



80% 1911 CLASSIC JIG INSTRUCTIONS



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DISCLAIMER: These instructions are intended for use by an individual who has basic machining knowledge. It is the user's responsibility to determine if finishing an 80% frame is permitted by law in their state and/or municipality. Stealth Arms, LLC assumes no liability for misuse or damage to the user, user's machinery, or frame. The purchase of this product and its instructions are considered acceptance of these terms.

OF AN 80% 1911 SINGLE STACK FRAME. THIS JIG IS SPECIFICALLY INTENDED TO AID IN FINISHING 80% 1911 FRAMES ONLY, AND IS NOT DESIGNED TO FINISH FRAMES THAT ARE LESS THAN 80% COMPLETED.

ITEMS INCLUDED IN THIS KIT:

RIGHT JIG PLATE – 1

LEFT JIG PLATE – 1

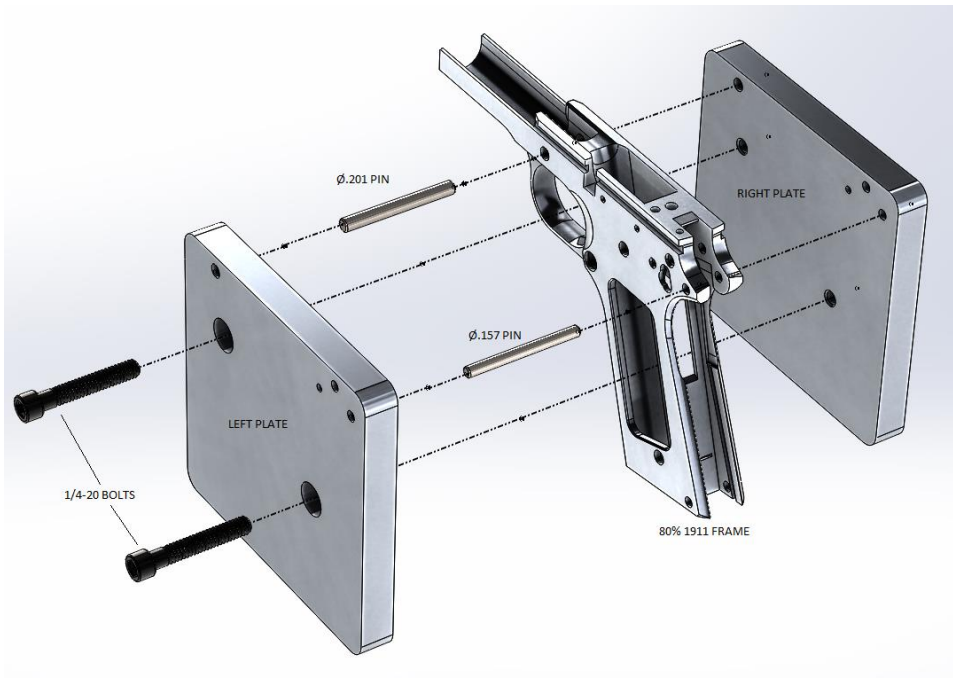
ALIGNMENT PINS – 2

DRILL BITS – 2:

