
APEX LOW-PROFILE MAGWELL INSTALLATION INSTRUCTIONS

**FOR SPRINGFIELD ARMORY SA-35/BROWNING
HI-POWER/GIRSAN MC P35 PISTOLS**



RECOMMENDED INSTALLATION TOOLS:

Springfield SA-35

- Permanent Ink Marker or Dykem Layout Fluid
- Digital or Dial Calipers
- Small Pillar or Needle File – Preferably with safe sides and 3/8” or less in width
- Small Non-Marring Hammer (Plastic or Rubber Ends)
- 3/16” and 7/32” Dia. Roll Pin Punches (Use 3/16” Roll Pin Punch to remove pin from frame)
- 5mm Split Pin (provided in kit)
- Granite Tile (available at Home Depot/Lowes)
- 600, 1500 Grit Wet/Dry Sandpaper

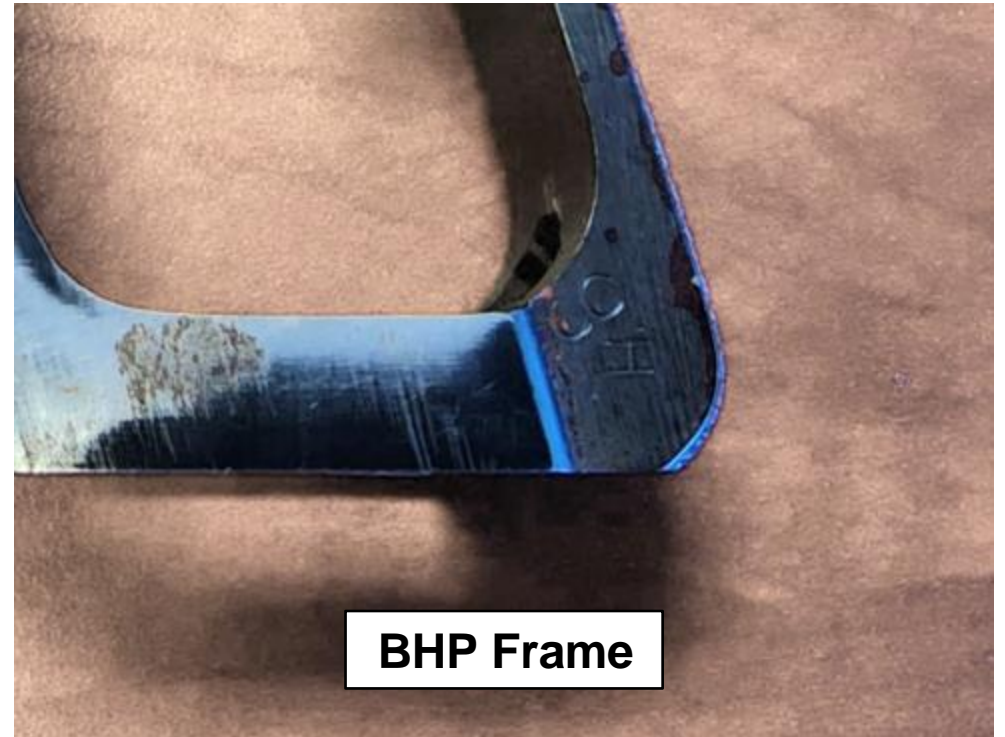
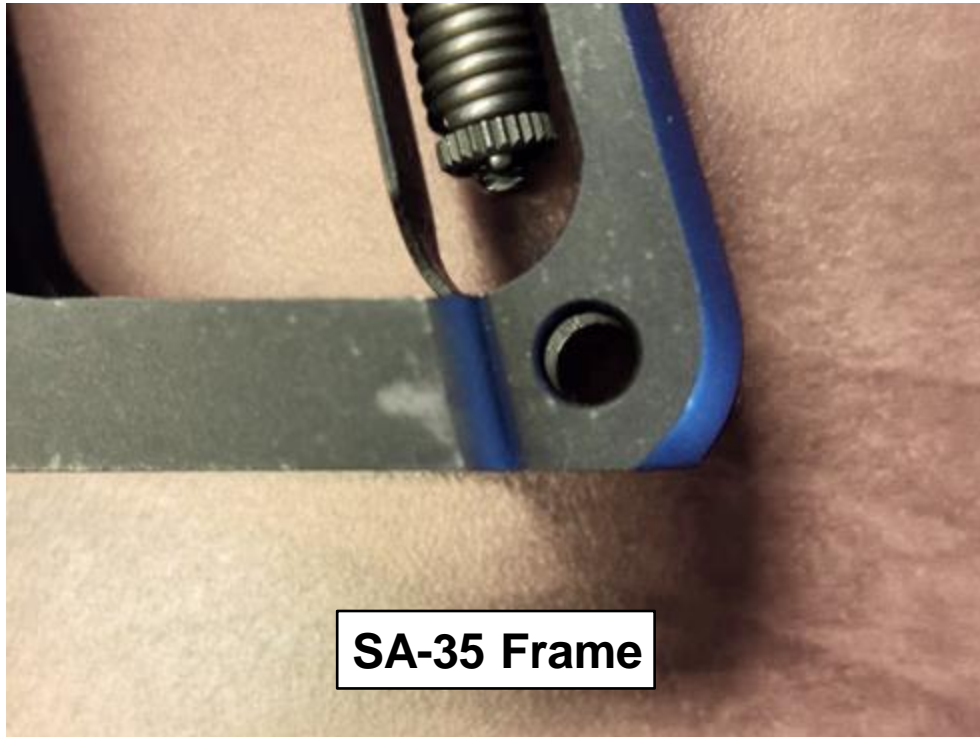
Additional tools needed for Browning Hi-Power/Girsan MC P35 Standard Frame (NOT MATCH or OPS)

