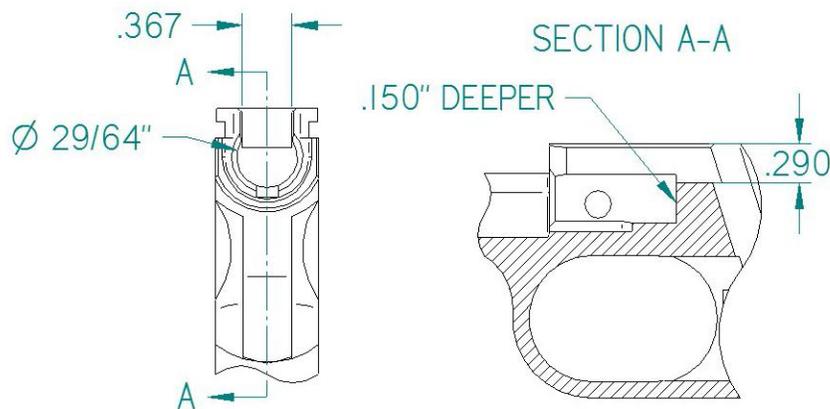


## 1911 RAMPED BARREL INSTALLATION INSTRUCTIONS

NOTICE – We recommend that this product be installed by a competent pistolsmith who is familiar with 1911 style auto barrel fitting. No liability is expressed or implied for improper installation or use of this product.

1. Fully disassembly your frame assembly.
2. Position the frame in your milling machine vise with the top of the frame rails EXACTLY 90° to your milling machine table.
3. Carefully line up the special 29/64" cutter with the original factory hole in the frame. Slowly lower the cutter into the frame making sure the cutter is cutting evenly all the way around. With everything perfectly aligned lower the cutter all the way until it bottoms out to the original factory depth. Check your readings and then slowly feed the cutter down .150" more to deepen this cut.
4. Set the frame up in the milling machine vise with the frame rails perfectly level with your milling table. Using either a ¼" or 5/16" end mill, cut the original feed ramp area away. This cut should be .290" deep measured from the top of the frame rails and .357" wide or however wide the particular frame is just ahead of the feed ramp area. Check to make sure the cut is deep enough before you remove the frame from the mill but sliding the slide assembly (barrel already fitted to the slide) onto the frame. Some frame/slide combinations may require that this cut be deepened by up to .010". Care should be taken to end up with working tolerance only since it is important that the bottom of the barrel ramp BOTTOM out in this cut when the slide is retracted
5. The two cuts you have made will leave a sharp corner at the front and it should be radiused with a safe edge file to correspond with the matching radius on the barrel. NOTE: Never remove the radius from the barrel.
6. Fit the barrel lugs to the slide stop.



NOTE: The rear locking lug recess on this Wilson Combat match grade barrel has been purposely left with extra material to allow the user to fit the barrel to the slide more accurately.

If necessary, gradually deepen the rear locking lug recess until the firing pin hole in the slide lines up with the primer flash hole, using an empty case to check the alignment.

When a satisfactory fit has been achieved, proceed to fit the lower lug (slide stop lug) as you would any oversize barrel.

Wilson Combat recommends that this barrel should be installed by a competent pistolsmith, thoroughly familiar with the 1911 Auto pistol design.