

Springer Precision

Parts Installation: SIG P320 Legion, M-17,

M-18 and X-Compact Optics Mounts

(Part Numbers SP0202, SP0245, SP0254, SP0255 and SP0257)

Know Your SIG: SIG offers more options and variations than virtually any other manufacturer, so it is critical that consumers take the time to learn their specific pistol model. If you are not sure if you have an X-5 or an X-5 Legion, an X-Carry or an X-Compact etc., *please* take a few minutes to determine this. Many P320 based guns have different optic "footprints" that will not work with optics plates made for very similar looking, and similarly named, variants. If you can't figure it out, contact a SIG factory representative. We at Springer Precision may be able to help, but we will almost always need pictures (usually via email).

Step One: Safety! All Springer Precision parts are intended for installation ONLY ON UNLOADED FIREARMS. Please review our guidelines for safe firearms repair and maintenance, available on our website at <https://springerprecision.com/instructions>.

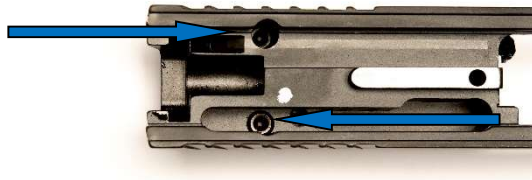
Step Two: Removing the Factory Sight Plate: First, remove the slide from your unloaded pistol. Depress the spring-loaded end of the extractor assembly located on the rear of the slide just to the right of the striker plate. Next slide the striker plate down off the slide. Set the strike plate aside. Remove the striker assembly and set it aside. Note: The striker assembly contains some very small parts held in place by some even smaller springs. We recommend that you place the assembly in a small plastic bag until you are ready to re-assemble.



Slide the extractor plunger rod out of the slide. Make note how this rod is oriented in the slide. Set this assembly aside in a safe place. Remove the extractor by rocking the rear outside corner out of the slide. You should practice removing and re-installing the extractor a few times before moving on. This is also a good time to clean the extractor recess and extractor with a small brush.

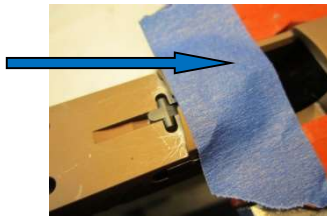


Turn the slide upside down. You will see two holes on the underside of the slide, closer to the rear of the slide than the breach face. There are two machine screws accessed through these holes. These screws hold the sight plate onto the slide. Using the 3/32" hex key (the larger of the hex keys) that came with your new SP optic plate, remove the two screws. Set the screws aside in a safe place.



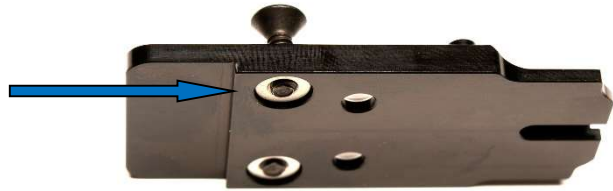
Sight Plate Mounting Screws (2)

Turn the slide back over and carefully lift the sight plate off the slide. **LOADED CHAMBER INDICATOR CAUTION:** If your model comes with a toggling loaded chamber indicator (LCI) at the top of the breach face, be careful. The sight plate secures the LCI in place. The LCI is a small part with a very small spring underneath. We strongly recommend that you use a piece of tape to secure the LCI in place, before lifting the sight plate off the slide.



Checking the MRD and Optic Plate Fit: Remove your SP optic plate from its packaging. Many of our plates are designed to work with more than one micro red dot (MRD) optic. Before you install the plate onto your slide, make sure you have selected the correct screws for mounting your specific MRD. This is best accomplished by placing your MRD on the plate and selecting the screws that pass through your MRD and come as close to flush with the bottom of the plate when snugged down. Remember, the screws cannot extend past the bottom of the plate, or they will prevent the plate from properly fitting with your slide during final assembly. Some of our plates include additional instructions to help you make the best screw selection. If you have any questions, please give us a call.

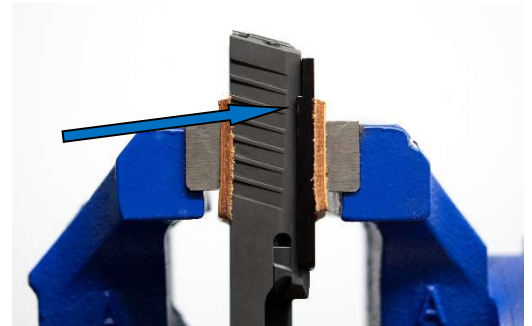
Correct Mounting Screw Fit (flush, but not protruding through)



Mounting the plate: Remove the MRD from the optic plate. Secure the slide, if possible, in a padded vice, or on a firm surface, top up. All of the plates in this instruction are designed to mount from front to back, much like slipping a foot into a shoe. Place the front bottom edge of the plate into the milled recess at the bottom of the front of the slide optic footprint. Be sure to press the plate as far forward as possible.

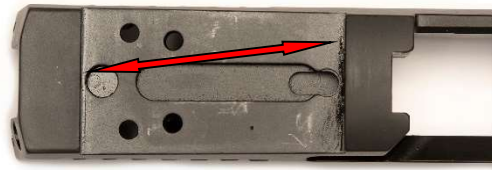


Press Fit: We find that the best way to seat the plate is to place the correctly positioned plate and slide vertically in your vice so that the padded jaws are applying force directly over the rear of the slide recess. Apply light compression with the vice. The mount will slide down into position. There should be a slight “click” as the plate slips into position. Make sure the plate is fully seated before removing the slide and plate from your vice. You can also use other clamping devices in a similar manner (Quik-Clamps, C-Clamps etc.). Be sure to protect your slide and mounting plate from damage by using padding)



Tap Method: As an alternate technique, you can tap the plate down into the slide recess. We recommend you use either a plastic mallet, or another firm but non-marring object. Be sure to apply the force directly over the rear part of the slide recess and not to any portion of the plate that extends back past the rear of the slide recess.





Sight Recess

“Loc-er Down”: With the plate in place, clean all the screws and threaded holes with a degreasing agent (rubbing alcohol, acetone etc.). Apply the blue thread locker to the threaded parts of the screws (WARNING: Don’t squirt the thread locker down into holes then top off with the screw. For all the plates except the SPO245 version, use the two short M4 metric screws to lock the plate down onto your slide. The M4 screws go through the plate in the two relatively large counter sunk holes in a downward direction. For the SP0245 mount (for Trijicon RMR and SRO), use the two cap-head 4-40 machine screws to secure the plate via the two holes on the underside of the slide (similar to how the sight plate was originally mounted). Note: The 4-40 cap head screws look almost identical to the factory *metric* screws that secured the sight plate to the slide. They are not the same! Make sure the screws mounting the plate to the slide are snug (about 14-16 inch pounds of torque). Secure the MRD to the plate using the manufacturer’s torque specs. If you cannot find any specs, we recommend “snug” (about 14-16 inch pounds). Use an adequate amount of thread locker. Allow thread locker to cure for at least 24 hours.



Periodically Check Those Screws!: It is critical that you check all of the screws in your MRD system from time to time. The MRD and mounting system experience a lot of snapping, jarring inertia, momentum etc with every shot. We recommend that you check the system at least as often as you give your gun a thorough cleaning (about every 500 rounds). Vibration is the enemy of the MRD slide mounting system. Good maintenance will extend the life of every part of the system.

Sighting In: Please review our Sighting-In Tips (<https://springerprecision.com/instructions>).

Final Step: Go shooting!! Enjoy your new MRD pistol, it’s a blast.