

# **FCW** *Frerking* *Custom Works*®



## **FCW, LLC** **Marvel Precision 1911-.22lr** **Conversion**

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## FCW, LLC 1911 - .22lr Conversion Unit General Information

Thank you for purchasing a Marvel Precision by FCW 1911-.22lr Conversion Unit. This is the finest 1911 conversion on the market. No other .22 caliber handgun conversion offers the accuracy, reliability or versatility of the Marvel Precision 1911-.22lr Conversion. Although there might be an occasional exception, this unit will "drop" into any Gov't .45 1911 frame without fitting or adjusting.

The Marvel Precision 1911-.22lr Conversion comes in two models:

### UNIT 1

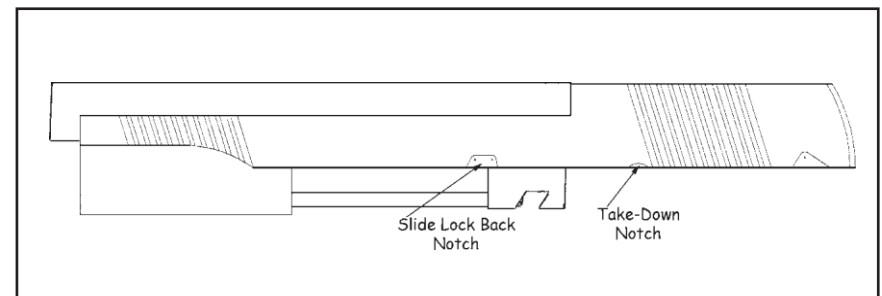
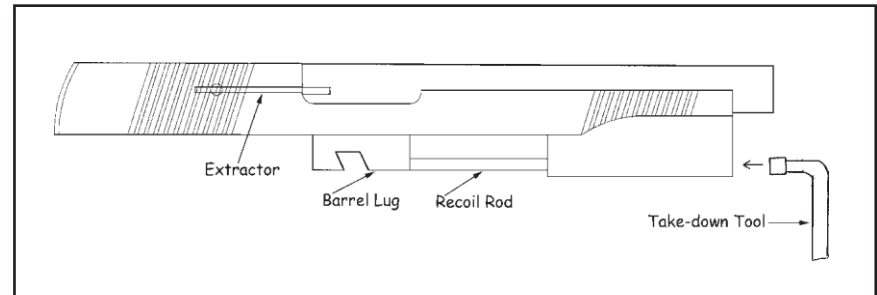
Our Unit 1 is designed for extreme accuracy. Unit 1's are supplied with a test target showing they shot better than 1" at 50 yards (5 shot group). This super reliable unit has a slide machined from billet 7075 aircraft grade aluminum or steel. They have an interchangeable sight rib allowing the user to configure it with adjustable sights, a scope mount rib or the combo rib which has both capabilities. The sight rib mounts directly to the barrel creating a rigid fit between sights and barrel. Our match grade barrel also gets locked down directly onto your 1911 frame via our machined steel slide stop and steel recoil guide rod. Couple that with our hardened steel breech insert and steel barrel lug and you have a super durable conversion capable of "World Class Accuracy". The Unit 1 comes in lock back and non lock back versions. The Unit 1 non lock back slide will not lock back after the last round. Using magazines and slide stop assemblies that lock the slide back will damage the lock-back notch and void the warranty. The Unit 1 is designed to shoot standard velocity .22lr ammo. The unit must be tuned for shooting certain high velocity .22lr ammo by changing out the recoil spring to one of our heavier springs. Comes with one FCW 10rd poly magazine, slide stop, takedown tool, instruction manual and case.

### UNIT 2

Our Unit 2 is designed for inexpensive shooting, IDPA, Stock pistol-limited class, hunting or the weekend warrior. This super reliable unit has a slide machined from billet 7075 aircraft grade aluminum. Our match grade barrel gets locked down directly onto your 1911 frame via our machined steel slide stop and steel recoil guide rod. Couple that with our hardened steel breech insert and steel barrel lug and you have a super durable conversion designed for years of fun. The Unit 2 is a lock back version. It's designed to shoot high velocity .22lr ammo. The unit can be tuned for shooting certain standard velocity .22lr ammo by changing to one of our lighter recoil springs. Comes with one FCW 10rd poly magazine, slide stop, takedown tool, instruction manual and case.

