SIG SAUER®



SIG P385® PISTOLS

OPERATOR'S MANUAL: HANDLING & SAFETY INSTRUCTIONS

READ THE INSTRUCTIONS AND WARNINGS IN THIS MANUAL CAREFULLY BEFORE USING THIS FIREARM.

WARNINGS

WARNING

BEFORE OPERATING THE FIREARM, REVIEW THE SAFETY WARNINGS MANUAL THAT WAS PROVIDED WITH THE FIREARM. ALTERNATIVELY, REFER TO SIGSAUER.COM FOR THE LATEST SAFETY WARNING INFORMATION.

For more information, scan the QR code below to visit sigsauer.com.

WARNINGS

SIG SAUER

1.0 SAFETY WARNINGS

READ THIS ENTIRE MANUAL THOROUGHLY AND CAREFULLY PRIOR TO USING THIS FIREARM.

The warnings in this operator's manual are extremely important. By understanding the dangers inherent in the use of any firearm, and by taking the precautions described in this manual, you can experience a high level of safety in the use of your firearm. Failure to heed any of these warnings may result in serious injury or death to you or others, as well as severe damage to the firearm or other property.

WARNINGS in this manual identify a clear danger to the person performing that procedure. Warnings are identified by a red banner with the word **WARNING** in white, bold, uppercase letters and a **WARNING** icon. Failure to comply with a **WARNING** can result in serious injury or death to you or a bystander.

WARNING

CAUTIONS in this manual identify a risk of damage to the firearm being maintained. **CAUTIONS** are identified by a black banner with the word **CAUTION** in white, bold, uppercase letters.

CAUTION

SIG SAUER INC.® ("SIG SAUER") firearms are designed to function reliably with proper care and knowledgeable use. Operators must understand the safe operation and use of any SIG SAUER firearm. Read and follow these instructions carefully. Do not use the firearm without understanding the instructions outlined in this manual and the safe operation of the firearm. **Failure to follow the instructions outlined in this manual may result in serious injury or death to the operator and/or others. Damage to the firearm and other property may also occur.**

WARNINGS

2.0 HANDLING

SAFETY MECHANISMS

MANUAL SAFETY

SIG SAUER OFFERS THE P385 WITH AND WITHOUT A MANUAL SAFETY. The important decision to purchase a Pistol with or without a manual safety rests with the purchaser and must take into account several factors, including the intended use of the firearm (e.g., law enforcement, defensive carry, home defense, range use, competition), level of firearms experience and training, frequency of practice, holster selection, and carry position. The internal safeties on the P385 are designed to prevent it from firing without the trigger being fully pulled. When the trigger is pulled or depressed, even unintentionally—whether by a finger or foreign object—the P385, like all firearms, will fire as designed. When engaged, a manual safety locks the trigger and prevents it from being accidentally or intentionally pulled, providing additional protection from unintentional discharge. However, an engaged manual safety will also prevent an operator from firing their pistol even when they need it to fire if the manual safety is not first disengaged.

SIG SAUER encourages those considering the purchase of a P385 firearm to carefully evaluate whether a firearm with or without a manual safety is the best choice for them. WITH OR WITHOUT A MANUAL SAFETY, IT IS THE OPERATOR'S DUTY TO PRACTICE SAFE FIREARM HANDLING.

WARNINGS

Firearms should always be treated as loaded and must be handled in a safe manner even if the firearm is equipped with a manual safety. A manual safety is designed to augment, not replace, safe firearm handling practices. You are responsible to protect against inadvertent trigger movement while carrying any firearm. Even if your firearm is equipped with a manual safety, you must ensure that the trigger is not contacted in any circumstance--whether by finger or an object--other than when you intend to discharge the firearm.

Utilizing an appropriate holster that protects the trigger when a firearm is being carried is of paramount importance, even for firearms that have a manual safety. Be advised, however, that holsters, while offering some degree of trigger protection, do not prevent all accidental discharges as it may be possible for a foreign object to get into the trigger area of a holstered firearm. This is particularly true for light-bearing holsters. EXTREME CAUTION SHOULD BE TAKEN WHEN HOLSTERING AND UNHOLSTERING A PISTOL TO ENSURE NOTHING WILL INTERFERE WITH THE TRIGGER. Pistol safeties, whether internal or external, should never be relied upon to excuse undisciplined handling of a firearm.

YOUR PISTOL IS INCAPABLE OF FIRING WITHOUT A ROUND IN THE CHAMBER AND LOADING A ROUND IN THE CHAMBER ONLY WHEN READY TO FIRE CAN PREVENT UNINTENDED DISCHARGES.

WARNINGS

BASIC RULES OF SAFE FIREARMS HANDLING

- ALWAYS treat every firearm as if it were loaded.
- ONLY load a round in the chamber when ready to fire.
- NEVER pull the trigger or place fingers on the trigger or in the trigger guard until ready to fire.
- NEVER allow clothing or other foreign objects to interfere or come in contact with the trigger.
- ALWAYS carry a pistol in a holster specifically designed for that pistol. It is the responsibility of the customer to ensure the holster is compatible with their specific pistol and any installed accessories.
- ALWAYS be sure the barrel is clear of any obstruction.
- ALWAYS be aware of the surroundings, and the safety of bystanders before shooting. Know the target and what is in front of and beyond it.
- ALWAYS use clean, dry, original factory-made ammunition of the proper type and caliber for the firearm.
- ALWAYS wear ear protection and safety glasses when shooting.

- ALWAYS carry a firearm so that control of the muzzle can be maintained in the event of a fall or stumble.
- NEVER shoot at a flat surface or water.
- DO NOT leave a loaded firearm unattended. Only store a firearm that is unloaded, cleared of all ammunition, and locked in a secure place inaccessible to children or unauthorized persons.
- NEVER allow the firearm to be used by anyone who has not read and understood the Operator's Manual.
- ALWAYS unload and clear a firearm according to the instructions in the Operator's Manual before handing it to another person.
- DO NOT point any firearm, loaded or unloaded, at any undesignated or unsafe target.
- NEVER discharge a firearm near an animal unless the animal is trained to accept the noise. An animal's startled reaction could injure it or cause an accident.
- NEVER drink alcoholic beverages or use drugs before or during shooting, as vision and judgment could be seriously impaired, making firearm handling unsafe.
- ALWAYS seek a doctor's advice before using a firearm if using medication that would impair judgment or usage.

WARNINGS

2.1 ABUSIVE HANDLING

SIG SAUER firearms incorporate effective mechanical safeties. However, like any mechanical device, exposure to abusive conditions may harm these safety mechanisms and cause them to fail to work as designed. Do not subject the SIG SAUER firearm to any abusive handling. This includes the firearm being dropped, impact to the firearm, or the firearm being struck by another object. Always maintain control of the firearm. If the firearm suffers an abusive event such as previously described, or experiences a malfunction, do not attempt to use the firearm. Keep the firearm pointed in a safe direction, unload and clear the firearm of all ammunition immediately, and have it inspected by a certified SIG SAUER armorer before using the firearm.

ALWAYS keep the firearm pointed in a safe direction. A safe direction is defined as an area where, if the firearm were to discharge, no property damage would occur, and no personal injury would result.

As previously noted, if the SIG SAUER firearm suffers an abusive event, unload it immediately and have it inspected by a certified SIG SAUER Armorer prior to using the firearm. If the firearm suffers an abusive event during a life-threatening/self-defense situation, follow the steps below immediately:

1. Pull the slide entirely rearward to eject the chambered cartridge.
2. Release the slide to chamber a new cartridge and reset the trigger mechanism. (Do not ride the slide forward.)
3. The firearm should now be returned to proper operational condition.

Intentional or repetitive abusive handling of any SIG SAUER firearm will void the manufacturer's warranty and could render the firearm unsafe.

3.0 ALTERATIONS AND REPLACEMENT PARTS

Do not attempt to disassemble a SIG SAUER firearm beyond the point explained in the Operator's Manual. Disassembly beyond the instructions in the Operator's Manual is restricted to a certified SIG SAUER Armorer. Failure to comply with these restrictions will void the warranty.

This SIG SAUER firearm was designed to function properly in its original condition. Unauthorized alterations can make it unsafe. Do not alter or substitute any parts or accessories not manufactured or specifically authorized by SIG SAUER for this firearm. Warnings and instructions about the use of SIG SAUER replacement parts, assemblies, and accessories may be described in instructions accompanying the specific products. Read and carefully follow those instructions. Failure to comply may result in serious injury or death to the operator and/or others. The use of aftermarket replacement parts is unauthorized and, in some instances, could alter the function of the firearm.

WARNINGS

3.1 ACCESSORIES

It is the responsibility of the operator to ensure all accessories are compatible with the firearm and do not interfere with the safe operation and handling of the firearm.

HOLSTERS

A properly designed holster should protect the trigger from being contacted inadvertently when the firearm is holstered.

- Ensure the holster is designed to accept the specific model of and accessories installed on the firearm. Holsters for firearms equipped with a tactical light typically have large openings to accommodate the bezel of the light, rendering the trigger area of the holstered firearm more accessible to foreign objects or fingers, particularly if a light is not installed or if the holster is not sized specifically for use with the light that is installed on the firearm. IF THERE IS A GAP IN YOUR HOLSTER, YOU MUST TAKE EXTREME CAUTION TO PREVENT FOREIGN OBJECTS, SUCH AS KEYS, ZIPPERS, STRINGS, etc., FROM GETTING INTO THE GAP AND CONTACTING THE TRIGGER.

- Ensure the holster will protect the pistol while seated in a vehicle from surrounding features or devices in the vehicle that could interfere with the safe carry of the pistol. For example, when entering and exiting the vehicle, the holster should prevent the seat belt latch from becoming snagged on the firearm or the holster.

Read and follow all warnings and instructions that are provided by the holster manufacturer before using. Failure to follow the instructions may result in serious injury or death to the operator and/or others.

3.2 TRANSPORTING

When transporting a firearm, be sure the firearm is unloaded and cleared of all ammunition. It is the responsibility of the operator to know the laws of different states when traveling with a firearm.

3.3 STORAGE

Safe and secure storage is an important responsibility. The only safe way to store a firearm is unloaded, cleared of all ammunition, and locked in a secure place inaccessible to children or unauthorized persons.

3.4 CHAMBER SAFETY FLAG

Every SIG SAUER firearm is shipped with a chamber safety flag. When installed, the chamber safety flag prevents the chambering of a round and provides a readily visible indication that the firearm's chamber is empty. The chamber safety flag is to be placed in the firearm's chamber at all times when the firearm is not in use. Many public ranges require chamber safety flags be installed when the firing line is cold.

WARNINGS

3.5 LIABILITY

PISTOLS and RIFLES are classified as FIREARMS and are sold by SIG SAUER with the specific understanding that SIG SAUER shall not be responsible in any manner whatsoever for malfunctioning of the firearm, physical injury, or property damage resulting in whole or in part from:

- Criminal or negligent discharge
- Improper, careless, or abusive handling
- Unauthorized modifications or parts replacement
- Defective, improper, hand-loaded, or reloaded ammunition
- Corrosion
- Neglect
- Other influences beyond our direct and immediate control

This limitation applies regardless of whether liability is asserted on the basis of contract, negligence, or strict liability (including any failure to warn). Under no circumstance shall SIG SAUER be liable for incidental or consequential damages such as loss of use of property, commercial loss, and loss of earnings or profits.

4.0 EYE AND EAR PROTECTION



Always wear safety glasses that meet the requirements of American National Standards Institute (ANSI) z87.1 or European Standard (EN)166:2001 and ear plugs and "earmuff" type protectors whenever shooting. Always make certain that persons close are similarly protected. Unprotected eyes may be injured by powder, gas, carbon residue, lubricant, metallic particles, or similar debris that may emanate occasionally from any firearm in normal use. Without ear protection, repeated exposure to shooting noise may lead to cumulative, permanent hearing loss.

5.0 AMMUNITION

Use only high-quality, original, factory-manufactured ammunition. Do not use cartridges that are dirty, wet, corroded, bent, or damaged. A damaged or deformed cartridge may impede chambering or cause the cartridge case to burst upon firing. Do not oil cartridges. Lubricant or other foreign matter on cartridges can potentially cause dangerous ammunition malfunctions. Some highly penetrative lubricants can also migrate inside cartridge cases and cause deterioration of the propellant powder; on firing, the powder might not ignite. If only the primer ignites, there is danger that the bullet may become lodged in the barrel. Only use ammunition of the caliber for which the firearm is chambered.

The proper caliber is permanently engraved on the firearm's barrel.

The use of reloaded, hand-loaded (re-manufactured), or other nonstandard ammunition voids all warranties. Reloading is a science, and improperly loaded ammunition can cause severe damage to the firearm and may result in serious injury or death to the operator and/or others.

Always use ammunition that complies with the industry performance standards established by the Sporting Arms and Ammunition Manufacturers' Institute, Inc. (SAAMI) or ammunition manufactured to U.S. military specifications.

SIG SAUER specifically disclaims responsibility for any damage or injury whatsoever occurring in connection with, or as a result of, the use of any SIG SAUER firearm of faulty, nonstandard, hand-loaded (reloaded) ammunition, or cartridges other than those for which the firearm was originally chambered. Excessive pressure inside the chamber or barrel while firing a firearm may cause severe damage and serious injury or death to the shooter or to others may occur.

