HK45C LEM Installation Instructions

Identification of Components [corresponding number on exploded diagram]

a. Slide [1]
b. Frame [45]
c. Back Strap [34]
d. Lock-Out Device [28]
e. Clamping Pin [33]
f. Cylindrical Pin [32]
g. Hammer Spring [27]
h. Hammer Strut [26]
i. Sear Axle [19] [19]
j. Detent Plate [38]
k. Disconnector [18]
l. Catch [20]
m. Sear Actuator [21]
n. Sear Complete [22]
o. Slide Plate [37]
p. Safety Lever [35]
q. Compression Spring [36]
r. Trigger Bar [12]
s. Hammer Axle [24]
t. LEM Hammer [25L]
u. LEM Cocking Piece [57L]
v. LEM Cocking Piece Spring [58L]
w. LEM Hammer Axle [24L]
x. LEM Hammer Spring [25L]

1. **CLEAR FIREARM**
   a. Place control lever on safe
   b. Remove magazine from pistol
   c. Lock Slide [1] to rear
   d. Verify no ammunition in chamber
2. **Remove Slide [1]** from Frame [45]
3. **Remove Back Strap [34]** from Frame [45] by drifting Clamping Pin [33] out either side
4. **Remove Hammer Spring [27]** Compress Lock-Out Device [28] (HOLD WITH CONSIDERABLE FORCE AS HAMMER SPRING [27] IS UNDER TENSION) Drift Clamping Pin [33] out in either direction with punch. **CAUTION:** Lock-Out Device [28] will launch across the room if you are not holding it or pointing it toward a

towel or other material to catch it! Remove Hammer Spring [27] and Hammer Strut [26]. Keep Hammer Spring [27] for Light LEM.

5. **Drift out Sear Axle** [19] with 1.5mm punch from LEFT to RIGHT.
6. **Remove Detent Plate** [38] from Frame [45]. This is no longer needed.
7. **Remove (in following order) Disconnector [18], Catch [20], Sear Actuator [21] and Sear Complete [22].** The Disconnector, Catch and Sear Actuator will be used later. The Sear Complete is no longer needed.
8. **Remove Safety Lever [35]** by compressing Slide Plate [37] and rotating lever upwards to 12 o'clock position. The Safety Lever is no longer needed.
9. **Remove Slide Plate [37] and Compression** Spring [36]. These are no longer needed.
10. **Remove Hammer Axle [24].** While pressing straight down on Trigger Bar [12], push Hammer Axle [24] out of Frame [45] LEFT to RIGHT. The Hammer Axle [24] is no longer needed.
11. **Place LEM Cocking Piece [57L] into LEM** Hammer [25L] with a small amount of grease to keep in place.
12. **Place LEM Cocking Piece Spring [58L] on LEM Hammer Assembly** (above) with small dab of grease to keep in place. Left spring leg will face muzzle and right spring leg will be parallel to hammer.
13. **Place Hammer Strut [26]** in to back of grip as originally installed. Keep in place and align as you complete the next step. The Hammer Strut [26] will fit inside of groove on LEM Cocking Piece [57L] and will align with the opening for the LEM Hammer Axle [24L]
14. Press straight down on the Trigger Bar [12]. **Place LEM Hammer Axle [24L] (with keyway facing downward) into axle hole on right side of Frame [45]. Insert LEM Hammer Assembly** so the Hammer Strut [26] engages groove in the bottom of the LEM Cocking Piece [57L]. Align axle hole on LEM Hammer Assembly and push LEM Hammer Axle [24L] from RIGHT to LEFT into Frame [45]. Confirm LEM Hammer Axle [24L] seats below flush line of Frame [45]. Release pressure from Trigger Bar [12]. Ensure it travels up against the LEM Hammer Axle [24L]. The Hammer Strut [26] may need to be held in place during the next steps.
15. **Pull left leg of Cocking Piece Spring [58L]** (the one facing muzzle) towards the LEM Hammer Assembly and push Sear Complete [22] down in front of LEM Hammer Assembly (placed between LEM Hammer [25L] and Flat Spring). Release left leg of the Cocking Piece Spring and it will rest against the Sear Complete [22].
16. **Install Disconnector [18], put the Sear Actuator [21] and Catch together and install next**, assuring the hook part of Catch hooks around LEM Hammer Axle [24L]
17. Using a 2.5mm punch, align and slave the Disconnector, Sear Complete [22], Sear Actuator [21] and Catch through the right side of the Frame [45] (work LEM Hammer [25L] slightly to help align parts, but DO NOT COCK!!!) Once all parts are

slaved via sear axle hole**, push the Sear Axle [19] into the Frame** [45] from the LEFT to the RIGHT, holding parts in place with punch while pushing Sear Axle [19] into sear axle hole. Make sure Sear Axle [19] is flush with the RIGHT side of Frame [45].

