WARNING

A firearm has the capability of taking your life or the life of someone else; be extremely careful with your firearm. An accident can occur at anytime and is almost always the result of not following basic safety rules.
TABLE OF CONTENTS

CHAPTER 1 INTRODUCTION ..................................................................................................................................................... 4
  SECTION I GENERAL INFORMATION........................................................................................................................................ 4
  SECTION II PISTOL DESCRIPTION............................................................................................................................................ 6
    1.2 Nomenclature................................................................................................................................6
    1.3 Principle of Operation.................................................................................................................. 7
    1.4 Major Assembly Groups............................................................................................................... 7
    1.5 Technical Specifications............................................................................................................... 9

CHAPTER 2 OPERATING INSTRUCTIONS............................................................................................................................. 10
  SECTION I SERVICE UPON RECEIPT OF MATERIAL........................................................................................................... 10
    2.1 Initial Inspection......................................................................................................................... 10
  SECTION II GENERAL DESCRIPTION.................................................................................................................................... 10
    2.2 Description.................................................................................................................................. 10
    2.3 Operation and Characteristics................................................................................................... 11
    2.4 Cycle of Operation ..................................................................................................................... 13
  SECTION III OPERATION UNDER NORMAL CONDITIONS................................................................................................ 18
    2.5 Cleaning Procedures.................................................................................................................. 18
    2.6 Clearing Procedures.................................................................................................................. 18
    2.7 Loading and Unloading the Magazine....................................................................................... 19
    2.8 Loading Procedure..................................................................................................................... 20
    2.9 Readying the Pistol for Firing.................................................................................................... 21
    2.10 Firing the Pistol......................................................................................................................... 22
    2.11 Firing the Pistal - Field Firing.................................................................................................. 22
    2.12 Loading and Unloading the Magazine....................................................................................... 22
  SECTION IV OPERATION UNDER UNUSUAL CONDITIONS................................................................................................ 23
    2.13 Extreme Cold............................................................................................................................ 23
    2.14 Heavy Rain and Water Operations - All Climates................................................................... 24
    2.15 Hot, Dry Climates.................................................................................................................... 24
    2.16 Hot, Wet Climates.................................................................................................................... 24
    2.17 Heavy Rain and Water Operations - All Climates................................................................... 24

PAGE 2
CHAPTER 1   INTRODUCTION
SECTION I - GENERAL INFORMATION

The HK Mark 23 .45 ACP pistol give shooters match grade accuracy equal to that of the finest custom made handguns — yet it exceeds the most stringent operational requirements ever demanded of a combat handgun. The Mark 23 provides this accuracy without the need for hand-fitted parts common in custom-built match pistols costing thousands of dollars more. Repair of the Mark 23 is reduced to a simple parts exchange.

The HK Mark 23, is a commercial model of the U.S. Government issue MK 23, MOD 0 pistol and is available in limited numbers. Designated the "Mark 23," it is almost identical to the MK 23 MOD 0 pistol used by the Special Operations Command, right down to its threaded barrel. The main differences are slide markings (Mark 23 as opposed to MK 23) and a barrel manufactured to SAMMI headspace specifications.

One of the most thoroughly tested handguns in history, the MK23/Mark 23 project originated in 1991 when HK was awarded a development contract for the Special Operations Forces Offensive Handgun Weapon System, consisting of a caliber .45 pistol, detachable sound and flash suppressor, and a laser aiming module. The MK23 pistols met the most stringent operational and accuracy requirements ever demanded of a combat handgun. During over 450 accuracy test firings from a precision firing fixture, MK 23 pistols far exceeded the government requirement, averaging 1.44 inches, with 65 groups of less than one inch. There were no groups of 5 groups of 6 or 7, each group totaling 5 rounds. The most accurate of these included with 5 rounds going through the same hole. This included the HK Mark 23, with 25 pistol owners exceeding the government minimum of 2000 rounds fired with no malfunction.

The HK23 pistols met the reliability requirement, the pistol had to demonstrate a minimum of 2,000 mean rounds between stoppages (MRBS) with M1911 ball and +P ammunition. The minimum MRBS achieved in testing was 6,027 with the Mark 23, and the maximum was 15,122. The HK Mark 23 also met the government requirement of 30,000 rounds of +P ammunition with no malfunctions, endurance testing demonstrated a service life of over 30,000 rounds of +P ammunition with no parts failure, the HK23 pistols met the government requirement of 0.50 inch groups of 5 rounds with no malfunctions.

The HK23 pistols far exceeded the government requirement, averaging 1.44 inches, with 65 groups of less than one inch. There were no groups of 5, each group totaling 5 rounds. The most accurate of these included with 5 rounds going through the same hole. This included the HK Mark 23, with 25 pistol owners exceeding the government minimum of 2000 rounds fired with no malfunction.

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Three pistols were tested for accuracy after firing over 30,000 rounds, the specified service life of the pistol, and still met the new pistol accuracy requirement. An innovative design feature, a high temperature rubber O-ring on the barrel that seals the barrel in the slide until unlocking, led to this remarkable achievement. The O-ring lasts beyond 20,000 rounds and can be replaced by the operator without tools in seconds.

To meet operational environmental requirements, the pistol was function tested at +140 and -250 F, immersed in salt water, exposed to surf, salt-fog, sand-dust, mud, icing, un lubricated, and a variety of other fouled environments. A special maritime surface coating protects the pistol from corrosion, in all of these operational environments.

