

1911 OWNER'S MANUAL



WARNING:
YOU MUST READ AND FOLLOW THE
WARNINGS AND INSTRUCTIONS
CONTAINED IN THIS MANUAL BEFORE
USING THIS FIREARM.

VOLKMANN PRECISION, LLC.

[www.VOLKMANNPrecision.com](http://www.volkmanprecision.com)

The Volkmann Precision Process

The process I use to build your pistol is ideal for a custom 1911. There are no assembly lines at Volkmann Precision and all pistols are built one at a time to the customer's specifications. My parts are machined to maximum dimensions, then hand fit for minimal tolerances while providing flawless functioning. I utilize only the best quality bar stock and hardened steel to craft my components. My custom frames and slides are CNC cut for extreme precision from an all steel forging then hand fit with small pillar files and lapped with a multitude of abrasive compounds. The larger working parts are then fit and blended into the frame and slide with the help of a vertical mill and special cutters.



My machined, hand broached and chambered barrels are cut to precisely mate up with my slides and frames. I fit these premium match barrels by hand along with an oversized Stainless Steel barrel bushing for guaranteed accuracy. After the pistol is in mechanical order, I unify the parts into one smooth form and dehorn all edges of the weapon. I disassemble the weapon and further polish out small tool marks by hand with an assortment of emery cloth and hand tools. Triggers are then installed, set and tested by hand and scale. Each Volkmann 1911 is extensively test-fired with an assortment of ammunition in my premium pistol magazines. Your firearm is then disassembled into the 53 single components, cleaned and prepped for your select choice of finishes. These protective coatings are applied to the interior and exterior of the parts and then personally inspected, lubricated and assembled to complete your custom built 1911.



One Masterpiece at a Time

As a one man shop, I can create a 1911 sure to please any level of enthusiast. Not having other gunsmiths or employees involved in the build process creates a very consistent custom pistol. My unique method of single-handed operation at Volkmann Precision is the real secret in making the highest quality 1911. With hundreds of combinations of custom options and finishes, no two pistols are exactly identical. Each pistol is created as an individual work of art and will have its own distinct look and feel that can not be duplicated by other manufacturers. When you order a Volkmann Precision 1911 you are buying the undivided attention you deserve and a one-of-a-kind heirloom that will be handed down through your family for generations.



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KNOW YOUR FIREARM - 1911 DIAGRAM



INTRODUCTION

This manual contains important information on safety, handling, lubrication, recommended ammunition and maintenance of your Volkmann Precision firearm. This is a custom made firearm intended for experienced users. Your safety, as well as the safety of others depends on your constant use of safe firearm handling practices. Seek further assistance if you are unfamiliar with firearms, or are unsure of your ability to handle this firearm safely in any way. Safe handling courses are run by local gun clubs, approved NRA instructors and similar qualified organizations. **THE CONTENTS OF THIS MANUAL ARE NOT INTENDED TO BE A COMPREHENSIVE INSTRUCTIONAL MANUAL, AND SHOULD NOT BE DEEMED TO BE A COMPREHENSIVE INSTRUCTIONAL MANUAL ON THE SAFE HANDLING OF FIREARMS. IF YOU ARE UNSURE OF THE SAFE HANDLING PRACTICES TO BE UTILIZED IN THE OPERATION OF YOUR FIREARM, PLEASE SEEK THE ADVICE OF AN APPROVED NRA INSTRUCTOR OR OTHER SIMILARLY QUALIFIED INDIVIDUAL OR ENTITY.**

WARNING:

**This firearm is a dangerous weapon,
and is potentially LETHAL.
Improper or careless handling
could cause an accidental discharge,
resulting in injury, death or property
damage.**

