

Signature Series® - Generation III

~Ultimate Revolver Tune~

An Exclusive High-Performance Custom Service

Only By: **HEFFRON PRECISION®**

The Signature Series® Generation III... Only Heffron Precision® would dare to come up with something so bold. We've now advanced this to the point, we don't know what our "next act" will be! If you are truly looking for the World's Finest Revolver, it's right here. Only Colt offers a foundation solid enough, consistent enough, and innovative enough (their performance enhancing features) to be the root of such a premium revolver. The specific New Series models are the *Python, Anaconda, and their siblings, the BOA, Grizzly, and the Kodiak.* These revolvers offer very strong internal and external parts, extreme manufacturing precision, broach-cut rifled barrels, and superb execution...at their respective price points. That's what this is about. Price points. When a company builds something, they have a price point in mind before they start. They do all they can up to the price-point limit, then it's time to balance out the compromises. Only a few select products in our world are built with a cost no object approach. In the Revolver World, you'll find that such products cost thousands and thousands of dollars. Building a superb revolver requires a completely different set of rules than building a superb pistol.

HOW IS THE NEW SIGNATURE SERIES® GENERATION III DIFFERENT?: Our previous versions involved part geometry changes and increasing part-rolling interactions with decreased part-sliding interactions. We decrease the amount of parts contact in key areas. They would receive a 3-stage polish for smooth operation. We would also perform our standard Blueprinted Accuracy Tuning® on these revolvers. Everything that could impact accuracy was evaluated. Anything out of spec would then be corrected (with the customer's permission and at the customer's expense). Our competition-winning AccuCrown® Match-Grade Barrel Crown was part of the deal. Performing the Comfort Contour® service on the trigger costs extra. Any machining or adjustments to bring the revolver within spec cost extra. Our exclusive Magic Ball Bore Lapping® service cost extra. These revolvers have proven themselves as being World Class already, they were a smash at Revolver-Fest, but.... Why not widen that margin out a bit? We ALWAYS are looking at things to improve function and accuracy.

The Generation III version of this classic and proven service includes everything we have learned while working with, researching, and testing these wonderful revolvers. We have discovered a SPECIFIC throat size that enhances accuracy. We have discovered a SPECIFIC forcing cone entrance size that enhances accuracy. We have discovered a minor alteration to our Magic Ball Bore Lapping® that enhances accuracy. We've discovered a specific barrel to cylinder gap that enhances accuracy. We've discovered a specific headspace spec that enhances accuracy. (See a common theme here?) We've discovered a specific chamber size that enhances accuracy. This is big stuff. What if we just did all of this to every revolver? We don't "check" anything. We just machine it all to our specifications, where we've proven superior accuracy. What if we added the Magic Ball Bore Lapping® and the Comfort Contour® trigger? What if we added an additional polishing step to the mechanism parts?

If we did all of that, we'd have to call it: SIGNATURE SERIES® GENERATION III.

It's here and it outperforms Korth, Spohr, and Manurhin revolvers handily. Other custom revolvers fall short. Colt provided the foundation. We create the Masterpiece.

The built-in improvements of our Flagship Tuning Service add up to higher-performance in the end. We take full advantage of Colt's Bank Vault Lockup to achieve perfect cylinder to barrel alignment. We take advantage of the extremely hard internal parts to maintain the mechanism's tuned state, long after the work has been done. We take advantage of the dimensionally accurate broach-cut rifled barrel so our improvements add up to something great. We take advantage of the oversize components within the mechanism and the enhanced girth of the frame to keep these accuracy-tuned revolvers accurate over the long haul. **THIS IS THE GREATEST REVOLVER ACCURACY WE'VE EVER ACHIEVED**, and that's really saying something.

This is a list of what the SIGNATURE SERIES© GENERATION III tuning involves:

- All part geometry changes that we can apply within the mechanism are applied. These improve end-user leverage, allows certain parts to "roll" against one another with less "sliding", reducing part to part contact in key areas to reduce friction. **THIS IS (partly) HOW WE ACHIEVE A SINGLE-ACTION TRIGGER PULL OF 2.00 - 2.25 LBS and A DOUBLE-ACTION TRIGGER PULL OF 8.00 – 8.25 LBS** while maintaining the ability to ignite Magnum primers.
- All contact points within the mechanism undergo a 4-STEP POLISHING PROCESS that leaves behind a "glassy" finish that can still carry lubricant. The mechanism simply glides when it's operated. The double-action trigger from start to finish has no hang-ups, no rough spots, it engages and rolls smoothly through its cycle. The trigger return/reset is extremely smooth and slick. The overall feel is confidence-inspiring to say the least, and done to perfection to say the most.
- The single-action sear is cut (then precision honed) differently from our other Colt tunes. It allows hammer fall with miniscule trigger movement. This is a hand-fitting step that creates unequalled pull quality.
- The revolver's timing is set so there is minimal possible trigger overtravel. This is another hand-fitting step that achieves ideal revolver lockup and a superior pull.
- The cylinder and crane are entirely disassembled and polished in key areas to reduce friction to enhance the efficiency of double-action firing.
- All of the chambers and cylinder throats are re-cut to pre-determined dimensions, the forcing cone entrance is re-cut to a pre-determined dimension, the barrel to cylinder gap and the cartridge headspace are set at pre-determined dimensions, all based on the research Heffron Precision© has performed regarding the achievement of maximum accuracy from these revolvers.
- The chambers, throats, forcing cone, and barrel are all lapped using our newest and most accurate techniques, including "Magic Ball" Barrel Lapping©.
- The barrel receives our critically acclaimed and proven AccuCrown© Match Barrel Crown which maintains depth and center to within .0001".
- We machine the trigger surface itself to match our Comfort Contour© specs (Python, Grizzly, and BOA only). This mimics the L to R curvature of the Old Series Python trigger. It also reduces the groove depth. It makes for more comfortable shooting.
- Upon final assembly and lubrication, the mainspring is "adjusted" so we achieve the exact hammer fall rate we desire. This adjustment is achieved with custom dies and a 2-ton press. Our mainsprings have been dry-fired in excess of 150,000 cycles and still land within spec. We do not "lighten" the mainspring in the conventional sense. We balance its power distribution, something that's not possible at the manufacturer's original retail price. It simply takes too much time. We do it!