The barrel is threaded to accept accessories such as a flash and sound suppressor. The unique HK polygonal bore profile increases muzzle velocity and service life, reduces bore fouling and eases cleaning.

The extended slide release lever and the ambidextrous magazine release are easily operated without adjustment of the firing grip using the firing hand thumb or index finger.

Other notable features include accessory mounting grooves on the frame, a mechanical recoil reduction system that reduces recoil forces to the shooter and components of the pistol by as much as 30%, a polymer frame, a one-piece machined steel slide, and a law enforcement/military magazine capacity of twelve rounds.

The weapon is aimed using either iron sights or an optional laser aiming component. The iron sights provide a 3-dot sight picture with white or optional self-luminous tritium dots.

The MK 23 became the first caliber .45 ACP pistol to enter U.S. military service since the venerable Government Model 1911A1. On May 1, 1996, the first MK 23 pistol was delivered to the U.S. Special Operations Command for operational deployment.
SECTION II - PISTOL DESCRIPTION

1.2 Nomenclature

1.3 Principle of Operation

A. The Mark 23 uses a modified linkless Browning style short recoil system to lock and unlock the breech. Upon firing, the propellant gas forces the slide and barrel assembly to the rear. After approximately 3 mm, the locking block will stop the rearward movement of the barrel as the barrel is forced downward due to the engagement of the angled surfaces of the locking block with those located at the rear sight and safety lever.

E. Upon firing, the pressure developed by the propellant gas forces the slide and barrel assembly to the rear. After approximately 3 mm, the locking block will stop the rearward movement of the barrel as the barrel is forced downward due to the engagement of the angled surfaces of the locking block with those located at the rear sight and safety lever.

B. Upon firing, the pressure developed by the propellant gas forces the slide and barrel assembly to the rear. After approximately 3 mm, the locking block will stop the rearward movement of the barrel as the barrel is forced downward due to the engagement of the angled surfaces of the locking block with those located at the rear sight and safety lever.

Figure 1 Left View

Figure 2 Right View
in the recoil spring guide rod. The locking block will disengage from the slide and the slide will continue rearward. The extractor located in the slide will then extract the fired cartridge case, the ejector located in the frame on the left side of the magazine well will eject the fired case as the slide continues rearward, cocking the hammer, and compressing the recoil spring. The slide moves forward feeding the next cartridge from the magazine into the chamber and locking to the barrel breech.

C. The slide locks open after the last round has been fired and ejected.

WARNING
Do not rely on the slide lock to determine if the magazine is empty. Always check visually and physically ensure the pistol is not loaded.

1.4 Major Assembly Groups (See Figure 3)

A. Slide - houses the firing pin, firing pin block and extractor. The slide moves forward during recoil.

B. Captured Recoil/Buffe Spring Assembly (with guide rod) - absorbs recoil and returns the slide and barrel to their forward positions, reduces impact of slide on receiver during recoil.

C. Threaded Barrel (with locking block) - contains cartridge and propellant gases during firing. The locking block initiates locking and unlocking of the breech during movement of the slide.

D. Frame - serves as support to all major components, controls functioning of pistol. The slide release locks the slide with barrel and recoil/buffer spring assembly...

The trigger guard is flared on both sides to prevent accidental discharge...
Figure 3 Major Assembly Groups

A. Slide
B. Captured Recoil/Buffer Spring Assembly
C. Threaded Barrel
D. Frame
E. Magazine
F. Slide Release

- Holds the cartridges in position for feeding and chambering.
- Holds slide in position when rear is depressed.
- Holds slide to rear when engaged; releases slide when lever is depressed and chamfered.
- Accessories: magazine release, decocker, buffer spring, guide rod, lanyard loop insert, C-clip.
1.5 Technical Specifications:

<table>
<thead>
<tr>
<th>Feature</th>
<th>Specification</th>
</tr>
</thead>
<tbody>
<tr>
<td>Caliber</td>
<td>.45 ACP</td>
</tr>
<tr>
<td>System of Operation</td>
<td>Short recoil, semi-automatic</td>
</tr>
<tr>
<td>Locking System</td>
<td>Browning system (modified)</td>
</tr>
<tr>
<td>Length</td>
<td>149 mm (5.87 in.)</td>
</tr>
<tr>
<td>Sight radius</td>
<td>197 mm (7.76 in.)</td>
</tr>
<tr>
<td>Magazine Weight (empty)</td>
<td>0.24 lbs. (.110 kg)</td>
</tr>
<tr>
<td>Magazine Weight (M1911 Ball)</td>
<td>0.81 lbs. (.366 kg)</td>
</tr>
<tr>
<td>Magazine Weight (M1911 Ball)</td>
<td>0.72 lbs. (.327 kg)</td>
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<tr>
<td>Pistol Weight (empty)</td>
<td>2.66 lbs. (1.21 kg)</td>
</tr>
<tr>
<td>Pistol Weight (12 rds M1911 Ball)</td>
<td>3.22 lbs. (1.46 kg)</td>
</tr>
<tr>
<td>Pistol Weight (10 rds M1911 Ball)</td>
<td>3.13 lbs. (1.42 kg)</td>
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<tr>
<td>Trigger Pull (Single-action)</td>
<td>4.85 lbs. (2.20 kg)</td>
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<tr>
<td>Trigger Pull (Double-action)</td>
<td>12.13 lbs. (5.50 kg)</td>
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<tr>
<td>Height</td>
<td>150 mm (5.90 in.)</td>
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<tr>
<td>Width</td>
<td>38.8 mm (1.53 in.)</td>
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<tr>
<td>Muzzle Velocity (M1911 Ball)</td>
<td>870 m/s (230 grain)</td>
</tr>
<tr>
<td>Muzzle Velocity (+P JHP)</td>
<td>348 m/s (185 grain)</td>
</tr>
<tr>
<td>Maximum Effective Range</td>
<td>50 m (54.7 yds)</td>
</tr>
<tr>
<td>Maximum Range (M1911 ball)</td>
<td>1461 m (1,467 yds)</td>
</tr>
<tr>
<td>Rifling</td>
<td>Polygonal bore right hand</td>
</tr>
<tr>
<td>Magazine Capacity</td>
<td>12 round (10 round civilian)</td>
</tr>
<tr>
<td>Safety Features</td>
<td>1. Safety lever (manual), 2. Double-action mode with 12.1 lb. trigger, 3. Firing pin block, 4. Disconnector, 5. Grouping (smooth, 10 rds M1911 Ball, 12 rds M1911 Ball, 10 rds M1911 Ball)</td>
</tr>
</tbody>
</table>
2.2 Description:
The Mark 23 is a semiautomatic, magazine fed, recoil operated, double/single-action pistol, chambered for the .45 ACP cartridge up to, and including, the commercial +P cartridges.