DISCLAIMER OF LIABILITY

VOLKMANN PRECISION, LLC. WILL NOT BE RESPONSIBLE FOR INJURY, DEATH, OR PROPERTY DAMAGE RESULTING FROM EITHER INTENTIONAL OR UNINTENTIONAL DISCHARGE OF THIS FIREARM. VOLKMANN PRECISION, LLC. WILL NOT BE RESPONSIBLE FOR THIS FIREARM'S FUNCTION WHEN USED FOR PURPOSES OR SUBJECTED TO TREATMENT FOR WHICH IT WAS NOT DESIGNED. VOLKMANN PRECISION, LLC. WILL NOT HONOR CLAIMS INVOLVING THIS FIREARM WHICH RESULT FROM CARELESS OR IMPROPER HANDLING, UNAPPROVED ALTERATION OR PARTS REPLACEMENT, CORROSION, NEGLIGENCE, THE USE OF INCORRECT CALIBER AMMUNITION, THE USE OF AMMUNITION OTHER THAN AN ORIGINAL HIGH GRADE COMMERCIALY MANUFACTURED AMMUNITION IN GOOD CONDITION, OR ANY COMBINATION THEREOF. VOLKMANN PRECISION, LLC. WILL NOT ACKNOWLEDGE CLAIMS INVOLVING THIS FIREARM FOR ANY REASON OR CAUSE WHEN SUCH CLAIMS ARE MADE BY THE SECOND OR SUBSEQUENT OWNER, OR ANY OTHER PERSON OR ORGANIZATION. BEFORE THIS FIREARM LEFT ED BROWN PRODUCTS, INC; IT WAS CAREFULLY INSPECTED, TESTED AND PACKAGED. VOLKMANN PRECISION, LLC. CANNOT BE RESPONSIBLE FOR PRODUCT HANDLING AFTER IT LEAVES THE FACTORY, THEREFORE, PLEASE EXAMINE THE FIREARM CAREFULLY AT THE TIME OF PURCHASE TO INSURE THAT IT IS UNLOADED AND UNDAMAGED. THIS IS YOUR RESPONSIBILITY. THE DEALER CAN ASSIST YOU IN MAKING THIS EXAMINATION AND ANSWER ANY FURTHER QUESTIONS YOU MAY HAVE. IF YOU HAVE SPECIFIC QUESTIONS CONCERNING THE STATE OF THE FIREARM WHEN IT LEFT THE FACTORY, CALL VOLKMANN PRECISION, LLC. IMMEDIATELY.

KEEP THIS INSTRUCTION MANUAL WITH YOUR FIREARM AT ALL TIMES. IT SHOULD BE TRANSFERRED WITH THE FIREARM UPON CHANGE OF OWNERSHIP. WE HOPE YOU ENJOY YOUR VOLKMANN PRECISION FIREARM SAFELY. READ THIS MANUAL AND FOLLOW THE INSTRUCTIONS FOR YOUR SAFETY AND THE SAFETY OF OTHERS. VOLKMANN PRECISION, LLC. HEREBY DISCLAIMS ANY IMPLIED WARRANTIES, INCLUDING THE IMPLIED WARRANTY OF MERCHANTABILITY AND THE IMPLIED WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE.

SAFE HANDLING PROCEDURES

1. Always keep the muzzle of the firearm pointed in a safe direction, and away from all humans, including yourself.
2. Handle every firearm as if it were loaded.
3. Always check to be certain the firearm is unloaded - never take anyone's word for it.
4. Always keep and carry your firearm empty, with the hammer forward, except when you are ready to shoot.
5. Do not place the hammer or allow the hammer to remain in the half-cock notch. This is not a safe carrying position and any effort to engage the hammer in the half-cock notch may result in the hammer perching on the lip of the half-cock notch. This is extremely dangerous. If the hammer is in this position it could fall forward and discharge the pistol, thereby risking injury, death or property damage.
6. Do not drink alcoholic beverages or take drugs before, or during, any shooting activity. Your vision and judgement may be seriously impaired, making your firearm handling unsafe. If you are taking medication, seek a doctor's advice to assure that you are fit to shoot and handle firearms safely.
7. Before beginning target practice, make sure your backstop is acceptable to stop and contain bullets. This is to ensure that you do not hit anything outside the shooting area.
8. To reduce the chances of an accident, place a knowledgeable and responsible person in charge to maintain safety control when a group is firing on a range. Always obey his or her commands.
9. Always wear and encourage others to wear ear protection when shooting, particularly on a range. Long-term, permanent hearing loss could be the result without hearing protection.
10. Always wear and encourage others to wear protective shooting glasses for the eyes.
11. Always make sure your firearm is clean. The barrel bore, chamber and action should be clean and free from obstructions. Clean a fouled pistol immediately so that it will function correctly and safely.
12. Use only clean, dry, original, high grade commercially manufactured ammunition in good condition, appropriate to the caliber of your firearm.
13. Always carry your firearm open and empty while on a range until preparing to fire. Keep it pointed toward the backstop when loading, firing and unloading to eliminate the risk of injury, death or property damage.
14. Always keep yourself and others clear of the ejection port. Injuries can occur because spent cartridges are ejected with significant force, and they are hot. The ejection port must be unobstructed to insure safe ejection of live rounds. Never place your fingers in the ejection port, they could be burned by hot metal and/or powder, or injured by the slide moving forward.

