


The Colt Single Action Hand Slot Stoning Kit provides the gunsmith with special stones to help smooth the machine marks and roughness that inhibit the smooth, friction-free movement of individual internal parts. These instructions DO NOT cover a trigger job. DO NOT use these stones to stone the trigger/hammer engagement surfaces. Those operations require special jigs and different stones. These instructions are written to help you smooth the functioning of the single action; they should not be considered as the definitive guide to a complete action job or rebuild. That is far beyond the scope of these instructions.


Special thanks to Eddie Janis of Peacemaker Specialists for his help in selecting these stones, and for assisting with these instructions.

Regarding Colt Clones

While these instructions are written for a Colt-made Single Action, the procedures can also be used on the Colt clones.



WARNING



Never attempt to disassemble or reassemble a firearm unless you are absolutely certain that it is empty and unloaded. Visually inspect the chamber, the magazine and firing mechanism to be absolutely certain that no ammunition remains in the firearm. Disassembly and reassembly should follow the manufacturer's instructions. If such instructions are not immediately available, contact the manufacturer to see if they are available. If they are not available at all, then you should consult other reference sources such as reference books or persons with sufficient knowledge. If such alternative sources are not available and you have a need to disassemble or reassemble the firearm, you should proceed basing your procedures on common sense and experience with similarly constructed firearms.

With regard to the use of these tools, the advice of Brownells Incorporated is general. If there is any question as to a specific application it would be best to seek out specific advice from other sources and not solely rely on the general advice and warnings given.

Care And Use Of The Stones

The MF-414 stone is very thin on one end and can be broken very easily. Be VERY careful! Use light pressure and take your time. The MF-14 and HF-823 stones are less fragile but will still break easily.

Always use a honing oil, or other light oil such as kerosene, to lubricate the stones. The oil keeps metal particles from filling the pores of the stone (causing the stone to "load up" so it will cut better and last longer. When a stone loads up it will not remove metal as quickly or efficiently.

Clean the stones with soap and water after each use. Store them in their padded box to protect them from breakage.

Smoothing The Colt Single Action Mechanism

Completely disassemble the revolver following the manufacturer's instructions. This includes removing the ejector rod housing. Total disassembly helps prevent damage to parts while working on the frame. Removing the ejector rod housing makes it much easier to hold the frame in your padded bench vise while the work is being done.

Stoning The Hammer

Use the MF-14 stone to smooth the tops of the hammer notch surfaces between the safety notch, half-cock notch and full-cock notch (See Figure 1). Keep the stone level on the tops of the notches, DO NOT rock the stone as you move it across the surface; doing so will round off the surfaces. Follow the MF-14 stone with HF-823 Hard Arkansas stone to polish these same areas. This operation will help you cock the gun more smoothly and quickly.

Smooth the sides of the hammer with the MF-14 to knock off any burrs or irregularities. Follow up with the HF-823 stone to provide a more polished surface.

Very, very carefully, stone a slight bevel on the top half of the hammer cam with the MF-14 stone. (See Figure 2.) This is a VERY DELICATE operation! DO NOT REMOVE TOO MUCH METAL! A few strokes will normally suffice. This operation makes sure that the side of the bolt leg which contacts

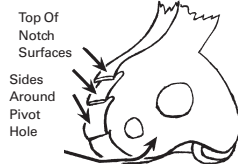


Figure 1

the cam slides smoothly over the cam when the hammer falls forward, and the leg must move back up, and over, the cam.

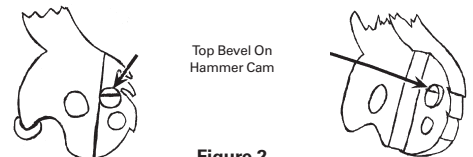


Figure 2

Stoning The Trigger

Use the MF-14 stone to smooth the back surface of the trigger that slides against the tops of the hammer notches. Keep this flat stone moving along the curve of the trigger, changing the angle slightly with each stroke to avoid cutting flats in the trigger's surface. Use the MF-14 to remove the machine marks, then polish the area with a 1/4" diameter, Cratex rod on your Dremel or Foredom tool. If you do not have Dremel or Foredom, use the HF-823 stone to polish the trigger's back surface. (See Figure 3.) Smooth the sides of the trigger with the MF-14 and polish them with the HF-823.