- Vertical Mill or Sturdy Drill Press
- #7 Drill (provided in kit)
- Anchor Bushings (2 provided in kit) 5mm Split Pin provided in kit is **NOT** used for BHP/Girsan Frames
- 0.202” Pin Gauge for aligning mill/drill to magwell anchor hole locations
- Method or fixture to secure the frame for milling/drilling. We recommend the Apex Hi-Power Tac Magwell Drill Fixture (coming soon)

SPRINGFIELD VS BROWNING FRAME COMPARISON



BEFORE YOU START!



Note: Bottom of frames may be different in this critical area!

FRAME INSPECTION/PREPARATION FOR MAGWELL INSTALLATION



SPRINGFIELD AND BROWNING FRAME INSPECTION/PREPARATION



Thickness of retaining ledge = 0.350 ± 0.005 . If your frame does not match this dimension, **STOP** and call Apex Customer Service



Increased lip due to machining differences on BHP Remove lip prior to magwell fitting

BROWNING HI-POWER FRAME RETAINING LEDGE ADJUSTMENT

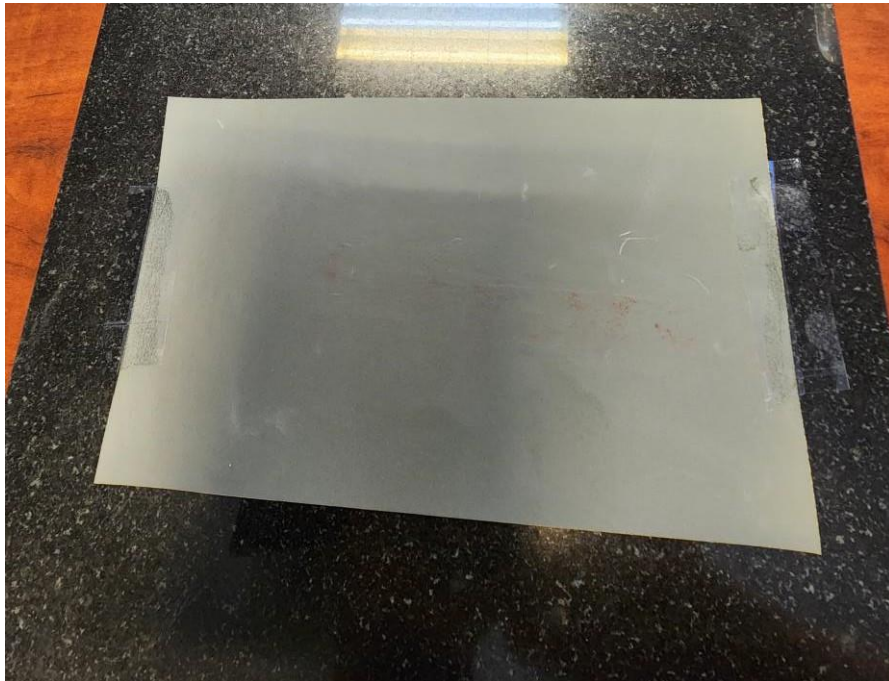


File raised lip on frame to correct dimension



Frame lip filed to correct dimension – both sides of frame 0.350

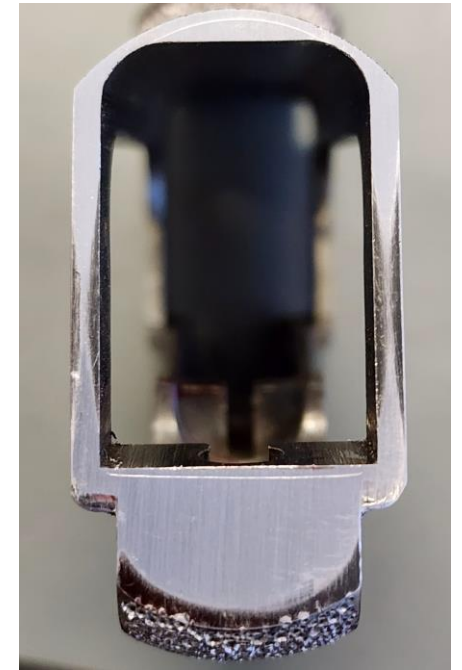
FRAME PREPARATION FOR MAGWELL INSTALLATION



Granite tile with 1500 grit sandpaper

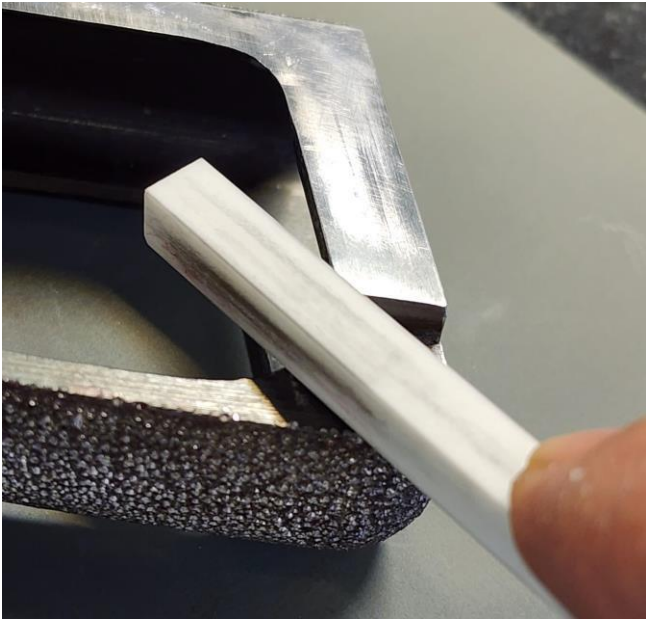