15. Never put your finger inside the trigger guard or squeeze the trigger until you are aiming at a target and ready to shoot. This will prevent you from firing the pistol accidentally.
16. Always be sure of your target and the area behind it before you pull the trigger. A bullet can travel through or past your target up to 1 ½ miles before it stops!
17. If your firearm fails to fire, keep it pointed towards the target or a safe open area and wait at least 30 seconds. If it is a hang fire (slow ignition) the round will fire within 30 seconds. Although it is very rare, you need to be aware of and prepared for this possibility. If the round does not fire, remove the magazine, eject the round and examine the primer. If the firing pin indent is light, off center, or nonexistent, have the firearm examined by a professional gunsmith. If the firing pin indent on the primer appears normal, assume faulty ammunition, separate the misfired round from other live ammunition and empty cases, reload and carry on firing. Dispose of misfired rounds in accordance with the ammunition manufacturer's instructions.
18. Never use your firearm if it fails to function properly. Never force a jammed action because a round may explode causing serious injury or death, and severe damage to your firearm. Before each shooting session, and before loading, give the firearm a quick safety check and visual inspection. If you find something that seems incorrect, do not load or fire. Ask a professional gunsmith for help.
19. Never leave your firearm cocked. This position is extremely dangerous and the firearm could be easily accidentally discharged, causing injury, death or property damage.
20. Never shoot at a hard surface such as a rock or liquid surface such as water. The bullet could ricochet, hitting you, another person or unidentified object, causing injury, death or property damage.
21. Never fire your firearm near an animal that is not trained to accept the noise. It could startle the animal, causing injury or an accident.
22. Horseplay should be forbidden while holding a pistol. It could accidentally discharge, causing injury, death or property damage.
23. Never follow a companion with your firearm cocked ready to fire, out of its holster, or with the hammer in any position other than forward on an empty chamber. When hunting, hold your pistol so that you can always control the direction of the muzzle, in case of an accidental discharge.
24. Never leave a loaded firearm unattended. Someone may accidentally fire it, causing injury, death or property damage.
25. Always make sure the firearm is unloaded before cleaning, storing, or traveling. The magazine should be removed with the slide latched open before laying it down or handing it to another person, so that it cannot be fired accidentally.
26. Always store your firearm and ammunition in separate, locked containers, out of the reach and sight of children, or anyone else who should not handle the firearm.

27. Always instruct children to respect firearms. When teaching children to shoot, teach them to treat and use the pistol properly and responsibly first. Always supervise children closely and stress safety to prevent injury, death and property damage.

THE FOREGOING SAFE HANDLING PROCEDURES ARE NOT INTENDED TO CONSTITUTE A COMPREHENSIVE LIST OF ALL SAFE HANDLING PROCEDURES OF A FIREARM. IF YOU REMAIN CONCERNED REGARDING THE SAFE HANDLING OF YOUR FIREARM, PLEASE CONSULT AN APPROVED NRA INSTRUCTOR OR OTHER SIMILAR QUALIFIED INDIVIDUAL OR ORGANIZATION TO ASSIST YOU.

SAFETY FEATURES

This firearm is equipped with several safety features which can minimize the danger of accidental discharge, if used properly.

NOTE: ALL safeties on this firearm are mechanical devices, which CAN FAIL. NEVER RELY ON A SAFETY DEVICE. Instead, depend upon safe firearm handling procedures, many of which are described in this manual.

GRIP SAFETY

The grip safety is located on the upper rear part of the receiver. The grip safety is automatically applied by a spring action to prevent rearward travel of the trigger unless the pistol grip is firmly and properly grasped. The front of the grip safety (inside the pistol frame) contacts the rear of the trigger to prevent its rearward movement. When the pistol grip is positively grasped, the grip safety is rotated out of contact with the rear of the trigger to allow trigger movement.