**WARNING**
The Mark 23 incorporates single and double action modes of operation. Anytime the trigger is pulled with the safety lever in the fire (down) position and a round in the chamber, the pistol will fire from either the hammer down (DA) or cocked position (SA).

### CHAPTER 2 OPERATING INSTRUCTIONS

#### SECTION I - SERVICE UPON RECEIPT OF MATERIAL

**2.1 Initial Inspection**

Upon initial receipt, the pistol is to be inspected to ensure it was received in proper working order. The Mark 23 is a semiautomatic.

<table>
<thead>
<tr>
<th>Step</th>
<th>Action</th>
<th>Reference</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Remove pistol and items from container</td>
<td>para. 3.3</td>
</tr>
<tr>
<td>2</td>
<td>Remove packing material</td>
<td>para. 3.4</td>
</tr>
<tr>
<td>3</td>
<td>Check for missing parts</td>
<td>para. 3.7, 3.9</td>
</tr>
<tr>
<td>4</td>
<td>Clean, dry and lubricate (if necessary)</td>
<td>para. 3.7, 3.9</td>
</tr>
<tr>
<td>5</td>
<td>Assemble (all necessary)</td>
<td>para. 3.4</td>
</tr>
<tr>
<td>6</td>
<td>Safety function check</td>
<td>para. 3.5</td>
</tr>
<tr>
<td>7</td>
<td>Field strip weapon and inspect for: para. 3.3</td>
<td></td>
</tr>
<tr>
<td>8</td>
<td>Missing parts</td>
<td></td>
</tr>
</tbody>
</table>

The pistol must be disassembled and reassembled in the proper working order. The Mark 23 is a semiautomatic.
CAUTION

A pair of Universal Mounting Grooves located on the front of the Mark 23 frame allow for a variety of accessories to be used with the pistol. Improperly designed or installed accessories may result in damage to the Mark 23 mounting grooves and/or the Mark 23. Such damage is not covered under warranty. Be certain to use only HK Authorized Accessories and follow installation and precautions carefully.

NOTE

Accessories designed for the Universal Self-Loading Pistol (USP) will not work on the Universal Mounting Grooves of the Mark 23.

2.3 Operation and Characteristics

A. Double/Single Action - The Mark 23

- Double Action (DA): Pulling the trigger will cock the hammer and immediately release it, discharging a chambered round. Further pulling the trigger (SA) will fire the chambered round without further cocking.
- Single Action (SA): Pulling the trigger will discharge a chambered round. The hammer must be manually cocked before pulling the trigger.

B. Magazine - The magazine is produced from sheet steel and has a total capacity of 12 rounds. The rounds are positioned within the magazine housing in a staggered arrangement. The floor plate can be easily removed for disassembly and cleaning of the magazine components. The viewing holes are marked with numerals and the floor plate is the magazone housing. The rounds are positioned within the magazine housing in a staggered arrangement. The rounds are numbered. The numbers are positioned within the magazine housing in a staggered arrangement.

C. Loaded Chamber Indicator - The Mark 23 pistol does not have a loaded chamber indicator. The extractor does not act as a loaded chamber indicator.

D. Decocking Lever - The decocking lever allows the operator to quietly lower the cocked hammer when the hammer is cocked. The lever may be lowered without concern of an accidental discharge.
safely by moving the decocking lever fully into the decocking (down) position. The decocking lever cannot be depressed (and therefore does not allow the hammer to be released) while the decocking lever is engaged due to the spring pressure exerted by the decocking spring.

E. Safety Lever

- The safety lever is an ambidextrous “thumb” lever located on the rear of the frame (See Figure 4a). The safety lever blocks the release of the cocked hammer when it is in the engaged (up) position. The safety lever cannot be placed in the “safe” (up) position if the hammer is uncocked (down).

WARNING

The pistol should always be carried with the safety lever engaged when carried in the single action mode. While there is a spring detent to prevent this, the safety lever can be moved to the “fire” position (down) with a minimum amount of force. During careless handling or during removal of the pistol from the holster, always check the position of the safety lever.

