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THE MARVEL ULTIMATE 1911 SEAR JIG MAY BE USED IN THREE DIFFERENT MODES TO GET THE RESULTS THAT YOU REQUIRE. THE THREE MODES REFER TO THE DIFFERENT METHODS THAT ARE USED TO SET THE SEAR ANGLE FOR STONING THE PRIMARY (ENGAGING) SURFACE.

THE STONING (CUTTING) TECHNIQUE DOES NOT CHANGE REGARDLESS OF THE METHOD USED TO SET UP THE SEAR ANGLE. *THE SECONDARY ANGLE* IS ALWAYS CUT LAST USING THE *PRE-SET* MODE WITH A 1911 SEAR PIN INSERTED INTO THE TOP HOLE OF THE SEAR BLOCK, SEAR LEGS PUSHED AGAINST THE PIN AND SECURED WITH THE BRASS KNOB ON TOP OF THE SEAR. ADJUST THE SEAR SO THAT IT BARELY TOUCHES THE STONE (THE BACK THUMB SCREW SHOULD BE TIGHTENED AGAINST THE JIG ANYTIME THAT YOU ARE ADJUSTING THE SEAR UP TO BE STONED.)

WARNING: CUT THE SEAR IN SMALL AMOUNTS, THE OVER-ALL LENGTH OF THE SEAR IS IMPORTANT. ANYTHING LESS THAN .770" IS CONSIDERED TOO SHORT AND FOR THE MARVEL 1911 CONVERSION UNITS THE OAL SHOULD BE AT LEAST .775" TO AVOID HAMMER "SHAKE-OFF" DUE TO THE SPEED OF THE SLIDE.

THREE MODES/SET -UPS FOR STONING THE PRIMARY ANGLE

PRE-SET: THIS IS THE RECOMMENDED METHOD OF SETTING THE SEAR ANGLE, IF YOU DO ALL THE OTHER ACTION WORK CORRECTLY, IT CAN GIVE YOU A CRISP TRIGGER RELEASE OF LESS THAN TWO POUNDS IF YOU WANT.

- 1) WITH THE SEAR BLOCK IN THE JIGS' ADJUSTING SLOT, PLACE THE SEAR ONTO THE THREADED SEAR PIN WITH THE BRASS KNOB LIGHTLY SCREWED ON TOP OF THE SEAR.
- 2) INSTALL A 1911 SEAR PIN INTO THE LOWER PIN HOLE IN THE SEAR BLOCK AND HOLD THE FRONT SEAR LEGS AGAINST THE PIN WHILE YOU TIGHTEN DOWN THE BRASS KNOB TO HOLD THE SEAR IN PLACE FOR STONING.
- 3) RAISE THE SEAR NOSE UP UNTIL IT **BARELY** TOUCHES THE BOTTOM OF THE STONE.
- 4) STONE ACROSS THE NOSE UNTIL BOTH OF THE BRASS ROLLERS ARE MOVING AND THEN STONE JUST A LITTLE LONGER TO INSURE THAT YOU HAVE FINISHED THE CUT.
- 5) CONTINUE TO **SLIGHTLY** RAISE THE SEAR UNTIL THE PRIMARY ANGLE IS FINISHED.
- 6) CUT THE SECONDARY ANGLE USING THE SEAR PIN IN THE TOP SEAR BLOCK HOLE AND BY USING THE SAME STONING METHOD.

MATING MODE: THIS GIVES A SLIGHTLY DIFFERENT ANGLE THAT WILL STILL GIVE YOU A GREAT TRIGGER PULL. THIS IS THE WAY THAT MY ORIGINAL SEAR JIG WAS DESIGNED AND HAD PROVED TO BE VERY GOOD.

- 1) LOCK THE SEAR BLOCK INTO THE MATING SLOT ON THE LOWER RIGHT OF THE JIG.
- 2) PLACE THE SEAR ON THE THREADED PIN AND THE HAMMER (USING A 1911 HAMMER PIN) ONTO THE JIG FACE.
- 3) APPLY PRESSURE AGAINST THE REAR OF THE HAMMER AND THE LEGS OF THE SEAR TO "MATE" THE TWO.
- 4) LOCK THE SEAR WITH THE BRASS KNOB WHILE HOLDING THE SEAR AND HAMMER FIRMLY AGAINST EACH OTHER.
- 5) STONE IN THE SAME MANNER AND IN THE PRE-SET STEPS 3, 4, 5, AND 6.