DISCONNECTOR

This safety device prevents a round being fired before it is in the chamber with the slide and barrel locked. When the slide is not fully forward the disconnecter is depressed, its lower part disengages the sear, so that the hammer cannot be released if the trigger is squeezed. However, when the slide and barrel are locked, a spring pushes the disconnecter up into a recess in the slide, this links trigger and sear so that the pistol can be fired by squeezing the trigger.

CAUTION: Never attempt to check or demonstrate the disconnecter function with a loaded firearm. Pushing on the muzzle with your hand or any other portion of the body is extremely dangerous, and could result in accidental discharge causing injury, death or property damage.

FIRING PIN

The firing pin, which is shorter than its housing, is held to the rear by a spring and cannot protrude through the face of the slide unless the force of a blow overcomes the spring pressure and the inertia of the pin. This will occur when the hammer falls normally or could occur by a blow on the muzzle or front of the firearm.

SLIDE LOCK SAFETY OR THUMB SAFETY

The slide lock safety is located on the left of the pistol just below the back of the slide. With the hammer fully cocked and the slide lock safety applied, the upper part of the slide lock safety engages the slide lock notch to prevent rearward movement of the slide, while an internal cam surface engages the sear to prevent the hammer from moving forward when the trigger is squeezed. This safety device can only be applied when the slide is fully forward and the hammer is in a fully cocked position. To apply the slide lock safety, point the pistol in a safe direction. Do not touch the trigger and pull the slide fully to the rear and allow it to return gently forward, leaving the hammer in the fully cocked position. Press up on the slide lock safety until it fully engages the slide lock notch.

HALF COCK NOTCH ON HAMMER

The half cock notch is an automatically operating fail-safe device which will engage the sear in the unlikely event of a primary sear notch failure. This will prevent the hammer from falling fully forward unintentionally and will insure against uncontrolled automatic fire. It also prevents the hammer from striking the firing pin should your hand slip from the slide while cocking the pistol, provided the hammer is rotated past the half cock notch. The half cock notch is not meant to be engaged by hand.

CAUTION: Never place or allow the hammer to remain in the half cock notch position. This is not a safe carrying position. Any effort to engage the hammer in the half cock notch may result in the hammer perching on the lip of the half cock notch. This is extremely dangerous. If the hammer is in this condition it could fall forward and discharge the firearm, thereby risking injury, death or property damage.

FUNCTION

Volkman Precision firearms are ready to fire when a loaded magazine is inserted into the firearm, the slide is pulled back to cock the hammer, and released to travel forward and feed a round from the magazine into the chamber. Final forward slide movement locks the barrel and slide together and deactivates the disconnecter. When the pistol stock is grasped, the grip safety is released so that the trigger may now be squeezed. When the trigger is squeezed, the sear disengages from the hammer which pivots forward under the force of the mainspring to strike the rear of the firing pin. The firing pin is driven forward to strike primer in the base of the cartridge. The energy imparted to the primer ignites it, the primer ignites the main powder charge which, in burning, rapidly generates extremely high gas pressure to drive the bullet down the barrel. Rifling grooves in the barrel impart a stabilizing spin to the bullet so that it will follow a more accurate path to the target. Force rearward on the slide breech face starts the slide and barrel on their rearward travel, however, the slide unlocks from the barrel only after gas pressure is reduced to a safe level. Rearward slide travel depresses the disconnecter, carries the spent cartridge rearward on the extractor until the base of the cartridge is struck by the ejector to propel it through the ejection port. Slide movement continues under the momentum to fully cock the hammer. If the last round has been fired, the magazine follower will activate the slide stop to hold the slide to rear, but if a round remains in the magazine, the slide will move forward to feed and lock the next round in the chamber. To fire the next round, the trigger must be released and squeezed again.

AMMUNITION

We recommend high quality factory ammunition only. Handloading your own ammunition and using it in this firearm can void your warranty.