## HOW TO INSTALL THE UNIT ON YOUR RECEIVER:

- 1) Remove magazine and unload firearm you intend to use. Double check the firearm to insure it is unloaded by looking into the chamber area and confirm there is not a round in the chamber. Make sure it is safe!
- 2) Remove the slide assembly of the 1911 (slide, barrel, recoil rod, spring, slide stop).
- 3) Slide the Marvel Precision 1911-.22 Conversion Unit onto the frame.
- 4) Install the Marvel Precision slide stop assembly into the frame completely; insuring that the barrel has been captured by the slide stop. Do not lock the slide back to install the slide stop or damage can occur to the ejector.
- 5) Pull the slide slightly out of battery (1/2" approx.) to expose the hex head of the recoil rod. Tighten the guide rod firmly with our take down tool to approx. 25in/lbs. This will draw the barrel firmly down onto the frame.
- 6) Move the slide back and forth checking that it is free and closes easily.
- 7) The slide can be locked back manually.
- 8) Dry firing can be done but is not recommended on a regular basis without the use of our dry fire device.



#### **MAINTENANCE:**

- Periodically check the tightness of the recoil rod and rib screws (Unit 1). When tightening the rib screws, alternately tighten each screw twice to draw the rib down evenly. A slight amount of either purple (222) or blue (242) Loctite or similar product needs to be used if recoil rod or rib screws become loose. **IMPORTANT: DO NOT USE RED OR GREEN LOCTITE.** These are permanent and you may not be able to easily disassemble the unit.
- We recommend replacing the recoil spring every 2,500 to 3,000 rounds.
- Use a small amount of oil on the slide rails and guide rod.
- Keep the breech area and the chamber clean for the best accuracy and reliability.
- The steel breech does not need to be removed from the slide for general maintenance.

#### **DISASSEMBLY FOR CLEANING:**

- Remove magazine and unload the firearm. Visually check the chamber for a live round – **make sure it is safe!**
- Loosen guide rod and remove slide stop assembly.
- Remove conversion unit from frame.
- Unscrew recoil rod completely out of the barrel lug being careful to control recoil spring.
- Remove recoil rod and spring from assembly.
- Remove barrel from the slide.
- Clean all parts with a quality gun cleaner, lubricate and reassemble.

#### **SOME CAUSES OF INACCURACY:**

- Oil or cleaning solvent in the bore.
- Damage to the crown of the muzzle.
- Certain types and lots of ammo.
- Bad magazines.
- Extreme temperatures (below 40° F and above 95° F).
- Too light of a mainspring or hammer hit.
- Hammer bumping the sear.
- Loose sighting system.
- High velocity ammo tends to be less accurate than standard velocity.
- Some brands of ammo do not function very well in any semi-auto .22.

#### **Marvel Precision Recoil Spring Color Codes**

**10# Red**

**9# No Color Code Standard Size for Unit 1 Aluminum**

**8# Yellow Standard Size for Unit 2**

**7# Orange**

**6# White Standard Size for Unit 1 Steel**

## **YOU ARE RESPONSIBLE FOR FIREARMS**

As a gun owner and/or gun user, you accept a set of very demanding responsibilities. How seriously you take these responsibilities can mean the difference between life and death.

**IT IS ESSENTIAL TO FOLLOW THE SAFETY INSTRUCTIONS FOR YOUR SAFETY AND THE SAFETY OF OTHERS. AT ALL TIMES HANDLE YOUR 1911 PISTOL AND ANY OTHER FIREARM WITH INTENSE RESPECT FOR ITS POWER AND POTENTIAL DANGER. READ AND UNDERSTAND THE CAUTIONS AND PROPER HANDLING PROCEDURES OUTLINED IN THIS ENTIRE BOOKLET BEFORE USING YOUR NEW MARVEL PRECISION 1911-.22lr CONVERSION UNIT OR ANY OTHER FIREARM.**

**1. ALWAYS KEEP THE MUZZLE OF YOUR PISTOL POINTED IN A SAFE DIRECTION.**

Never point any firearm at anything you do not intend to shoot. Be extremely alert and aware of all persons and property within the range of your ammunition.

