

NosePiece Compensator T1 Install & Removal

Patent US 8,132,352

The Manual should help you on page 12 obtainable online at:

www.karlippard.com/military.

First let us communicate some simple facts. 1911 pistols are NOT precision firearms. They are loose in order to function. But having examined many hundreds of 1911's we have discovered that barrels are often not cut square in the frame. This means the barrel in recoil is going through the barrel bushing sideways. Many guns we have seen have the barrel bushings cut on an angle for the gun to fire and cycle. You install a NCO Comp on one of these guns and it will bind and break. However, when a pistol is in for A2 Upgrade the barrel link modification centers the barrel and corrects problems of the past.

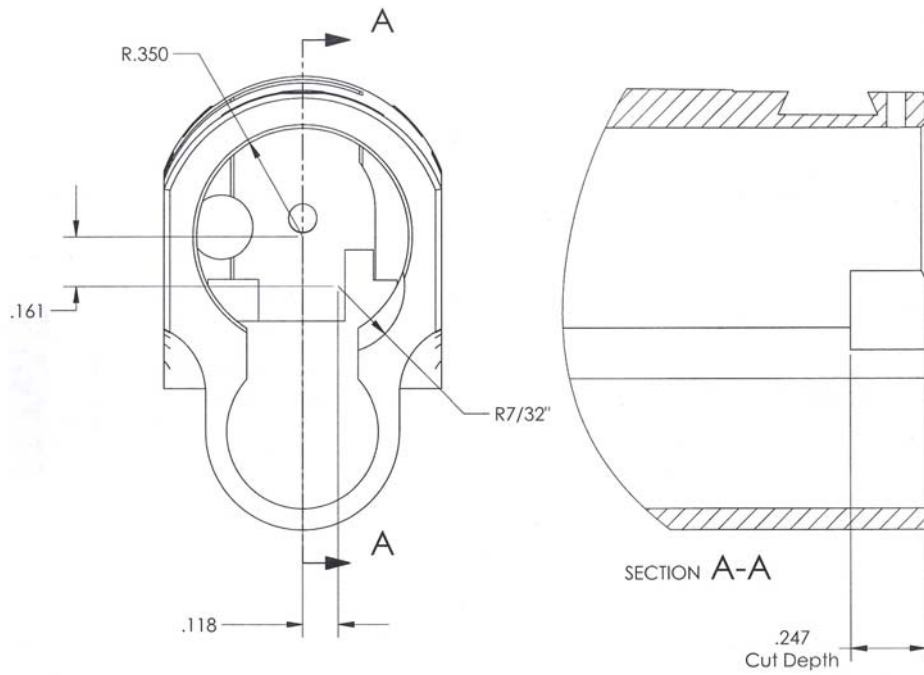
This brings us to barrels.

Some barrels have a straight wall and others have many variations of a collar. You can feel it with your hand when inspected. The collar is a good thing provided it has a cone shape at the bottom. This allows the barrel to be guided home after cycling and smooth entry into the bushing. If the shoulder is abrupt then in closing the barrel will slam against the bushing causing failure and breakage.

For these reasons and our inability to see your pistol in advance of use, we limit the warranty of the NCO part to refund if it should break and not replacement. You cannot BREAK a comp unless something is wrong with your pistol. If it breaks once it will break again.

New T1 Compensator:

The T1 or Tactical One is a more robust example of its predecessor used for standard 1911 .45 acp 820 fps ammunition. Today with more modern cartridges the recoil has been increased in common 1911 pistols to over 100%. Use of a weighted distribution device can cause long term problems from inertia if firing to the added slamming of the slide in return to battery. To avoid this, connection foot has been enlarged by 100% in connection width. All available height of the connection foot has been added to increase purchase inside the Slide cut recess. Accordingly, T1's must have a Slide modification to allow for the increased connection size of the New +P Compensator. See fig. machine cut diagram.