#35 DRILL BIT FOR SEAR PIN HOLE

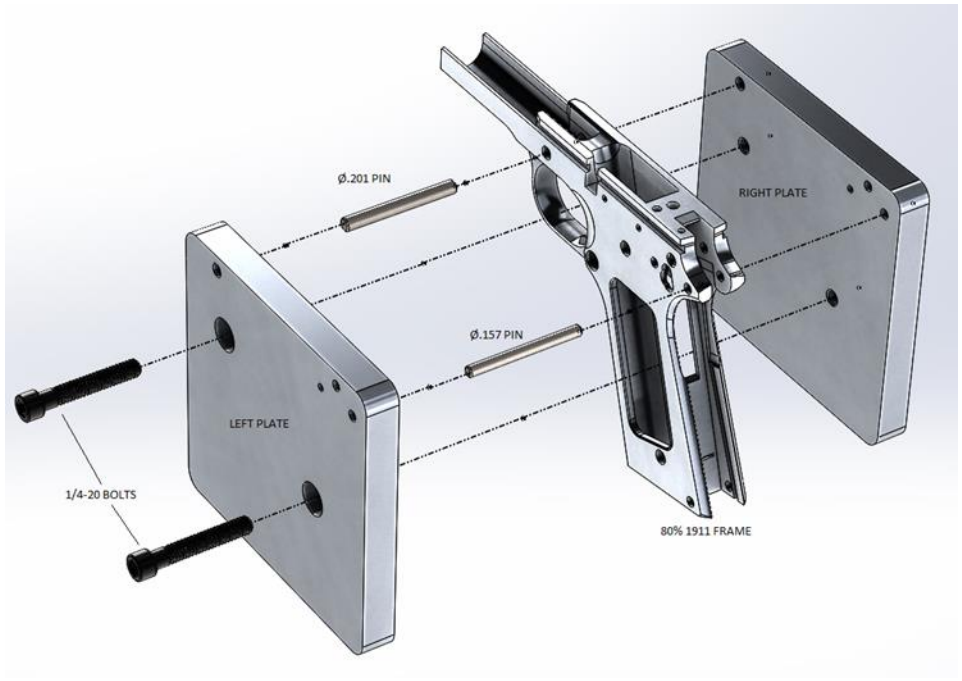
#22 DRILL BIT FOR HAMMER PIN HOLE

1/4-20 BOLTS – 2



- 1.) Assemble the left and right side plates as shown above. Slide the guide pins in the respective holes on the frame.
- 2.) Next, fit each side plate on either side of the frame, inserting the pins through the guide holes on each plate.
- 3.) Finally, insert the 1/4-20 bolts and tighten them snugly so the plates and frame are tightly secured together.