12
2.4 Cycle of Operation

Began with weapon loaded, hammer cocked, safety lever disengaged.

F. Frame
- The front and back straps of the fiberglass reinforced polymer frame are checkered to ensure a firm grip, even with wet hands or under conditions of rapid movement. A threaded insert is molded into the front face of the trigger guard and the frame is grooved forward of the trigger guard for attachment of an accessory such as a laser. The slide rides on these metal inserts during production. The slide release lever engages the recess visible on the left side of the slide and is spring loaded within the grip. The slide release lever is disengaged when the weapon is in manual operation. The slide release lever engages the lower surface of the rear of the trigger guard to shield the lever from accidental actuation.

G. Slide Release Lever
- This lever is used to lock the slide open and for disassembling the weapon. As a slide stop, it is depressed upward against the trigger guard and forward of the magazine release lever to shield the lever from accidental actuation. The frame is a one-piece molded component with metal inserts (cocking insert and springs) cast into the frame during production. The slide release lever is spring actuated. The slide release spring holds the slide release lever in the open position when the weapon is cocked and the safety lever is disengaged. This lever can be actuated by the firing thumb of the right-handed operator or the index finger of the left-hand operator.

H. Magazine Release Lever
- This ambidextrous, spring actuated lever holds the magazine within the grip by engaging in the notch found in the upper third of the magazine. This lever is disengaged when the weapon is in manual operation and the safety lever is disengaged. The magazine release lever is disengaged when the weapon is loaded, hammer cocked, safety lever disengaged.
Figure 5  

A. Firing  
(See Figure 5)  Pulling the trigger rearward pulls the trigger bar forward. The trigger bar pivots the sear actuator upwards which disengages the firing pin from the lower of the two shelves located on the hammer. The compressed hammer spring drives the hammer forward into the rear end of the firing pin. The firing pin strikes the primer of the chambered round. The propellent is ignited by the primer and propellent gases are created inside the chambered case. These propellent gases are ejected out of the barrel locking block and rear end of the barrel. The barrel locking block is locked to the barrel by the engagement of locking surfaces on the slide, which is locked to the barrel by the engagement of locking surfaces on the slide. The opposing angled locking surfaces and propellent gases produced by the propellent gases push rearward on the slide, which is locked to the rear end of the barrel, to unlock the breech block and rear end of the barrel.

B. Unlocking  
(See Figure 6) The gas pressure produced by the propellent gases pushes the slide rearward independently of the barrel. The slide is now free to recoil rearward. The compressed hammer spring drives the hammer forward into the rear end of the firing pin. The firing pin strikes the primer of the chambered round. The propellent is ignited by the primer and propellent gases are created inside the chambered case. These propellent gases are ejected out of the barrel locking block and rear end of the barrel. The barrel locking block is locked to the barrel by the engagement of locking surfaces on the slide, which is locked to the barrel by the engagement of locking surfaces on the slide. The opposing angled locking surfaces and propellent gases produced by the propellent gases push rearward on the slide, which is locked to the rear end of the barrel, to unlock the breech block and rear end of the barrel.
E. Cocking - (See Figure 7) - As the slide continues rearward the recoil impulse is dampened by the buffer spring. The recoil spring is compressed and the hammer recocked.

D. Ejection - (See Figure 7) - The rim of the cartridge case strikes the stationary ejector. The empty case is ejected from the open ejection port.

C. Extraction - The empty cartridge case is held firmly against the face of the slide by the claw of the extractor as the slide recoils rearward.

B. Extraction - The empty cartridge case is held firmly against the face of the slide by the claw of the extractor as the slide recoils rearward.

A. Extraction - The empty cartridge case is held firmly against the face of the slide by the claw of the extractor as the slide recoils rearward.
new round is ready to be fired.

Figure 8  Feeding

F. Feeding - (See Figure 8) - The compressed recoil spring drives the slide forward. If the magazine is empty, the magazine follower will stop. If the slide release is pressed, the magazine follower will return spring drives the slide forward. If the magazine is empty, the magazine follower will stop.
2.5 Safety Features

A. Safety Lever - This safety locks the hammer in the cocked position. The hammer is let off by squeezing the trigger. This safety blocks the release of the cocked hammer in the SA mode. The safety lever is an external, manually operated, ambidextrous "thumb" lever located on the left and the right side of the frame farthest back from the trigger. The shaft of the lever is pressed by a spring detent. The safety lever cannot be placed in the safe (up) position when the hammer is down (uncocked).

B. Double-Action Mode - This safety keeps the hammer in an uncocked condition until the moment of firing. The double-action mode is a passive safety feature in the pistol. The hammer is left uncocked until the decision to fire is made. At all times, the firing pin is locked by the firing pin block. The mode of operation also ensures the function of the safety lever. When the hammer is down (uncocked), the safety lever cannot be engaged or disengaged. Engaging the trigger in this mode of operation cannot be released. Engaging the hammer is in turn, does not allow the safety to be engaged and disengaged. The safety lever must be manually engaged by the operator. When the hammer is in the safe mode, the safety lever is locked by the firing pin block. The mode of operation must be manually selected by the operator. The safety lever must be manually released to allow the cocked hammer to be cocked and fired. The safety lever must be manually released to allow the cocked hammer to be cocked and fired.

