of the insert. Under no circumstances can you trim any aluminum from either end of the insert.

After drilling, the hole must be thoroughly cleaned with a strong solvent like toluene. Wrap a very small piece of kleenex around a thin toothpick and swab the hole several times with toluene. Wipe away excess toluene and allow to air dry for five minutes. At this point some cold blue can be applied to the area of the hole that will not be covered by the insert. Allow the cold blue surface to air dry for about 10 minutes and then clean up again with toluene.

The inserts are clean as supplied. They must not be immersed in strong solvents like toluene. It will swell the silicone rubber which crushes the glass capsule and the lamp will go out in a matter of days or weeks. If you get oil on the insert, wipe the outside with a tissue moistened with toluene, not wet.

Use only Loctite Black Max as adhesive. This is a cyanoacrylate base super glue type of adhesive. It is available from us if you cannot locate an industrial source near you. Do not experiment with other adhesives as we have already done so without success. Use a hypodermic size plastic nozzle (.035" OD, .017" ID Loctite #999310) with the bottle of Black Max. Insert the tip of the plastic hypo into the drilled hole and gently squeeze out a small drop about 1/16 inch diameter to just fill the hole from the top and down about 1/16 inch. Excess causes too much cleanup afterwards. Grip the insert from the sapphire end with a pair of tweezers and apply a small bead of Black Max to the other end, just wetting the end and back about 1/16 inch. Push the insert into the hole with a smooth motion, and use a clean toothpick to seat it flush with the outer surface of the sight. Remember, the Black Max sets up in a few seconds, after which there is no repositioning. Use Loctite X-NMS clean up solvent if you get any Black Max on the sapphire. Allow the inserts to set overnight.

A gun with Trijicon inserts installed MUST NOT be soaked or immersed in solvents for cleaning. It can be cleaned with powder solvents and wiped off without causing a problem. Light gun oil is also not a problem.

SPECIAL SITUATIONS

S&W. An S&W with adjustable rear blade may require a .142 flat bottom drilling to properly fit our replacement blade (in some cases it may be larger or smaller than .142). A new screw and nut (spring and plunger too if these parts pop out) will also be required. Very shallow ramp S&W front blades should be drilled from the muzzle end with the drill being supported as it breaks out. Front red ramp blades are drilled right through without any problem.

COLT. The front blade on a Colt must be staked before drilling it. For the rear blade, we are providing about .010 inches of material to be removed to fit a factory new Colt. If we made the blade to perfectly fit a new Colt, it would be too loose on older guns where the dovetail has been widened. Our Colt rear blade is .325 inches high and equals the height of the Colt Officers model. A correspondingly higher front is needed, usually .180 high, but can vary depending on the ammo and bbl length being used. Drill the hole for a D insert at .065 below the top of the finished height of the front.

OTHER FIXED SIGHT AUTOMATICS. See note above referring to fit of rear blade on Colt.

BERETTA. The front blade is hard. We find that a carbide drill is best at a 15 degree angle to the barrel to follow the shape, .050 inches below the top to the centerline of the hole.

STEYR GB. The Steyr GB hole follows the 6 degree slope of the front blade, centerline .072 below the top.

SIG. Our SIG rear blade is .235 inches high. Be aware of a possible variance in the height measurement of your SIG.

H&K P-7. The standard plastic inserts must first be removed. If they do not come out easily by sticking the sharp point of an Xacto knife into them and prying them out, then do the following: Heat the end of a paper clip or pin with a match flame for a few seconds, push into the plastic and allow to cool. Then pull out the pin with the plastic insert. Take a #49 drill and use it with the fingers to scrape the old glue out of the hole until it comes clean. Before gluing, you must check that the hole is deep enough for the insert. A few P-7 have been found with incomplete holes. If necessary, drill hole to proper depth. Clean the hole with toluene as above. All H&K P-7 have vent holes drilled from below.

Label provided with inserts must, by law, be affixed to your gun—usually inside grip or frame.