WARNING: CANCER AND REPRODUCTIVE HARM—www.P65warnings.ca.gov



DISCHARGING FIREARMS IN POORLY VENTILATED AREAS, CLEANING FIREARMS, OR HANDLING AMMUNITION MAY RESULT IN EXPOSURE TO LEAD AND OTHER SUBSTANCES KNOWN TO THE STATE OF CALIFORNIA TO CAUSE BIRTH DEFECTS, REPRODUCTIVE HARM, AND OTHER SERIOUS PHYSICAL INJURY. MAINTAIN ADEQUATE VENTILATION AT ALL TIMES. WASH HANDS THOROUGHLY AFTER EXPOSURE. SHOOTING OR CLEANING FIREARMS MAY EXPOSE OPERATORS TO LEAD.

6.0 LOCKING DEVICES



All SIG SAUER firearms are shipped with a key-operated locking device or a lockable case.

Never install the locking device inside the trigger guard or in any way that makes it possible to pull the trigger. Do not leave the keys in the lock.

All firearm owners are responsible for secure storage of any firearm.

ALWAYS refer to the locking device's manufacturer directions for installation and removal of the device.

7.0 SAFETY INFORMATION

Do not practice loading or firing any firearm with live ammunition until the Operator's Manual has been read and understood.

Seek supervised instruction for any additional information.

The SIG SAUER Academy provides all levels of firearms safety and skill training.

For more information contact:

SIG SAUER ACADEMY

sigsaueracademy.com • (603) 610-3400
Epping, New Hampshire

SAFETY MUST BE THE FIRST AND CONSTANT CONSIDERATION OF EVERY PERSON WHO HANDLES FIREARMS AND AMMUNITION.

For more information about safety, responsible firearms ownership, and shooting sports, contact:
National Rifle Association (NRA) of America
11250 Waples Mill Road, Fairfax, VA 22030-7400 • 1-800-672-3888
nra.com



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8.0 MECHANICAL CHARACTERISTICS

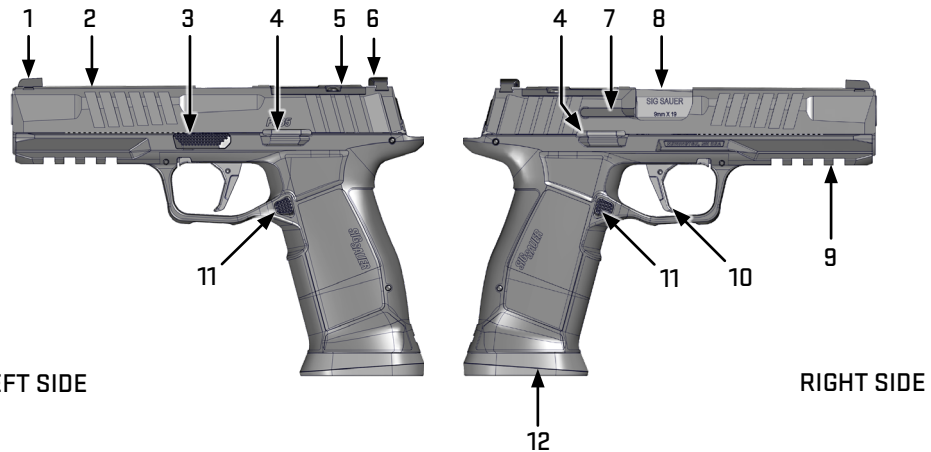
8.1 DESCRIPTION OF FIREARM

The SIG SAUER P385 pistol is a modern handgun incorporating the latest technical advances in firearm design for military, law enforcement, and sporting use. The P385 is a striker fired, mechanically locked, short recoil operated pistol with semi-automatic reloading. The striker is pre-tensioned before the trigger is pulled and is ready to fire. Firing takes place with each pull of the trigger. The slide remains open after the last cartridge has been fired.

The SIG SAUER P385 is offered in 9mm and features an interchangeable grip module, a reversible magazine catch, and ambidextrous controls. An accessory rail is integrated into the grip module, facilitating easy attachment of industry standard tactical accessories.

Additional information about SIG SAUER products, SIG SAUER Academy and the SIG Experience Center, Special Programs, and additional support can be found by scanning the QR code below to visit sigsauer.com.

8.2 MAIN COMPONENTS AND OPERATOR CONTROLS



CONTROLS AND FEATURES		
1	Front Sight	A visual aid for proper alignment of the pistol.
2	Slide	Chambers and ejects rounds, cocks the internal hammer, provides a locking mechanism, houses firing and safety components, and manages recoil.
3	Takedown Lever	Allows the slide to be removed from the frame.
4	Ambidextrous Slide Catch Lever	Holds and releases the slide and aids in reloading.
5	Optic Filler Plate	Protects the optic footprint and can be easily replaced with an optic.
6	Rear Sight	A visual aid for proper alignment of the pistol.
7	Extractor	Pulls spent casings or cartridges out of the chamber of the barrel.
8	Barrel	Guides the projectile from the chamber to the muzzle when the pistol is fired.
9	Accessory Rail	Provides a mounting platform for accessories and attachments.
10	Trigger	When pressed actuates the internal components to fire the pistol.
11	Magazine Catch Button	Either a left or right Magazine Catch can be installed in the pistol. Holds and releases the magazine in the grip module.
12	Magazine Funnel	Provides a flared opening at the bottom of the grip module to help guide the magazine into the magazine well.

8.3 PRINCIPAL SAFETY FEATURES

STRIKER SAFETY LOCK

The striker is mechanically blocked from hitting the primer unless the trigger is pressed to the rear.

TAKEDOWN SAFETY LEVER

Slide must be locked to the rear to rotate takedown lever for disassembly. The takedown lever can't be rotated to the takedown position (perpendicular to the slide) with a magazine inserted. When the takedown lever is rotated to the takedown position, the takedown safety lever lowers the sear so that the slide can be removed without energizing the striker.

MAGAZINE DISCONNECT MECHANISM

Some models feature a magazine disconnect mechanism which mechanically blocks the movement of the trigger bar, preventing the trigger from being pressed to the rear unless a magazine is inserted.

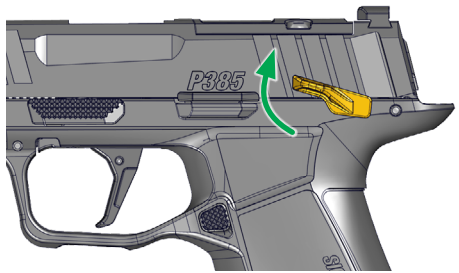
TRIGGER BLOCK MECHANISM

Mechanically blocks the trigger from being actuated unless the trigger block is depressed with the trigger.

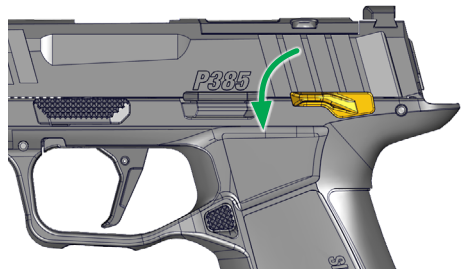
MANUAL SAFETY EQUIPPED PISTOLS

The SIG SAUER P385 is offered with an optional ambidextrous manual safety. The manual safety mechanically blocks the movement of the trigger bar, preventing release of the striker.

To engage the manual safety, rotate the manual safety lever upward. The manual safety is ambidextrous. Pressing up on the lever from either side will rotate the opposite lever upward and engage the manual safety. The slide can be manipulated with the manual safety engaged.



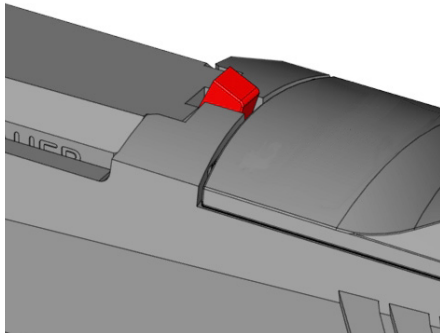
ENGAGE MANUAL SAFETY



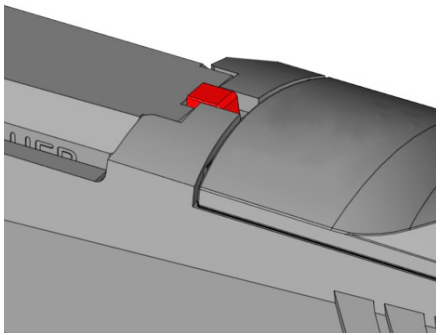
DISENGAGE MANUAL SAFETY

LOADED CHAMBER INDICATOR (LCI) EQUIPPED PISTOLS

Some models feature a loaded chamber indicator which provides a visual and tactile indication that there is a live round in the chamber. In limited visibility situations, the non-firing hand can be used to determine if the loaded chamber indicator is in the elevated position indicating a live round in the chamber.



ROUND IN CHAMBER



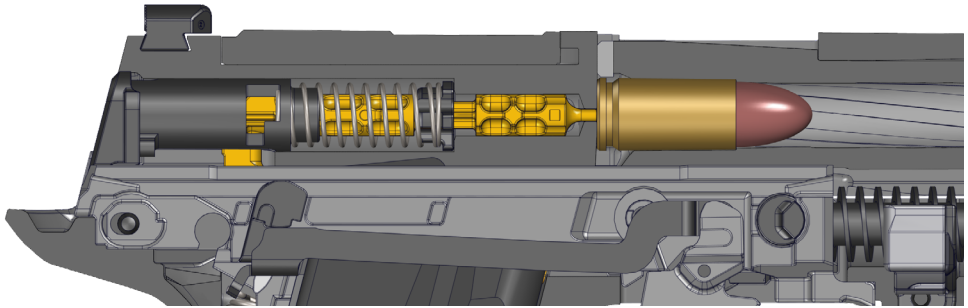
EMPTY CHAMBER

8.4 CYCLE OF FUNCTION

There are eight steps in the cycle of function for the P385 that begin when the trigger is pressed.

FIRING

The trigger is pulled and releases the striker pin. The striker pin hits the primer of the cartridge, igniting the powder. The resulting pressure forces the projectile out of the cartridge and down the barrel of the firearm.



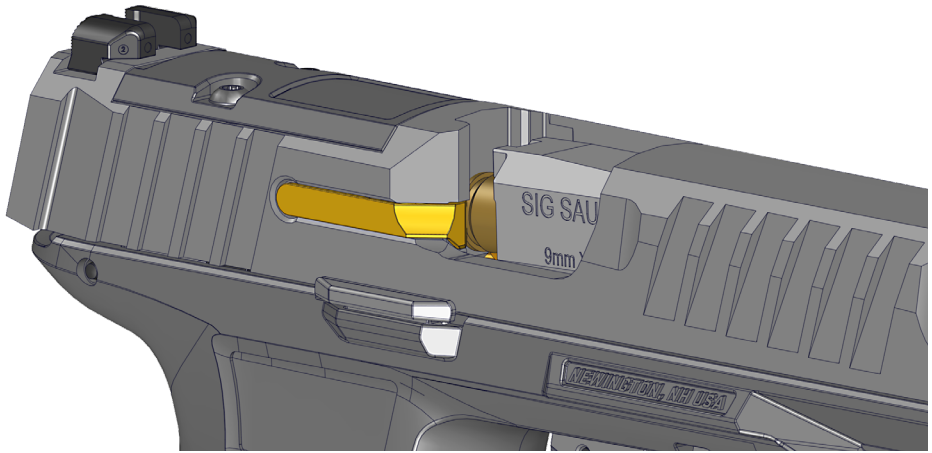
UNLOCKING

The pressure from the round simultaneously forces the slide and barrel rearward. The barrel unlocks from the slide and the back of the barrel rotates down into a recess inside the frame, stopping its movement.



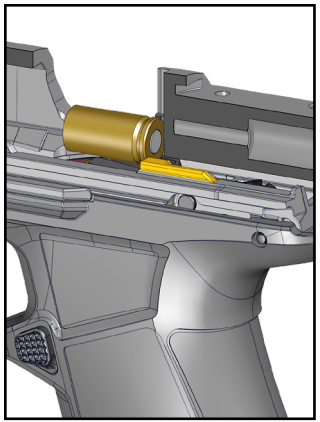
EXTRACTING

The extractor pulls the empty casing from the barrel chamber.



EJECTING

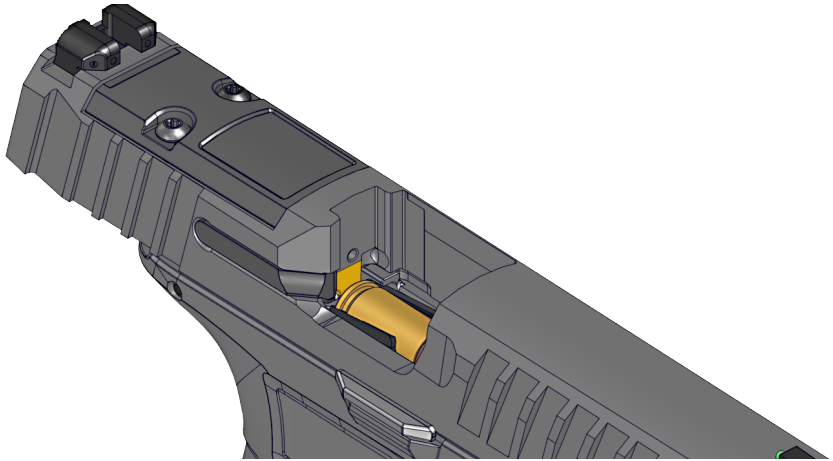
The left side of the cartridge contacts the ejector while the extractor continues to pull from the right, and the empty case is forced out of the ejection port.