C. Firing Pin Block - This safety prevents the firing pin from striking the primer when the weapon is dropped, the hammer is bumped, or when the slide slams forward. The firing pin block is located in the slide and is actuated by a spring. The firing pin block is extended by a spring, and engages within the recess provided in the center portion of the firing pin.
D. *Disconnector* - This safety prevents the release of the hammer unless the slide is fully forward and/or the trigger is reset (released) between rounds. This important safety prevents serious malfunctions from occurring, such as "slam-fires" (rounds that fire during loading), automatic fire, or a round being fired out of the barrel (with the breech unlocked). The disconnector disconnects the engagement of the hammer when the slide is fully forward, the leading edge of the disengaged disconnector resides in a recess provided in the bottom of the slide.

**SECTION III - OPERATION UNDER NORMAL CONDITIONS**

**WARNING**

Always clear the pistol before handling it.

NEVER ASSUME THE PISTOL IS CLEAR!

1. The fire control lever and safety lever are set on "safe".
2. The slide is locked to the rear.
3. The chamber is free of brass or ammunition.
4. The magazine is removed.
5. The safety lever is set on "safe".
6. The magazine release lever is depressed.
7. The slide is locked to the rear and free of brass.

B. To Clear the pistol:

**NEVER ASSUME THE PISTOL IS CLEAR!**

1. Make sure fingers are outside of the trigger guard and the pistol is pointed in a safe direction at all times!
2. Decock Hammer or Engage Safety - depress the decocking lever or engage the safety lever.
3. Remove Magazine - depress the magazine release lever.
4. The slide is locked to the rear.
5. The magazine is removed.
6. The chamber is free of brass or ammunition.
7. The safety lever is set on "safe".
8. The hammer is disengaged.
9. The barrel is pointed in a safe direction.
10. The chamber is free of brass or ammunition.
11. The magazine is removed.
12. The safety lever is set on "safe".
13. The hammer is disengaged.

**WARNING**

Always clear the pistol before handing off. Provided in the bottom of the slide, the disengaged disconnector resides in a recess of the barrel. When the slide is fully forward, the leading edge of the disengaged disconnector resides in a recess provided in the bottom of the slide, the disengaged disconnector resides in a recess provided in the bottom of the slide.
4. Open Slide - lock slide open by pulling slide rearward as you engage the slide release lever (up). Watch for live round or empty case to be ejected.

5. Inspect Chamber - inspect chamber for the presence of a live round or empty case:
   a. Visually view chamber through ejection port.
   b. Physically insert fingers into chamber.
   c. Remove any live rounds or empty cases present in the chamber.

The pistol is now considered "clear."
Figure 9   Loading the Magazine

2.8  Loading Procedure

A. Administrative Loading - used to initially load the pistol before it is to be fired.

Method A (Slide rearward, chamber empty)

1. Make sure fingers are outside of trigger guard and pistol is pointed in a safe direction, i.e. up

2. Insert magazine firmly into the frame. Tug on magazine to ensure that it is fully seated and engaged.

3. Release the slide fully and release. Do not ride slide forward.

4. Engage the slide release lever to release the slide and to chamber the first round.

5. Depress the slide release lever to release the slide.

6. Remove magazine and top off with one additional round.

B. Unloading the Magazine - engage with the trigger

Method B (Slide forward, chamber empty)

1. Make sure fingers are outside of trigger guard and pistol is pointed in a safe direction, i.e. up

2. Insert magazine firmly into the frame. Tug on magazine to ensure that it is fully seated and engaged.

3. Retract the slide fully and release. Do not ride slide forward.

4. Engage the slide release lever to release the slide and to chamber the first round.

5. Depress the slide release lever to release the slide.

6. Remove magazine and top off with one additional round.

B. Unloading the Magazine - engage with the trigger
2.9 Readying the Pistol for Firing

5. Depress slide release to chamber first round.
6. Depress slide release to chamber first round.

B. Tactical Reloading - used to quickly reload

1. Engage safety lever or depress decocking lever.
2. Make sure fingers are outside of trigger guard and pistol is pointed in a safe direction at all times.
3. Depress the magazine release with finger or thumb of firing hand to drop partially empty magazine.
4. At the same time, retrieve a full magazine with finger or thumb of firing hand to drop magazine.
5. Depress magazine into full magazine with finger or thumb of firing hand to drop magazine.
6. Depress magazine into full magazine with finger or thumb of firing hand to drop magazine.

Tactical Reloading - used to quickly reload

1. Make sure fingers are outside of trigger guard and pistol is pointed in a safe direction at all times.
2. Keep eyes on target area.
3. Depress the magazine release with finger or thumb of firing hand to drop partially empty magazine.
4. At the same time, retrieve a full magazine with finger or thumb of firing hand to drop magazine.
5. Depress magazine into full magazine with finger or thumb of firing hand to drop magazine.
6. Depress magazine into full magazine with finger or thumb of firing hand to drop magazine.
WARNING

1. BE SURE OF YOUR TARGET AND WHAT'S BEHIND IT! Even a .45 caliber projectile can easily penetrate wood, plasterboard walls, or a car door, and can travel as far as one mile!

2. Ensure that all parts of your hand and body are kept away from the muzzle of the pistol at all times!

3. Always wear eye and ear protection where possible when firing the pistol.

4. Whenever the pistol is dropped on a hard surface landing on the hammer (cocked or down), it should be sent to the HK Service Department as soon as practicable to inspect the sear axle. If the sear axle is bent, it should be replaced.