LOADING

To load the magazine:

1. Use only high grade commercially manufactured ammunition in good condition.
2. With the open end uppermost, grasp the magazine, appropriate to caliber, in one hand. Place a round on the magazine follower with the base just forward of retaining lips. Press round down and back until base of round touches rear flat edge of magazine.
3. Place next round on top of previous round and press down and back. Repeat until magazine is fully loaded.

CAUTION: To minimize risk of unintentional discharge, load live ammunition into the pistol only when you are ready to shoot.

To load a pistol:

1. Remove the empty magazine from pistol by placing your hand under the magazine and push the magazine catch (located on left of pistol behind trigger guard) to release and eject the magazine from the magazine well.
2. Hold the firearm by the stock with one hand, keeping the other hand clear of the ejection port, and grasp the cocking serrations on both sides of the slide.

3. Pull the slide back slightly and look in the chamber to ensure it is empty.
4. Allow the slide to return forward. If the slide was fully to the rear, release the cocked hammer by squeezing the trigger after ensuring the chamber is empty.
5. Insert the loaded magazine into the magazine well with bullets pointing forward. Push the magazine fully home until the magazine catch is heard to click, locking it in place. It is important not to strike the base of the magazine to drive it home, just push it firmly into the pistol. Otherwise, you could damage the magazine and injure your hand.
6. When you are ready to shoot, grip the slide and pull it fully to the rear to cock the hammer. Release the slide to feed a round from the magazine into the chamber. The firearm is now loaded and ready to fire. Apply the slide lock safety to hold the slide forward and prevent the hammer from falling forward if the trigger is moved.

WARNING: When a round is in the chamber, the firearm may discharge accidentally if it is dropped or receives a blow. This can occur regardless of the position of the hammer or any of the various safety devices. Do not put a round in the chamber until the pistol is in your hand and you are ready to shoot, and clear the firearm immediately after shooting.

CAUTION: Never leave the firearm cocked ready to fire without the slide lock safety applied, as this is the fire condition and is extremely dangerous. The firearm could easily be accidentally discharged, causing injury, death or property damage.

NOTE: The safest way to carry your pistol is with an empty chamber and an empty magazine. However, if you wish to carry the pistol with a loaded magazine installed, keep the chamber empty, slide forward and hammer down.

UNLOADING

CAUTION: Always unload your firearm immediately after use and prior to cleaning and storage to minimize the risk of accidental discharge.

To unload the firearm:

1. Keep the pistol pointing in a safe direction. Do not touch the trigger and keep hands away from the muzzle and ejection port.
2. Place your hand under the magazine to prevent it from falling and press the magazine catch to release and eject the magazine.

If the slide is locked in the rearward position as a result of firing the last round from the magazine, the next steps do not apply.

3. With the thumb of your right hand, press the slide lock safety down out of engagement with the slide.
4. Using the slide cocking serrations, pull slide sharply rearward to extract and eject a round from the chamber.
5. Visually inspect the chamber to ensure it is empty and the magazine has been removed.

6. Release the slide forward onto the empty chamber by pulling the slide fully rearward and releasing or manually rotating the slide stop downward past the slide stop notch. Allow the slide to gently return forward on an empty chamber. **CAUTION:** Repeatedly allowing the slide to slam closed on a empty chamber will cause premature wear and could damage the finely stoned surfaces of the sear which may ruin the trigger pull or cause an unsafe condition.
7. Squeeze the trigger to allow the hammer to fall forward.
8. Remove the remaining live rounds by sliding them forward out of the magazine.
9. Collect the live ammunition for safe storage and spent cartridge cases for disposal.

FIRING

CAUTION: Always wear and encourage others to wear ear and eye protection when shooting.

1. Point muzzle in a safe direction
2. Load the firearm as previously described.
3. Grasp the firearm by the stock and with your index finger resting along the outside of the trigger guard and take aim. (Aim by aligning the target with the front and rear sights.)
4. Release the slide lock safety by pressing it down out of engagement with the slide lock notch.
5. Keeping steady aim, place your index finger on the trigger and squeeze gently until the hammer falls. Don't jerk the trigger as you will disturb your aim and spoil your accuracy. To fire the second and subsequent rounds, release the trigger and squeeze it again after every shot until you have completed firing. **NOTE:** This is a semi-automatic firearm and is immediately loaded and ready to fire again after each shot, until the magazine is empty.
6. If all rounds have not been fired and you want to stop shooting, release the trigger, remove your index finger from the trigger, and engage the slide lock safety by pushing it up into the slide lock notch.
7. If the last round has been fired from the magazine, the slide will stay to the rear so the slide lock safety cannot be applied.