True up bottom of frame

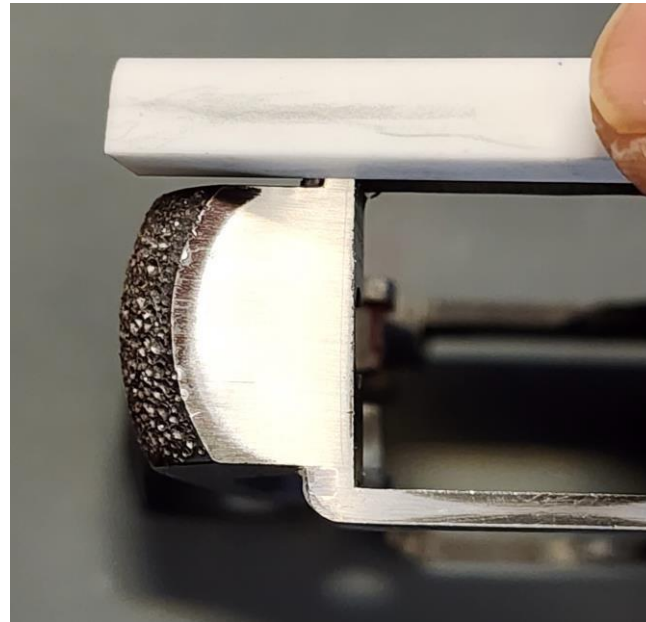


Bottom of frame trued and leveled

FRAME PREPARATION TIPS – SA-35 AND BHP/GIRSAN



Stone filed edge and bevel

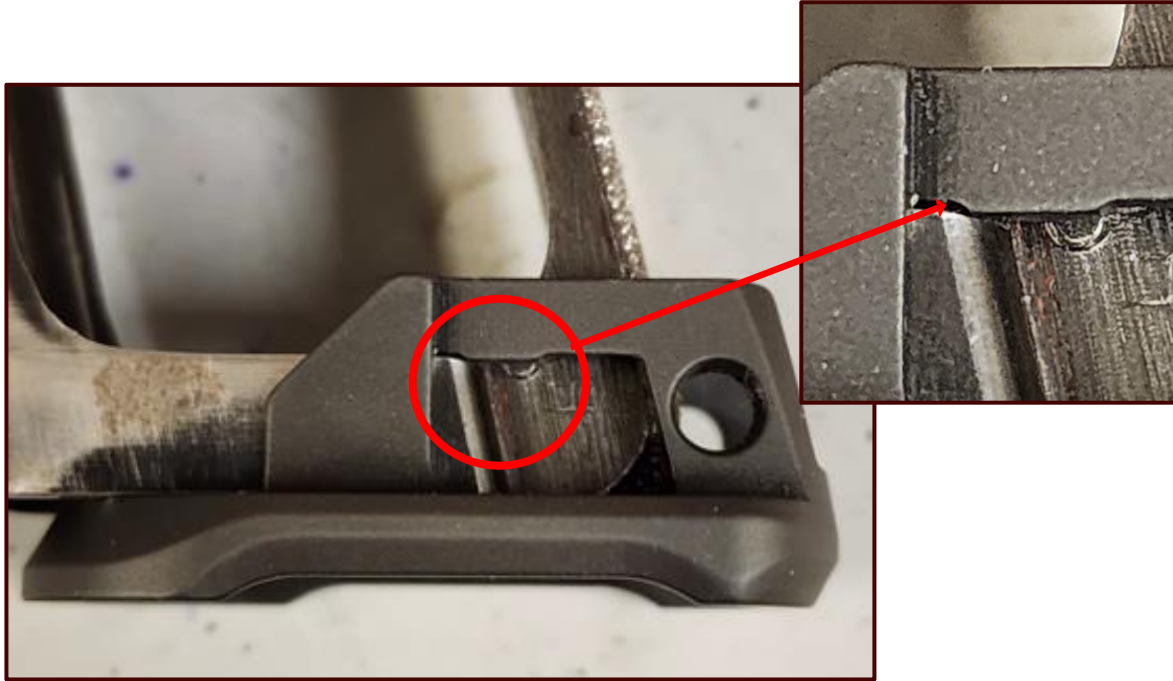


Stone and bevel bottom edges of frame



Stoned and beveled

MAGWELL FITTING PROCEDURE – SA-35/BHP/GIRSAN



Slide magwell onto frame until fitting tabs make contact

Using finger pressure to hold the bottom of the magwell down against the frame and fitting pads contacting the frame tangs, with a plastic mallet lightly tap the rear of the magwell in area shown.