2.10  Firing the Pistol

A. Single-action mode (Hammer back/cocked)

(≈ 4.8 lbs.) For precise and accurate shooting....

CAUTION

Single action mode trigger pull is lighter & shorter than double action mode. Keep your finger off the trigger & outside the trigger guard except when firing the Mark 23.

B. Double-action mode (Hammer down/uncocked)

Provides the operator with a long, heavy (≈ 12.1 lbs.) trigger pull for the first shot only. Subsequent shots will be fired in single-action mode as the slide will be locked in single-action mode by the hammer safely during handling and carrying of the pistol when the manual safety is engaged.

1. Aim at the target.
2. Fire the weapon by pressing the trigger straight to the rear with gradually increasing pressure.
3. Depress the decocking lever to lower the hammer to return to the double-action mode once firing is completed, or engage the safety lever to remain in the single-action mode.
SECTION IV - OPERATION UNDER UNUSUAL CONDITIONS

NOTE

Unusual conditions are defined as any climatic condition requiring special maintenance of the pistol. Perform the maintenance outlined for the climate that most applies to your operational area. Refer to paragraph 3.9 for lubrication instructions.

CAUTION

If extensive corrosion is found and cleaning does not solve the problem, contact the HK Service Department.

2.11 Extreme Cold

A. When operating pistol in extremely cold climates, clean and lubricate the pistol inside at room temperature if possible.
B. Apply a light coat of LAW (Lubricant, Arctic Weapons) to all functional parts.
C. Always keep mud or dirt out of the barrel.
D. Always keep mud or dirt out of the bore.
E. Do not lay a hot pistol in snow or ice.
F. Keep ammunition dry and clean.
G. Always keep snow out of the bore. If snow should get into the bore, clean the bore immediately. Keep ammunition dry and clean.
H. Always keep snow out of the bore.
I. Do not lay a hot pistol in snow or ice.
J. Always keep the pistol dry. When moving from a warm to a cold area, this can cause moisture to build up inside the pistol, resulting in freezing. To prevent freezing, keep the pistol covered when moving from a warm to a cold area.

2.12 Hot, Wet Climates

A. Perform maintenance more frequently. Inspect hidden surfaces for corrosion. If corrosion is found, clean and lubricate.
B. To help prevent corrosion, remove hand prints with a cloth. Dry and lubricate the pistol with CLP/LSA (Cleaner, Lubricant, Protectant).
C. Check ammunition and magazines frequently for corrosion. Clean the magazine using CLP/LSA (Cleaner, Lubricant, Protectant).
D. Always keep mud out of the barrel. If mud should get into the bore, clean the bore immediately.

CAUTION

Interchangeable Internals, Parts located on the underside of the pistol, are NOT interchangeable. For the correct and most applicable to your pistol, refer to paragraph 2.9 Unusual Conditions are defined as any climatic condition requiring special maintenance of the pistol. Maintenance requirements must be performed on the pistol for unusual conditions.
2.13 Hot, Dry Climates

A. Dust and sand will get into pistol and cause malfunctions and excessive wear on component contact surfaces during firing. Keep the pistol covered when possible.

B. Corrosion is less likely to form on metal parts in a dry climate. Therefore, lightly lubricate internal working surfaces only with CLP/LSA. Do not lubricate external parts of the pistol.

C. Always try to drain any water from barrel prior to firing. Keep pistol dry.

D. Always attempt to keep pistol dry.

A. Perform maintenance in accordance with the appropriate climatic conditions.
SECTION V - MALFUNCTIONS AND STOPPAGES

2.15 Remedial Action

- Remedial Action is the action performed to remedy an unanticipated interruption of the pistol's operation and place the pistol back into operation.

**WARNING**

During remedial action, make certain the pistol is pointed in a safe direction at all times.

**A.** Clear the pistol!

**B.** Attempt to lock the slide.

**C.** Remove magazine.

**D.** Inspect chamber.

**E.** Insert fresh magazine.

**F.** Release slide.

**G.** Attempt to fire the pistol.

If the Mark 23 fails to fire, return the weapon to the HK Service Department for service.

**WARNING**

If a round is assembled without powder (a fault of the manufacturing process), the primer alone has enough power to propel the projectile into the bore. A projectile lodged in the bore may cause damage to the barrel and/or the pistol if another round is fired and could cause personal injury. This event is commonly called a "pop and no kick" or "squib load" and is characterized by a much reduced report and little or no movement of the pistol. The operator should notice the occurrence of this event in time to avoid firing the next round.

Selection and Use of a Holster -

**Selection -** When selecting a carrying holster for the pistol:

1. The holster must not make contact with or actuate any of the operating controls. This includes the hammer, slide release, magazine release lever, and any of the safety features. The reduce the risk of injury. The pistol is a medium to large size handgun.

2. The holster must not make contact with or actuate any of the operating controls. This includes the hammer, slide release, magazine release lever, and any of the safety features.
2. The holster should not cause the slide to move.
3. The holster should not cause the slide to jam.
4. Choose a holster designed for the Mark 23.

WARNING

The pistol must never be returned to the holster unless the above procedures have been followed or injury or death could occur.

The design of the holster must also not actuate these controls when the pistol is carried in, drawn from, or returned to the holster.

