

Beretta 21a Hammer spring guide

Items needed

21a Spring kit

3" bolts, nuts, washers

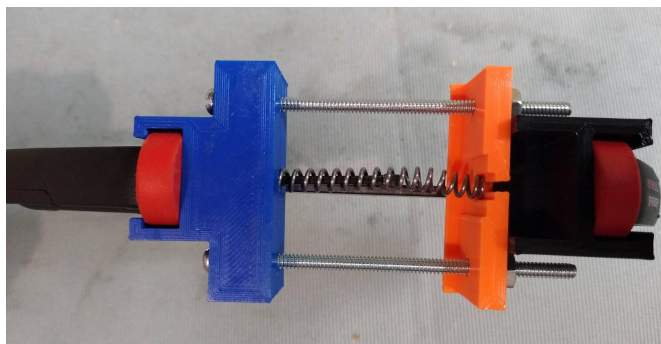
Bar clamp

Vice

Printed jig parts



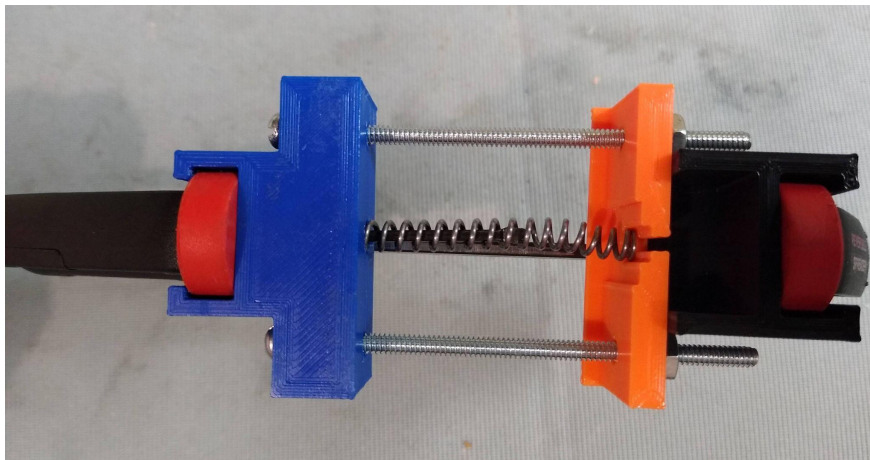
Chances are the bar clamp you use won't fit the supplied jig parts. Just edit the STL so they'll rest securely against the pads.



Once you have the jig setup make sure the hammer strut is oriented correctly. You want the tilted end facing down in the assembly. The notch will be facing up when completed.

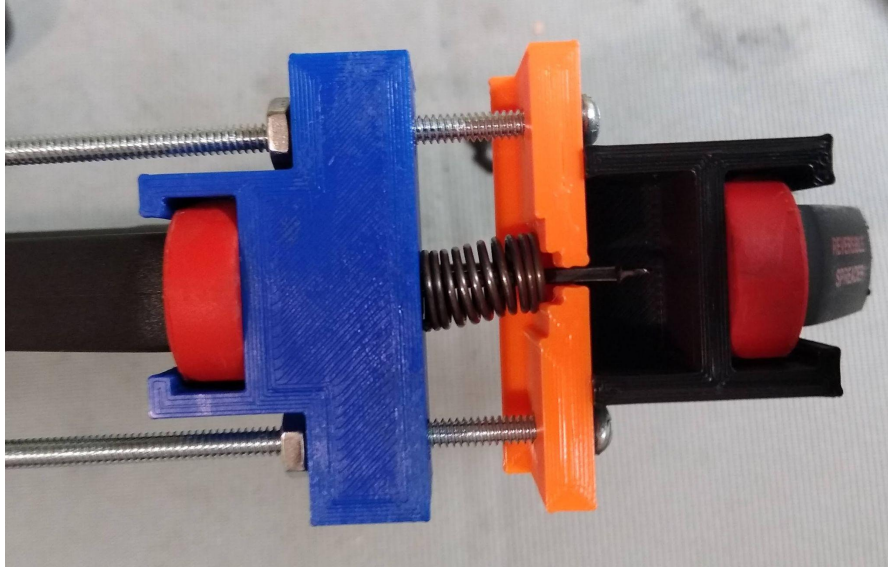


Next start compressing the spring with the bar clamp. Make sure the strut doesn't bind up. Make sure the spring stays straight. Be very careful during this process. You are dealing with a lot of pressure.