If your firearm fails to fire, keep it pointed toward the target or a safe open area and wait at least 30 seconds. If it is a hang fire (slow ignition) the round will fire within 30 seconds. Although it is very rare, you need to be aware of and prepared for this possibility.

If the round does not fire, remove the magazine, eject the round and examine the primer. If the firing pin indent is light, off center, or non-existent, have the firearm examined by a professional gunsmith. If the firing pin indent on the primer appears normal, assume faulty ammunition, separate the misfired round from other live ammunition and empty cases, reload and carry on firing. Dispose of misfired rounds in accordance with the ammunition manufacturer's instructions.

CAUTION: Keep firearm pointing in a safe direction, and unload as previously described. If you cock your firearm but do not fire it, apply the slide lock safety until ready to fire. If you lose the opportunity to fire, unload your pistol as previously described. Remember, if a round is in the chamber, there is a risk of accidental discharge. Never leave a firearm cocked and ready to fire. The fire condition is very dangerous and the firearm could easily be accidentally discharged, causing injury, death or property damage.

WARNING: When a round is in the chamber, the firearm may accidentally discharge if it is dropped or handled in a way that it was not designed, regardless of the position of the hammer or any of the various safety devices. Do not put a round in the chamber until the pistol is in your hand and you are ready to fire the firearm. Clear the pistol immediately after shooting. We do not recommend carrying this firearm with a cartridge in the chamber. Remember that ALL safeties on this firearm are mechanical devices and they CAN FAIL. YOU SHOULD NEVER DEPEND ON A SAFETY DEVICE. Instead, depend upon safe firearm handling procedures, many of which are described in this manual.

PROPER CARE AND MAINTENANCE FOR YOUR VOLKMANN PRECISION 1911

LUBRICATION

Keep the pistol well lubricated with any high quality oil. Lube all parts that move against each other, especially in the barrel fit area and slide to frame fit area. It is impossible to use too much lubrication, and we cannot recommend it enough. Clean and lube the gun after each firing session. We recommend lubricating the gun every few magazines during a firing session, if possible. It only takes a few seconds and helps to ensure flawless functioning.

SPRING REPLACEMENT

Replace recoil springs every 3,000 rounds. 5" models are equipped with a 16.5# recoil spring, while our 4.25" models are equipped with a 20# recoil spring.

SHOCK BUFFERS

Shock buffers are not necessary and not recommended in Volkmann Precision pistols, as our frames and slides are sufficiently hard to withstand the impact without damage.

FUNDAMENTALS OF 1911 HANDLING

The fundamentals are simple and easy. Like all fundamentals they are the source of most problems people experience.

1. Never slam the slide shut without a round being fed from the magazine. Slamming the slide shut on an unloaded gun is hard on the frame, barrel fit, and especially the hammer/sear engagement surfaces. Also never drop a round into the chamber and drop the slide on it. This springs the extractor out of position. Always feed rounds from a magazine.
2. Use high quality ammunition, such as Federal or Winchester.
3. Use high quality lubrication, and keep the firearm well lubricated and clean.
4. Maintain a firm grip on the firearm and a locked wrist throughout the entire firing cycle. The 1911 is a recoil operated firearm. You should be gripping the firearm so tightly that a slight imprint of the checkering (if any) is left on your hand. In order to cycle properly, the slide inertia needs to be absorbed solidly and a good grip will ensure this.
5. Make sure your recoil spring is correctly matched to the ammunition you are shooting. If brass is falling within a few feet of you, your spring is too heavy for that load. If brass lands more than about 12 feet away, your spring is too light for that load. Either case leads to reduced reliability. A common problem is a novice shooter trying to “shoot anything and everything” through his 1911 from 185 grains up to 230 grains without considering the proper recoil spring setup. Another common problem is the novice buying a carry gun with a shorter slide, then shooting the hottest personal protection ammo he can get, while ignoring the recoil spring and ejection pattern. For the ultimate in reliability, we recommend choosing a consistent high quality load and sticking with it once it’s proven to work well with your particular setup.

