

.22LR RIMFIRE CONVERSION KIT

• 1911



SIG SAUER
when it counts®

OWNER'S MANUAL

INTRODUCTION

The SIG SAUER .22LR Rimfire Conversion for the 1911. This kit allows the use of inexpensive .22LR ammunition for training or recreational use in 1911 SIG SAUER pistols. The .22LR Conversion Kit is a blowback design that had been engineered to provide the same level of performance as the original pistol.

CONTENTS

- Slide • Barrel • Recoil Spring/Guide Assembly • Drift Adjustable Sights
- .22LR Magazine • Owner's Manual • Hard Carry Case

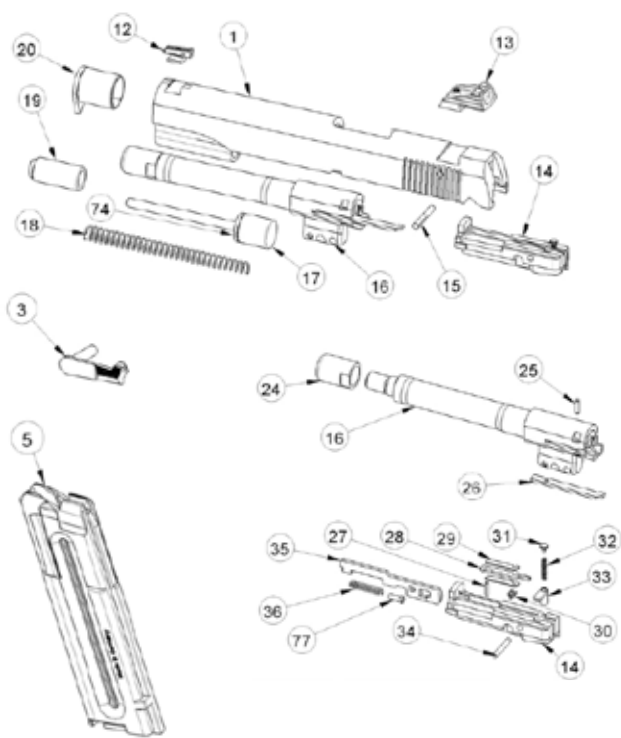
FEATURES

- Hard coat anodized slide assembly
- 10 round .22LR magazine
- Drift Adjustable Sights

GENERAL INFORMATION

We recommend using Hi-Velocity .22LR ammunition with this Conversion Kit. While this kit will perform well with the majority of commercially available Hi-Velocity ammunition, not all brands will function as well as others. Try different brands until you find a selection that provides a level of performance you are satisfied with. Using standard velocity ammunition will cause erratic or inconsistent function of the Conversion Kit.

1911-22 CONVERSION KIT PARTS



- 1 Slide
- 3 Slide Stop
- 5 Magazine
- 12 Front Sight
- 13 Rear Sight
- 14 Breech Bolt
- 15 Breech Bolt Pin
- 16 Barrel
- 17 Recoil Spring Guide
- 18 Recoil Spring

- 19 Recoil Spring Plug
- 20 Barrel Bushing
- 24 Muzzle Cap
- 25 Ejector Pin
- 26 Ejector
- 27 Extractor Pin
- 28 Extractor
- 29 Extractor Spacer
- 30 Extractor Spring
- 31 Firing Pin Safety Plunger

- 32 Firing Pin Safety Spring
- 33 Firing Pin Safety
- 34 Firing Pin Retainer
- 35 Firing Pin
- 36 Firing Pin Spring
- 71 Trigger Screw
- 72 Staking Pin
- 73 Guild Rod Bushing
- 74 Guide Rod Disk

1911-22 CONVERSION KIT INSTRUCTIONS

⚠ WARNING – MAINTENANCE



Verify the magazine is removed – visually and physically confirm the pistol is unloaded before attempting disassembly or performing any maintenance steps. Failure to ensure the firearm is unloaded could result in unintentional discharge, causing injury or death.

