

Instructions for Use

HD-803 Extractor Slot Cutting Fixture

1) If you have intentions of replacing the firing pin stop, do it before you set up your new extractor. Once the new FPS is fitted to the slide, use gauge pins in the rear of the extractor tunnel to measure the dimension from the RH edge of the FPS to the opposite side of the extractor tunnel. (Ref. Photograph A) I usually find this to be in the range of .164" to .167". Record your dimension "A".



2) Measure the diameter of head of the new extractor just forward of the flat. You should see something around .270" - .272". (Ref. Photograph B) Record your dimension "B". Subtract A from B and this will give you the depth that you'll machine your new slot to.



3) Remove the FPS from the slide and measure the thickness of the RH "rail". It's usually around .099" - .100" thick. Record your dimension.

4) Measure the length of your slide's "breach block" (taken from the breach face back to the rear face where the FPS slot is located) and record this dimension "C". (Ref. Photograph C)



5) Take the measurement from the underside of the slide using accurate calipers and put the tips of the calipers in at a point about even, top to bottom, with the firing pin port and extractor tunnel. The dimension will be something over 2.160"

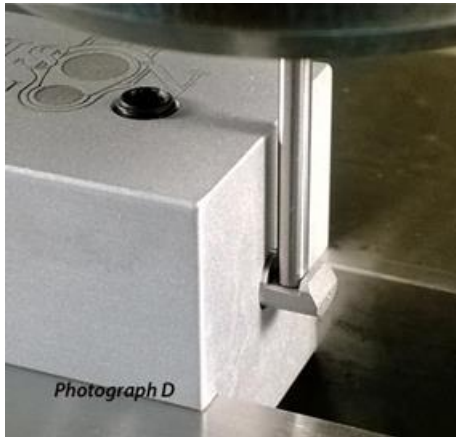
7) Add "C" to the distance that you want the extractor claw to be set forward of the breech face. On .45 ACP pistols, .070" - .075" works well. I have been adding an additional .010" to this because the extractor typically has a slight arc to it and the claw face is often machined at a slight angle. (I've found that without this, I am usually short by .010"-ish when measuring the finished result) The result - "D" is the distance that you want to locate the front edge of the new FPS slot, back from the extractor claw. So $"C" + .070-.075" + .010" = "D"$

8) Back out the set screws and insert the new extractor into the HD-803 Fixture with the claw facing upwards and the claw all the way through the fixture until the edge of the fitting pad is slightly past even with the end of the fixture. Finger tighten the set screws against the extractor, then snug down the top screws with a hex key. Hold the fixture in the vise jaws on your mill. Install a 3/32" collet with a .094" gauge pin.

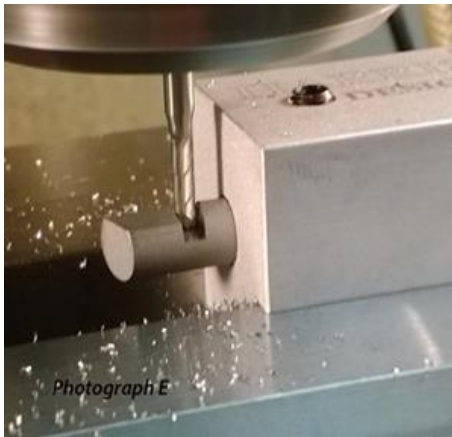
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HD-803 Extractor Slot Cutting Fixture (cont'd)

9) Move the table until the .094" gauge pin is above the claw and use it and a slip of thin paper to locate the edge of the claw. (Ref. Photograph D)



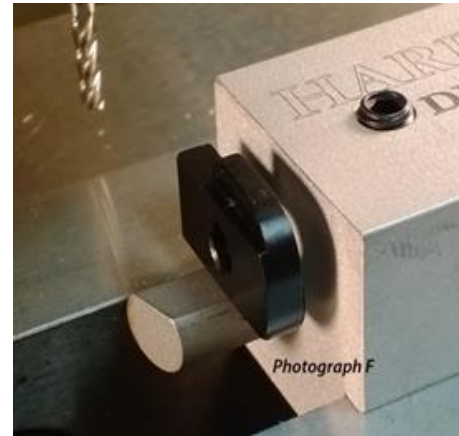
10) Zero your dial or DRO and travel the distance calculated in "D" above to the opposite end of the fixture. Remove the gauge pin and replace it with a 3/32" (.094") end mill. (Ref. Photograph E)



11) Bring your quill down to touch off on the extractor and zero your "Z" axis. For reference, your end mill should be just at the area where the extractor head goes from being round to having the flat on one side. Machine your slot to the depth calculated above in "B" – "A". That depth will probably be something over .100", so step that in passes that you are comfortable your end mill will handle. I cut .025" passes myself.

12) Once the slot is to full depth, you'll need to measure it and probably widen it to match the "rail" width of your FPS, so you'll need to step

over as necessary and make another pass. Test fit with the FPS or gauge pins. (Ref. Photograph F)



13) Clean up slot cut, do any shaping or ramping that you normally do to the area around the claw, adjust the fitting pad if needed, set

the tension and trim down the rear end flush with the heel of the slide. Photograph G shows the desired relationship between the case rim, breech face and extractor claw. Done in this manner, the extractor claw typically does not need any removal of material on the front face, leaving it as strong as possible.