BASIC DISASSEMBLY

NOTE: Safety glasses are recommended, as there are several springs under tension. Remove magazine and unload gun as previously instructed in this manual. Visually confirm there are no live rounds in the chamber. It is preferable to have no live cartridges anywhere around you.

1. Pull back on the slide to align the slide stop catch with the takedown notch in the slide. Control the top of the gun while pushing the slide stop pin out as far as possible from right to left, then pull it out completely.
2. Wrap your hand around the top portion of the slide using your fingers to prevent the recoil spring from jumping out and carefully remove the slide from the frame. **CAUTION:** the recoil spring is under pressure!
3. Set the frame aside and prepare to release the recoil spring and plug.
4. Carefully remove the recoil spring and recoil spring guide. The recoil spring plug can then be removed from the slide.
5. Turn the bushing fully counter-clockwise then slide barrel and bushing out the front of the slide. If necessary, use a bushing wrench.

BASIC REASSEMBLY

NOTE: Safety glasses are recommended, as there are several springs under tension. Remove magazine and unload gun as previously instructed in this manual. Visually confirm there are no live rounds in the chamber. It is preferable to have no live cartridges anywhere around you.

1. Insert barrel and bushing into the slide from the front. Make sure the link is pushed forward.
2. Turn bushing so it is lined up to accept the recoil spring plug. Make sure barrel is pushed all the way back so it engages the locking lugs.
3. Slide the recoil spring plug into position from the back. Make sure it lines up in the bushing.
4. Insert the recoil spring with the recoil spring guide attached into the rear of the plug. With one hand controlling the spring use your other hand to press the recoil spring guide into position ahead of the barrel link. Make sure the rounded cut out in the recoil spring guide is against the barrel, and the link is in the upward position.
5. Hold the spring firmly in place while assembling the slide onto the frame. Be careful not to allow the spring to jump out.
6. Insert the slide stop pin through the frame, make sure it goes through the barrel link. It should rest just below the slide stop plunger.
7. Pull back on the slide to align the takedown notch in the slide. Control the top of the gun while pushing the slide stop up and into the frame. Be careful here to push up and in, it is easy to misapply the pressure and scratch an ugly radius into your frame or slide if you do not push directly in and slightly up to seat the slide stop in the slide stop window of the frame.

LIMITED LIFETIME WARRANTY

Volkman Precision, LLC. (“we” or “us”) warrants to you, the original retail purchaser of a new firearm purchased from us or an authorized Volkman Precision, LLC. dealer (and to each subsequent lawful owner of the firearm), that for the lifetime of the firearm, your Volkman Precision firearm will be free from defects in original materials and workmanship. If you follow the procedures provided below with respect to a warranty claim, and we determine that you are entitled to a remedy pursuant to this Limited Warranty due to defective original materials or workmanship and the claimed defect is not otherwise excluded pursuant to the terms and conditions of this Limited Warranty, then we will replace or repair the firearm (at our sole option and discretion) without charge to you, with the same or comparable parts or firearm.

Our liability under this Limited Warranty, subject to the exclusions described below, shall be limited solely to the obligation to repair the firearm.

Exclusions from Limited Warranty and Liability

This Limited Warranty does not cover defects or damage to the firearm caused by abuse, misuse, accident, careless handling, hand loaded, low quality or other non-standard ammunition, obstructions in the barrel, failure to provide proper care and maintenance, failure to comply with instructions in the manual, normal wear and tear, rust or corrosion, unauthorized repair, adjustments or alteration of the firearm, coating, springs, grips, tritium bulbs or white outlines around the tritium bulbs of the Product.