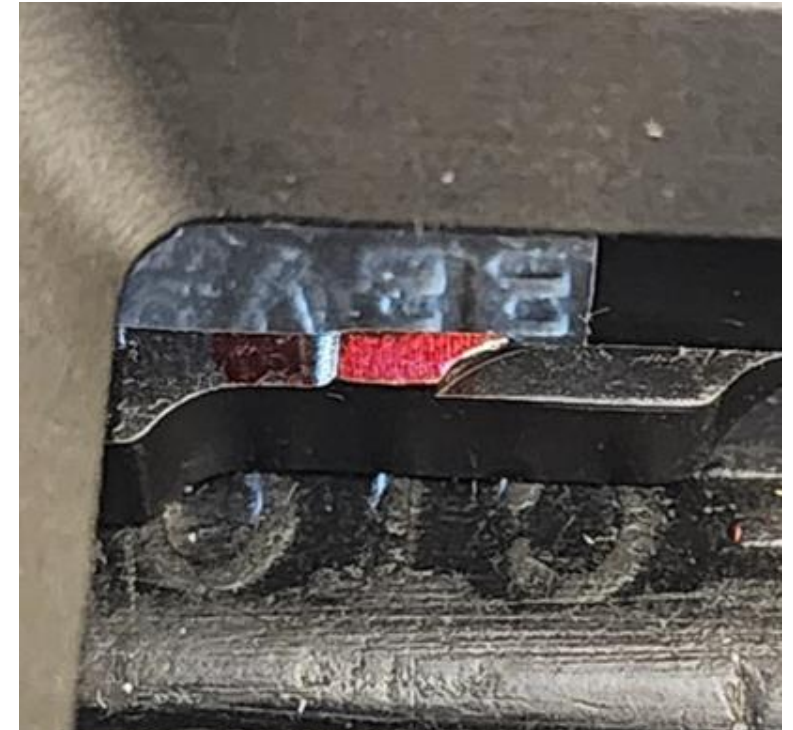
MAGWELL FITTING PROCEDURE – SA-35/BHP/GIRSAN

Note witness mark left after tapping with plastic mallet. Witness marks should be present on BOTH left and right side fitting pads

