

## **Combat NCO Ambi-Safety Installation Instructions**

### **Procedure of install by qualified gunsmith:**

1. **The hammer pin is rounded and long.** It protrudes from the frame and will hold the Right Ambi-Safety **off the surface** and prevent functioning. **File the Hammer pin flush**, add cold blue and replace hammer pin.
2. Test existing safety for hardness of movement. Remove old safety.
3. Install NCO left safety and rotate on and off safe. Check to see that it works in the fire and safe position. Remove the NCO safety and look at the Sear contact point for any drag on the Sear. If necessary adjust Safety ledge for slight or no contact.
4. Remove the Grips.
5. Next install the new NCO Sear pin. Tap out the old one with a punch leaving the punch in place.
6. Insert the new NCO Sear Pin from the left and push it thru until flush with the left side.
7. Place the Right Safety key way notch over the Sear Pin. Move the Right Safety up and down the keyway checking for resistance. If resistance is present remove the pin and remove material see Notes. It should move freely.
8. Position the Left Safety in the middle position or neutral position between On and Off safe. The Right Safety will now assemble onto the Left Safety Post and Sear Pin.
9. Insert the Safety screw by turning it counter clockwise until the threads align. Then screw down until finger tight. The Screw aids in tension adjustment for the two Safeties working together.
10. Adjust until both work when actuated by either lever to satisfaction.
11. Replace the Right Grip and check to insure travel of the safety. Remove any material that obstructs travel.
12. Replace both Grips and check for full function.

### **Note:**

All Safeties should be installed by a qualified gunsmith to insure firearm safeties work properly. It is recommended that **Loctite 248** stick be used on the threads. The screw can be removed and replaced but will not move from location in normal use. At home finger nail polish will work fine.

**1911 frames vary in thickness** which effects NCO Sear Pin exposure fit. Measure your frame first to save time. A .762" frame is standard and no adjustment has to be made. If a .752 frame is encountered the inner inside surface of the key way of the Sear Pin will have to remove 0.010" to compensate and likely the end of the pin as well. If .772 thick likely the inside outer Sear Pin surface reduced by as much.

The **Combat NCO** patented Safeties are the finest of their type and will last a lifetime. American made of the finest material and hardened to RC45 from solid billet S7 tool steel. Thank YOU for using **Combat NCO™** parts and components.

Karl Lippard