When the hammer is cocked:
1. All fingers are off of the trigger and out of the trigger guard.
2. The pistol is "clear" or;
3. The hammer is in the decocked (down) position or;
4. The safety lever is engaged in the safe position.

WARNING

Returning a pistol to the holster: The pistol is considered safe when:

1. All fingers are off of the trigger and out of the trigger guard.

Returning the Pistol to the Holster - The HK Mark 23 must be made "safe" (or cleared) prior to returning it to the holster.
CHAPTER 3 MAINTENANCE INSTRUCTIONS

SECTION I - TOOLS & EQUIPMENT

NOTE
The service life and performance of your HK Mark 23 is dependent upon the correct handling and proper care by the operator.

3.1 Operator Tools and Equipment Required.

- Cleaning rod with handle and eyelet
- Long handled nylon brush
- Bronze bristle bore brush (.45 caliber)
- Cotton swabs
- Solvent/bore cleaner/CLP
- Cleaning patches (.45 caliber)
- Rag
- Cotton balls
- Cleaning rod with handle and eyelet
- Cleaning rod with handle and eyelet

CAUTION
Use safety goggles when using solvents and cleaning products. Exercise care if using compressed air.

SECTION II - PREVENTATIVE MAINTENANCE (PM)

SERVICE CHECKS & MAINTENANCE PROCEDURES

3.2 General

- This PM Service section lists those required checks and services to be performed by personnel who operate the Mark 23 pistol. These procedures, ensure that the firearm is in proper condition and operating properly.

WARNING
Before starting an inspection procedure CLEAR THE PISTOL! Inspect the chamber to ensure it is empty. Do not keep live ammunition near your maintenance work area.

NOTE
Handing and proper care by the operator, the service life and performance of your HK Mark 23 is dependent upon the correct handling and proper care by the operator.
Figure 10

CAUTION

Hold the recoil/buffer spring assembly in place while removing the slide from the frame.

NOTE

Before starting any PM Service procedure ensure that the Firearm Service Record has been updated with the correct round count and any PM Service performed documented.

Before starting any PM Service procedure ensure that the Firearm Service Record has been updated with the correct round count and any PM Service performed documented.

3.3 Disassembly (Field stripping)

A. Pistol

1. Clear the pistol.
2. Depress slide release and allow slide to move forward.
3. If applicable, remove any mounted accessories.
4. Using the left hand, retract and hold the slide approximately 25 mm until the front end of the slide release is centered on the recess visible on the left side of the slide (see Figure 10). With the right hand push the slide release into the recess on the right side of the frame until completely removed from the frame. Remake the slide release from the slide assembly.

Figure 10

Recess

Slide

Release
10-Round Civilian Magazine

1. Using a blunt pointed instrument depress the locking insert detente located in the floor plate and hold it there.

2. Place a portion of either hand over the base of the magazine to control the release of the magazine spring and locking insert.

3. With the locking insert still depressed, squeeze the floor plate locking tabs located on the right and left sides of the magazine.

4. Gradually allow the locking insert and magazine spring to expand out of the magazine housing.

5. Remove the locking plate, magazine spring and magazine follower from the magazine housing.

6. Remove the slide with barrel and captured recoil/buffer spring assembly off of the frame by sliding it forward.

7. Remove the captured recoil/buffer spring and locking insert from the barrel and slide by lifting upon the rear of the guide rod. The entire assembly can now be slid out of the slide.

8. Place a portion of either hand over the base of the magazine housing and hold it there. The magazine housing is now ready for disassembly.

9. Lift the rear of the barrel by the locking block and withdrawn from the slide.

10. Remove the slide with barrel and captured recoil/buffer spring assembly off of the frame by sliding it forward.

12-Round Law Enforcement Magazine

1. Using a blunt pointed instrument depress the locking insert protruding through the bottom of the magazine floor plate and hold it there.

2. Place a portion of either hand over the base of the magazine to control the release of the magazine spring and locking plate.

3. Slowly slide the floor plate forward off of the magazine housing.

4. Gradually allow the locking plate and magazine spring to expand out of the magazine housing.

5. Remove the locking plate, magazine spring and magazine follower from the magazine housing.

6. Remove the slide with barrel and captured recoil/buffer spring assembly off of the frame by sliding it forward.
Operator disassembly of the Mark 23 pistol is now complete. Only trained HK Service Department personnel may disassemble the weapon further.

3.4 Reassembly (From field strip)

A. Magazine

1. Place the magazine follower onto the end of the magazine spring having the loop at the end of the wire on the left side of the follower.
2. Insert the follower and the magazine spring into the magazine housing.
3. Place the locking plate onto the protruding end of the magazine spring so that the locking detent is visible (see Figure 11A).
4. Push the locking plate down into the magazine housing against the pressure of the magazine spring so that the locking detent fits within the hole provided in the floor plate.
5. Slide the floor plate over the base of the magazine housing making sure the loop at the end of the magazine spring is fully seated on the magazine housing.
6. The floor plate engages the tabs located on the left and right sides of the magazine.

CAUTION

Weapon function may be compromised if operator disassembly of the Mark 23 pistol is performed by personnel other than trained HK Service Department personnel. Only trained HK Service Department personnel may disassemble the Mark 23 pistol.
1. Place the magazine follower onto the magazine spring with the end of the spring positioned on the left of the follower.

2. Insert the follower and magazine spring into the magazine housing.

3. Place the locking insert (on 10-round magazines) onto the protruding end of the magazine spring so that the rounded corners face towards the front of the magazine.