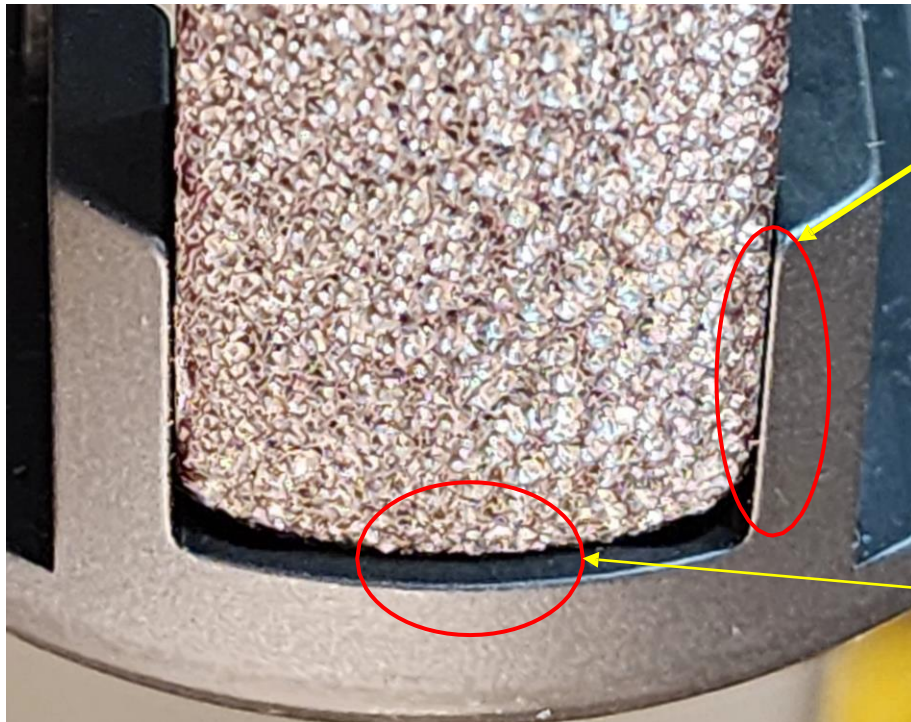


Using a small safe sided file, take down surfaces of left and right fitting pads evenly. 4" Pillar file is available on our website. Part # 104-009

Coat fitting pads with colored marker and repeat tap and file process until magwell is fully seated forward and stops against rear of frame.



MAGWELL FITTING PROCEDURE –BHP/GIRSAN PISTOLS



Support towers are at or slightly below flush with frame sides

Rear bottom of frame in solid contact with magwell stop surface

Magwell is fully seated to BHP frame



Magwell is correctly fit and aligned with frame channel.
Ready to blend!

BHP/GIRSAN ANCHOR BUSHING INSTALLATION PROCESS

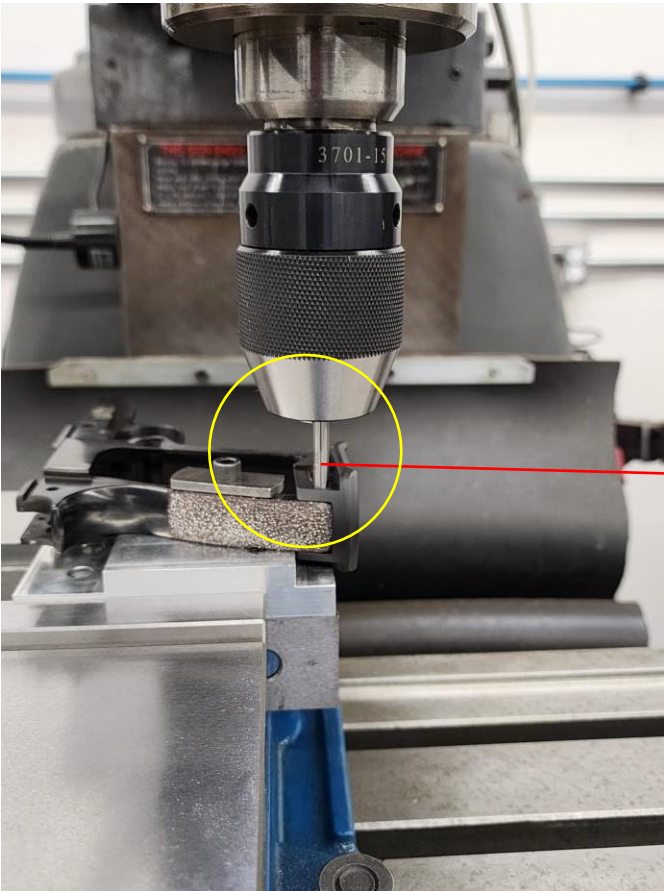
TOOLS NEEDED:

- Mill or Drill Press with mounted vise
- # 7 Drill (Included in kit)
- Anchor Bushings (2 included in kit)
- 4-40 Socket Head Screw (Included in kit)
- 0.202 inch Pin Gauge (McMaster-Carr, Grainger, etc.)
- Method or fixture to secure the frame for milling/drilling.