VERIFY THE FIREARM IS UNLOADED

Before disassembling, remove the magazine:

- Check before cleaning if the pistol is unloaded.
- Do not put your finger into the slide.
- Unload and the pistol (See Section 6.0 of the 1911 owners manual)

1911-22 CONVERSION KIT INSTALLATION

⚠ WARNING – SPRING UNDER PRESSURE

Recoil spring and recoil spring plug are under pressure. Use caution when removing the barrel bushing uncontrolled, the recoil spring and the recoil spring plug could dislodge from the slide assembly causing injury. **MAINTAIN POSITIVE CONTROL DURING SLIDE ASSEMBLY TO PREVENT DAMAGE OR INJURY. WEAR EYE PROTECTION.**

PISTOL DISASSEMBLY

Removing The Center Fire Slide Assembly

1. Always make sure the magazine is removed and the pistol is not loaded.
2. Position the pistol so that the muzzle is pointed up and rest the back end of the pistols frame on a table.

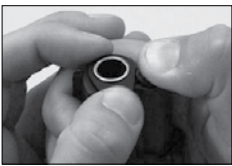


Fig 1: Rotating the barrel bushing

Fig 2: Releasing the recoil spring

Fig 3: Removing slide stop

3. Pull the slide back about 1/4 inch. Press down on the recoil spring plug while rotating the barrel bushing clockwise about 1/4 turn (see Figure 1). If necessary, use a barrel bushing wrench. Once the bushing is rotated, the plug and recoil spring will be free. Keep the plug contained with both hands and allow the recoil spring to fully extend (see Figure 2).

4. Remove the plug from the spring.

5. Cock the hammer.

⚠ WARNING – Dropping the hammer while the slide is removed from the frame will cause damage to the frame.

6. Pull the slide to the rear until lug on slide stop is aligned with the disassembly notch. Push on the end of the slide stop shaft that protrudes from the right side of the pistol and remove the slide stop from the left side (see Figure 3).

7. Push the slide forward off the frame.

PISTOL ASSEMBLY

Assembling the 1911-22 Slide Assembly

1. Ensuring the plunger lever is in the down position (see fig 4 & 5) install the 1911-22 slide assembly onto the frame of the pistol.

2. Position the slide so that you can see the hole in the barrel through the slide stop hole. Push the slide stop into the slide stop hole, but don't fully insert it. Align the slide stop lug with the disassembly notch. Now push the slide stop up and in against the slide stop plunger until the slide stop is fully inserted. **NOTE:** Use only the slide stop supplied with the conversion kit for proper function.



Fig 4: Plunger lever in the down position ready for assembly.



Figure 5: Plunger lever in the up position.

⚠ WARNING – This condition will stop rearward travel of the slide and can cause damage to the plunger lever or frame.

SIG SAUER® LIMITED LIFETIME WARRANTY

SIG SAUER® warrants that the enclosed .22LR Rimfire Conversion Kit (Kit) was originally manufactured free of defects in material, workmanship and mechanical function. For the lifetime of the original purchaser, SIG SAUER agrees to correct any defect in the Kit for the original purchaser by repair, adjustment or replacement, at SIG SAUER's option, with the same or comparable quality components (or by replacing the Kit at SIG SAUER's option); provided, however, that the Kit is returned unloaded and freight prepaid to SIG SAUER at 18 Industrial Drive, Exeter, NH 03833. This limited warranty is null and void if the Kit has been misused, damaged (by accident or otherwise), fired with handloaded, reloaded or improper ammunition, fired with an obstruction in the barrel, damaged through failure to provide reasonable and necessary maintenance as described in the manual accompanying the Kit, or if unauthorized repair or any alteration, including of a cosmetic nature, has been performed on the Kit. This limited warranty does not apply to normal wear and tear of any parts. Subject to the foregoing, this limited warranty confers the right to have the covered Kit or its parts repaired, adjusted or replaced exclusively upon the original purchaser, which right is not transferable to any other person. No implied warranties of any kind are made herein and this warranty does not apply to any accessory items attached or appurtenant to the Kit. In no event shall SIG SAUER be liable for any incidental or consequential damages arising from or in connection with this limited warranty.