**Limited Warranty**

Every Wheeler Engineering™ product is warranted to be free of defects in materials and workmanship for a period of one (1) year from the date of original purchase. Wheeler will, at its option, repair or replace without charge, except for transportation costs, parts that fail under normal use and service when operated and maintained in accordance with our instructions. This warranty does not apply to normal wear; to product failures due to modifications by the user; or to items whose life is dependent upon their use and care. This warranty is in lieu of all other warranties, expressed or implied and releases Wheeler Engineering, its affiliates, and its suppliers from all other obligations and liabilities.

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**Instructions**

Revised 1-6-04

**Universal Bench Block**

Product # 672-215

A Battenfeld Technologies, Inc. Product

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**Drifting the Rear Sight:**

The backside of the block is molded with a rectangular, flat-bottomed channel. This channel allows the slide to lay in the correct position while drifting the rear sight (Figure 9).

Figure 9

**Staking the Front Sight, Dressing the Slide Rails:**

The backside of the block has a round-bottomed channel for laying a pistol slide on its top when stoning burrs from the frame rails or when staking on a new front sight (Figure 10). The .20" deep recess at the end of the channel is designed to hold the front sight steady during the staking operation. Depending on the sight configuration, some modification to the block may be necessary for a secure fit. This position also works for removing the firing pin from Series 80 models.

Figure 2

Figure 10

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Although the Universal Bench Block can be used for disassembly and assembly of virtually any action as shown in Figures 1-3, there are several features designed into this block specifically for 1911-style pistols.
Barrel link pin removal:

The 1911 barrel lays in the v-channel running through the middle of the block. The link pin will align on the 1/4" hole on the block, allowing easy removal of the link pin. (Figure 4).

Removal of Hammer and Sear Pins:

The frame will lie flat on the surface of the block with the plunger tube aligned with the square channel at the top of the block and the magazine release and grip screw bushings aligned with strategically placed holes (Figure 5). The hammer and sear pins can now be easily removed.

Mainspring Removal:

The rectangular recess and round boss at the bottom of the block allow the spring plunger to be easily compressed while removing or replacing the retaining pin (Figures 6 & 7). When replacing the retaining pin, rotate the mainspring housing 180° (Figure 8).

Applications:

Drifting and Staking Assembly Pins (see figures 1-3).

WARNING: ALWAYS MAKE SURE FIREARMS ARE UNLOADED BEFORE ATTEMPTING DIS-ASSEMBLY OR REASSEMBLY. INSPECT THE CHAMBER AND MAGAZINE TO BE SURE THERE IS NO AMMUNITION IN THE FIREARM.

CAUTION: WEAR SAFETY GLASSES WHILE DISASSEMBLING AND ASSEMBLING FIREARMS.

Dressing the Ejector Port:

The round bottomed channel described above will also hold the slide upright while opening up or flaring the ejection port or removing the firing pin (Figure 11).