



Instructions for EWK Arms adapters/alignment washers for S&W 422 Series

Over the years of offering the Smith & Wesson 422 series thread adapters, we have occasionally received customer feedback in regards to POI (Point of Impact) shifts after installing a thread adapter. At first, this seemed limited to the model 61/Escort. Recently, as the popularity of the 422 series has increased, this problem has become somewhat more common, and has cropped up with multiple models. Based on customer feedback, this doesn't seem to be a prevalent issue. To make a long story short, it seems the problematic pistols have frames, where the adapter bottoms, that are out of square in relation to the barrel. So when the adapter is tightened down, the out of square frame pulls the adapter out of alignment in relation to the barrel bore. The alignment washers are designed to solve this issue.

These washers are designed for use with EWK Arms thread adapters. The washers are not designed to compensate for manufacturing issues with the thread adapter itself, which may be an issue with other makers adapters. EWK Arms 422 series adapters are “zero run out” meaning the OD and ID threads are perfectly concentric, being machined in one setup.

IMPORTANT-Before beginning installation of the adapter/washers, insure the gun is unloaded-magazine removed and no round is in the chamber.

THREAD ADAPTER INSTALLTION-

Install the adapter, and check the alignment. We don't recommend using the factory lock washer, as it tends to cut up the frame, and the rough surface of the frame from the cuts/dents will cause issues with alignment. If there are any rough/raised spots from the lock washer on the frame, they need to be removed/smoothed first. Torque the adapter to 25 INCH (not foot) pounds. This is very important, as more than 25 inch pounds tends to distort the barrel, and will cause POI shifts also. Check adapter/barrel bore alignment. If good, you may need to use removable thread locker to keep the adapter from working loose during use. If alignment is out, remove the adapter, and install the alignment washers.

ALIGNMENT WASHER INSTALLTION-

See Figure 1. Install the smaller washer first, with the flat face of the washer bottomed against the frame, and its conical face facing outwards. Install the larger washer, with its conical face mating with the previously installed washer, and its flat face towards the thread adapter.

Insert alignment rod in barrel bore.

Install the thread adapter into your 1/2-28 device so the shoulder of the adapter just bottoms against the device or is a small amount away from it. We want to be able to easily screw the adapter out of the device later on, while the adapter remains on the barrel threads. The 1/4” hex wrench used with the adapter can be inserted from the barrel thread side of the adapter if the adapter gets stuck in your device.

See figure 2. Thread the device/adapter combination onto the barrel threads. Note the alignment before the adapter bottoms in the frame pocket. If you can pull/center up the device bore in relationship to the alignment rod while the adapter is loose, that is a good sign the alignment washers will work on your gun!

Snug/bottom the adapter/device combination on the barrel threads and check alignment. If alignment is out, loosen

the thread adapter from barrel threads just enough to shift the device to center it up on the alignment rod, tighten, and recheck. Once you have the correct alignment, screw the device off, and remove alignment rod. Torque the adapter to 25 inch pounds. Install the device on the thread adapter, reinsert the alignment rod, and check alignment. Repeat the process until correct/concentric alignment is achieved. You may need to use removable thread locker to keep the thread adapter from backing off during use.

If you are unable to get correct alignment, try reversing the alignment washers-large washer installed first, and the small one next. Again, the conical faces of both still mating.

Any questions or feedback, please don't hesitate to contact EWK Arms. Any feedback, good or bad, is greatly appreciated!

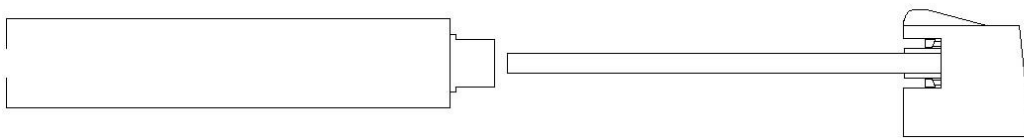


Figure 1

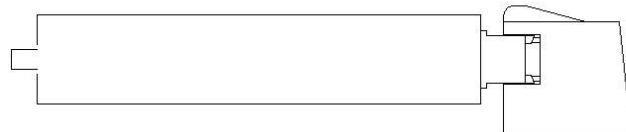


Figure 2