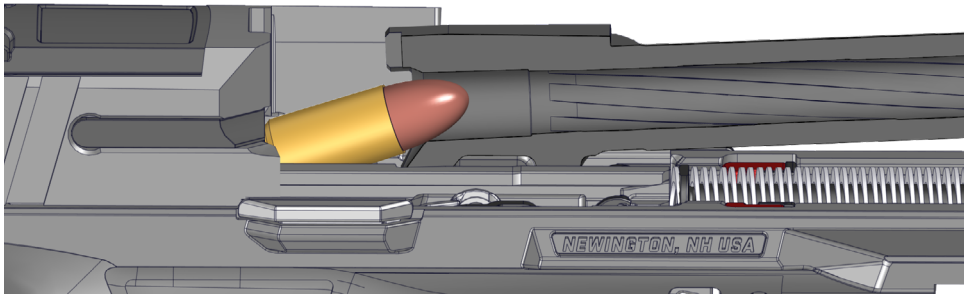
FEEDING

The energy of the compressed recoil spring forces the slide forward. As the slide travels forward, the bottom of the breech face contacts the next cartridge in the magazine and pushes it toward the chamber.



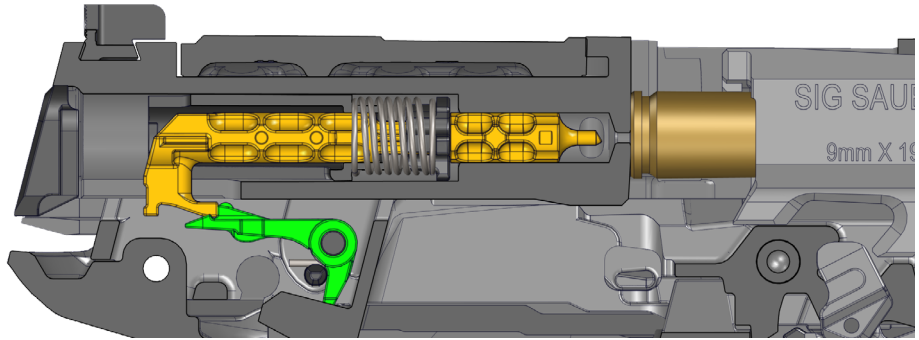
CHAMBERING

The slide's forward movement and the magazine spring's pressure force the cartridge into the chamber.



COCKING (ENERGIZING)

As the slide travels forward, the sear rotates upward to capture the striker pin and lock it in place. When the firearm returns to its locked position, the striker pin is energized by spring pressure and is ready to be released when the trigger is pressed.



LOCKING

The cartridge seals the chamber, and the barrel locks into the slide.



9.0 HANDLING

9.1 PREPARATION INSTRUCTIONS

⚠ WARNING MAINTENANCE

PRIOR TO PERFORMING ANY MAINTENANCE ON THE FIREARM, READ AND UNDERSTAND THE OPERATOR'S MANUAL. ENSURE THAT THE FIREARM IS UNLOADED, CLEARED, AND THE MAGAZINE IS REMOVED. SAFETY GLASSES SHOULD BE WORN WHENEVER DISASSEMBLING, CLEANING, INSPECTING, OR ASSEMBLING A FIREARM. FAILURE TO COMPLY MAY RESULT IN SERIOUS INJURY OR DEATH TO THE OPERATOR OR BYSTANDERS.

Perform an initial cleaning and lubrication of the pistol after unpacking it. Any fouling is from final range testing at the factory prior to shipping. See *11.2 Cleaning and Lubricating on page 62* for instructions on cleaning the pistol.

9.2 UNLOADING AND CLEARING THE PISTOL

WARNING UNLOAD/CLEAR

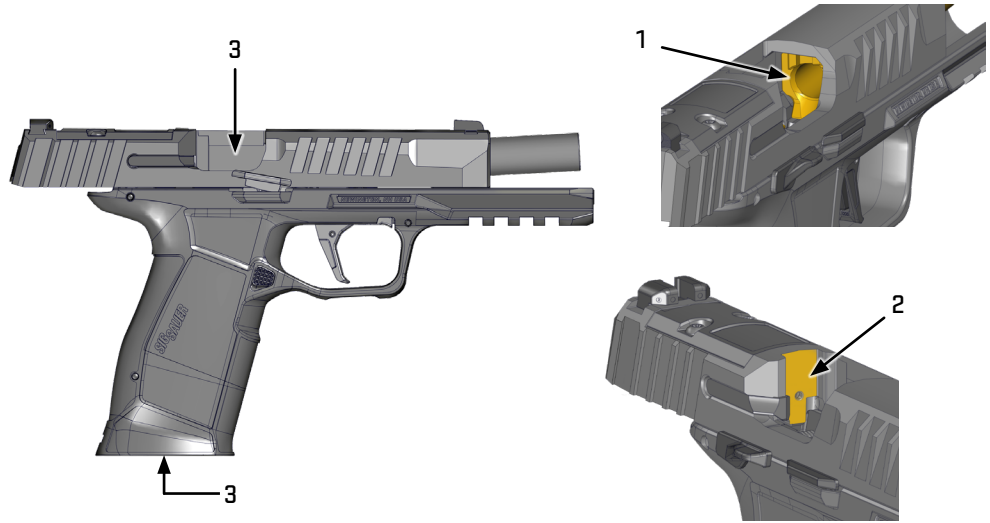
FAILURE TO ENSURE THE FIREARM IS UNLOADED AND CLEARED COULD RESULT IN UNINTENTIONAL DISCHARGE, CAUSING SERIOUS INJURY, DEATH, OR PROPERTY DAMAGE.

REMOVING THE MAGAZINE FROM THE FIREARM DOES NOT PREVENT A CHAMBERED ROUND FROM BEING FIRED UNLESS THE FIREARM IS EQUIPPED WITH A MAGAZINE DISCONNECT MECHANISM.

When the chamber has a live cartridge in it, the firearm will discharge if the safety is disengaged and the trigger is pulled. Always completely unload and clear the pistol when it is not in use, before handling the pistol, or before handing or receiving the pistol from another person.

1. If equipped, engage the manual safety.
2. Point the muzzle in a safe direction.
3. Release the magazine.
4. Lock the slide rearward to open the chamber.
5. Verify that chamber and barrel are clear of any cartridges.
6. Visually and physically check the firearm is clear of all ammunition twice by inspecting the chamber (1), breech face (2), and magazine well (3).

UNLOAD AND CLEAR: VISUAL AND PHYSICAL INSPECTION



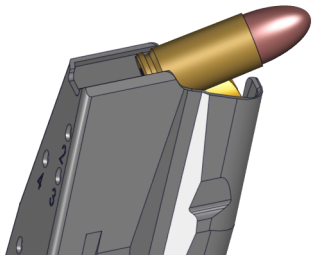
9.3 LOADING THE MAGAZINE

CAUTION

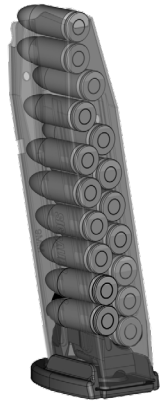
DO NOT ATTEMPT TO INSERT MORE CARTRIDGES THAN THE MAGAZINE'S DESIGNED CAPACITY.

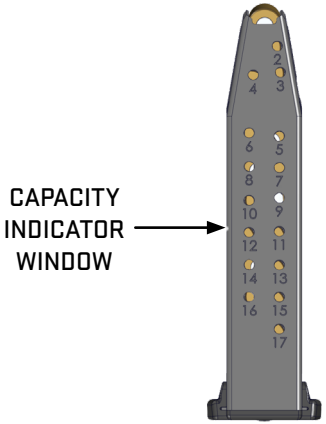
NOTE: Ensure that the magazine is the proper type and caliber for the P385.

1. Press down on the magazine follower using the cartridge case rim. Ensure that the projectile is facing the front of the magazine.



2. Push the cartridge to the rear and under the magazine lips.
3. Repeat until the magazine holds the desired number of cartridges or is full.



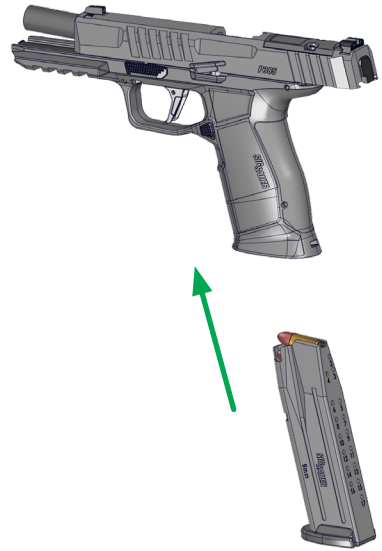


9.4 LOADING THE PISTOL

1. Point pistol in a safe direction and, if equipped, engage the manual safety.
2. Fully retract the slide and lock it to the rear by pushing up on the slide catch lever.



3. Insert a loaded magazine into the magazine well until it locks in place. Listen for an audible click, and pull on the magazine to ensure it is fully seated.



4. Chamber a cartridge by releasing the slide, either by:

   a. Pressing down on the slide catch lever.
   b. Pulling back on the slide until the slide catch lever drops clear of the slide then releasing it. Do not ride the slide forward. Failure to do so may induce a stoppage.



WARNING LOADED FIREARM

THE PISTOL IS NOW LOADED AND READY TO FIRE.

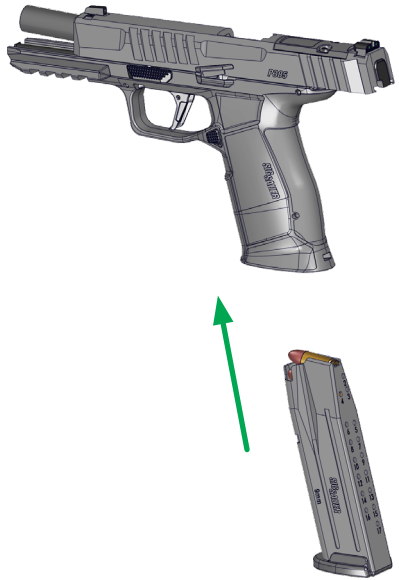
RELOADING DURING SHOOTING — MAGAZINE DEPLETED

NOTE: When the last cartridge in the magazine is expended, the slide will be locked to the rear by the slide catch lever.

1. Point the muzzle in a safe direction and, if equipped, engage the manual safety.
2. Press the magazine catch to release the empty magazine.



3. Insert a loaded magazine into the magazine well until it locks. Listen for an audible click, and pull on the magazine to ensure it is fully seated.



4. Chamber a cartridge by releasing the slide, either by:
   a. Pressing down on the slide catch lever.
   b. Pulling back on the slide until the slide catch lever drops clear of the slide then releasing it. Do not ride the slide forward. Failure to do so may induce a stoppage.



WARNING LOADED FIREARM

THE PISTOL IS NOW LOADED AND READY TO FIRE.

RELOADING DURING SHOOTING — PARTIAL MAGAZINE

NOTE: A magazine does not need to be empty to be removed.

1. Keep the muzzle pointed in a safe direction.
2. If equipped, rotate the manual safety lever upward to engage the manual safety.



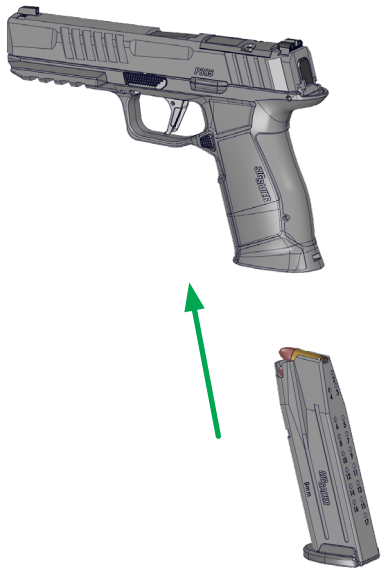
3. Press the magazine catch to remove the loaded magazine.



WARNING LOADED FIREARM

THE PISTOL STILL HAS A LIVE CARTRIDGE CHAMBERED. UNLESS EQUIPPED WITH A MAGAZINE DISCONNECT, THE PISTOL CAN BE FIRED IF THE MANUAL SAFETY IS DISENGAGED AND THE TRIGGER IS PULLED.

4. Insert a loaded magazine by pushing it up and into the magazine well until it locks in place. Listen for an audible click, and pull on the magazine to ensure it is fully seated.



UNLOADING THE PISTOL (MAGAZINE NOT EMPTY)

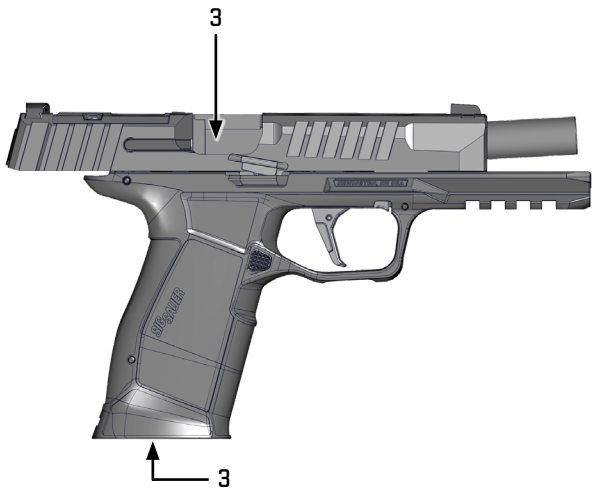
1. Keep the muzzle pointed in a safe direction and, if equipped, engage the manual safety.
2. Press the magagine catch and remove the magazine.