**2. NEVER RELY TOTALLY ON YOUR FIREARMS MECHANICAL "SAFETY" DEVICES. ALWAYS ASSUME THAT YOUR PISTOL CAN BE FIRED AT ANY TIME, EVEN WITH ALL SAFETY MECHANISMS ENGAGED. LIKE ANY MECHANICAL DEVICE, A "SAFETY" CAN SOMETIMES FAIL; IT CAN BE JARRED OR INADVERTENTLY MANIPULATED INTO AN UNSAFE CONDITION. SAFETY IS ALWAYS FIRST, THINK ABOUT YOUR ACTIONS AND HOW THEY MAY IMPACT ON OTHERS OR OTHERS PROPERTY.**

Mechanical "safeties" merely aid safe gun handling and are no excuse for pointing your gun's muzzle in an unsafe direction. While it is a good idea to "test" your gun's mechanical "safeties" periodically for proper function, never test them while your pistol is loaded or pointed in an unsafe direction.

**3. THE RECOMMENDED CARRYING POSITION OF THE MARVEL PRECISION 1911-.22 CONVERSION UNIT IS WITH THE HAMMER IN THE DROPPED POSITION.**

**4. DO NOT CARRY YOUR 1911-.22lr CONVERSION UNIT WITH A ROUND IN THE CHAMBER.**

For good safety practice, it is recommended that a round not be chambered until immediately before your pistol is to be fired. Never place your pistol on any unstable object. Completely unload the firearm before crossing a fence, climbing a tree, jumping a ditch or negotiating other obstacles.

**5. WHENEVER YOU HANDLE YOUR MARVEL PRECISION 1911-.22lr CONVERSION UNIT ESPECIALLY WHEN IT IS ATTACHED TO A 1911 FRAME, MAKE SURE IT IS COMPLETELY UNLOADED.**

To fully unload your Marvel Precision 1911-.22lr Conversion Unit you must first remove the magazine, open and lock the slide rearward, and visually inspect the chamber to be certain it does not contain a cartridge. It is vital that you remove the magazine from your pistol so a cartridge is not automatically chambered when you close the action.

6. **DROPPING YOUR MARVEL PRECISION CONVERSION UNIT WHEN LOADED CAN CAUSE AN ACCIDENTAL DISCHARGE EVEN WITH THE HAMMER IN THE DROPPED POSITION.**

*Be extremely careful during any type of shooting activity to avoid dropping any firearm.*

7. **BEWARE OF OBSTRUCTIONS TO THE BARREL.**

*Always check your pistol for barrel obstructions while preparing to shoot. Do this by (1) fully unloading the pistol by removing the magazine, (2) locking the action open and (3) inspecting the chamber. BE CERTAIN THERE ARE NO ROUNDS IN THE CHAMBER. Then glance down the barrel, NEVER FROM THE MUZZLE END, to be sure it is clear of any obstruction. A small obstruction can dangerously increase pressures. Before the first firing, clean the bore with a cleaning rod and patch, and wipe away any moisture in the chamber and around the action.*

8. **LOOK FOR SIGNS OF AMMUNITION MALFUNCTIONS.**

*If you detect an off sound or lighter than anticipated recoil when a cartridge is fired, do not load another cartridge in the chamber. Fully unload by removing the magazine and removing the cartridge from the chamber. Glance down the barrel from the breech end, NEVER FROM THE MUZZLE END, to make sure that an obstruction does not remain in the barrel. If there is an obstruction, completely clear the barrel before loading and firing again. IF YOU FAIL TO FOLLOW THESE INSTRUCTIONS AND THE INSTRUCTION IN YOUR OWNERS MANUAL, you can cause extensive damage to your gun, the Marvel Precision 1911-.22lr Conversion Unit and possible serious and even life threatening injury to yourself and others.*