-We hone the cylinder latch for smoother operation.

-We have specifically addressed the firing system to create more efficient energy transfer to the firing pin. By doing so, primer impact has increased by approximately 15%. You'll get reliable ignition characteristics on Magnum primers.

-We then take it to the range for accuracy testing. The standard is stricter today than ever!

In order to pass the final accuracy testing, the standards are the same for the Python/Grizzly/Boa and the Anaconda/Kodiak. We are achieving superior accuracy, the best ever, so we have set new standards.

Using our test ammunition, we must achieve specific 6-shot group sizes when fired at 100 yards using a Ransom Machine Rest. The accuracy standard only varies with barrel length.

GROUP SIZE (BY BARREL LENGTH) REQUIREMENT CHART

<u>CALIBER</u>	<u>BARREL LENGTH</u>	<u>MAX. GROUP SIZE</u>	<u>DISTANCE</u>
357 & 44 MAG	8"	1.75"	100 YDS
357 & 44 MAG	6"	2.00"	100 YDS
357 & 44 MAG	5"	2.25"	100 YDS
357 & 44 MAG	4.25"	2.50"	100 YDS
357 MAG	3.00"	2.50"	75 YDS
357 MAG	2.50"	2.50"	75 YDS
45 COLT	8"	2.25"	50 YDS
45 COLT	6"	2.50"	50 YDS
45 COLT	4.25"	2.75"	50 YDS

(NOTE: Due to the slower velocities obtained with the 45 Colt cartridge, bullet stability is lessened over long distances, therefore the accuracy standard is held to 50 yards. The revolver DOES exhibit the same degree of precision and theoretical potential.)

ARE YOU READY FOR THE BEST AVAILABLE ANYWHERE?

This truly is "The Best of the Best". It's Made In America. It's Customized In America. The overall performance obtained with this Custom Performance Service will eclipse the performance of ANY double-action revolver made, regardless of price! We guarantee it!

Moving forward, ALL SIGNATURE SERIES© TUNING WILL BE GENERATION III TUNING. WE ARE NO LONGER PERFORMING THE PREVIOUS VERSIONS.

OPTIONAL: You MIGHT want a lighter double-action pull. We can, through mainspring manipulation, (again, we do not bend them, but swage them with a press and dies) achieve double-action trigger pulls of 7.00 – 7.25 lbs. THIS LIKELY WILL NOT IGNITE MAGNUM PRIMERS. It is very useful if you shoot 38 Special caliber in competition! Let us know!

You can also add NUMBERED CHAMBERS and/or CHAMFERED CHAMBERS. Have the hammer and trigger jeweled for a custom touch! Go "full tilt" with the target-

tuning philosophy and have your gun converted to Single-Action Only. This offers the fastest locktime! Have a double-action only conversion done with a bobbed hammer! See our “Colt Revolver Custom Add-On Services” sheet.

THE MASTERS OF NEW-SERIES COLT REVOLVER TUNING

ALL SIGNATURE SERIES© GENERATION III REVOLVERS MUST SATISFY SPECIFIC STANDARDS FOR SMOOTHNESS, TRIGGER PULLS, AND ACCURACY BEFORE LEAVING OUR FACILITY. ALL WILL INCLUDE A CERTIFICATION CERTIFICATE*.

SIGNATURE SERIES© GENERATION III REVOLVER TUNE:

\$1050 – for stainless guns

\$1150 – for blued guns

All work performed by Mike Heffron. Total shop time involved is 22+ hours.

Under the grips, each revolver will have “SS, Month and Year, Order Number, and HP” stamped onto the frame along with Mike Heffron’s engraved signature and date completed. Due to the associated labor intensity, we only build a few of these (15-20) each year.

“The Signature Series©, now at its Generation III level, has been a continuously evolving series of upgrades built into one flat-rate custom-service package. Due to this, Heffron Precision© has never been able to lock in old price rates on any Signature Series© order, as it would halt the evolving nature of this upgrade. All noted price increases have not been inflationary, but instead spurred by advances within this custom service. Now at the Generation III level, I don’t envision this going any further because there’s really nowhere to go. With this service, rather than advanced tuning combined with inspection and where needed, correction, the Generation III offers the most advanced action and trigger tuning we’ve ever offered in combination with dimensional optimization for achieving the highest level of accuracy possible. The Signature Series© Generation III has several steps completed by machines (operated by me), along with several hours of hand adjustment, hand tuning, hand fitting, and hand finishing (again, by me) all directed towards creating The World’s Finest Double-Action Revolver. The only domestic brand and models available that offer the secure and precise foundation needed for such an undertaking are the New Series Colt Python, Grizzly, BOA, Anaconda, and Kodiak. I have worked with many brands for decades. All others fall short of offering the world-class potential I demand for such a product. Due to the number of hours involved with this service, we are only able to offer a limited number every year. Even among the Korth and Manurhin revolvers we have, the Signature Series Gen III revolvers are the best guns here.”

-Michael A. Heffron

Master Revolversmith – Pistolsmith – Engineer/Designer