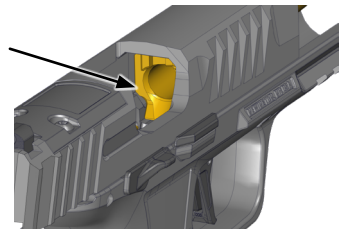


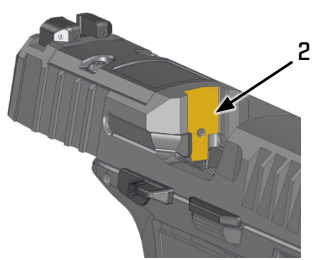
3. Pull the slide completely to the rear while watching for the ejection of a live cartridge.
4. Push up on the slide catch lever to lock slide open.



5. Visually and physically check the chamber, magazine well, and breech face to ensure that pistol is completely free of ammunition.



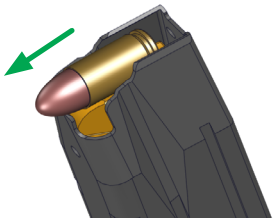




6. Press the slide catch lever to send the slide forward.



7. Unload the magazine.

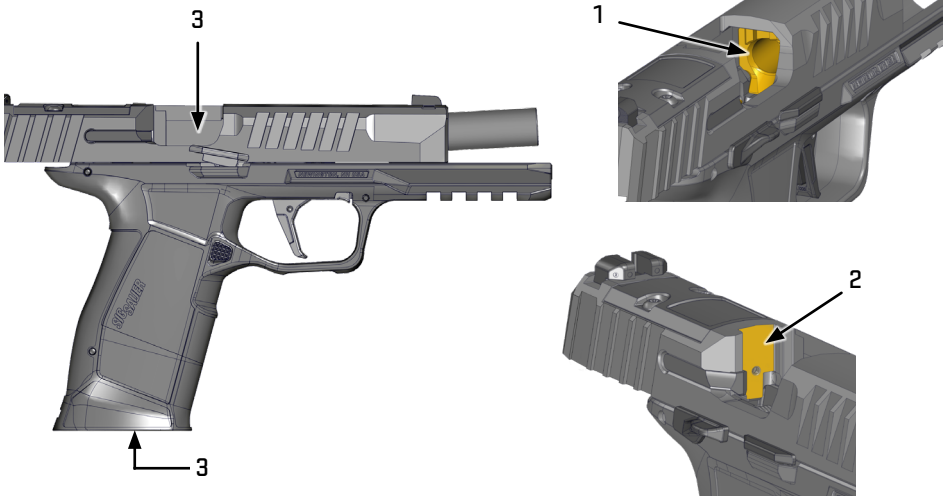


UNLOADING THE PISTOL (MAGAZINE EMPTY, SLIDE OPEN)

1. Keep the muzzle pointed in a safe direction and engage manual safety if so equipped.
2. Press the magazine catch and remove the magazine.



3. Visually and physically check the chamber, magazine well, and breech face to ensure that the pistol is completely free of ammunition.



4. Press the slide catch lever to close the slide.



10.0 FIRING

WARNING LOADED FIREARM

KEEP FINGERS OUT OF TRIGGER GUARD AND OFF THE TRIGGER UNTIL READY TO FIRE. ALWAYS ENSURE FIREARM IS POINTED IN A SAFE DIRECTION. FAILURE TO COMPLY MAY RESULT IN SERIOUS INJURY OR DEATH.

1. Aim the pistol at a safe target.
2. If equipped, press down on the manual safety lever to disengage the manual safety.
3. Pull the trigger to fire.
4. Keep the pistol aimed at the target until done shooting.
5. To unload and clear the firearm, see *9.2 Unloading and Clearing the Pistol on page 36*.



11.0 AUTHORIZED OPERATOR LEVEL MAINTENANCE

WARNING UNLOAD/CLEAR

FAILURE TO ENSURE THE FIREARM IS UNLOADED AND CLEARED COULD RESULT IN UNINTENTIONAL DISCHARGE, CAUSING SERIOUS INJURY, DEATH, OR PROPERTY DAMAGE.

REMOVING THE MAGAZINE FROM THE FIREARM DOES NOT PREVENT A CHAMBERED ROUND FROM BEING FIRED UNLESS THE FIREARM IS EQUIPPED WITH A MAGAZINE DISCONNECT MECHANISM.

11.1 PISTOL DISASSEMBLY

1. Unload and clear the pistol. See *Unload and Clear: Visual and Physical Inspection on page 37*.
2. Lock the slide to rear by pulling the slide rearward and pushing up on the slide catch lever.



3. Rotate the takedown lever clockwise until it stops.



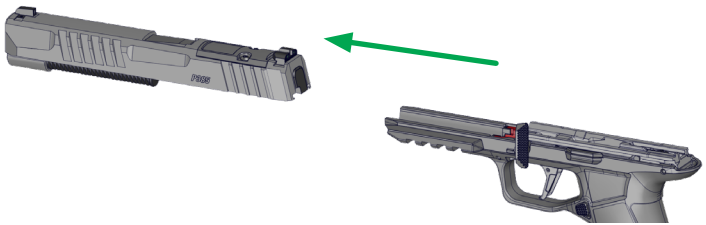
WARNING PARTS UNDER SPRING TENSION

FIREARMS CONTAIN SEVERAL SPRING LOADED PARTS. WEAR EYE PROTECTION AND MAINTAIN CONTROL DURING MAINTENANCE. FAILURE TO COMPLY MAY RESULT IN INJURY.

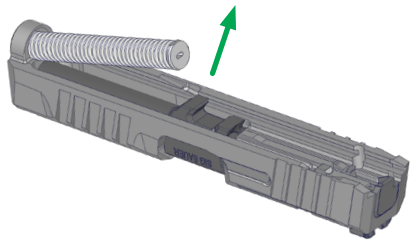
4. Pull the slide to the rear to disengage the slide catch lever while maintaining control of the slide assembly.



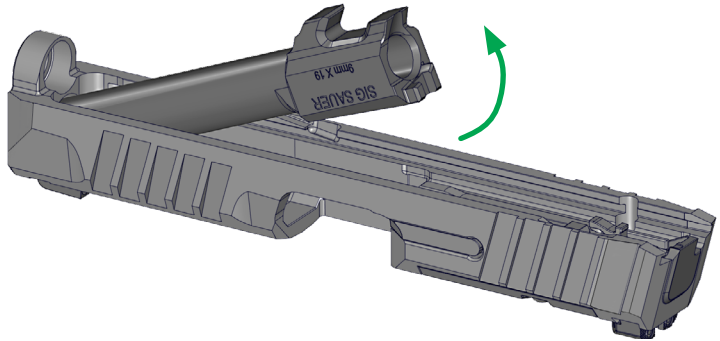
5. Guide the complete slide assembly (slide, barrel, recoil spring, and guide) forward and off of the frame.



6. Push the recoil spring guide forward slightly and lift it from the rear to remove the recoil spring guide assembly from the slide.



7. Remove the barrel from the slide by pulling it upward slightly and to the rear.



NOTE: This level of disassembly is sufficient for thorough cleaning after firing.

11.2 CLEANING AND LUBRICATING

WARNING CLEANING

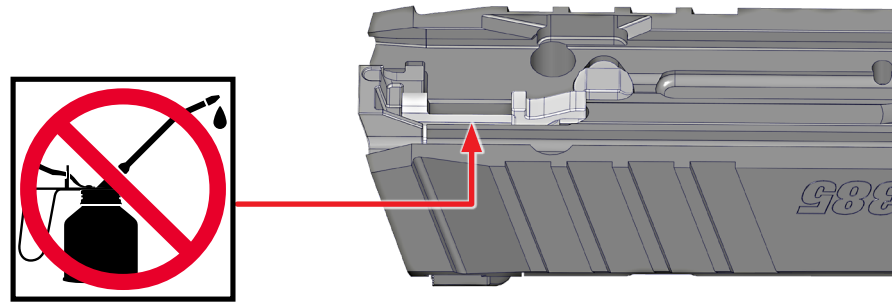
READ AND FOLLOW THE MANUFACTURER'S WARNINGS BEFORE USING SOLVENTS OR CLEANERS. USE IN A WELL-VENTILATED AREA. WEAR EYE PROTECTION.

CAUTION

NEVER CLEAN THE BARREL FROM THE MUZZLE END. DO NOT USE A STEEL WIRE BRUSH AS IT CAN DAMAGE THE SMOOTH SURFACE OF THE BARREL. USE A SUITABLE CLEANING ROD AND BRONZE BRUSH OF THE CORRECT CALIBER. SOLVENTS CAN BE HARMFUL TO THE SURFACE FINISH OF THE PISTOL. AVOID OVER-LUBRICATION OF COMPONENTS.

CAUTION

DO NOT LUBRICATE THE STRIKER OR ALLOW LUBRICANT TO FLOW INTO THE STRIKER CHANNEL OF THE SLIDE. THIS MAY CAUSE A LIGHT STRIKE TO THE CARTRIDGE RESULTING IN A FAILURE TO FIRE.



MATERIALS REQUIRED

- Cleaning patches
- Cleaning cloth
- Bore brush of the proper caliber
- Cleaning rod
- CLP (Cleaning, Lubricant, Preservative)
- Lubricant, Low Temperature when applicable
- Cleaning brush

The following instructions are for normal environmental conditions. Clean and lube before or after the pistol is fired or every 500 rounds. A compensator, if installed, does not need to be removed for routine maintenance and cleaning.

SLIDE ASSEMBLY

1. Remove all of the old lubricant before reapplying new lubricant.
2. Clean the slide assembly with a cloth. Use a soft brush and CLP to clean excessive dirt and carbon buildup. Ensure the extractor, rail slots, and breech face are free of dirt and residue.
3. If the slide has an integrated compensator, use a nylon brush to remove all residue buildup from the compensator and the front of the slide.
4. Apply a light coat of CLP to the frame rail slots of the slide.
5. Lightly lubricate all external parts.
6. Do not lubricate the striker assembly or allow oil to flow into the striker channel.

BARREL

1. Soak a patch with CLP and push it through the bore from the chamber end and out past the muzzle.
2. If compensator is installed, push barrel forward in the slide to allow space to run rods and patches through the barrel.
3. Allow the CLP to soak for several minutes to loosen residue and soften carbon deposits.
4. Wipe the exterior of the barrel with a cloth soaked in CLP.
5. Repeat step #1.
6. Use the bore brush and a cleaning rod to scrub heavy deposits from the bore.
7. Repeat step #1.
8. Push dry patches through the bore until they come out clean.
9. Lightly oil bore and chamber if the pistol is to be stored for a period of time.
10. Always remove any lubricant from the bore prior to firing the pistol.

RECOIL SPRING AND GUIDE ASSEMBLY

The P385 recoil spring and guide assembly should not be disassembled. It is serviced and replaced as a single unit.

1. Clean the recoil spring guide assembly with CLP and a soft brush.
2. After cleaning, apply a light coat of CLP.

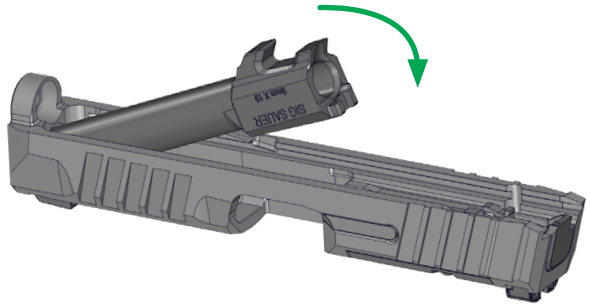
FRAME ASSEMBLY AND GRIP MODULE

1. Wipe the frame and grip module assembly with a soft cloth.
2. Use cotton swabs to clean hard to reach areas. Pay special attention to the frame rails, takedown lever, and slide catch lever.
3. Lubricate the frame rails with a light coat of CLP.
4. Apply CLP to accessible functioning parts.
5. Clean the magazine well of any dirt, dust, or residue with a soft cloth.
6. Clean the trigger assembly and ensure any debris is removed between the trigger and trigger block.

Perform a function check after every cleaning and disassembly. See *13.0 Function Check on page 76*.

11.3 PISTOL ASSEMBLY

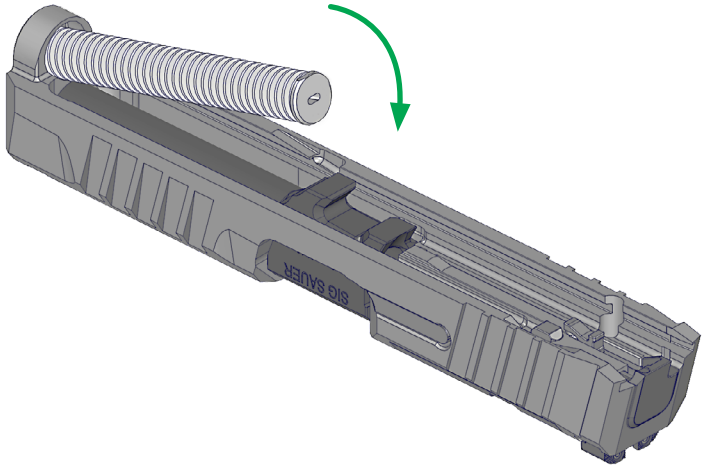
1. Verify that the barrel is clear of all foreign matter.
2. Turn the slide upside down and insert the barrel into the slide.



WARNING PARTS UNDER SPRING TENSION

FIREARMS CONTAIN SEVERAL SPRING LOADED PARTS. WEAR EYE PROTECTION AND MAINTAIN CONTROL DURING MAINTENANCE. FAILURE TO COMPLY MAY RESULT IN INJURY.