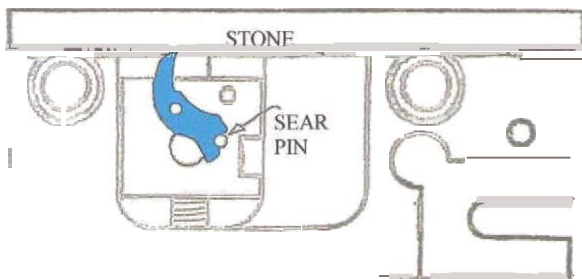
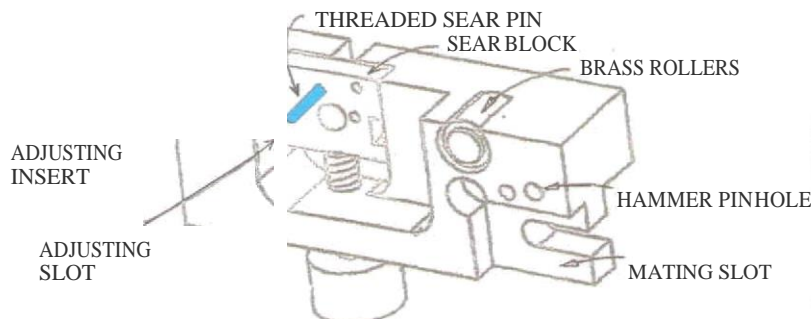
ADJUSTABLE ANGLE MODE: THIS IS IF YOU DON'T CARE FOR THE ANGLES THAT THE OTHER TWO MODES OFFER OR IF YOU WISH TO EXPERIMENT WITH DIFFERENT ANGLES.

- 1) WITH THE SEAR BLOCK IN THE ADJUSTING SLOT, PLACE THE ADJUSTING INSERT INTO THE SEAR BLOCK.
- 2) INSTALL THE SEAR ONTO THE THREADED PIN WITH THE BRASS KNOB LIGHTLY ON TOP OF THE SEAR.
- 3) SIMPLY ADJUST THE SET SCREW AGAINST THE SEAR LEGS UNTIL YOU HAVE THE ANGLE YOU LIKE AND THEN SECURE THE SEAR WITH THE BRASS KNOB.
- 4) THE STONING METHOD IS THE SAME AS BEFORE.

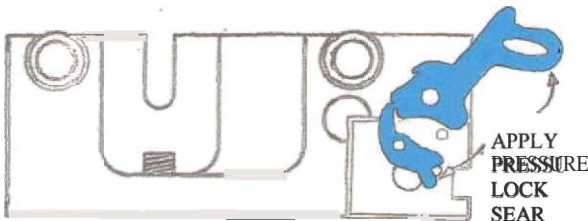
OTHER FACTORS

QUALITY OF THE HAMMER AND SEAR – QUALITY OF THE TRIGGER, SEAR SPRING, DISCONNECTOR AND HOW ALL OF THE PARTS ARE FINISHED – 90 DEGREES OF THE HAMMER HOOKS IS A MUST – LENGTH OF THE SEAR, .770 IS MIN. – HAMMER SPRING – WEIGHT OF HAMMER – BEND OF THE FINGERS OF THE SEAR SPRING – LACK OF BIND IN THE STRUT TO SEAR SPRING OR TO THE MAIN HOUSING – HOW WELL THE TRIGGER FITS THE FRAME – POLISH ON MATING PARTS – LENGTH OF HAMMER HOOKS – TRIGGER STOP (IS IT SET TO CLOSE AND BUMPING THE SEAR ON THE WAY DOWN) – ETC.

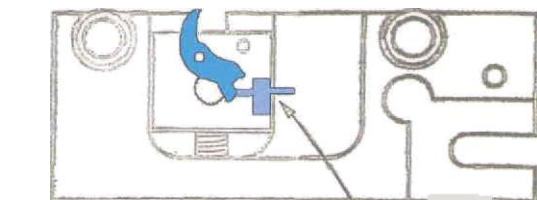
FCW Marvel Ultimate 1911 Sear Jig



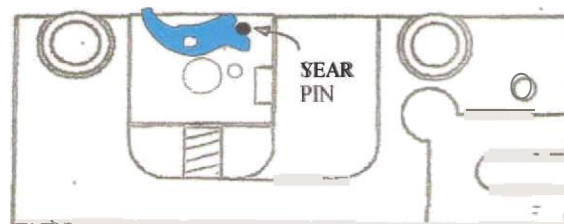
PRE-SET
MODE



MATING MODE



ADJUSTABLE
ANGLE
MODE



SET UP FOR STONING THE
SECONDARY ANGLE

AFTER SECURING THE SEAR TO THE SEAR BLOCK BY ONE OF THE THREE MODES, THE STONING TECHNIQUE IS:

1. SET THE SEAR BLOCK IN THE JIGS' ADJUSTING SLOT SO THAT THE NOSE OF THE SEAR IS SLIGHTLY BELOW THE STONE THAT HAS BEEN PLACED ACROSS THE ROLLERS.

2. FIRMLY SECURE THE BLOCK TO THE JIG BY THE THUMB SCREW IN THE BACK.

3. CAREFULLY RAISE THE SEAR NOSE UNTIL IT **BARELY** TOUCHES THE STONE.

4. STONE ACROSS THE SEAR—CONTINUING UNTIL BOTH ROLLERS ARE ROLLING. STONE LONGER THAN YOU THINK THAT YOU NEED TO. THIS IS TO INSURE THAT THE PROCEDURE IS COMPLETE.

5. CONTINUE TO **BARELY** RAISE THE SEAR UNTIL THE SURFACE IS EVEN.

6. CUT THE SECONDARY ANGLE BY USING A 1911 SEAR PIN IN THE TOP HOLE IN THE SEAR BLOCK