



Brownells Lip Forming Anvil and Yoke help the gunsmith alter original equipment-style, .45 caliber, 1911 Auto magazines to properly feed ammunition with semi-wadcutter bullets.

Issue-style feed lips are designed for round nose, 230 grain, jacketed bullets which have a long ogive and ride up the barrel's feed ramp easily. Rounds loaded with shorter, lighter, blunt nosed or semi-wadcutter bullets can either run into the feed ramp as the slide carries them forward or "stand up" too soon and cause a smokestack jam.

Changing the lip contour with these tools causes the magazine to release the rear of the cartridge sooner so the extractor can pick it up and help direct it up the ramp and into the chamber.

Most aftermarket magazines like those made by Metalform, Wilson, McCormick, Pachmayr and others, already have a similar feed lip shape. The Lip Forming Anvil and Yoke can often be used to restore the lips on these magazines if they get damaged.



**WARNING**



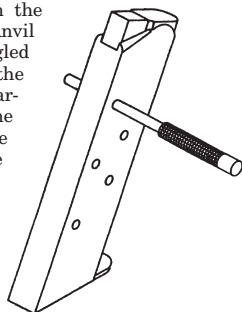
Never attempt to disassemble or reassemble a firearm unless you are absolutely certain that it is empty and unloaded. Visually inspect the chamber, the magazine and firing mechanism to be absolutely certain that no ammunition remains in the firearm. Disassembly and reassembly should follow the manufacturer's instructions. If such instructions are not immediately available, contact the manufacturer to see if they are available. If they are not available at all, then you should consult other reference sources such as reference books or persons with sufficient knowledge. If such alternative sources are not available and you have a need to disassemble or reassemble the firearm, you should proceed basing your procedures on common sense and experience with similarly constructed firearms.

With regard to the use of these tools, the advice of Brownells Incorporated is general. If there is any question as to a specific application it would be best to seek out specific advice from other sources and not solely rely on the general advice and warnings given.

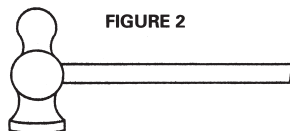
**HOW TO USE**

Remove both follower and spring from the magazine. Coat the Magazine Lip Forming Anvil with a light lubricating oil and insert the angled end into the magazine until the 1/8" hole in the Anvil lines up with the magazine hole nearest the feed lips. Put a punch through the two holes to help keep Anvil and magazine together (see Figure 1). If you are using the Lip Forming tools to restore the lips on an aftermarket magazine, the Anvil hole may not line up with a magazine hole. In this case, slide the Anvil in until about 1/2" of it sticks out above the feed lips.

Place the magazine and Anvil on a smooth, flat, steel surface. Flatten the area ahead of the feed lips on both sides of the magazine with an 8 oz. ballpeen hammer (See Figure 2).



**FIGURE 1**

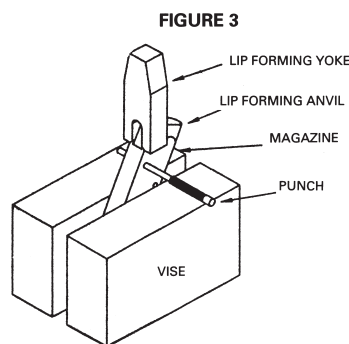


**FIGURE 2**

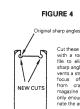


Flatten both sides of magazine at Area "A" with a smooth-faced, ball peen hammer.

Keep the Anvil in the magazine and carefully clamp both pieces in the padded jaws of a bench vise. Tilt the magazine so the feed lips are level when held in the horizontal position (See Figure 3).



**FIGURE 3**



**FIGURE 4**

Position the Lip Forming Yoke over the Anvil until it is in full contact with the feed lips. The Yoke must be VERTICAL, (See Figure 3). Strike the top of the Yoke twice with an 8 oz. hammer. Remove the Yoke and check the feed lips. They should touch the Anvil along the full length and be uniformly bent. If they have not taken the correct shape, reposition the Yoke and strike twice more.

After the lips have been formed, cut reliefs in back of the magazine (See Figure 4).

Remove the Anvil and thoroughly clean and dry the inside of the magazine. Replace the spring and follower, load the magazine and test-fire it in the gun to check for proper feeding.

# BROWNELLS<sup>®</sup> MAGAZINE LIP FORMING TOOLS

READ & FOLLOW THESE  
**INSTRUCTIONS**

## BROWNELLS<sup>®</sup>

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