9. **BE CERTAIN YOUR FIREARM IS COMPLETELY UNLOADED BEFORE CLEANING, DISASSEMBLY OR REASSEMBLY.**

*Many gun accidents happen when a firearm is being cleaned. Therefore, you must exercise special and extreme care to ensure your gun is unloaded before cleaning, disassembly and/or reassembly. KEEP AMMUNITION AWAY FROM THE CLEANING LOCATION. NEVER TEST THE MECHANICAL FUNCTION OF YOUR FIREARM USING LIVE AMMUNITION.*

10. **ALWAYS UNLOAD YOUR FIREARM WHEN NOT IN USE.**

*You are responsible for your firearm even when it is unattended. Store your firearm and ammunition separately and well beyond the reach of children. KEEP YOUR FIREARM UNLOADED WHEN NOT IN USE OR IN STORAGE OR WHEN UNATTENDED. Take all safeguards to ensure that your firearm and your Marvel Precision 1911-.22lr Conversion Unit do not become available to untrained, inexperienced or unwelcome hands.*

11. **USE PROPER AMMUNITION.**

*FCW, LLC. assumes no liability for accidents which occur through the use of cartridges of non-standard dimensions or that develop pressures in excess of commercially available ammunition that has been loaded in accordance with standards established by the Sporting Arms and Ammunition Manufacturers' Institute (SAAMI). The Marvel Precision 1911-.22lr Conversion Unit is designed for .22 caliber long-rifle cartridges. FAILURE TO USE CORRECT AMMUNITION MAY RESULT IN SERIOUS INJURY TO YOURSELF OR OTHERS.*

**Do not use hyper-velocity ammunition.** FCW, LLC cannot assume any liability for the use of unsafe or improper arms and ammunition combinations. It is your responsibility to read and heed all warnings in the instruction manual and on ammunition boxes.

12. **MAKE SURE THERE IS ADEQUATE VENTILATION IN THE AREA THAT YOU DISCHARGE A FIREARM. WASH YOUR HANDS THOROUGHLY AFTER EXPOSURE TO AMMUNITION OR CLEANING A FIREARM.**

13. **DO NOT DRY FIRE THE FIRING PIN ON AN EMPTY CHAMBER – THE CHAMBER MAY NOT BE EMPTY!!!**

*Treat every firearm with the appropriate respect as if it were loaded, even if you are certain it is not loaded.*

14. **KEEP FINGERS AWAY FROM THE TRIGGER WHILE COCKING THE HAMMER, UNLOADING, LOADING AND REMOVING THE MAGAZINE, UNTIL YOU ARE READY TO SHOOT.**

15. **BE SURE OF YOUR TARGET AND BACKSTOP.**

*Take additional care and precautions during periods of low light. Know the range of your ammunition. Never shoot at water or hard objects.*

16. **IF YOUR MARVEL PRECISION 1911-.22lr CONVERSION UNIT FAILS TO FIRE, KEEP THE MUZZLE POINTED IN A SAFE DIRECTION.**

*Hold this position for a minimum of 30 seconds. Remove the magazine. Carefully open the action and remove the cartridge. If the primer is indented, the cartridge should be disposed of in a way that cannot cause harm. If the primer is not indented, completely unload the pistol. A qualified gunsmith should examine your firearm and the cause of the malfunction should be corrected before further use.*

17. **WEAR APPROPRIATE EAR AND EYE PROTECTION WHEN SHOOTING.**

*Unprotected, repeated exposure to gunfire can cause hearing damage. Wear ear protectors (shooting ear plugs or muffs) to guard against such damage. Wear shooting glasses to protect your eyes from flying particles. Always keep a safe distance between the muzzle of your firearm and any persons nearby, as muzzle blast, debris and ejecting shells could inflict serious injury. Also, wear eye protection when disassembling and cleaning your pistol to prevent the possibility of springs, spring-tensioned parts, solvents or other agents from contacting your eyes.*

