

PY2A G Frame Print and

Assembly Instructions



Required tools:

- Utility Knife
- Sandpaper/File
- Needlenose Pliers
- Punch Set and Mallet
- Chisel
- Flat tip Screwdriver

Build list:

G17/69 - PY2A rails, G17 slide, barrel, G17 3-pin locking block, lower parts kit

G19/45 - PY2A rails, G19 slide, barrel, G19 3-pin locking block, lower parts kit

G26/96 - PY2A rails, G26 slide, barrel, G26 3-pin locking block, lower parts kit

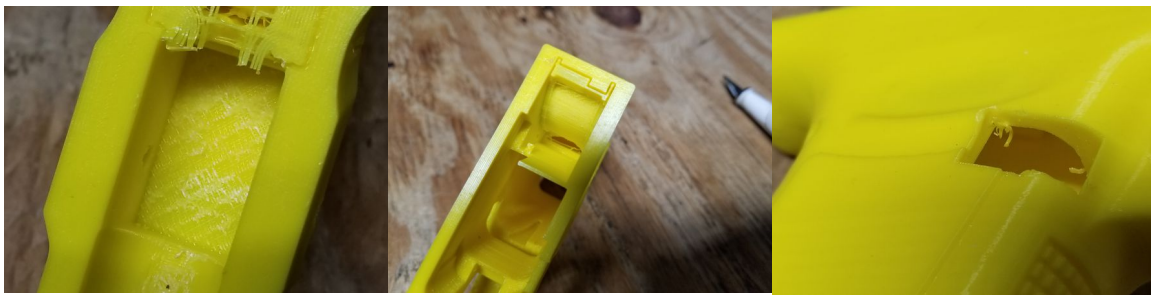
All frames will require 3 pins to complete, some LPKs only come with 2 pins. Parts to complete frames are available at PY2A.com



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

Layer height: 0.1-0.12mm 100% infill 15% infill overlap Line Supports: 10% density

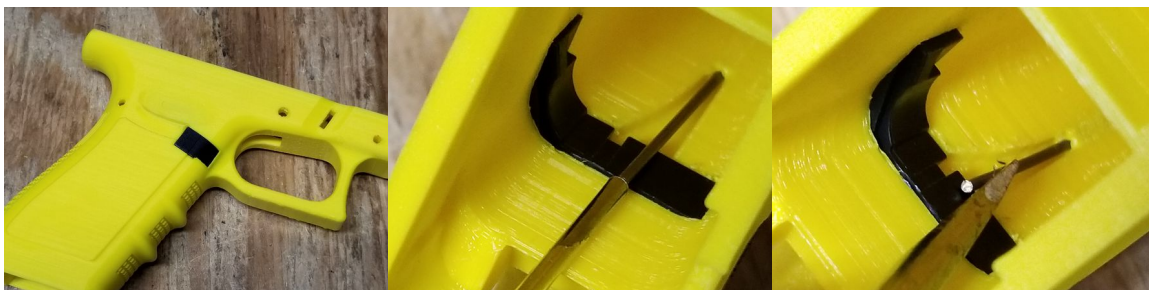
Suggest printing in PLA+ or Nylon. Rear supports can be blocked out if desired. These are only recommended settings, adjust as needed. Frame should be printed rails down without raft on a clean bed. Glass is the preferred medium to print on. Do not use frames that are warped or printed poorly.



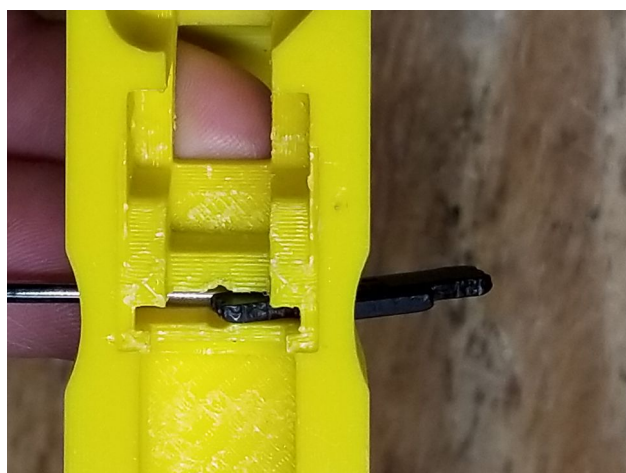
Remove all supports. Make sure to remove any loose filament strands in the rail cavities. Rails may not fully seat and other components may not function properly if this step is skipped.



Check fit of all pins before assembly. 3mm pins will fit snugly. In most cases the pins can be tapped in with a plastic or brass mallet **DO NOT DRILL OUT 3MM PIN HOLES**. Trigger pin hole can be drilled out with 4mm bit, if needed. Remove pins and check mag catch clearance. Clean pocket if needed.



Install mag catch spring and seat with punch until deep enough to clear spring slot. Push into slot with flat tip screwdriver



Insert slide lock spring and hold down with small punch. Slide stop lever can then be pushed over the punch until the corner covers the spring



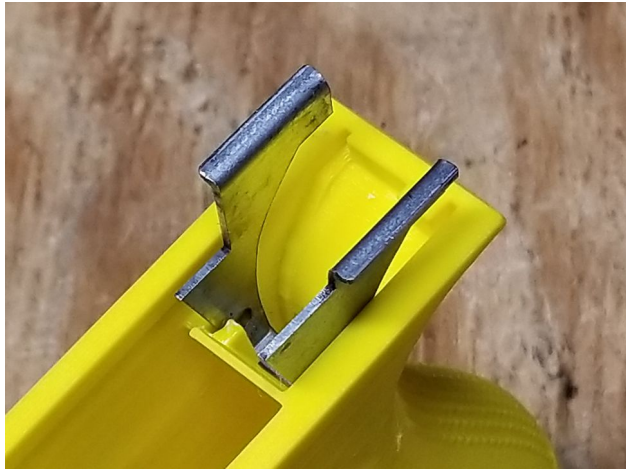
With lever over spring remove punch and insert the rest of the way. Push down in the middle to clear opening on opposite side



Install front rail and rail insert. Check that rail/ insert seats fully and holes line up



Use the longer 3mm pin(oe glock locking block pin) for the front rail. The short 3mm pin(trigger housing pin) holds the rear rail. Install the front pin. Check that the depth is even on both sides.



Install rear rail and trigger assembly. Make sure rear hole lines up and install rear pin. If you are having trouble installing the pin, try from the other side.



Install locking block, push in until holes align. If the locking block will not seat, check for support material underneath.



Insert the slide stop lever between the trigger and frame. Push under the locking block. Lever spring should rest on the back edge of the locking block. If it jumps in front, remove and retry.



While holding the slide stop lever, push forward and lift up to align pin holes. Push trigger pin into place or lightly tap with mallet. Lever may need to be moved slightly to assist in install. Once pin clears lever hole, make sure trigger shoe is aligned and install trigger pin completely. Slide stop lever should seat into trigger pin groove.



Make sure the slide moves freely with no binding. If rails are too tight or there is binding, polishing edges will help. Slide should go into battery without assistance. Check for proper trigger function. Rack slide several times to help break it in. Insert an empty magazine and check slide stop function. Once everything works properly, use dummy rounds to check operation before firing.