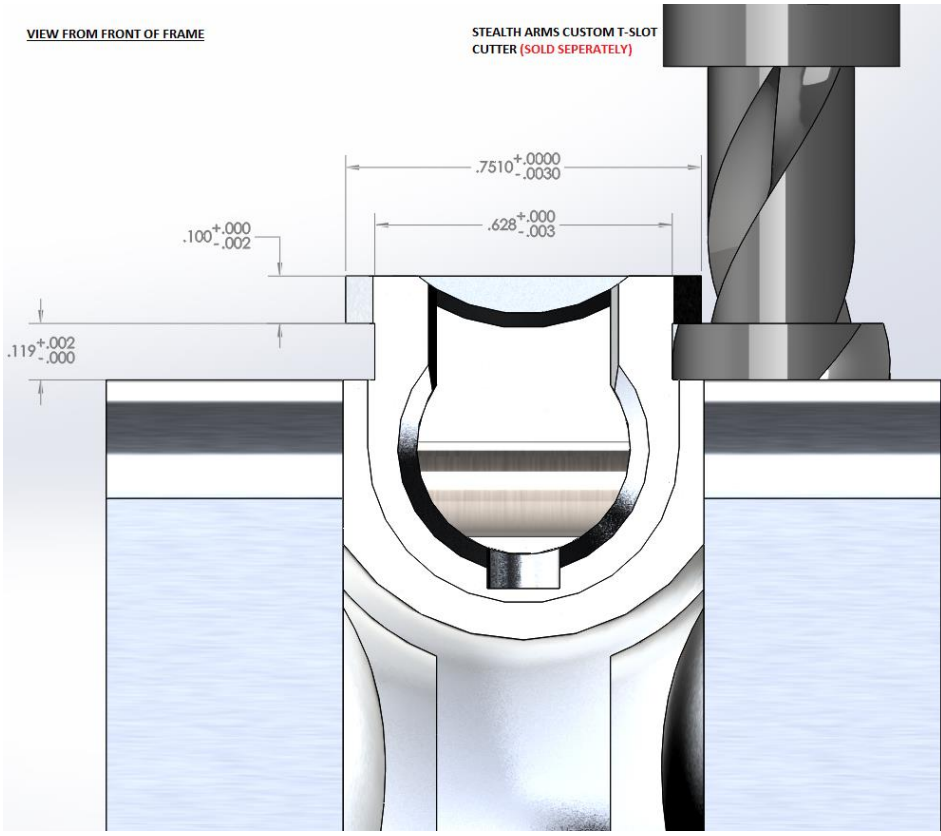
ASSEMBLY: EXPLODED VIEW



CUTTING THE RAILS

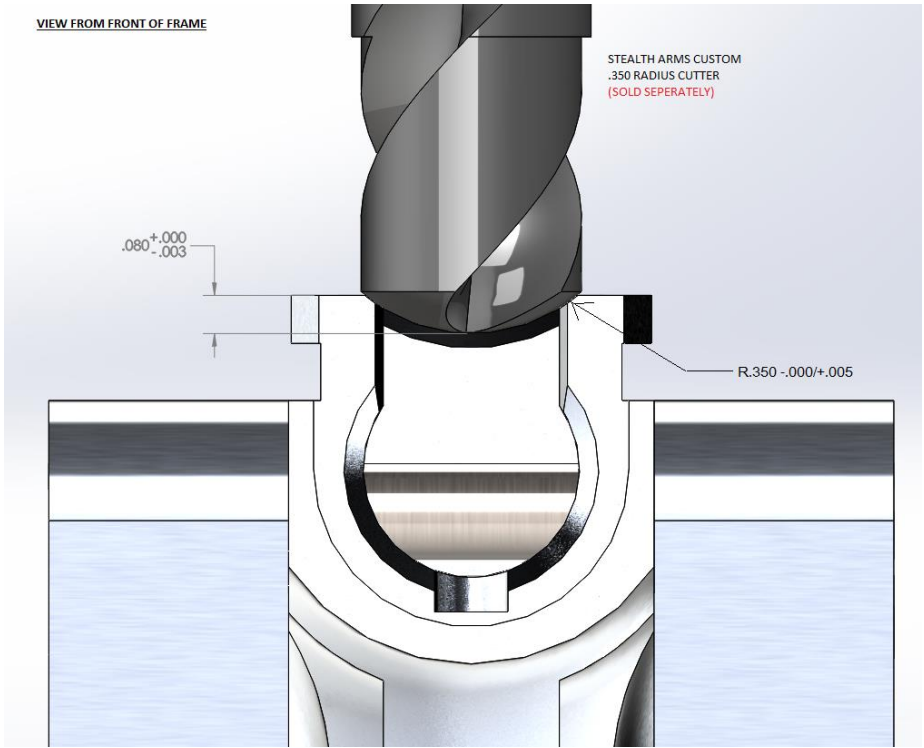
VIEW FROM FRONT OF FRAME

STEALTH ARMS CUSTOM T-SLOT
CUTTER (SOLD SEPERATELY)



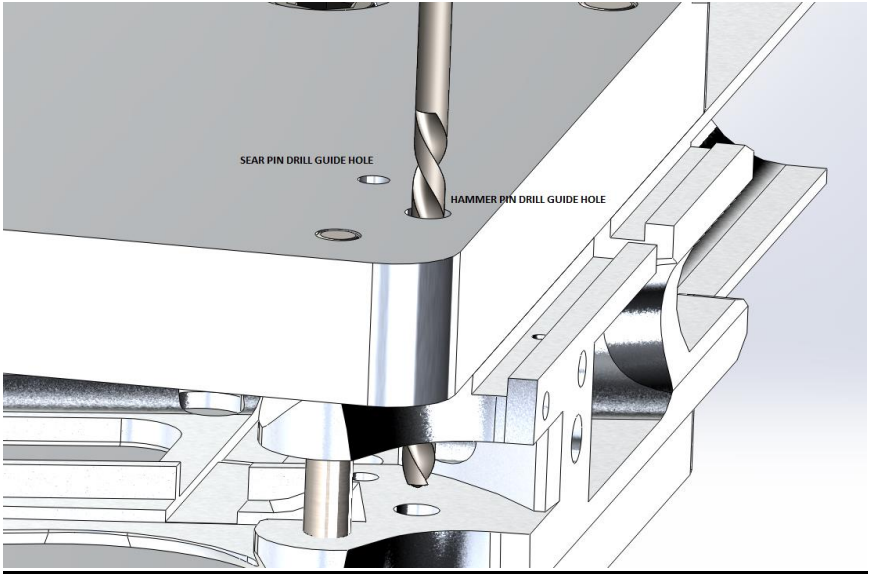
- 1.) Cut the rails to the dimensions shown above using a milling machine. A heavy duty drill press may be sufficient, but NOT recommended, as the spindle may not be able to hold tolerances.
- 2.) The top of the jig plate has been precisely machined to act as a guide for cutting the rails. The top of the jig plate is aligned with the bottom of the slide rail cut.

CUTTING THE BARREL SEAT



The barrel seat needs to be cut in the **CENTERLINE** of the frame to the depth of **.080 (-.003 tolerance)** from the top of the rails. We recommend using the **Stealth Arms Custom** cut ball nose endmill (shown above) in order to get the correct **.350** radius. You could also use an **18mm** ball nose end mill, which will also be sufficient to cut the barrel seat.

DRILLING HAMMER PIN AND SEAR PIN HOLES



Drill the hammer pin and sear pin holes using the drills provided in your Jig Kit using a drill press and the guide holes found on either side plate. We recommend drilling the holes from each side, instead of trying to drill through both sides of the frame from one side, because the drill will tend to “walk off” when trying to drill through the second side. So, only drill through one side at a time.

If you have any questions regarding the Stealth Arms Classic 1911 Jig, please feel free to contact us at www.stealtharms.net. We will be glad to assist you in any way possible. THANK YOU for your business!



MADE IN THE U.S.A.