18. Turn Frame [45] over **and place Hammer Spring [27] on Hammer Strut [26].** NOTE: Stock Hammer Spring [27] is used for LIGHT LEM. Option is to use heavier LEM Hammer Spring [25L].
19. **Insert Lock-Out Device [28] over bottom of Hammer Spring [27]** and align with channel in back of Frame [45]. Push Lock-Out Device [28], with Hammer Spring [27] and Hammer Strut [26] aligned, into channel until the hole for the Cylindrical Pin [32] is aligned with the upward most hole. Insert Cylindrical Pin [32] into the upward most hole, securing the Lock-Out Device [28]. NOTE: This will take a considerable amount of force. A soft tool, like a toothbrush handle may be used to press on Lock-Out Device [28].
20. **Replace Back Strap [34] and insert Clamping Pin [33].**
21. **Replace Slide [1] to Frame [45].** Cycle Slide [1] several times and squeeze trigger several times slowly to verify proper installation.
22. Congrats! You have just installed the LIGHT LEM trigger system into your HK45C.

Note: This is only a summary of what worked for me when translating the USP instructions. This is not official information and the author is not liable for any damage or accidents that may come from misuse of this information. If you are not comfortable with working on your handgun, please take to local gunsmith or send directly to HK USA for service.

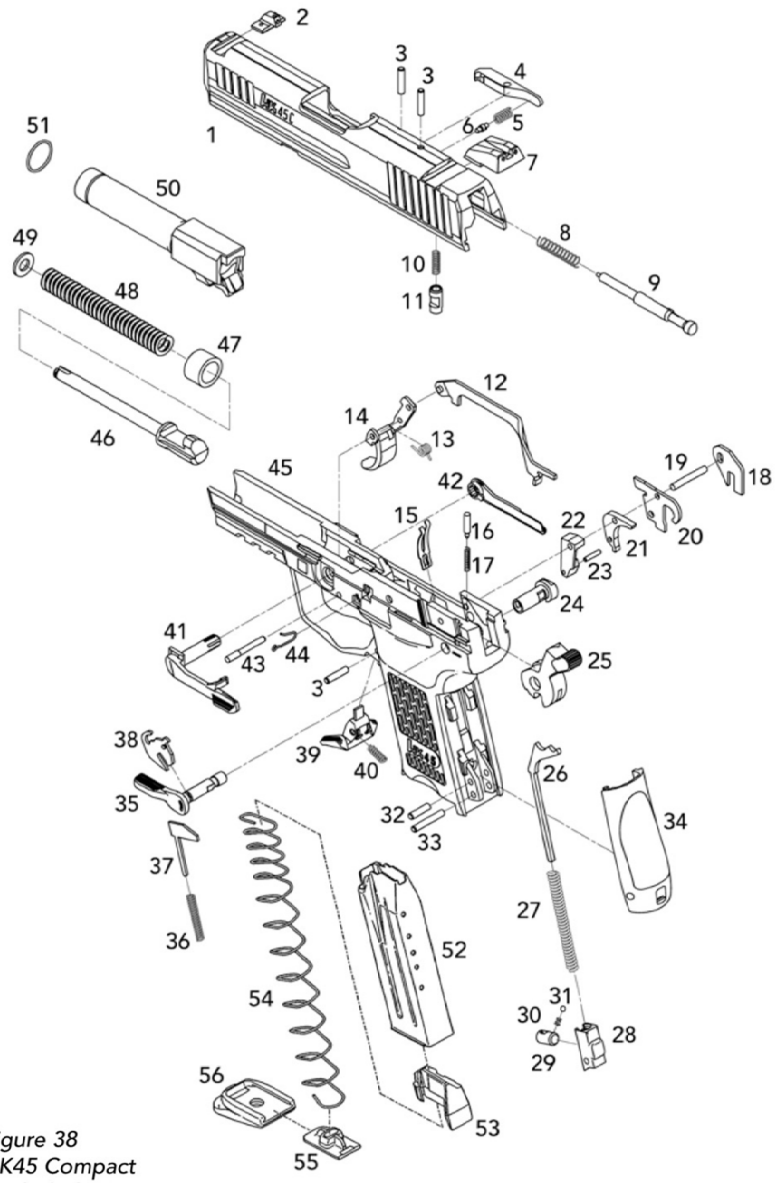
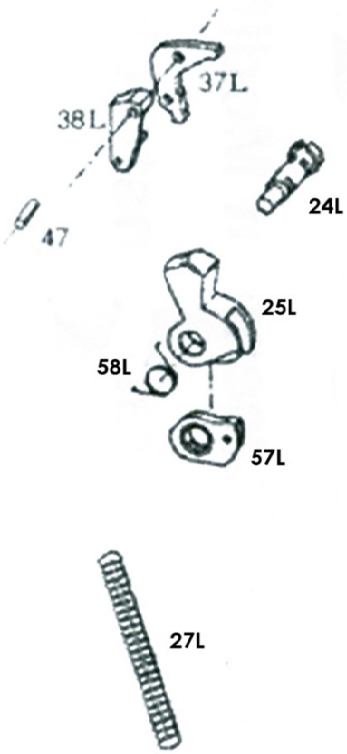