**Gunsmith Slide Modification for T1 Nosepiece
Scale 3:1**

Fig. 1 Machine cut diagram



Note the T-1 connection lug on the right compared to one on a 1911 left

Slide Modification bench install:

1. Insert the T1 Comp into the slide.
2. Note the location of the Comp foot.
3. Turn the Comp counterclockwise until the foot is just inside the left side of the Slide wall.
4. Now take a scribe or razor blade and mark around the out side of the foot that is resting on the Slide.
5. Remove the NosePiece Comp.
6. Held in a padded vice lay the Slide on its left side. **See fig. 1.**
7. With a 3/8 grinding stone grind the inside of the slide cutting down carefully to the scribed line made. Be careful not to cut down too far.
8. Grind further inside back from the outside edge. **See fig. 2.**
9. Insert the Comp to inspect the fit.
10. Tap the Comp in until it will rotate smoothly into position
11. Cold blue or leave bare.
12. Modification is complete.



Fig. 1



Fig.2

The T1 modification does not affect the use of original parts. It does allow for more modern barrel bushings and accessories. The added pressure on the plug has become more than double. Older barrel bushings and comps are subject to breakage as a result.

Removal

Basically you put a 5.56mm round, a pencil or dowel round object in the smaller access hole at the bottom of the Comp. Depress the Plug inside about 3/8" to free it from the Comp collision. Once the Plug is below the Comp connection foot it allows for free rotation of the foot over the top of the plug.

Rotate the Comp carefully **counter clockwise** to about 3 o'clock. Gently pull it out being careful; the plug and spring behind it are under pressure and can fly out! Wiggle it and slightly turn left and right if tight. Once out turn the Comp 90 degrees and slide it back on the barrel under no tension to align the barrel for further disassembly. Slide the Slide to the Slide Stop Notch, and remove the Slide Stop pin. Turn the pistol upside down. On a towel or pad, tap the top of the Slide on a table or work bench gently to drop the link down and slide the Frame rearward to remove. Continue disassembly normally. See Note if difficult to remove.

To assemble, reverse the procedure.

Internally there are lubrication grooves.

Use Nickel Anti-seize to lubricate or heavy grease. Close tolerances require lubrication here to keep the barrel from binding. Diameter of the barrel should be from .579 to .580". If you have a larger diameter your barrel may bind. Use an NCO™ barrel with a collar for tighter grouping but under no condition use a collared barrel with a bushing contact surface of more than 0.200 inches length measure from the barrel muzzle. Breakage can occur of the Compensator or Slide itself.



If you have a current Para Ordinance barrel with collar likely it will have to be modified. The collar measured here was 0.360" and would break the Compensator. A sloppy gun can have the same effect. Therefore if a question exists ask your Gunsmith or Karl Lippard Designs for assistance. We warrant our parts to be made to Mil-Spec and cannot warrant parts made by others. Further we **do not** advocate the use of any rounds in a 1911 type pistol other than the 820 fps the gun was designed for. **+P rounds are dangerous** if used in a 1911 mil spec barrel. +P use requires a barrel and recoil spring change to a 20 lb. Standard 1911 spring is 13.5 lbs.

Note: Removal may be difficult even with the NosePiece rotated into position. The Locking foot sets deeper into the Slide recess for greater purchase and support. In disassembly with a live 5.56mm if military or something like a Pachmayr Widget tool, depress the plug 1/4" down while rotating the NosePiece to the disassemble position

counter clockwise to 3 o'clock. The NosePiece locking foot will ride over the plug and no longer bind. Rock the NosePiece back and forth pulling to remove being cautious the Plug is under spring tension and eye protection is advised.

Shape of the Comp: The Nosepiece is sloped down and in some cases sets down below the Slide for a reason. Combat NCO pistols are 400 yard accurate guns and one must see over the NosePiece to shoot at distant targets. The 2 degree slope is intentional and normal. Also because profiles of the 35 clones and models out there, an exact line match is impossible.

Warranty: NosePieces are warranted. Comps may be attached to guns that may have binding issues, alignment problems of barrel in the frame or barrels not of a mil-spec design. We are not responsible for any damage to the gun if or NosePiece Comp is used. If damaged or broken the NosePiece will be refunded. It will NOT re-placed. This warranty is extended to the original owner only with proof of purchase.

Karl Lippard Designs