



Express Sight Alignment



INSTALLATION VIDEOS
AVAILABLE @
WWW.XSSIGHTS.COM

The full circle of the Dot front sight is visible and centered over the shallow V and the vertical bar of the Express rear sight.

Express Sight Picture



Close Range - 15 yards and in
Point of Impact - Within the Dot

Get a quick hit at normal defensive ranges by placing the full front Dot on the intended point of impact.



Extended Range - 25 yards and out
Point of Impact - Top of the Dot

Allows for precise shot placement beyond normal defensive ranges.



2401 Ludelle St. • Fort Worth, TX, 76105 USA
1-888-744-4880 • www.xssights.com



Precision Machined Gunsights

"Gunsmith Installation Only."



S&W J-Frame Instructions

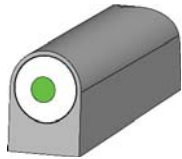
Form# SW-JF121409



Installation Components

Included

Front Sight



Walrus



**Gunsmith
Tips!**

Need to Grab

Putty Epoxy
(J-B WELD)



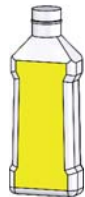
File



Cold Blue



Alcohol



Q-tips
(5-10)



Always wear eye protection when using tools.



**Problems? Call us first! We'll try to help you the fastest.
XS® Tech Support: (888) 744-4880 • 8:30 AM - 5:00 PM CT**



WARNING!

Gunsmith Installation Only

“Customers should be fully aware that installation of this sight requires milling off the original factory front sight from the barrel. Returning a pistol to the original condition will require installation of a whole new barrel at the factory.”

YOU'RE DONE! ENJOY!!

XS Sight Systems Limited Lifetime Warranty

XS Sight Systems, Inc. (herein after XS) products (excluding tritium) are warranted to be free from defects in material and workmanship during normal use. There are no implied warranties. Upon return (prepaid) to XS, XS will - at it's option - repair or replace any defective products. XS shall not be liable for any loss - direct, indirect, or consequential - arising from your use or inability to use, any of its products. This warranty gives you specific legal rights, and you may have other rights that vary from state to state.

XS warrants full replacement against breakage of its tritium lamps for 10 years; and between 10 and 15 years, XS offers replacement for 50% of the then current tritium sight cost. This warranty does not cover damages deemed from abnormal, abusive, or improper use, including any fault resulting from an accident or improper service. Remember that tritium naturally decays, but can be expected to have a useful “service” life of at least 10 years.

Tritium is regulated by the Nuclear Regulatory Commission and sights containing tritium may not be disassembled by anyone other than NRC licensees. For any non warranty claim other than defects or tritium lamp breakage, please return your product to the place of purchase, along with your receipt. When returning products to XS remember to insure the package and include a copy of your receipt.

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6 Check Fit, File as Necessary



“With a small file, cut away the corners of the stub until the new front sight will sit down leaving little to no minimal gap between the bottom of the sight and top of rib.”

7 Deburr All Edges & Cold Blue



1. *Deburr all edges*
2. *Cold blue any surfaces requiring finish*
3. *Clean all surfaces of stub & XS® Sight bottom in preparation of gluing sight over stub.*

8 Install Sight with Putty Epoxy



1. *Mix a small amount of a putty epoxy like (J-B Weld)*
2. *Apply to bottom of sight.*
3. *Press sight down over stub.*
4. *Wipe off excess putty with clean Q-tips.*

9 Check Alignment & Let Cure.



1. *Double check to ensure sight is straight.*
2. *Set aside for 5 hours for epoxy to cure before shooting.*



Gun Model Info

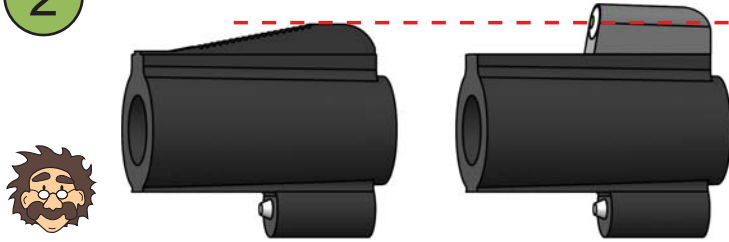
“This sight is designed to be installed on the current series (1985+) of S&W “J” frame revolvers which have a front sight width of 0.100” or wider. While it is possible to install on the older thin blade front sights, much care must be taken so for front sight to be installed straight. Barrels for these older models may not be available from the factory.”

1

UNLOAD FIREARM!
REMOVE ALL AMMO FROM ROOM



2 Installation Intent (only Barrel shown)



“When the sight is installed according to these directions, the center of the tritium dot will be at the same height as the top of the original front sight.”

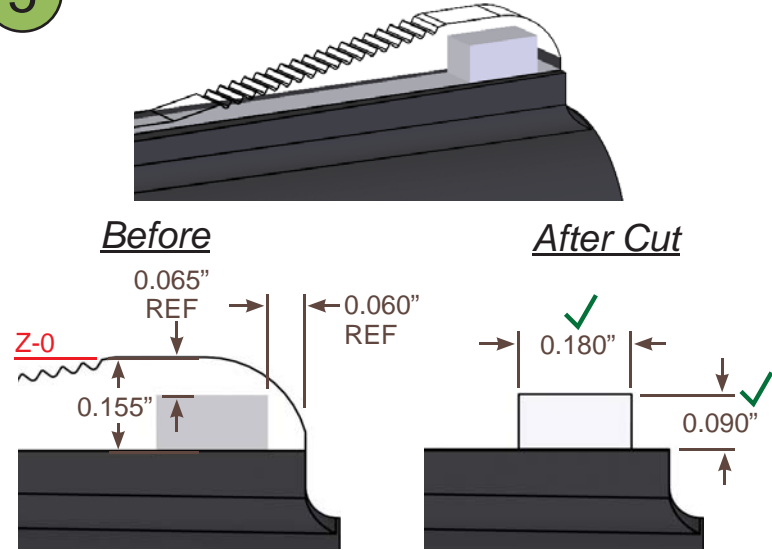
3 Disassemble Pistol

1. Disassemble pistol to remove grips and cylinder.
2. Remove side plate and internal parts.
3. Press side plate back onto frame and tap it down until it is back flush with the frame.
4. Do not install the side plate screws.

4 Prep for Machining

1. Chuck frame into mill vise and level across top of frame.
2. Install a sharp, carbide end mill (\varnothing 0.250"-0.375") into the mill.

5 Machine Stub from Original Front Sight



1. Bring the end mill down until you touch off on the top of the original front sight and zero your "Z"
2. Cut down the top of the front sight down until it is 0.065" below the initial zero.
3. Come down another 0.090" (0.155" from initial zero) and bring tool around until it just touches the front of the front sight blade. Cut the front sight back 0.060" and bring the tool out and around to cut away the back portion of the front right until you have a stub that is 0.180" long.
4. After milling you should be left with a small stub 0.180" long x 0.090" tall above the original rib. The front will be 0.060" back from the front edge of the rib.