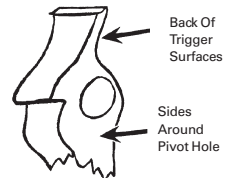


Figure 3

Stoning The Hand

If the sides of the hand exhibit noticeable roughness, they can be carefully smoothed with the MF-14 stone and polished with the HF-823. DO NOT remove very much metal, just take off any burrs or heavy machine marks. DO NOT alter or stone the top of the hooks of the hand! If this occurs, the timing of the revolver can, and probably will, be altered. Again, DO NOT alter the hooks of the hand! You can smooth the front face of the hand, below

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HAND SLOT

STONING KIT

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the hooks, with the MF-14 stone and polish it with the HF-823. This will help the hand slide smoothly past the lower edge of the hand window.

Stoning The Bolt

The sides of the bolt around the bolt screw hole can be smoothed but DO NOT alter the sides of the bolt head which go through the frame and into the bolt notches in the cylinder. Stoning the sides of the bolt head will keep the cylinder from locking up tightly. The flat, underside of the bolt where the bolt return spring bears should also be stoned smooth. No need to remove much material; just make sure it is smooth.

Stoning The Bolt/Trigger Return Spring

Stone both edges of this spring with the MF-14 stone to remove any burrs. Also, gently round the end of the long leg of this spring. This end bears against the trigger. The smoother this contact area, the smoother the movement of the trigger. Finally, check the curve of the short leg of the spring where it bears against the bolt. A smooth surface here will help the bolt to move with less resistance or friction.

Stoning The Hand Slot

Note: Colt has been making the Single Action for more than 100 years and the various clones have been made by several makers over many years. As a result, dimensions vary and we have seen hand slots that will not accept the HF-823 stone. On those slots you will only be able to use the MF-414 stone.

Use the MF-414 stone to remove any high spots or burrs from the three sides of the hand slot. Bolt the thick end of the stone and reach in with the tapered end. BE CAREFUL, you can break the end of the stone very easily. Go slowly and do not apply much pressure. When you have finished with

the MF-414 stone, use the HF-823 stone to polish the surfaces. Note: This stone is a very, very close fit! Manufacturing tolerances in the production of the stone and the frame may keep the stone from fitting into the hand slot. If it won't fit, you will only be able to smooth the slot with the MF-414. DO NOT force the stone into the hand slot.

General Stoning Inside The Frame

Use the MF-14 stone to remove burrs and irregularities inside the frame. The smoother the inside of the frame, the less friction will be encountered as the internal parts move and interact. Areas to check include: the sides of the recess for the bolt spring and the sides of the lower "ears", around the hammer screw holes, where the hammer pivots.

Check the breech face of the frame for any burrs. The heads of the cartridge cases must move across this area and it should be quite smooth. It is not necessary that it be highly polished; just reasonably smooth.

The face of the recess in the frame for the cylinder ratchet should be checked and touched up if there are any burrs. Do not remove any significant amount of metal or you will create cylinder endshake.

After stoning, carefully clean all components with solvent to remove all traces of stone residue. Any that remains can act as an abrasive and wear the gun's mechanism. When the parts are absolutely clean, they should be lubricated with a suitable, high quality lubricant such as Brownells Action Magic II™ or Action Lube Plus™.

Reassemble the firearm according to the manufacturer's instructions. Check for proper functioning using **ACTION PROVING DUMMIES**. Make sure **ALL SAFETY MECHANISMS** are fully functional as designed and approved by the manufacturer. If these tests prove satisfactory, test-fire the firearm with live ammunition in a **SAFE** and **APPROPRIATE** manner.