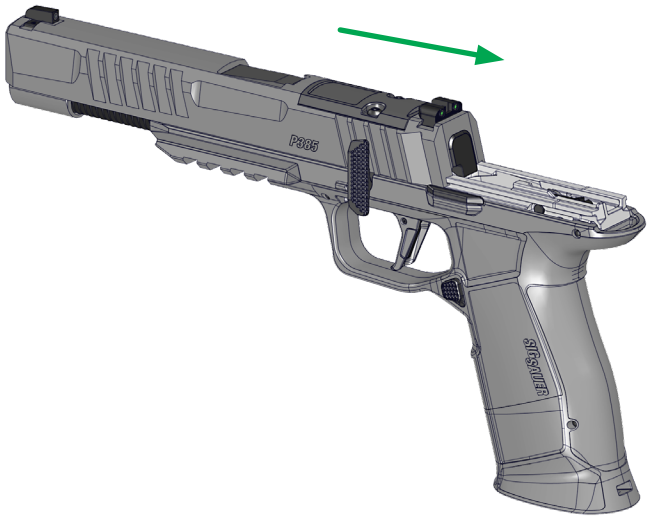
3. Insert recoil spring guide assembly into slide.



4. Ensure the takedown lever is rotated clockwise until it stops.



5. Guide the slide onto the frame rails from the front.



6. Retract the slide fully to the rear. Engage the slide catch lever to lock the slide in the open position.
7. Rotate the takedown lever counterclockwise until it stops.



8. Press the slide catch lever to release the slide, or pull back on the slide assembly to release it. Do not ride the slide forward. Failure to do so may induce a stoppage.



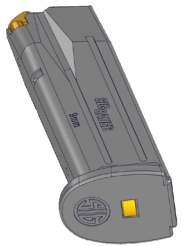
12.0 MAGAZINE MAINTENANCE

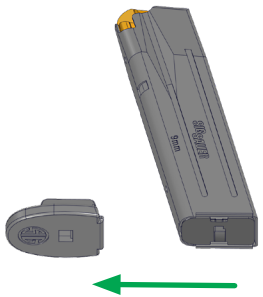
12.1 MAGAZINE DISASSEMBLY

WARNING PARTS UNDER SPRING TENSION

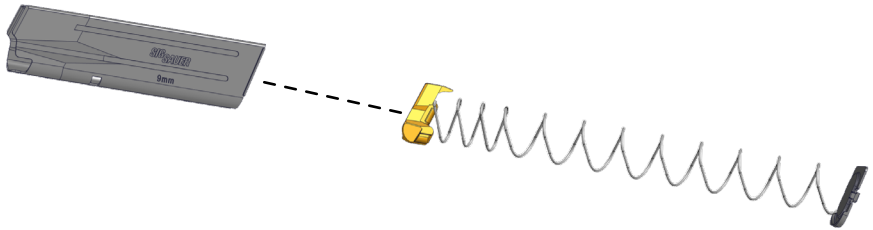
FIREARMS CONTAIN SEVERAL SPRING LOADED PARTS. WEAR EYE PROTECTION AND MAINTAIN CONTROL DURING MAINTENANCE. FAILURE TO COMPLY MAY RESULT IN INJURY.

1. Using a punch or similar tool, push the tab of the magazine insert forward then down to release and remove the floorplate.





2. Remove the magazine follower and magazine spring from the magazine tube.



12.2 CLEANING

1. Wipe the magazine tube and follower with a cloth. Clean the magazine tube and follower with a soft brush and CLP.
2. Use a cloth to clean the magazine spring, floorplate, and insert.
3. Apply a light coat of CLP to the spring and outside of the magazine tube.

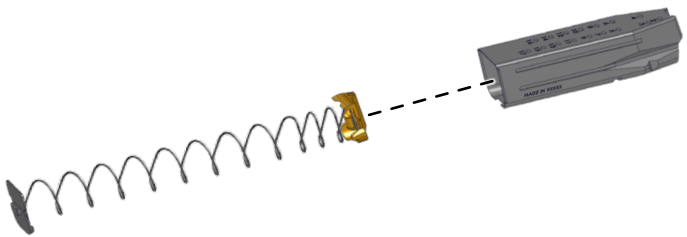
12.3 MAGAZINE ASSEMBLY

1. Place the magazine follower on the magazine spring and insert it into the bottom of the magazine tube.

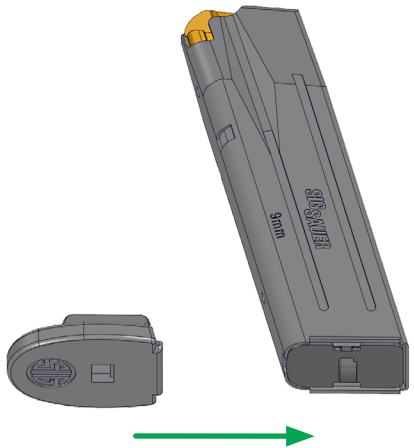
WARNING PARTS UNDER SPRING TENSION

FIREARMS CONTAIN SEVERAL SPRING LOADED PARTS. WEAR EYE PROTECTION AND MAINTAIN CONTROL DURING MAINTENANCE. FAILURE TO COMPLY MAY RESULT IN INJURY.

2. Compress the magazine spring fully into magazine tube until the magazine insert is flush with the bottom of the magazine tube.



3. Holding the magazine insert in place, slide the magazine floorplate onto the magazine tube lips until the floorplate is locked in place by the insert.



13.0 FUNCTION CHECK

A function check should be performed after the completion of maintenance, repairs, cleaning, or

WARNING UNLOAD/CLEAR

FAILURE TO ENSURE THE FIREARM IS UNLOADED AND CLEARED COULD RESULT IN UNINTENTIONAL DISCHARGE, CAUSING SERIOUS INJURY, DEATH, OR PROPERTY DAMAGE.

REMOVING THE MAGAZINE FROM THE FIREARM DOES NOT PREVENT A CHAMBERED ROUND FROM BEING FIRED UNLESS THE FIREARM IS EQUIPPED WITH A MAGAZINE DISCONNECT MECHANISM.

1. Insert an empty magazine into the magazine well. There should be an audible click and the magazine catch should hold the magazine in place.
2. Grasp the slide and pull it completely to the rear. The follower of the magazine should push up the slide catch lever, locking the slide to the rear.
3. Press the magazine catch. The magazine must fall free of the pistol under its own weight. Press the slide catch lever to release the slide to its forward position.

IF THE PISTOL IS NOT EQUIPPED WITH A MAGAZINE DISCONNECT, SKIP TO STEP 6.

4. With the pistol pointed in a safe direction, pull the trigger. Nothing should happen. Release the trigger. Insert an empty magazine. Pull the trigger. The striker should release with an audible click.
5. Hold the slide and pull it completely to the rear. Press the slide catch lever to release the slide.

IF THE PISTOL IS NOT EQUIPPED WITH A MANUAL SAFETY, SKIP TO STEP 9.

6. Push up on the manual safety lever to engage the safety.
7. Pull the trigger. The striker should NOT be released. Release the trigger.
8. Press down on the manual safety lever to disengage the safety.
9. With the pistol pointed in a safe direction, pull the trigger to the rear and HOLD. The striker should release and there should be an audible click.
10. With the trigger still pulled to the rear, pull the slide completely to the rear and release.
11. Release the trigger. There should be a light audible click as the striker resets.
12. With the pistol pointed in a safe direction, pull the trigger without engaging the trigger block (from the edge of the trigger or just below the block). The trigger should not go fully to the rear, and the striker should NOT release.
13. Continuing to point the pistol in a safe direction, pull the trigger while engaging the trigger block. The striker should release and there should be an audible click.
14. Pull the slide completely to the rear and release.
15. Retract the slide approximately 0.4 inches (10mm) or until the barrel hood drops out of the slide, then press the trigger. The striker should not be released.

CAUTION

NEVER USE A FIREARM OR MAGAZINE THAT SHOWS SIGNS OF DAMAGE OR FAILS A FUNCTION CHECK. VERIFY THE MAGAZINE IS THE CORRECT MODEL AND CALIBER FOR THE PISTOL. IF THE CONDITION OR FUNCTION OF THE PISTOL OR MAGAZINE IS SUSPECT, RETURN THE PISTOL OR MAGAZINE TO SIG SAUER FOR EVALUATION.

14.0 SIGHTS

WARNING TRITIUM SIGHTS

SPECIAL CONSIDERATIONS FOR DAMAGED NIGHT SIGHTS

SOME SIG SAUER PISTOLS COME EQUIPPED WITH SIGHTS THAT CONTAIN RADIOACTIVE MATERIAL FOR ILLUMINATION DURING LOW LIGHT CONDITIONS ("NIGHT SIGHTS"). THESE SIGHTS ARE COMMONLY MARKED "H3". THE RADIATION SOURCE IS HYDROGEN-3 (H3), ALSO KNOWN AS TRITIUM, CONTAINED IN A SEALED VIAL. SIG SAUER NIGHT SIGHTS CONTAIN LESS THAN 90MCI OF TRITIUM AND MEET THE UNITED STATES NUCLEAR REGULATORY COMMISSION (NRC) REQUIREMENT 10 CFR 32.23.

THE OPERATIONAL TEMPERATURE RANGE OF SIG SAUER TRITIUM SIGHTS IS -30°C/-22°F TO +60°C/+140°F. THE BETA RADIATION EMITTED BY TRITIUM IS ONLY A HAZARD IF THE TRITIUM VIAL IS BROKEN AND INGESTED OR INHALED. THE BODY DOES NOT EASILY RETAIN HYDROGEN OR TRITIUM AS A GAS. HOWEVER, THE BURNING OF TRITIUM PRODUCES TRITIUM OXIDE WHICH IS 10,000 TIMES MORE HAZARDOUS. FOR THIS REASON, GREAT CARE SHOULD BE TAKEN TO AVOID FLAME IN THE PRESENCE OF DAMAGED TRITIUM SIGHTS.



CONTACT WITH A SUSPECTED DAMAGED TRITIUM SIGHT, CAREFULLY WASH HANDS WITH SOAP AND WATER. DO NOT HANDLE DAMAGED SIGHTS WITH OPEN SKIN CUTS OR ABRASIONS. DO NOT EAT, DRINK, SMOKE OR APPLY COSMETICS IN THE PRESENCE OF DEFECTIVE OR DAMAGED TRITIUM NIGHT SIGHTS.

WARNING TRITIUM SIGHTS

SPECIAL HANDLING FOR REPAIR, RETURN, OR DISPOSAL

END USER IS EXEMPT FROM ANY REGULATORY RESPONSIBILITY.

USE ONLY A PROPER SIGHT INSTALLATION/PUSHER TOOL. USE OF A PUNCH MAY DAMAGE THE TRITIUM VIAL.

DO NOT ATTEMPT TO DISASSEMBLE OR REPAIR A TRITIUM NIGHT SIGHT.

TRITIUM NIGHT SIGHTS ARE EXPECTED TO LOSE APPROXIMATELY HALF THEIR BRIGHTNESS AFTER 5 YEARS. TRITIUM NIGHT SIGHTS SHOULD BE DISPOSED OF IN ACCORDANCE WITH LOCAL REGULATIONS AND SHOULD NEVER BE BURNED.

SIG SAUER WILL RESPONSIBLY DISPOSE OF OLD OR DAMAGED TRITIUM NIGHT SIGHTS.

PLEASE CONTACT SIG SAUER CUSTOMER SERVICE FOR INSTRUCTIONS TO RETURN OLD OR DAMAGED NIGHT SIGHTS FOR DISPOSAL OR TO OBTAIN RETURN MERCHANDISE AUTHORIZATION FOR REPAIR OR RETURN OF ITEMS STILL UNDER WARRANTY.

WARNING UNLOAD/CLEAR

FAILURE TO ENSURE THE FIREARM IS UNLOADED AND CLEARED COULD RESULT IN UNINTENTIONAL DISCHARGE, CAUSING SERIOUS INJURY, DEATH, OR PROPERTY DAMAGE.

REMOVING THE MAGAZINE FROM THE FIREARM DOES NOT PREVENT A CHAMBERED ROUND FROM BEING FIRED UNLESS THE FIREARM IS EQUIPPED WITH A MAGAZINE DISCONNECT MECHANISM.

14.1 TORQUE SPECIFICATIONS

NOTE: Torque values will be listed as in-lbf for inch pounds of force and ft-lbf for foot pounds of force. If there is no Nylok® patch present on the fastener, use specified Loctite®.

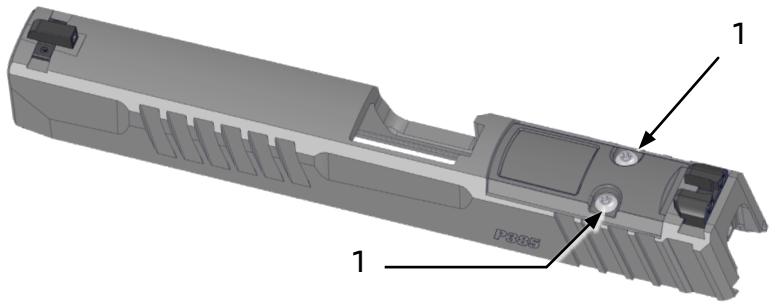
Fasteners with Nylok patch are reusable. Do not remove Nylok patch if present. Fasteners with Loctite must have old Loctite removed and threads cleaned prior to applying new Loctite.

