

G17, 19 & 45 Print and Assembly Instructions

Required tools:

- Xacto knife
- ruler
- 3 & 4mm drill bits (optional)
- Sandpaper/files
- sidecutter
- punches

Build list:

G17 G17 slide, barrel, 3-pin locking block, lower parts kit

G19/45 G19 slide, barrel, 3-pin locking block, G17 or 19 lower parts kit(recommend using G17 kit with longer slide lock spring)

All frames will require 3 pins to complete, some LPKs only come with 2 pins

1. Print frame upside down



Print Temp:210°C Bed Temp:50°C Speed:60mm/s

Layer height:0.1mm Shell:1.2mm 15% infill overlap Line Supports:10%

Suggest printing in PLA, PLA+ or ABS. PLA+ works best. Rear supports can be blocked out if desired. These are only recommended settings, adjust as needed.

Frame should be printed rails down without raft on a clean bed. Glass is the preferred medium to print on. Do not use frames that are warped or printed poorly.

2. Remove supports



Remove rear supports, then remove supports from the front , working your way to the back. Make sure to remove any loose filament strands in the rail cavities. Once internal supports are removed, push out trigger guard supports.

3. Clean up pin holes



Use a sharp blade to lightly go around pin holes. Only remove material at opening. Check fit and remove more material as needed. Pins will fit snugly.

!!!!!!DO NOT DRILL OUT PIN HOLES!!!!!! If needed use a drill bit by hand. Small holes are 3mm, large hole is 4mm.

4. Sand down trigger guard



Sand until smooth and trigger clears. Avoid sanding the upper rear portion where trigger safety lever engages. A fair amount of material can be removed here and still be solid enough to take an impact. Install trigger to check clearance, sand down more if needed.

5. Assemble

For G17:



Top is OE, Bottom is adjusted. Adjust slide lock spring by bending the inserted end towards the other end, if needed. Spring will only need to be adjusted if it will not move freely in channel.

For G19/45:



Bottom is OE, top is adjusted. For Longer spring(left), trim 3/16" off inserted end and adjust as shown. For shorter spring(right), bend slide lock engaging end flat and bent inserted end slightly straight.



Install front rail, slide lock/spring and pin.



Install rear rail, trigger assembly and pin.



Install locking block, slide stop and trigger pin.

6. Verify proper function



Make sure the slide moves freely with no binding. Check for proper trigger function. Rack slide several times with a decent amount of force. Insert an empty magazine and check slide stop function. Once everything works properly, use dummy rounds to check operation before firing.