

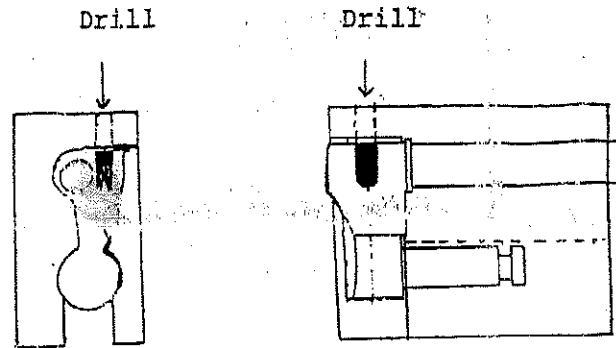
# Grand Masters, L.L.C.

D.B.A. as Power Custom

29739 Hwy. J • Gravois Mills, MO 65037

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**Smith & Wesson® Crane Ball Drilling Fixture**  
(Designed for K, L, and N Frame Models)



## INSTRUCTIONS:

Place the revolver yoke in the fixture as illustrated above. It is best to use a drill press and easier if the fixture is placed in small portable vise. Use a #30 drill. Hold the yoke in the fixture and slide it under the drill. Run the drill down to the yoke and adjust the stop to drill the hole .250 inch deep. After drilling the hole, Remove the yoke and place it in a small vise with the bottom of yoke down on the bottom of the vice. (recommend 2 1/2 inch vise) pad the vise jaws with paper so you will not mark the yoke finish. Put the crane ball spring in the hole and place the 1/8" ball on top of the spring. Push the ball down to be sure the ball will depress even with the top of the yoke. You are now ready to stake the ball in the yoke. Use the crane ball punch. Note the hole in the center of the punch. This is so it will be centered on the ball and hole. With care, tap the punch lightly with a small hammer. Stake the ball only just enough to hold it in the yoke. Once the proper staking job is completed; replace the yoke in the frame. With the yoke open, apply a coat of layout marking fluid recommend blue Dykem) on the inside of the frame (on the area where the crane ball locks in the frame). After allowing time for the Dykem to dry, close and open the yoke. Note the marked line the crane ball left on the frame. Next, use a 1/8" Dremel Carbide Cutter, No. 9903 grind a small ball seat, with the center of the ball seat approximately .010" to .020" from the end of the mark. The ball seat is located so the spring loaded ball is used to cam the yoke closed.

*Old World Craftsmanship Coupled With Modern  
Technology and Design Produces The Finest*

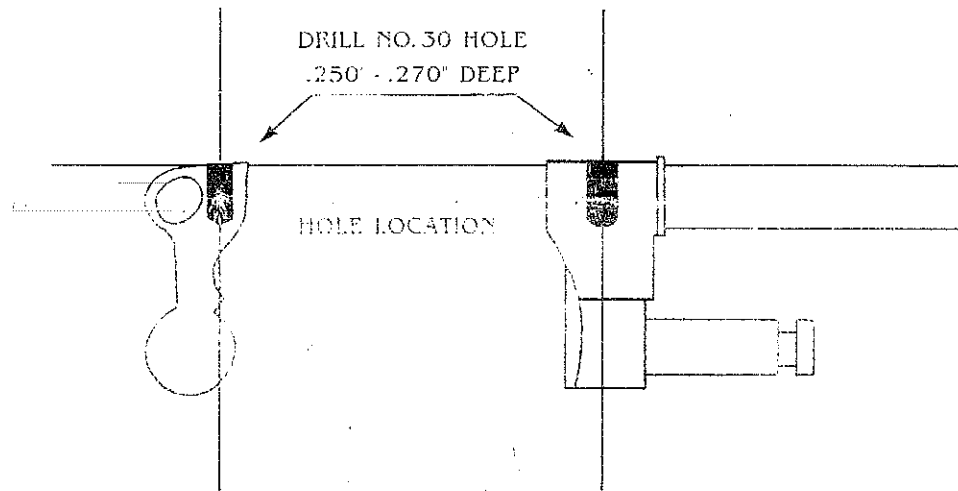
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## STAINLESS STEEL CRANE BALLS .125 DIAMETER WITH SPRINGS



### INSTRUCTIONS:

Locate proper spot on top of the yoke to drill hole for the crane ball & spring. Location should be approximately in the center of the yoke located between the edge of the extractor rod hole and the outside edge of the yoke. Mark the location with center punch. With the yoke straight up and down, drill No.30 hole to depth of .250" - .270".

**CAUTION:** DO NOT drill too deep or drill in location where you may drill into edge of extractor rod hole or out the side of the yoke.

Next, place the spring in the hole, place the stainless steel ball on top of the spring, use punch with end diameter .156" - .160" to stake ball in with. Be sure not to stake too much or the ball won't come up enough to operate properly.

**NOTE:** A hollow ground punch works best as it will align with the center of the ball and the staking will be even around the edge of the hole.

Once the proper staking job is completed, replace the yoke in the frame. With the yoke open, apply a coat of Dykem Layout Fluid (available from Brownell's) on the inside of the frame (on the area where the crane ball locks in the frame). After allowing time for Dykem to dry, close and open the yoke. Note the marked line the crane ball made on the inside of the frame. Next, use center punch to make small indent at the end of the marked line. With a 1/8" Dremel Carbide Cutter No.9903, grind a small ball seat at the end of the mark. The ball seat is located so the spring loaded ball is used to cam the yoke closed.

Kit No. 713-035-000 ..... 20 Crane Balls, 20 Springs with Punch

Refill Kit No. 713-035-001 ..... 10 each Crane Balls & 10 Springs



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