

## XS Sight Systems Installation Instructions for Kahr Arms

**Included:** Front Sight, Rear Sight, Threadlocker, Delrin Punch, Allen Wrench

**Needed:** Hammer, Degreaser, Q-Tips, Vise, Brass Punch, 6-8" smooth file, 60° dovetail file, Digital Calipers

**Do NOT Use:** Sight Pusher Tool

**WARNING** – BEFORE INSTALL OR ADJUSTING YOUR SIGHTS, BE SURE THE GUN IS UNLOADED! DOUBLE CHECK TO BE SURE. Please read and understand all instructions before attempting to install sights.

### **DISSASSEMBLY OF FIREARM:**

1. With the pistol pointed in a safe direction, remove the magazine and ensure that there are no rounds in the chamber. Visually inspect to ensure that the pistol is completely unloaded.
2. Remove the slide from the pistol.
3. Remove the barrel and recoil spring assembly from the slide.

### **FRONT SIGHT:**

1. Place the slide in a padded vise.
2. Drive out the existing sight from the base, using a brass or steel punch.
3. Clean the factory dovetail until smooth (Q-tip, toothbrush, file as necessary).
4. Slide the sight into the dovetail. Entry side does not matter; test both sides to find the best fit. If it goes in at least  $\frac{3}{4}$  of the way (Figure 1), or loosely slides through, skip to step 8. **A tight friction fit is not necessary.**
5. Using a dial or digital caliper, measure:
  - a. The depth of the dovetail on the slide from top of slide to bottom of dovetail cut



- b. Front sight from bottom of blade to bottom of dovetail section



6. Using a smooth file on a flat surface, pull the sight across the file 1 stroke, turn 180° and repeat. Duplicate until the sight slides into the dovetail  $\frac{3}{4}$  of the way. (See Figure 1) Take note! Do not file the dovetail (5b) shorter than the depth measured in Step 5a. If the sight still does not fit, but you have reached the minimum height, move to step 7; otherwise, skip to step 8.



Figure 1

7. Using a dovetail file, evenly file the sides of the dovetail until the sight enters  $\frac{3}{4}$  of the way.
  - a. 60° Dovetail Slot sight base file (Brownells #080-648-260WB)
8. Remove the sight. Degrease the dovetail and the sight.
9. Apply red threadlocking compound to all mating surfaces. \*Red threadlocker is a necessary component of our installation process – sights will fall off without the use of red threadlocker.
10. Install the sight using a non-marring punch.
11. Let the slide sit for 15 minutes. Remove the excess red threadlocking compound with a Q-tip and let set for 3 hours.

**REAR SIGHT:**

1. Place the slide in a padded vise.
2. Drive out the existing sight using a brass or steel punch.
3. Clean the factory dovetail until smooth (Q-tip, toothbrush, file as necessary).
4. Slide the sight into the dovetail. If it goes at least  $\frac{3}{4}$  of the way, or fits without resistance, skip to step 5. **Friction fit is not necessary.**
5. Using a smooth file, follow the method in Figure 1 to remove steel from the bottom of the Express Sight until it will enter the dovetail  $\frac{3}{4}$  of the way.
6. Install the sight and snug down the set screws (if any) using finger pressure only. If you wish to zero the sights at this time you may, note the adjustment of the rear sight.
7. When you are satisfied with your zero, apply red threadlocking compound to both the right and left edges of the sight and allow it to leach under the sight. This will lock the sight in place but still allow for windage adjustments with the non-marring punch by drifting the sight left and right. \*Red threadlocker is a necessary component of our installation process – sights will fall off without the use of red threadlocker
8. Let the slide sit for 15 minutes, then remove excess red threadlocking compound with a Q-tip and let set for 3 hours.

**DISCLAIMER NOTICE:**

Failure to properly install this sight on your Kahr pistol may result in personal injury, death, damage to the sight system, or damage to your firearm. Kahr Arms is not responsible for any damages as a result of the installation of this sight system. Accordingly Kahr Arms factory warranty will void due to improper installation and or damage to the firearm.