NOMENCLATURE	PAGE	QTY	in-lbf	nm	THREAD LOCKER OR EQUIVALENT
Optic Filler Plate Mounting Screws	54	2	8	0.90	NONE
SIG-LOC PRO Optic Mounting Screws	57	2	18	2.03	NONE
PRO Optic Mounting Screws	58	2	28	3.16	LOCTITE 243

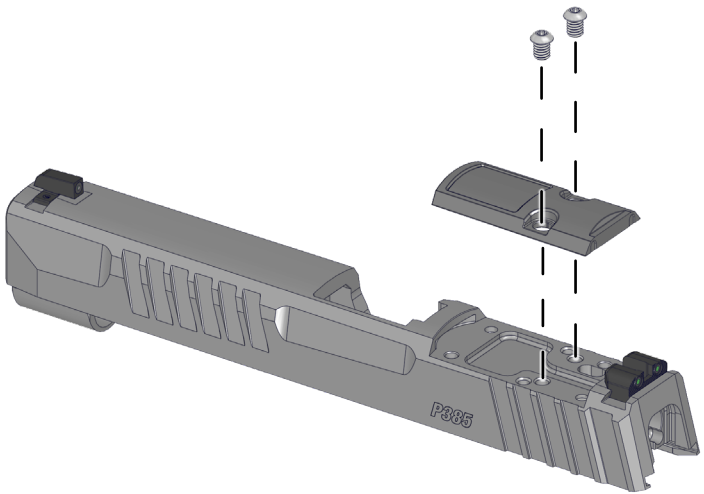
14.2 SIGHT PLATE REMOVAL AND INSTALLATION

SIGHT PLATE REMOVAL

1. Disassemble the pistol. See *11.1 Pistol Disassembly on page 57*.
2. Using a 3/32 in. Hex drive bit, remove the sight plate screws (1) from the bottom of the slide.

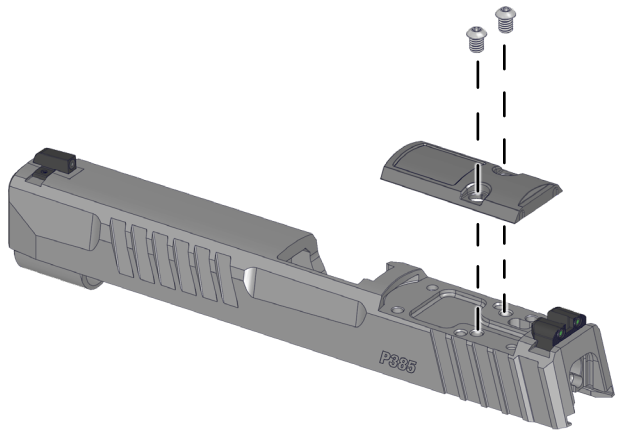


3. Lift the sight and plate from the slide, and if equipped, remove the LCI post and spring.



SIGHT PLATE INSTALLATION

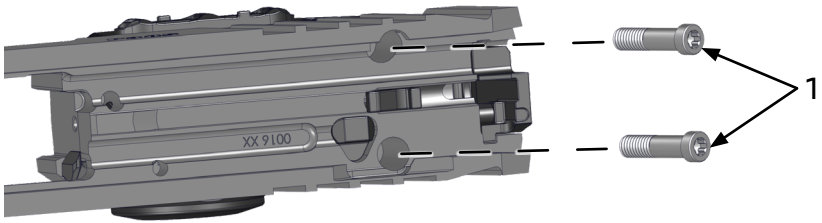
1. If equipped or installing, place LCI post and spring into slide.
2. Install sight plate and sight onto slide and hold LCI post and spring in place.
3. Insert sight plate screws into the bottom of slide and tighten to 20 in-lbf using a 3/32 in. Hex drive bit.



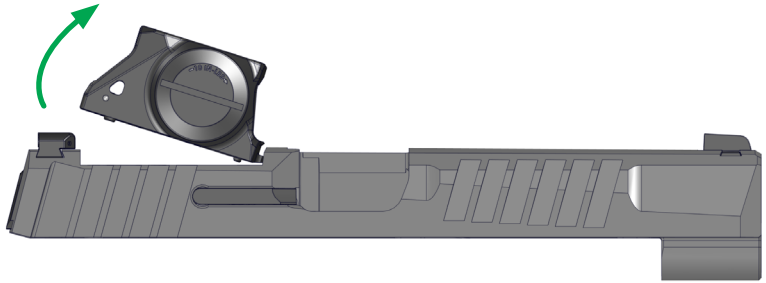
14.3 ROMEO SIG-LOC RED DOT

ROMEO SIG-LOC REMOVAL

1. Use a T10 drive bit to remove the mounting screws (1).

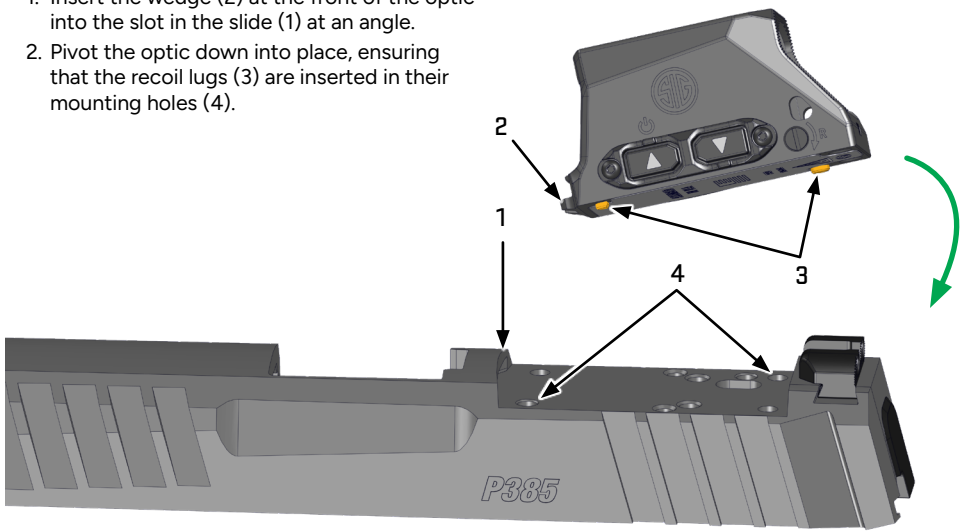


2. Lift the rear of the optic, and remove the optic from the slide.

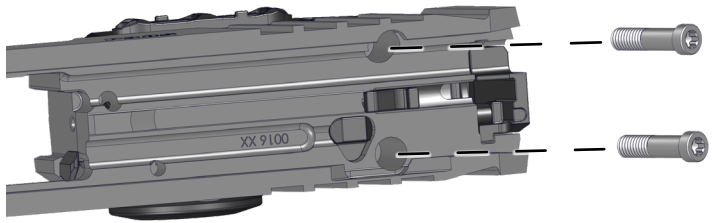


SIG-LOC COMPACT OPTIC INSTALLATION

1. Insert the wedge (2) at the front of the optic into the slot in the slide (1) at an angle.
2. Pivot the optic down into place, ensuring that the recoil lugs (3) are inserted in their mounting holes (4).



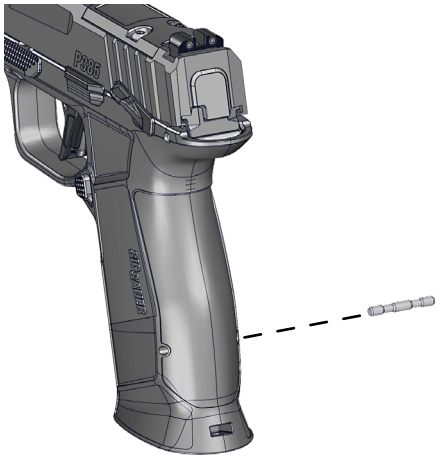
3. Using a T10 drive bit, install the mounting screws from the bottom of the slide and torque to 20 in-lbf.

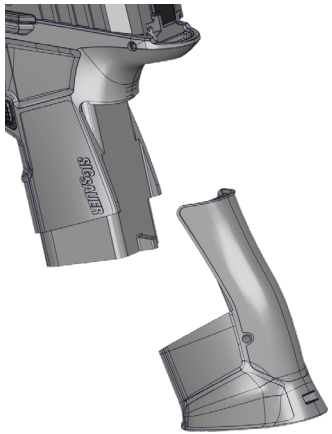


15.0 MAGSTRAP

15.1 MAGSTRAP REMOVAL

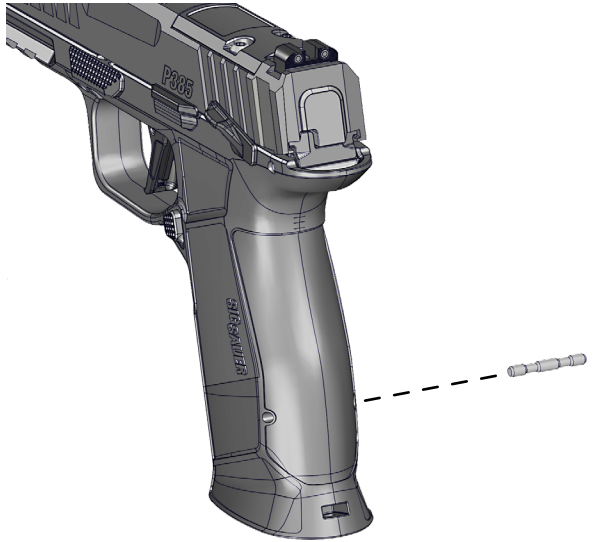
1. Remove magstrap pin and magstrap from the frame.





15.2 MAGSTRAP INSTALLATION

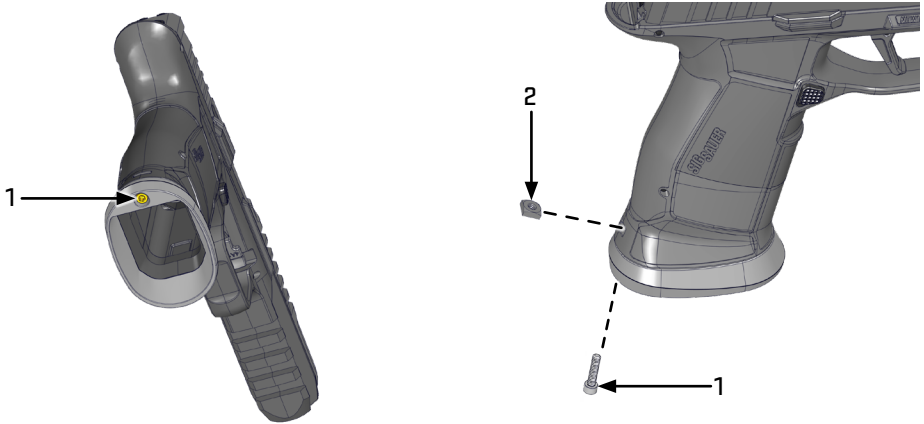
1. Align magstrap on frame.
2. Push pin through the magstrap and ensure it is flush on both sides.



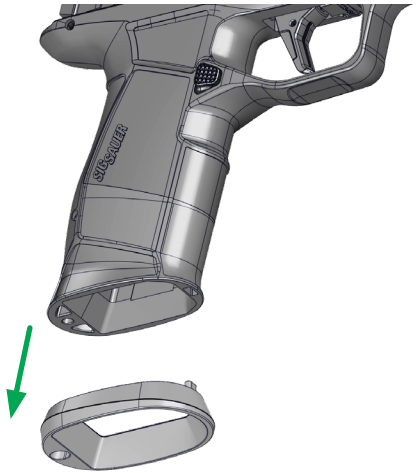
16.0 MAGAZINE FUNNEL

16.1 MAGAZINE FUNNEL REMOVAL

1. Using a IP10 bit, loosen and remove the magazine funnel screw (1) and then remove the square nut (2).

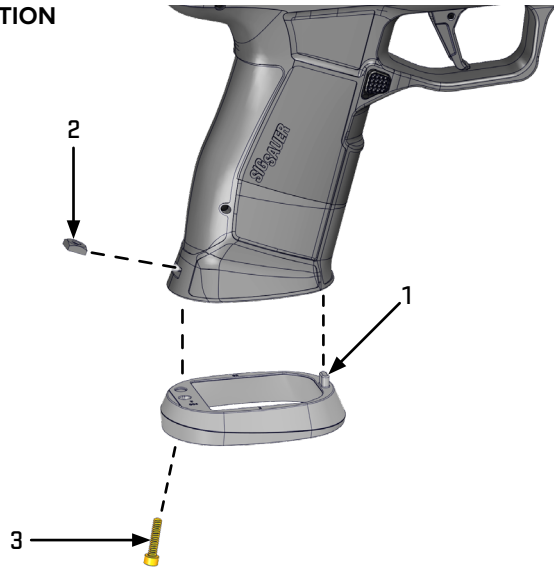


2. Pull the magazine funnel off the grip.



16.2 MAGAZINE FUNNEL INSTALLATION

1. Align the tab (1) on the funnel to the grip module and insert the square nut (2) into its recess.
2. Thread the screw (3) until hand tight to secure the magazine funnel and the square nut.
3. Torque the screw to 11 in-lbf.



17.0 MAGAZINE CATCH REMOVAL AND INSTALLATION

WARNING **UNLOAD/CLEAR**

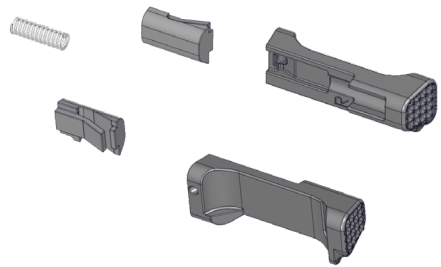
FAILURE TO ENSURE THE FIREARM IS UNLOADED AND CLEARED COULD RESULT IN UNINTENTIONAL DISCHARGE, CAUSING SERIOUS INJURY, DEATH, OR PROPERTY DAMAGE.

