

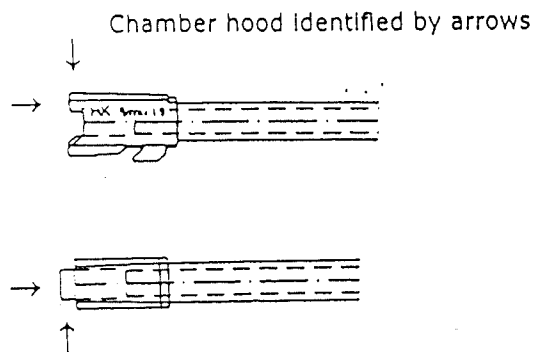
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O RING BARREL

INSTALLATION INSTRUCTIONS

PLEASE READ AND FAMILIARIZE
YOURSELF WITH THIS BOOKLET
BEFORE INSTALLING BARREL

One in 12 pistols, the tail end of the chamber hood will need to be shortened between .002 - .003" and possibly need polishing on the chamber hood's sides as well. If your barrel is a tight fit, do not panic - it is simply a reflection of the fact that your slide is on the tight side of tolerances. Arrows (Fig. 1) indicate where to polish if barrel was tight.



In the event yours is a tight fit, take a marker pen, blacken the tail end and sides of the chamber hood, re-install and then remove. Look for where white metal is showing - i.e., where the marker ink has been rubbed off. That is where you will polish it. Using a medium arkansas stone, polish only the sides of the hood that showed the rub marks on the ink stained surfaces.

Use LIGHT STROKES POLISHING WITH THAT STONE - you can easily remove .002 to .003" in very little time - don't

be in a hurry. Remember, the snugger the fit, the more accurate your pistol will print. Polish the hood some, then redarken with the marker pen and refit & remove. If still a tight fit, polish again. Once you are able to install the barrel's chamber hood into the breech face smoothly, then polish those same surfaces lightly with a fine grit stone.

On the slide opening, we suggest you inspect the inside edge of your pistol's slide opening - i.e., the edge that will rub against the barrel & O ring to insure there are no burrs (even microscopic burrs). If you are installing your barrel into a Glock pistol or your HK slide's inside edge shows machine marks, skip ahead to page 4. When the slide opening edges appear smooth, we still recommend checking for burrs. Easiest way is to take a Q tip (the kind you use to clean your ears) and wipe real light inside the entire edge. If there is a burr, it will catch and hold a strand of the cotton. Any burr will cut the O ring and cause failure. If there is a slight burr, wipe real lightly with a round stone or ceramic stick or sand lightly with some 800 grit wet/dry paper; then with 800 paper and finally some 1000 paper. Have only had one in about 200 barrels sold that a slide had a burr but it doesn't hurt to check.

In the event an O ring breaks while at the range, do not continue to fire your pistol without an O ring on the barrel as this will damage both the barrel and slide permanently. *see instructions in rear of this booklet for installing new O ring.

If you follow some simple precautions, the O ring will last 20,000 + rounds (that is HK Oberndorf's claim and we now accept it as I have over 16,000 rounds on a single O ring).

SOME SIMPLE PRECAUTIONS AND INSTRUCTIONS FOR CLEANING

1st - when you clean gun, do not remove the O ring - as the only way to get it out is by using a pin or needle you will nick it - nick it and it is like sheet rock - it will break wherever it is nicked. The O ring is made of a synthetic that is impervious to any gun cleaning solution you might reasonably be expected to put on the pistol, so there is no reason to remove it for cleaning.

2nd - after cleaning gun and just before re-assembly, put a single drop of a thin gun oil on the O ring. Remember, as the slide opening rides over the O ring, it is compressing the O ring down into the groove on the barrel. If the O ring is dry, when the slide travels rearward on the next shot, the O ring will try to get traction and roll with the slide - as it is captured in the groove it cannot roll, so it will simply shear in five or six places simultaneously around the barrel.

When HK first came out with the MK23 and Tactical 45 with the O ring system, O rings were breaking because of the first two precautions being violated.

3

Wrap the sand paper around the plastic conduit to give ourselves approx a 2.5 inch long sanding area on the conduit.

Then slip the slide over the plastic conduit, putting the end of the conduit thru the front slide opening. We set our machine to a slow turning speed. Move the slide up and down the turning plastic conduit with only slight pressure - basically to sand the edges of the slide opening that will be rubbing against the rubber O ring.

Study the slide to know what surfaces will be rubbing against the barrel's O ring - at the top of the slide opening, only the front side of the bevel in the slide opening will be rubbing against the O ring as it approaches the O ring from behind when returning to full lockup or battery position. On the lower or bottom of the slide opening, both the front of the bevel and a slight area behind the bevel will be coming in contact with the O ring as the O ring will sit slightly behind the drop off when in full battery.

We do not try to sand the machine marks totally out - just to take the crests or high / rough spots of the machine marks off.

When finished, after cleaning the area you've just sanded, take some of the teflon grease (in the 35mm film cannister), heat the slide on a warming table to maybe 130 - 135 degrees fahrenheit, & rub the grease into the area you polished with the sand paper like you would rub shoe polish into shoe leather. Rub repeatedly, let cool, then wipe off excess.

You do not have to carry a can of oil with you to the range. I have fired my pistol over 600 rounds without lubricating (over a span of 30 days just to test that O ring's durability) and it is the O ring I now have over 16,000 rounds on.

INSTRUCTIONS FOR SLIDES SHOWING MACHINE MARKS ON THE OPENING'S EDGES

Inspect the edge of the front slide opening that will be rubbing against the barrel's O ring. Most Glock slides have some pretty serious machine marks left there on that very edge. If so, sand it starting with **600, going up to 1200 grit**. If your slide opening does not have machine marks, we still suggest sanding starting with 800, then 1000 and finishing with 1200 paper as we have had slides with microscopic burrs that will still nick the O ring. If nicked, it will break. Think of the O ring as being just like sheet rock, wherever it is nicked is where it will break - the load path of the compression & torsional forces acting on the O ring will focus at that nick instead of flowing past it.

An easy item to use as a sanding mandrel is a 1/2" piece of plastic conduit, wrapping the sand paper around the plastic conduit. Cut a slot in one end of the conduit so you can pull a 2 - 2 & 1/2" strip of the sand paper thru and then wrap it around the conduit 1 & 1/2 to 2 times. Then chuck the plastic conduit in a drill press.

4

That teflon is a temporary coating, but is an effective corrosion preventive as well offering dry lubrication. By the way, it was designed for use in the barrel's bore. If it will take the pressure and temperature inside the barrel, other surfaces in the pistol are a walk in the park.

When you re-assemble the barrel to the slide, one drop of oil on the O ring is required.

TIP FOR REPLACING O RINGS

In the event you find yourself replacing your O ring - do not try to stretch it and drag across the bare threads on the Tactical barrel. Take a piece of vinyl tape, starting on the smooth surface of the barrel, tape forward over the threads, down across the muzzle, back over the threads and onto the smooth surface of the barrel again. Then, after putting a drop of a thin gun oil in the groove, simply roll your O ring over the threaded area to the groove.

Then simply remove the tape.

Enjoy and be safe

5

6