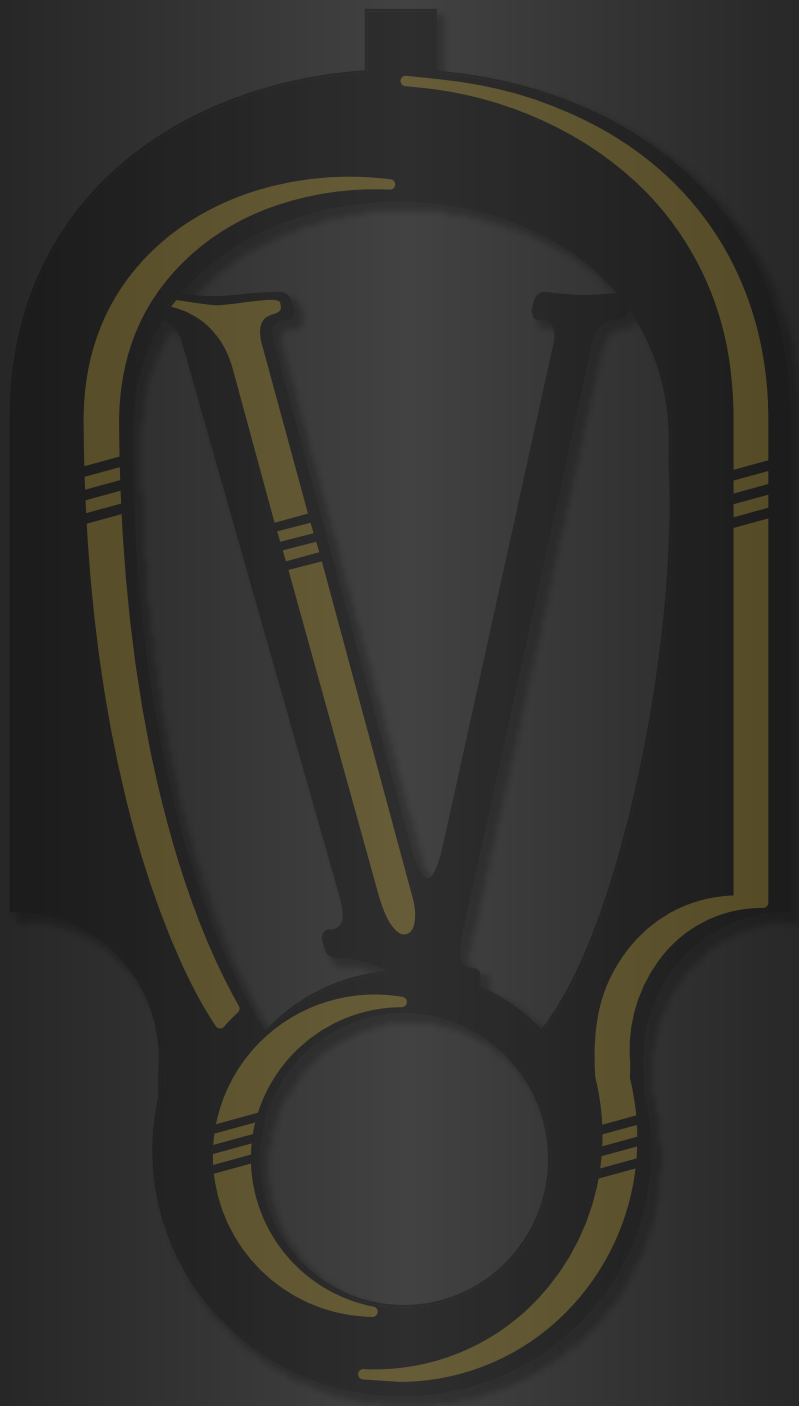
Volkman Precision, LLC. will not be liable for any loss or damage arising from the use of this firearm, whether direct, indirect, consequential, or punitive. Under no circumstances shall we be responsible for incidental or consequential damages with under this Limited Warranty with respect to economic loss or injury to property or personal injury or death to others, whether as a result of express or implied warranty, negligence or otherwise.

DO NOT SHIP OR OTHERWISE RETURN THE FIREARM TO US UNTIL YOU HAVE RECEIVED AUTHORIZATION FROM US AND SPECIFIC INSTRUCTIONS CONCERNING THE SHIPMENT OF A FIREARM TO US FOR WARRANTY EVALUATION. No shipment will be accepted without Authorization and no shipment will be accepted C.O.D. All freight must be pre-paid by you. **NOTICE:** It is illegal to ship a firearm with ammunition in the firearm or in the same packaging. Firearms and ammunition must be shipped separately.

For any questions or concerns about the information in this owner’s manual, visit:

VOLKMAN PRECISION, LLC.
WWW.VOLKMANPRECISION.COM

NOTES



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