

Grand Masters, L.L.C.

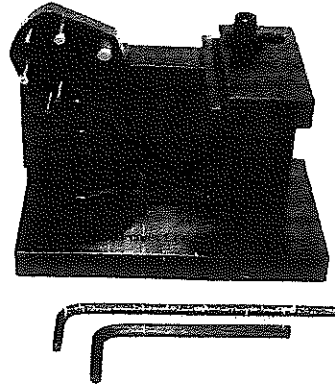
D.B.A. Power Custom

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2nd Generation Series II Stoning Fixture



(Shown with the Series II Universal Adapter)

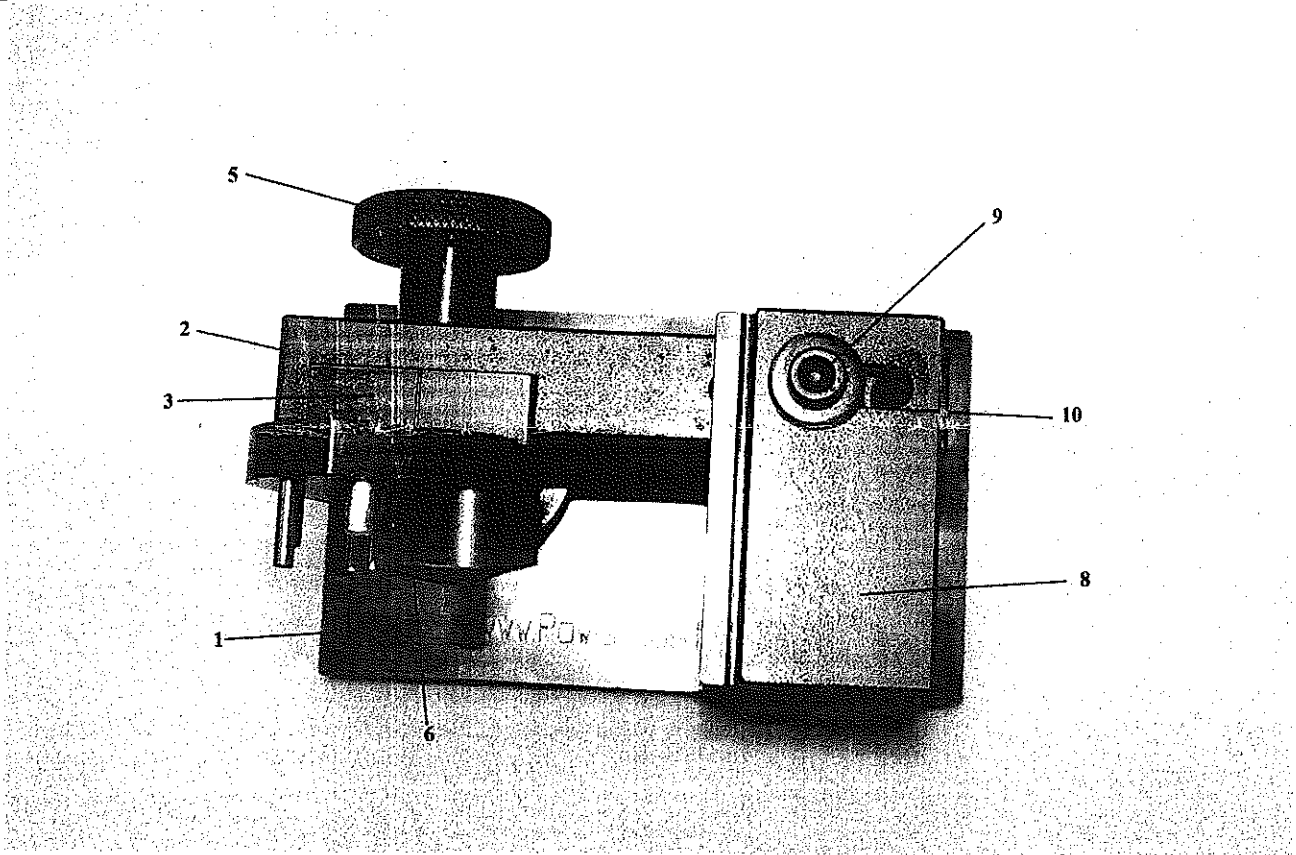
1. This fixture is designed to start with the elevator up 20 clicks. To do this,
 - a. Loosen the elevator lock knob (5) 1/8th of a turn,
 - b. Rotate elevation click wheel (4) counter clock-wise all of the way down.
 - c. Now rotate the elevator click wheel (4) clock wise and count up 20 clicks.
 - d. Now lock the elevator lock knob (5) by tightening it clock wise with 5/32" Ball End Allen wrench in retainer screw (6) socket.
2. Adapter Installation
 - a. Screw the selected adapter on the elevator (3) with the 5/32 Ball End Allen Wrench from the rear side through the elevator slot.
 - b. Line up the "H" or "S" mark on back of adapter with the center line mark on the elevator.
 - c. Tighten with Allen wrench. (7)
 - d. See the instructions with each adapter.
 - e. The "H" mark is for the hammer, and the "S" mark is for the sear.
 - f. This is only the approximate location.
 - g. Using a Power Custom Triangle Stone Holder with Stone or 1 1/4" wide stone, place hammer or Series II 1/14" wide stone, place hammer or sear as shown on the adapter illustration.
 - h. Coat the engagement surface with Dykem layout fluid or similar layout or high point marking fluid or marker.
 - i. Place stone on engagement surface and on stoning guide groove (8).
 - j. With a 3/16" Allen wrench, loosen guide lock screw (9), and adjust stone guide up against stone with just enough clearance to allow the cross way movement of the stone.
 - k. Tighten the lock screw (9).
 - l. With one short stroke of the stone, see if all of the marking fluid is removed from the engagement surface.
 - m. If not, re-adjust by rotating the adapter a few degrees. This is accomplished by loosening the retaining screw (6) with the 5/32 Allen wrench and making the small adjustment of the adapter in the required direction. The retaining screw can be accessed from the rear side through the elevator slot.
 - n. The stone guide will then need to be adjusted.
 - o. Remark the engagement surface with the layout fluid and check to make sure that you start with the correct factory angle as an exact starting point.

