

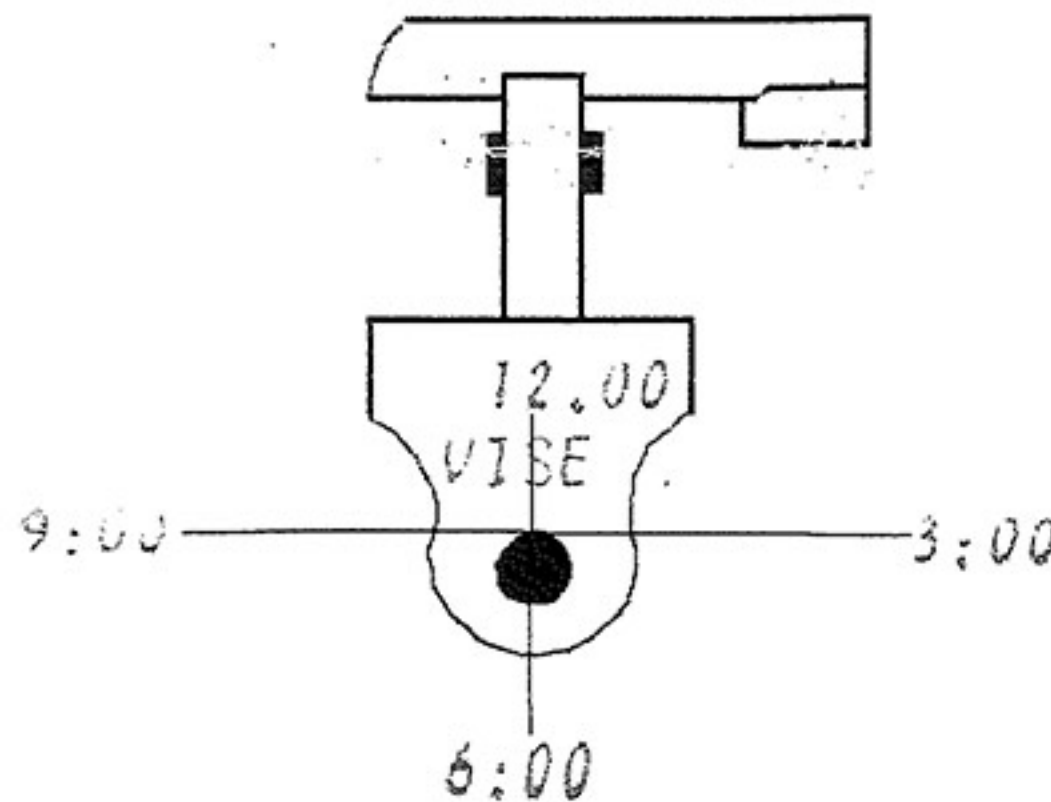


Hower Custom Inc.

Slide Rail Compound Clamp & Slide Rail Spreaders Instructions

The slide Rail Compound Clamp and the Slide Rail Spreaders are used in conjunction with a heavy duty bench vise. Open the vise jaws enough to place the lower feet of the slide clamp or spreaders in the middle of the vise jaws. The area of the slide that needs to be "sprung in" is placed in the upper steps of the compound clamp. Note - There are two machined steps at the squeeze area of the compound clamp. The first step at the top of the clamp is both the same length. These apply even amounts of pressure on both sides of the slide at the same time. On some slides, one side may spring in or bend in more than the other side. When this occurs, it is necessary to use the second step. Note - The second step, one has a longer bearing surface. This surface gives more support to the slide, and the opposite step gives less pressure. The slide then usually springs or bends in on the side that has less support. Note - When tightening the vise handle, it is easy to over do it, and break the slide. Extreme pressure on the vise handle will easily cause damage to the slid when using either of these tools. It is best to measure the slide as it is being adjusted, and only move the vise handle in small increments. Most Gunsmiths use the "Clock" method when making squeeze adjustments when using a vise. Imagine dividing one complete rotation of the vise handle into the hours of a clock face. With 12 o'clock being straight up. When tightening the vise handle to about the right amount of pressure to spring the slide in or out, stop the handle, and imagine what hour the handle stops at. Loosen the vise handle, remove the slide, and measure the amount of metal movement (use dial calipers). Say that you only want just a few thousands more movement, place the slide in the clamp or spreader tool and tighten the handle only one half to one full hour of movement on the vise handle. Example - If the vise handle stopped at the 3 o'clock, only tighten to 3:30 or 4 o'clock. Do not move the vise handle 2 or 3 hours at a time, or you will break the slide.

It must be understood that slides are of different types of steel and hardness. Some slides are soft and bend easily, while others are glass hard and are hard to spring in without them cracking and breaking. Therefore it is necessary to use extreme caution when using these tools.



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