REMOVING THE MAGAZINE FROM THE FIREARM DOES NOT PREVENT A CHAMBERED ROUND FROM BEING FIRED UNLESS THE FIREARM IS EQUIPPED WITH A MAGAZINE DISCONNECT MECHANISM.

P385 MAGAZINE CATCH

The P385 ships with both a left and a right magazine catch. Follow these steps for removal and installation to change the side of the pistol's magazine catch.

The magazine catches are engraved L for left-handed shooter (catch on the right side of the pistol) and R for right-handed shooter (catch on the left side).



17.1 MAGAZINE CATCH REMOVAL

NOTE: This procedure can be performed with or without the slide removed from the pistol.

1. Ensure that the magazine is removed and the pistol is unloaded and cleared. See *9.2 Unloading and Clearing the Pistol on page 36*.
2. Press the magazine catch button until the opposite side protrudes from the grip module. A small hole should be visible in the back of the catch.

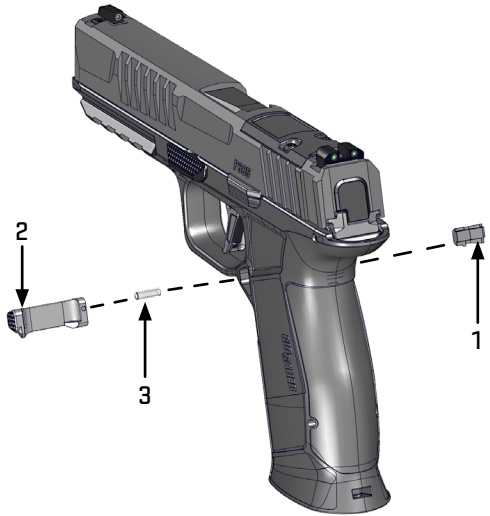




3. Press the end of a small round pin, such as a paper clip, into the hole of the magazine catch button. This will release the magazine catch stop.
4. Work the magazine catch stop out of magazine catch with the pin using a back-and-forth motion.

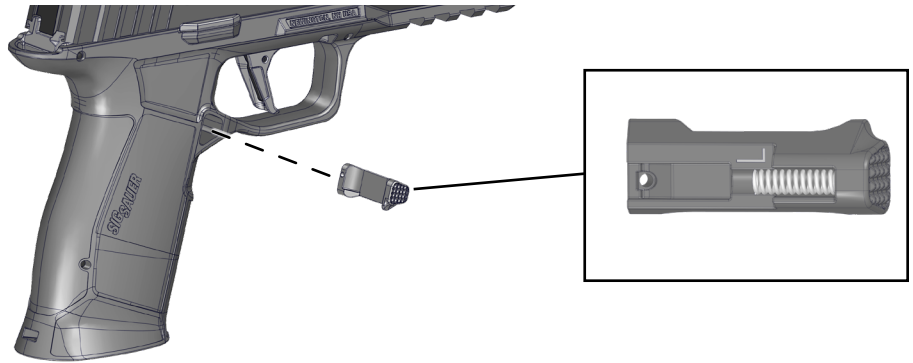


5. Remove the magazine catch stop (1), magazine catch (2), and the magazine catch spring (3) from the grip module.



17.2 MAGAZINE CATCH INSTALLATION

1. Place the magazine catch spring into the magazine catch that corresponds to the side which the operator is installing the magazine catch.
2. Insert the magazine catch and the spring into the side of the grip module that matches the magazine catch. In the example below, the left-handed magazine catch is being installed.



3. Completely depress the magazine catch, and insert the magazine catch stop until it snaps into place.

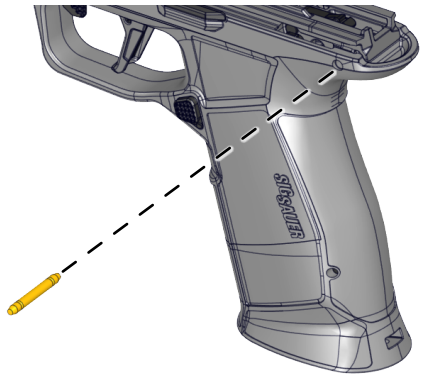


4. Check that the magazine catch can be pressed, that it has spring tension, and that it retains and drops a magazine.

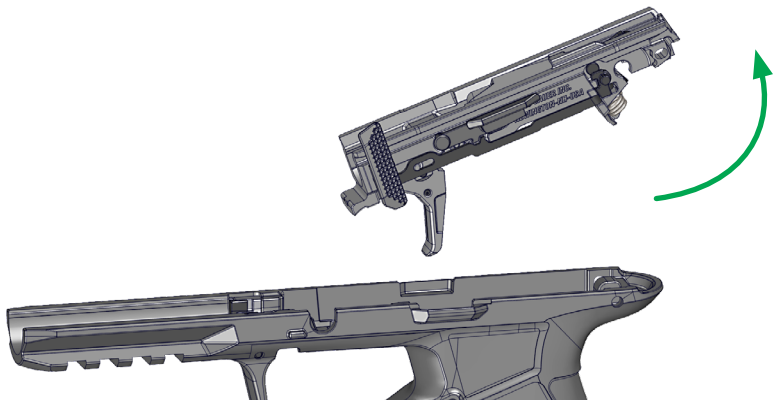
18.0 FIRE CONTROL UNIT (FCU) REMOVAL AND INSTALLATION

18.1 FCU REMOVAL

1. Remove the slide assembly. Disassembling the barrel, recoil spring, and recoil spring guide is not necessary. See *11.1 Pistol Disassembly on page 57*.
2. Ensure the takedown lever is rotated up.
3. Use a punch or similar tool to remove the FCU pin.



4. Pull up on the frame rails, and rotate the FCU up and out from the grip module.

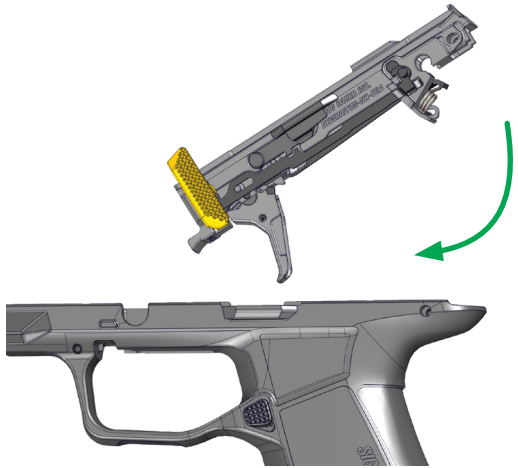


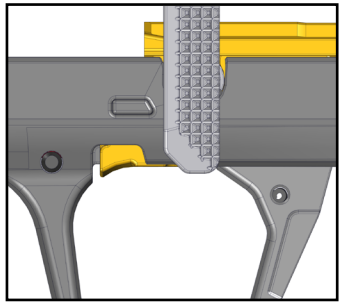
CAUTION

NO FURTHER DISASSEMBLY OF THE FIRE CONTROL UNIT (FCU) IS AUTHORIZED.

18.2 FCU INSTALLATION

1. Insert the FCU into the frame. The locking tab on the FCU needs to fit inside the mating slot on the top of the trigger well.





2. Insert FCU the pin from right to left. Ensure the pin is flush on both sides.

CAUTION

THE DIRECTION OF INSTALLATION IS IMPORTANT AS PUSHING THE FRAME PIN FROM THE OTHER SIDE COULD DAMAGE A SPRING IN THE FRAME.



19.0 STORAGE AND TRANSPORTATION

19.1 STORAGE

WARNING STORAGE

NEVER PLACE OR STORE ANY FIREARM IN SUCH A MANNER THAT IT MAY BE DISLODGED. FIREARMS SHOULD ALWAYS BE STORED, LOCKED, UNLOADED, SEPARATE FROM THEIR AMMUNITION, AND INACCESSIBLE TO CHILDREN AND ANY OTHER UNAUTHORIZED PERSON. THE USE OF A LOCKING DEVICE OR SAFETY LOCK IS ONLY ONE ASPECT OF RESPONSIBLE FIREARMS STORAGE. FAILURE TO PROPERLY STORE FIREARMS MAY CAUSE SERIOUS INJURY OR DEATH TO SELF OR OTHERS, OR PROPERTY DAMAGE.

Short Term Storage (90 days or less)

1. Ensure the chamber and magazine do not contain live ammunition.
2. Clean the bore and chamber.
3. Apply a generous coat of CLP to the chamber and bore.
4. Apply a light coat of CLP to all other metal surfaces for corrosion protection.

Long Term Storage (90 days or longer)

1. Ensure the firearm is thoroughly cleaned.
2. Apply a medium coat of CLP to the chamber and bore.
3. Apply a light coat of CLP to all other metal surfaces for corrosion protection.
4. Wrap the firearm with a waterproof material.
5. Place the firearm in a corrosion resistant barrier bag.

Environmental Storage Recommendations (Armory)

Control the relative humidity to no greater than 40% at 80°F (26.7°C). If personnel will be working in these areas, design to 68°F (20.0°C) dry bulb and 40% RH for indoor design heating conditions, and 75°F (23.9°C) dry bulb and 40% RH for indoor design cooling conditions.

19.2 TRANSPORTATION

IT IS THE OWNER'S RESPONSIBILITY TO FAMILIARIZE THEMSELVES WITH THE LAWS OF ANY JURISDICTION(S) THEY ARE PLANNING TO TRAVEL TO AND THROUGH WITH THE FIREARM.

When transporting the firearm to and from shooting activities, keep it unloaded for safety purposes. When storing the firearm for transportation, keep it separated from ammunition, under lock and key, and out of the reach of children and other inexperienced or unauthorized persons.

If transporting the firearm in a vehicle, ensure that it is secured within the confines of the vehicle. Should the vehicle become involved in an accident, the firearm could become dislodged and move about the interior of the vehicle or be ejected from the vehicle.

20.0 TROUBLESHOOTING GUIDE

20.1 STOPPAGES

WARNING STOPPAGE

IF A DISCHARGED ROUND SOUNDS OR FEELS UNUSUAL, STOP FIRING IMMEDIATELY. WHEN ANY STOPPAGE OCCURS, KEEP THE FIREARM POINTED IN A SAFE DIRECTION AND UNLOAD AND CLEAR THE FIREARM. IF A BORE OBSTRUCTION EXISTS, REFER TO *20.2 OBSTRUCTED BORE ON PAGE 106.*

A stoppage is an interruption in a firearm's cycle of function. When this occurs, the firearm will not continue to fire. When time and situation allow, always unload, clear, and inspect the firearm before attempting to fire after a stoppage. Immediate action should only be used when the operator cannot stop to inspect the firearm. If damage to the firearm is found, the stoppage persists, or the operator's remedial action fails, take the firearm to a certified SIG SAUER Armorer for service.

IMMEDIATE ACTION

Follows three simple correctives: tapping the magazine to make sure it is seated, manipulating the slide, and attempting to fire. If the weapon does not fire, perform remedial action.

REMEDIAL ACTION

A stoppage that is not fixed by immediate action, or the operator notices something unusual in the course of fire. When practical, the operator should always perform remedial action to investigate the cause of a stoppage. Unload and clear the weapon. Remove any debris, objects, or brass inside the firearm. If no obstruction is found and the firearm is clear, reload a magazine and attempt to fire.

20.2 OBSTRUCTED BORE

WARNING OBSTRUCTED BORE

STOP FIRING IMMEDIATELY AND KEEP THE FIREARM POINTED IN A SAFE DIRECTION. UNLOAD AND CLEAR THE FIREARM. DO NOT FIRE ANOTHER ROUND UNTIL THE OBSTRUCTION IS CLEARED. FAILURE TO COMPLY CAN RESULT IN SERIOUS INJURY OR DEATH TO THE OPERATOR AND/OR OTHERS AND CATASTROPHIC DAMAGE TO THE FIREARM.

Immediately stop shooting and keep the firearm pointed in a safe direction whenever:

- There is difficulty or unusual resistance in chambering a cartridge;
- A cartridge misfires (does not go off);
- The mechanism fails to extract a fired cartridge case;
- Unburned grains of propellant powder are discovered spilled in the mechanism;
- A shot sounds weak or abnormal.

It is possible that a bullet is lodged in the barrel. Bullets can become lodged in the barrel when the cartridge has been improperly loaded without propellant powder, the powder fails to ignite, or the bullet was not properly seated in the cartridge case.

If a bullet is in the bore, do not attempt to shoot it out by using another cartridge or by blowing it out with a blank or a cartridge from which the bullet has been removed.

Immediately unload and clear the firearm. Field strip the firearm and look through the bore of the barrel from the chamber end of the firearm. It is not sufficient to only look at the chamber as a bullet may be lodged some distance down the barrel where it cannot be seen at first glance. Attempt to remove the bullet by tapping it out with a cleaning rod. If the bullet can be removed, clean any unburned powder grains from the bore, chamber, and mechanism before resuming shooting. If the bullet cannot be dislodged, take the firearm to a certified SIG SAUER Armorer.

20.3 COOK-OFF

WARNING COOK-OFF

COOK-OFF IS DEFINED AS A CHAMBERED CARTRIDGE DETONATING DUE TO THE HEAT OF THE BARREL. FAILURE TO COMPLY WITH THE BELOW LISTED STEPS COULD RESULT IN DEATH, SERIOUS INJURY, OR PROPERTY DAMAGE.

