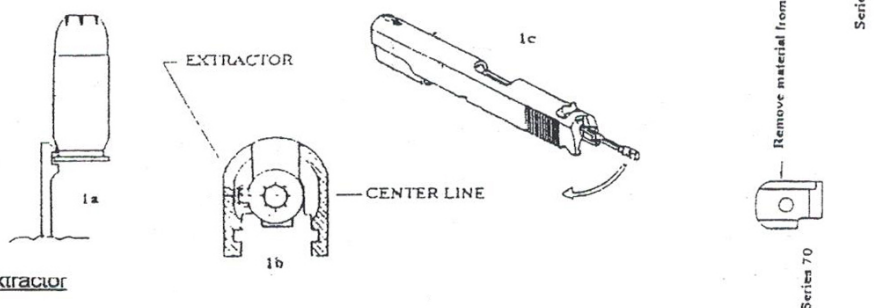


INSTALLATION INSTRUCTIONS FOR #415 SERIES BULLET PROOF® EXTRACTOR

A well fit extractor is essential to the reliability of any 1911 style pistol. With the introduction of our #415 Bullet Proof® Extractor, machined with a pre-fitted hook and locator pad, we have attempted to make this a drop-in part for many pistols and only require minor fitting on others. Should you need to adjust the extractor, due to the variations in manufacturing tolerances for different brands of slides, there are three important areas to address:

1. Correct Tension

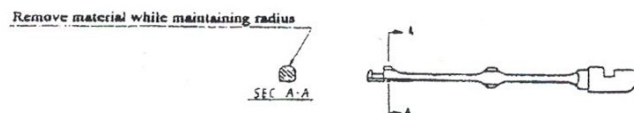
With the slide taken off the frame and with the barrel removed, pull out the old Extractor and install the #415 Bullet Proof® Extractor. With this done, slip the rim of a loaded cartridge under the extractor hook and position it so that the hook is gripping the case at the center line, see fig. 1a and 1b. You should now be able to lightly shake the slide in any position without the cartridge falling off. If this test is unsuccessful, you will need to adjust the tension. For tension adjustment, place approx. 1/2" of the tip of the extractor into the extractor channel and apply just enough pressure to slightly bend the extractor. Be careful - a little goes a long way! The technique is illustrated in fig. 1c. Do not put more tension on the extractor than needed to perform this simple test, too much tension will result in feeding malfunctions whereas too little tension can cause failure to extract and/or erratic ejection.



2. Positioning of extractor

The locator pad (the radiused lug behind the extractor groove) determines at what point the bottom of the extractor groove contacts the rim of the cartridge and puts tension on it. Slide the rim of an empty case under the extractor hook and position the case so that the extractor hook grips it at the center line. Now pull the case downward approx. .075" - .100"; there should still be tension enough to keep the empty case in position even when the slide is lightly shaken. The same test performed with a loaded round should result in the cartridge falling off! This equals roughly 1 - 1 1/2 lb of tension on the case. If you have correct tension on the case when it's centered on the breech face, as described in point 1 above, but little to no tension at all with the case being pulled down approx. .075 - .100", you need to bring the extractor groove closer to the firing pin hole. This is done by removing a small amount of material at a time from the locator pad, while maintaining the radius. Constantly check for correct tension so that you don't take too much material off.

See sketch below:



3. Fitting to the firing pin stop

The slot in the Bullet Proof® extractor for the firing pin stop is designed slightly shallow to achieve a good fit between the two parts. This is done to prevent the extractor from moving or turning which causes inconsistent ejection. With the extractor installed, the firing pin stop should slide into position using normal finger pressure. If the firing pin stop binds, you will have to reduce the width by removing material from the right side of the firing pin stop, where it contacts the extractor. Remove only a few thousandths at a time, while being careful to keep the right side parallel to the left side. When correctly installed, the firing pin stop will fit snugly into place, which prevents the extractor from twisting.

Like all Wilson Combat® Bullet Proof® 1911 parts, your #415 Bullet Proof® Extractor is built to outlast standard parts many times over. Should it ever break or wear out under normal use, we will replace it at no charge.