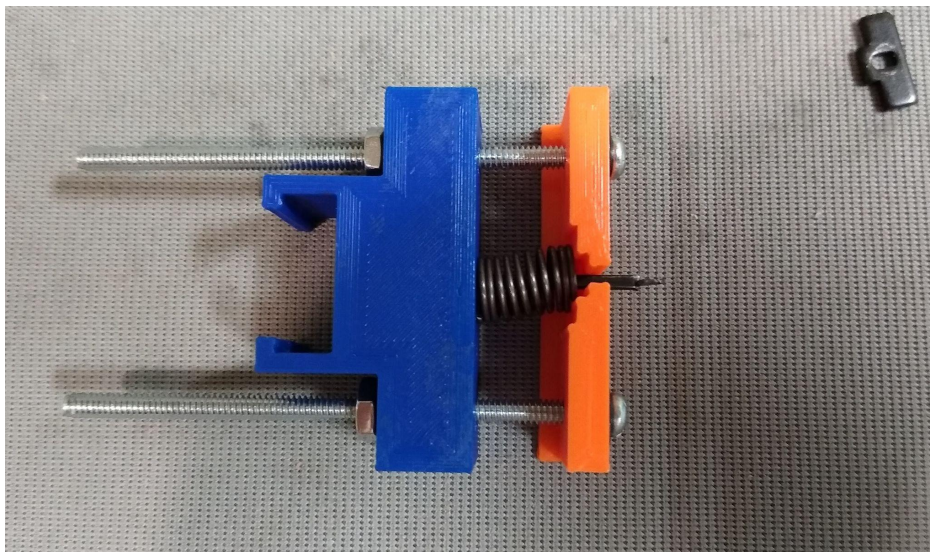


In the process of compressing, draw the bolts down.

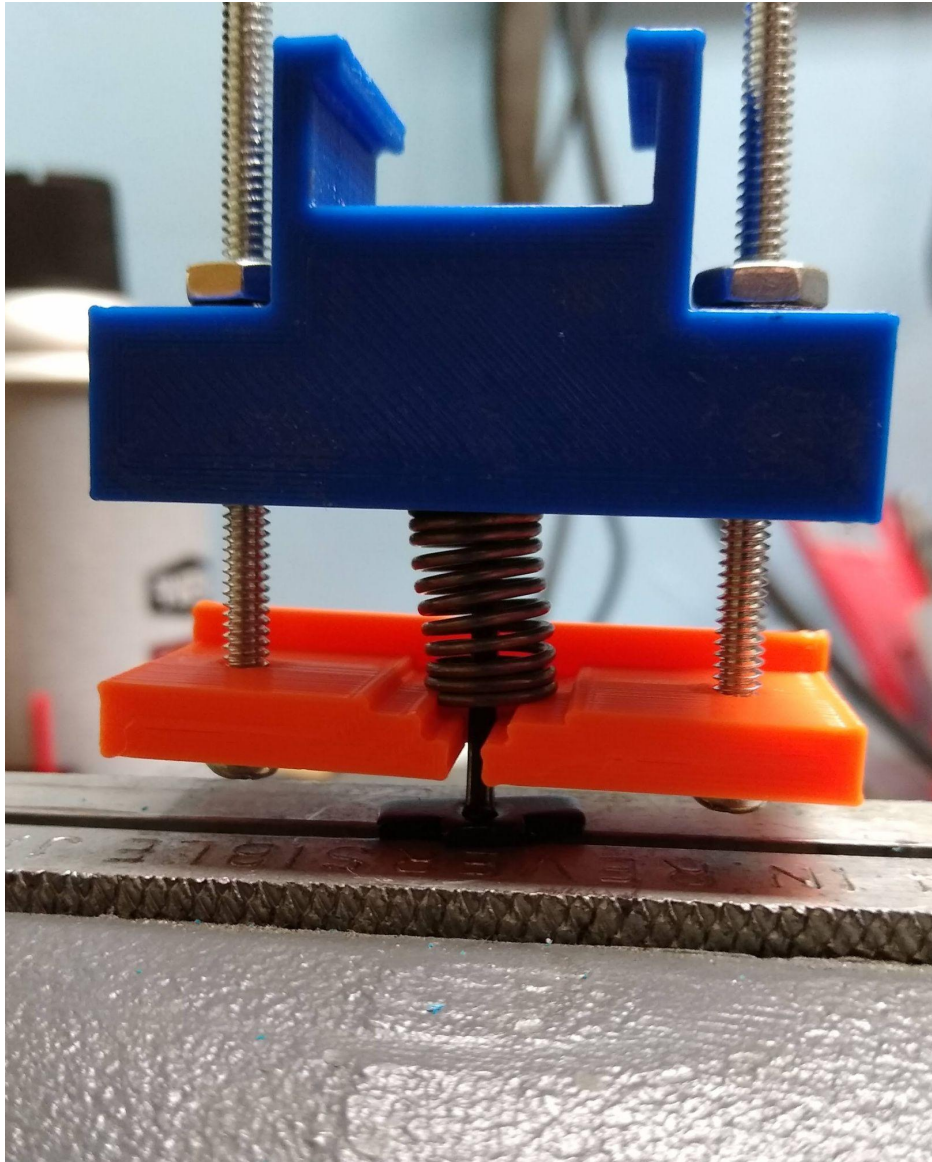
Note the orientation of the bolts, this will be important in the following steps.



Once compressed carefully remove the assembly from the clamp.



Move the assembly over to the vice.



Remember, notch facing forward/up on the retainer.

You will be crushing the end of the strut in the vice.

VERY IMPORTANT

You only want to crush about 2mm of the strut end. If you crush too much your spring will not have enough travel.

Once you have crushed the strut end remove the assembly from the vice. Check to make sure the crushed area will be enough to hold the retaining plate on.

If all is well slowly undo the screws allowing the spring to uncompress. If everything went well and it didn't fly apart you're almost done.

You'll notice the middle section of the jig is trapped, simply cut it away carefully. It sacrificed itself for the job.

Hopefully at this point you have a fully assembled hammer spring strut assembly.