If the pistol stops firing with a live cartridge in the chamber of a hot barrel due to a misfire or stoppage:

1. Keep the muzzle pointed in a safe direction to ensure the operator or any other person would not be injured by the possibility of a cartridge “cooking off.”
2. If equipped, engage the manual safety.
3. Immediately release the magazine and clear the chambered cartridge.
4. If the cartridge cannot be removed within 10 seconds, keep the muzzle pointed in a safe direction and wait at least 15 minutes before attempting to remove it or moving the pistol.



20.4 GENERAL TROUBLESHOOTING

Stoppage	Cause	Correction
Failure to Feed		
No cartridge fed into chamber. Cartridge partially still in magazine.	Magazine not properly inserted or is damaged.	Correctly insert magazine or replace magazine.
	Damaged/broken magazine spring.	Replace magazine.
	Relaxed grip/shooter induced.	Increase grip on pistol.
Failure to Chamber		
Cartridge is free from magazine but not fully seated into chamber.	Dirty chamber.	Clean chamber.
	Damaged ammunition.	Replace ammunition.
	Weak or broken recoil spring guide assembly.	Contact SIG SAUER Customer Service.
	Relaxed grip/shooter induced.	Adjust or tighten grip on pistol.
Failure to Fire		
Trigger is pressed but no detonation.	Faulty ammunition.	Replace ammunition.
	Slide not fully locked forward.	Pull slide to rear and release.
	Damaged/broken striker assembly.	Contact SIG SAUER Customer Service.

Stoppage	Cause	Correction
Failure to Fire		
Trigger is pressed but no detonation.	Magazine not fully inserted on models equipped with magazine disconnect mechanism.	Properly insert magazine into magazine well.
Failure to Extract		
Expended case remains in chamber.	Dirty chamber.	Clean chamber and bore.
	Broken extractor or extractor spring.	Contact SIG SAUER Customer Service.
Failure to Eject		
Expended case remains in ejection port.	Damaged or broken ejector/slide catch lever.	Contact SIG SAUER Customer Service.



20.5 MINIMIZING STOPPAGES

- Most stoppages can be minimized by cleaning and lubricating the pistol. See *11.2 Cleaning and Lubricating on page 62*.
- Cleaning and lubricating the firearm after each range session will reduce the chances of a stoppage due to dirt and residue buildup.
- Perform maintenance if the firearm is exposed to extreme environmental conditions (rain, snow, freezing temperatures, etc.).
- Periodically inspect the pistol if it is to be stored for extended periods of time without use.
- Most stoppages are directly related to the magazine. Perform maintenance on the magazines as well as the firearm. See *12.1 Magazine Disassembly on page 72*.
- A good practice is to mark the magazines so a magazine that is related to a stoppage can be easily identified.

21.0 REPLACEMENT PARTS POLICY

WARNING

IT IS THE PURCHASER'S RESPONSIBILITY TO BE ABSOLUTELY CERTAIN THAT ANY PARTS ORDERED FROM THE FACTORY ARE CORRECTLY FITTED AND INSTALLED. FIREARMS ARE COMPLICATED MECHANISMS AND IMPROPER FITTING OF PARTS MAY RESULT IN A DANGEROUS MALFUNCTION, DAMAGE TO THE FIREARM, AND SERIOUS INJURY TO THE SHOOTER AND OTHER PERSONS. THE PURCHASER AND INSTALLER OF PARTS MUST ACCEPT FULL RESPONSIBILITY FOR THE CORRECT ADJUSTMENT AND FUNCTIONING OF THE FIREARM AFTER SUCH INSTALLATION.

Parts Policy

Our Service Department maintains a full complement of replacement parts. Even though most gunsmiths have the knowledge, training, and the ability to make necessary repairs to the firearm, the skill and workmanship of any particular third-party gunsmith is totally beyond our control.

Should the firearm ever require service, it is strongly recommended that it be returned to SIG SAUER. A firearm is a precision instrument and some replacement parts will require individual fitting to ensure correct operation. A wrong part, improper fitting, or incorrect mechanical adjustment may result in an unsafe condition or dangerous malfunction, damage to the firearm, or cause possible serious injury to the shooter or others.

IF ANY PART IS ORDERED WITHOUT RETURNING THE FIREARM TO SIG SAUER the customer bears full responsibility for ensuring that the part supplied is correct for their particular firearm and is properly installed and fitted by a qualified gunsmith.

SIG SAUER IS NOT RESPONSIBLE FOR THE FUNCTIONING OF ANY FIREARM IN WHICH REPLACEMENT PARTS ARE INSTALLED BY OTHERS.

THE USE OF AFTERMARKET PARTS IS NOT AUTHORIZED AND WILL VOID THE WARRANTY OF THIS FIREARM. THE REPLACEMENT OF ORIGINAL EQUIPMENT MANUFACTURER (OEM) SIG SAUER PARTS WITH AFTERMARKET PARTS IS UNAUTHORIZED AND IN SOME INSTANCES COULD ALTER THE FUNCTION OF THE FIREARM, CREATING A DANGER TO THE OPERATOR.

Scan the QR code below to visit the Small Parts Shopper page at sigsauer.com.

22.0 FACTORY REPAIR OF THE FIREARM

Contact Customer Service for questions or concerns regarding the performance or serviceability of the firearm. There are three ways to contact Customer Service:

Have the firearm's serial number available before contacting Customer Service.

1. Call (603) 610-3000, choose option 1.
2. Email CustomerService@sigsauer.com.
3. Go to https://www.sigsauer.com/customer-support to message Customer Service electronically. Scan the QR code below to visit the Customer Support page at sigsauer.com.

22.1 RETURNING FIREARMS FOR REPAIR

Do not ship a firearm without an RMA number provided by Customer Service.

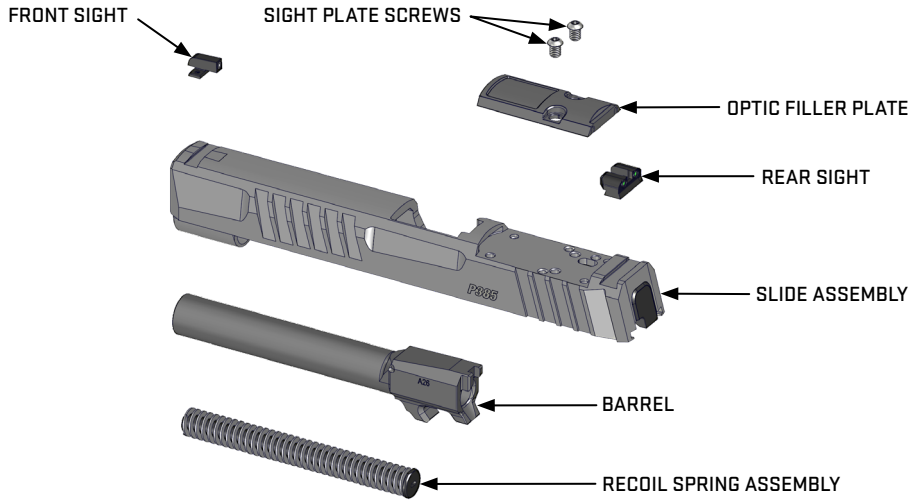
WARNING DO NOT SHIP AMMUNITION

BEFORE SHIPPING ANY FIREARM, BE ABSOLUTELY CERTAIN THAT THE FIREARM AND MAGAZINES ARE UNLOADED. DO NOT SHIP AMMUNITION WITH A FIREARM.

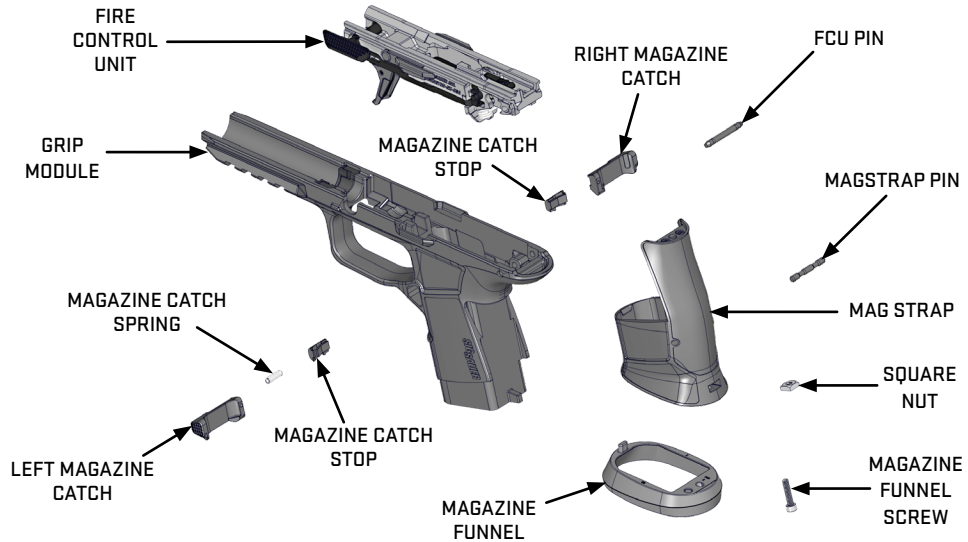
1. The RMA number allows SIG SAUER to track the status of the return from the time SIG SAUER receives the firearm until it is returned.
2. Package the firearm securely to prevent damage.
3. Do not include any accessories such as scopes or mounts unless directed to do so.
4. Some states and localities, require firearms to be shipped and returned to SIG SAUER using a federally licensed firearms dealer.
5. Federal law prohibits persons who do not possess a Federal Firearms License (FFL) from shipping a firearm via the U.S. Postal Service.
6. Any shipment of firearms outside U.S. borders is subject to the export laws of the United States and to the valid laws of the specific country.
7. SIG SAUER is not responsible for any damage to a firearm during shipping until it is received.
8. Firearms must be insured and prepaid prior to shipment (SIG SAUER does not accept collect shipments) to the address provided by Customer Service.

23.0 P385 PARTS DIAGRAM

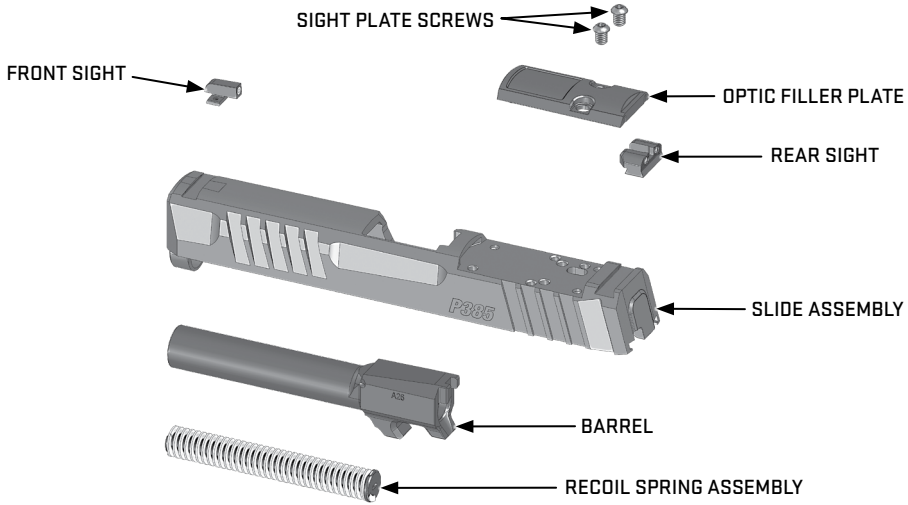
23.1 STANDARD SLIDE PARTS DIAGRAM



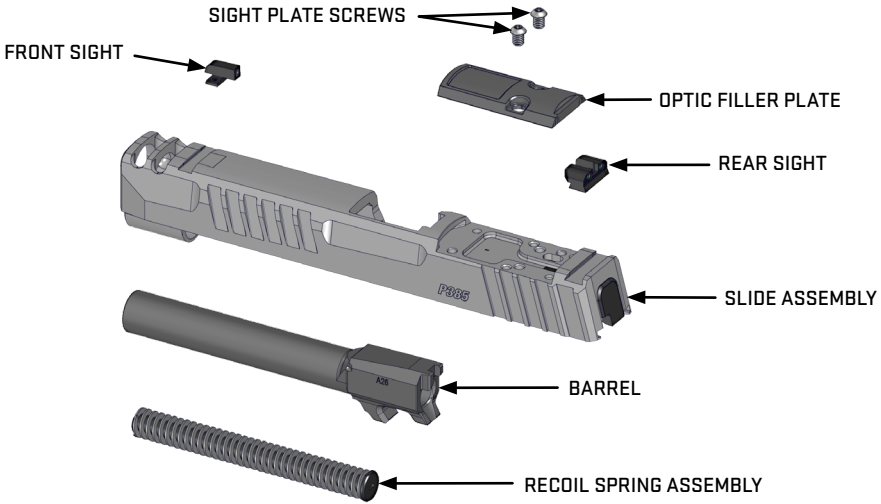
23.2 STANDARD FRAME PARTS DIAGRAM



23.3 CARRY SLIDE PARTS DIAGRAM



INTEGRATED COMPENSATOR SLIDE DIAGRAM



SIG SAUER INFINITE GUARANTEE™

For warranty information on new SIG SAUER firearms, scan the QR code below to visit the SIG SAUER Warranty Information and Registration page. New firearms can also be registered and warranty information can be found on the website.



NOTES:

NOTES:



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