We recommend the Apex BHP Frame Milling Fixture
(coming soon)

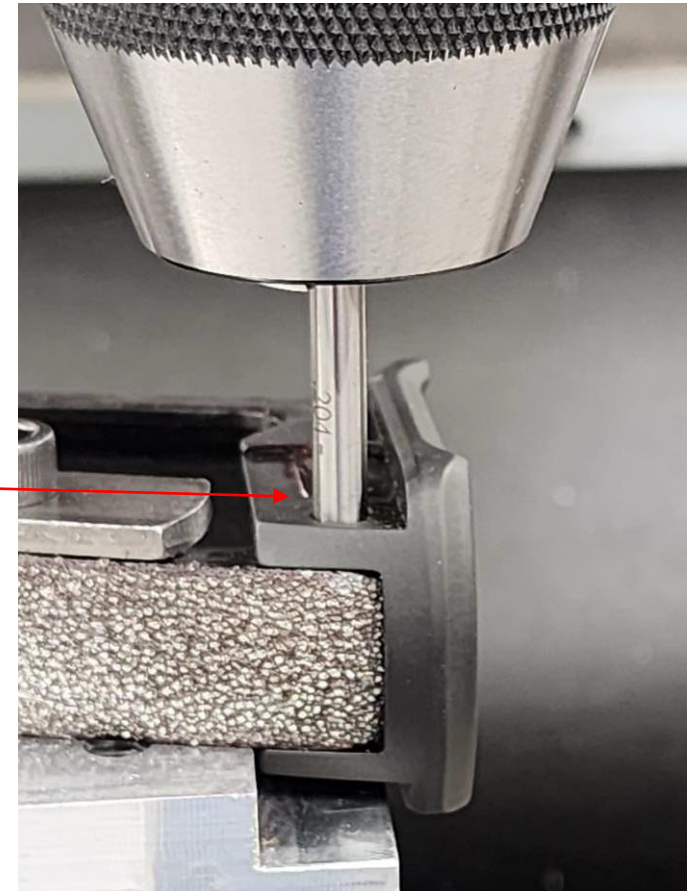


BHP/GIRSAN ANCHOR BUSHING INSTALLATION PROCESS



STEP 1

Use 0.202" Gauge Pin to center Collet/Drill Chuck to magwell anchor hole



BHP/GIRSAN ANCHOR BUSHING INSTALLATION PROCESS



STEP 2

Lower provided #7 Drill until it contacts the side of the frame

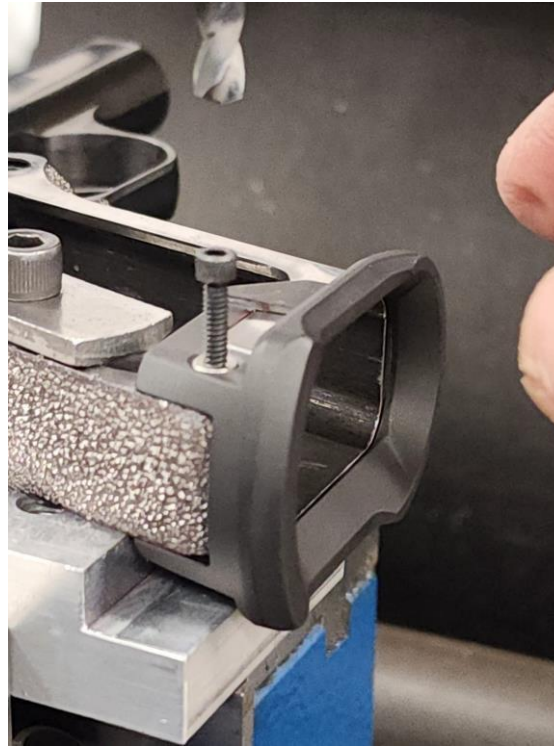
Drill to a depth of 0.185" +/- 0.005".
Raise Quill and remove frame from fixture. Flip frame to opposite side and repeat **Step 1** and **Step 2**

CAUTION – DO NOT DRILL THROUGH FRAME!