18. **BE DEFENSIVE AND ON GUARD AGAINST UNSAFE GUN HANDLING AROUND YOU AND OTHERS. DO NOT BE TIMID WHEN IT COMES TO GUN SAFETY.**

*If you observe other shooters violating any of these safety precautions, politely suggest safer handling practices.*

19. **SUPERVISE AND TEACH FIREARMS SAFETY TO ALL MEMBERS OF YOUR FAMILY**

*This is especially important when children and non-shooters are involved. Closely supervise newcomers to the shooting sports. Encourage enrollment in hunting/shooting safety courses.*

20. NEVER DRINK ALCOHOLIC BEVERAGE OR TAKE ANY TYPE OF DRUGS BEFORE OR DURING SHOOTING.

*Your vision and judgment could be dangerously impaired, making your gun handling unsafe to you or others.*

21. PERIODIC MAINTENANCE – AVOID UNAUTHORIZED SERVICING.

*Your firearm and your Marvel Precision 1911-.22lr Conversion Unit is a mechanical device which will not last forever, and as such, is subject to wear and requires periodic inspection, adjustments and service. The manufacturers recommended provider of such service should service your firearm. FCW, LLC cannot assume any responsibility for injuries suffered by unauthorized servicing, alterations or modifications to your 1911 Semi-Automatic pistol or to the Marvel Precision 1911-.22lr Conversion Unit.*

22. FCW, LLC. RESERVES THE RIGHT TO REFUSE SERVICE ON CONVERSION UNITS THAT HAVE BEEN ALTERED, ADDED TO OR SUBSTANTIALLY CHANGED.

23. NO LIABILITY WHATSOEVER CAN BE ACCEPTED IN THE CASE OF CRIMINAL MISUSE, NEGLIGENCE, RESALE, USE UNDER THE INFLUENCE OF DRUGS OR ALCOHOL, MODIFICATIONS, CARELESS HANDLING, ETC.

## **LIMITED WARRANTY**

### **TWO YEAR LIMITED WARRANTY AGAINST DEFECTS IN MATERIAL AND WORKMANSHIP**

This warranty is good only to the original owner who has registered their ownership with FCW, LLC. FCW, LLC will not honor claims involving any of its products for any reason or cause when such claims are made by the second or subsequent owner.

Warranty card must be completed and returned to FCW, LLC within thirty (30) days of the purchase to insure the protection of the warranty. Notice of defect in materials and/or workmanship must be received by the company within two (2) years from the date of purchase. Please retain your sales receipt for proof of purchase date.

FCW, LLC will not honor claims involving this product which results from careless or improper handling, normal wear, unauthorized adjustment, modification, parts replacement, corrosion, neglect, use of wrong caliber ammunition or use of ammunition other than original high quality, domestically produced, commercially manufactured ammunition in good condition, and/or combination thereof. Do not use hyper-velocity ammunition. Doing so voids the warranty.

THIS WARRANTY GIVES YOU SPECIFIC LEGAL RIGHTS, AND YOU MAY HAVE OTHER RIGHTS WHICH VARY FROM STATE TO STATE.

After notice of defect in material and/or workmanship is received, FCW, LLC will give instructions for shipment of the firearm; and repairs will be made and the unit returned within a reasonable time. Cost of shipping, insurance charges, etc. involved in returning the firearm to the company shall be prepaid by the owner. Do not ship live ammunition under any circumstances.

Cost of parts and labor performed shall be provided without charge by FCW, LLC. Returned freight to owner shall be paid by FCW, LLC on warranty claims.

If FCW, LLC, after receipt of the unit, determines that the defects in material and/or workmanship were the results of abuse and/or neglect, or otherwise not covered by the warranty set forth above, FCW, LLC shall notify such owner to that effect and give an estimate for repair. In such cases, repair, return shipping and insurance charges, etc. shall be paid by such owner.

In the event that FCW, LLC is unable to make warranty repairs to the unit, it shall, within a reasonable time after its receipt, notify the owner to that effect and give him/her the option to receive a replacement of the same model, if then available in its inventory, or to receive a refund, either of which is feasible, will be made through the store of purchase.