- p. Note: It is important to start at this exact reference point.
- q. After the exact reference point is established and the adapter is tightened by the retainer screw (6), you are now ready to stone the hammer/sear.
- r. Follow the instructions for each adapter.
- s. Be sure that the sear/hammer is in the proper location before holding it against the stop. A machinist clamp maybe used (not supplied).
- t. Now, you are ready to stone the engagement surface.

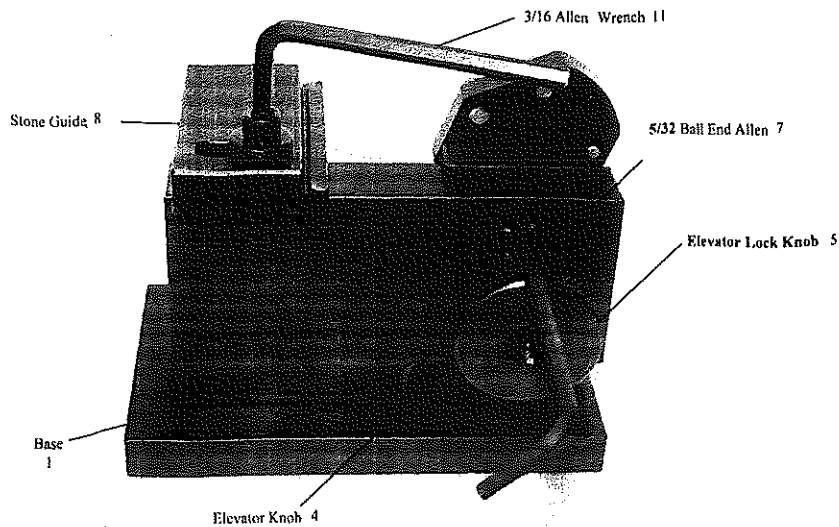
3. Stoning the engagement surface

- a. Make about 1 1/2" strokes holding the stone against the guide grooves and letting the sharp edge of the stone float on the engagement surface.
- b. It is best to prep the hammer first and just clean up the factory angle, unless you are getting "hammer cam to the rear" or "push off". If either of these things happen, adjustment of the engagement surface has to be made.
- c. Just remember, raising the elevator lightens the pull and lowering it increases the pull.
- d. After the hammer has been prepped, it is usually best to adjust the pull by alternating the sear engagement surfaces.
- e. Be sure to completely read and understand the instructions with each adapter.
- f. Keep good sharp and clean stones and start with the factory angle as an exact reference point.
- g. It is the Gunsmith's responsibility to possess the knowledge and skill to produce a safe, good action job.
- h. If you have any problems or suggestions for improvement, call me at the above listed phone number.

4. Top View



5. Front View



6. Parts List

Part Number	Name of Part
1	Base
2	Back - with fixture upright
3	Elevator
4	Elevator Click Wheel - 8 clicks per full revolution
5	Elevator Lock Knob
6	Retainer Screw - 1/4-20 x 3/4 Flat Head
7	Retainer Screw Allen Wrench - Ball End
8	Stone Guide with hardened groove
9	Stone Guide Lock Screw - 1/4-20 x 1
10	Stone Guide Lock Screw Washer - 1/4
11	3/16 Allen Wrench for Stone Guide Lock Screw

Adapters Available for the following Firearm Models:

B-92, M-16, AR-15, P-89, P-226, P-9, M-14 (M1A), Universal, M-1 Carbine, Mini 14 & 30

Notes:

1. Adapters for many more models will follow in the future.
2. The Series II Stoning Fixture is designed to alter the angle of the engagement surfaces that have inside angles like on the Beretta 92 sears that have an extension of the sear above the engagement surface on the sear face. These types of sears can not be altered by the Series I Stoning Fixture. These types of engagement surfaces have to be altered from the sides. When properly used, the Series II Fixture will change these angles in precise increments. The Series II Stoning Fixture is added to the tool line, not a replacement for the Universal Stoning Fixture, which we now list as the Series I Fixture. Both of these fixtures will assist the professional gunsmith to do a professional, repeatable alteration to nearly all popular models and designs of firearm actions.
3. Also available are Hammer and Sear bench blocks for each of the firearms that the Series II Stoning Fixture Adapters are designed. These are made of steel, with precision locations for the hammer and sear pivot pins. These Hammer and Sear Bench Blocks can also be used as a pin punch block for the corresponding model firearm.