Figure 38
HK45 Compact
Exploded Diagram

HK45 Compact Parts List

	Slide, complete (1-11)	234017
1	Slide	234018
2	Front sight, complete (5,9 mm)	227711
2.1	Front sight, complete (6,1 mm)	234327
2.2	Front sight, complete (6,3 mm)	234328
2.3	Front sight, complete (6,5 mm, standard)	234329
2.4	Front sight, complete (6,7 mm)	234386
2.5	Front sight, complete (6,9 mm)	234387
3	Roll pin (3x)	988891
4	Extractor	218316
5	Extractor spring	218315
6	Rubber plug	209294
7	Rear sight, complete	234323
8	Firing pin spring	215822
9	Firing pin	215928
10	Firing pin block spring	209296
11	Firing pin block	209313
	Frame, complete (12-45)	234660
12	Trigger bar	215924
13	Trigger rebound spring	214164
14	Trigger	215816
15	Flat spring	215691
16	Trigger bar bolt	214165
17	Trigger bar spring	214166
18	Disconnector	214840
19	Sear axle	214101
20	Catch	214817
21	Sear actuator	219442
	Sear, complete (22/23)	214179
22	Sear, incomplete	214180
23	Roll pin	982785
24	Hammer axle	214774
25	Hammer	218570
26	Hammer strut	234459
27	Hammer spring	234479
	Gunlock, complete (28-31)	234664
28	Gunlock	234665
29	Safety	207191
30	Compression spring	985934
31	Ball	929134
32	Cylindrical pin	970074
33	Clamping pin	978170
34	Back strap "S"	234021
	Back strap "M"	234022
35	Safety lever	234339
36	Compression spring	214104
37	Slide plate	214105
38	Detent plate	234465
39	Magazine release	234270
40	Magazine release spring	215929
	Magazine, complete (8 rounds)	234269
41	Slide release	234337
42	Slide release, right	209268
43	Trigger axle	214154
44	Shaped spring	214171
45	Frame	234016
	Frame, complete (12-45)	234015
46	Recoil spring guide rod	215931
47	Sleeve	215932
48	Recoil spring	215830
49	Recoil spring retainer	215831
	Recoil spring guide rod, compl.(46-49)	215930
50	Barrel	234019
51	O-ring	986429
	Magazine, 8 rounds, complete (not illustrated)	234269
52	Magazine housing (8 round)	215934
53	Follower	215938
54	Magazine spring (8 round)	214212
55	Locking plate/insert	215937
56	Magazine floorplate (8 round)	234150
	Magazine, 10 rounds, complete (not illustrated)	234268
	Magazine housing (10 rounds)	233317
	Follower	215938
	Magazine spring (10 rounds)	234155
	Locking plate/insert	215937
	Magazine floorplate (10 rounds)	234151

NOTE: Not all parts and components for all HK45 Compact variants depicted or listed



24L LEM Hammer Axle
25L LEM Hammer
57L LEM Cocking Piece
58L LEM Cocking Piece Spring
27L LEM Hammer Spring

The images above were taken from the HK45C owner's manual and the USP LEM installation instruction manual.
Although there may be discrepancies, I did the best I could to accurately portray the components with the information I had on hand.