BHP/GIRSAN ANCHOR BUSHING INSTALLATION PROCESS



Raise quill or drop milling table.
Use 4-40 Screw to insert Anchor
Bushing into drilled hole



Press Bushing into hole. Bushing
should be flush to slightly below
flush with the magwell surface



Remove screw. Anchor Bushing
properly seated

SPRINGFIELD ARMORY SA-35 ANCHOR PIN INSTALLATION

TOOLS NEEDED:

- 5mm Split Pin (included in Kit)
- 7/32" Roll Pin Punch
- 3/16" Roll Pin Punch

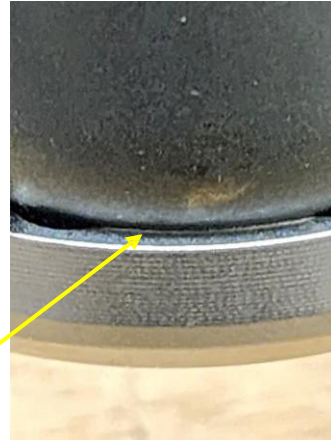
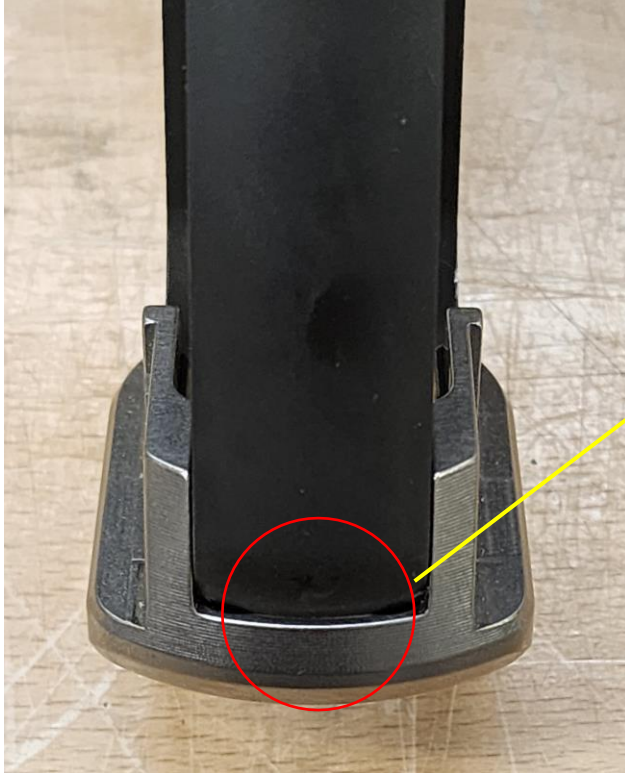


RECOMMENDED ITEMS:

- LOK Grips machined to fit the Apex Magwell
- 115-335 Dark Red/Black Grip Set
- 115-334 Gray/Black Grip set
- Two (2) Grip Screw O-rings (included with grip sets purchased through Apex)
- 7/32" Roll Pin Punch
- 3/16" Roll Pin Punch



SPRINGFIELD ARMORY SA-35 ANCHOR PIN INSTALLATION



Magwell anchor hole and hole through frame should align if magwell is fully seated forward against frame

Verify that the magwell is fully seated forward so bottom of frame contacts the stop surface of the magwell

SPRINGFIELD ARMORY SA-35 ANCHOR PIN INSTALLATION



Use 7/32" Roll Pin punch to begin seating the split anchor pin

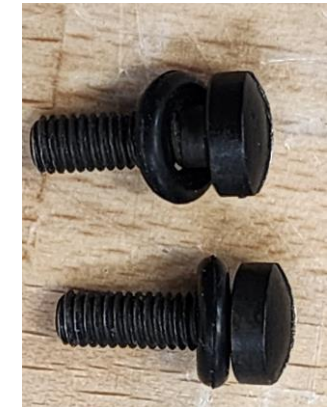


Drive split anchor pin until slightly below flush



If needed, use 3/16" Roll Pin punch to seat anchor pin below surface of magwell. Pin should be below flush on each side

GRIPS TO USE WITH THE APEX LOW-PROFILE MAGWELL



Place O-rings onto grip screws to prevent loosening while shooting

Dark Red/Black and Gray/Black LOK grips made specifically for the Apex magwell are available on [the Apex website](#). For other color options, contact LOK grips directly at 616-389-0666 or visit www.lokgrips.com