4. Push the locking plate down into the magazine housing against the pressure of the magazine spring and hold it there.

5. Push the floor plate up onto the base of the magazine housing until the locking tabs engage in the sides of the housing. Check to see if the locking tabs on the floor plate are securely locked into the housing and the locking detente on the locking plate fits within the hole in the floor plate.

6. Check the magazine for proper assembly by insure that the follower slides up and down freely within the magazine housing and with spring tension. Also check that the magazine follower rises within the magazine housing to be nearly flush against the bottom of the magazine lips.

Pistol

1. Insert the muzzle of the barrel through the large hole located in the front of the slide.

2. Drop the barrel down into the slide and push it forward until the O-ring engages the slide, the locking block fits within the ejection port, and the angled locking surface of the locking block is visible along the bottom of the slide.

3. Place the magazine follower into the magazine housing.

4. Push the magazine spring and follower into the magazine housing.

5. Push the follower into the magazine housing until the locking tabs engage in the sides of the housing. Check to see if the locking tabs on the floor plate are securely locked into the housing and the locking detente on the locking plate fits within the hole in the floor plate.

6. Check the magazine for proper assembly by insure that the follower slides up and down freely within the magazine housing and with spring tension. Also check that the magazine follower rises within the magazine housing to be nearly flush against the bottom of the magazine lips.
O-ring will now hold the muzzle tight in the front of the slide.

3. Install the captured recoil/buffer spring assembly into the slide so that the front of the recoil spring guide rod engages in the smaller hole located in the front of the slide.

4. Align the opposing angled locking surfaces of the recoil spring guide rod with those located on the bottom of the barrel locking block.

5. Push the rear of the recoil/buffer spring assembly forward enough so that the recoil spring retainer can be engaged on the shelf provided on the front of the barrel locking block. (see Figure 12)

6. Hold the slide in the right hand and with the thumb on the rear of the slide above the front edge of the frame. (see Figure 13)

7. Hold the frame in the left hand. Position the assembly in place on the slide (see Figure 13).

8. Draw the slide back onto the frame so that the rails of the locking insert and guiding part slide within the grooves in the slide.

9. Assemble the O-ring recessed and guiding part slide rails of the locking insert and guiding part slide into the rear end of the recoil spring guide rod. (see Figure 12)

10. Hold the slide in this position and insert the slide release from the left to right into the frame until it is flush with the side of the frame and locks in place. (see Figure 12)
Operator reassembly of the Mark 23 pistol is now complete, but not finished without a safety/function check.

3.5 Safety/Function Check

A safety/function check should be performed anytime the pistol is reassembled. This quick check indicates whether or not the pistol was properly assembled and with all the components in place. It also allows the operator to quickly check for any obvious malfunctions that could occur between the interactive components of the pistol.

B. ALWAYS clear the pistol before performing a safety/function check. DO NOT assume the pistol is clear.

1. Clear the pistol.
2. Remove the slide and the operating controls to inspect the slide.

3. Actuate the slide and the operating controls to

- magazine and catch - the magazine is securely in place by the magazine catch and that it drops free of the frame when the catch is depressed.
- slide - the slide moves freely and without binding on the frame (with and without a magazine inserted). If it binds, examine the slide bearings and slide rails for any obstructions or other problems.
- barrel - the barrel locking block does lock fully into battery within the ejection port of the slide as the slide is closed.
- Slide Release - the slide release does hold the slide open when retracted while:
  - thumb holding recoil/buffer spring assembly on the locking block
  - frame
  - slide

NOTE: A Safety/Function Check

Figure 13 Correct Position for Holding Slide
a) an empty magazine is in place.

b) the slide release is engaged (pressed upwards).

2) The slide release does permit the slide to snap forward when:
   a) the slide release is depressed.
   b) the slide is retracted without a magazine installed.

3) The slide release does rebound with spring pressure.

3. Perform the following safety checks:

a. Safety Lever Test.

1) With the pistol unloaded and hammer down (uncocked), attempt to press the safety lever upward into the safe position. The safety lever should not engage. If the safety lever engages, return the pistol to the HK Service Department for service.

2) With the pistol unloaded, the hammer does not go beyond the stopping position with spring pressure when the safety lever is depressed upward into the normal position. If the hammer does not go beyond the stopping position, return the pistol to the HK Service Department for service.

3) With the pistol unloaded, cock the hammer and depress the decocking lever. Grasp the pistol in the shooting position and squeeze the trigger three or four times. If the hammer falls, return the pistol to the HK Service Department for service.

b. Decocking Lever Test.

1) With the pistol unloaded, cock the hammer and depress the decocking lever. If the hammer does not fall or the decocking lever does not rebound (upward into its normal position), return the pistol to the HK Service Department for service.

2) With the pistol unloaded, cock the hammer and press the safety lever upward into the safe position. Attempt to depress the decocking lever three or four times. If the decocking lever is not depressed, return the pistol to the HK Service Department for service.

3) If the decocking lever is not depressed, return the pistol to the HK Service Department for service.
c. Decocked (hammer down) Test

1) With the pistol unloaded, cock the hammer. Return the pistol to the HK Service Department for service.

2) With the pistol unloaded, squeeze the trigger. If the hammer fails, return the pistol to the HK Service Department for service.

3) With the pistol unloaded, hold the hammer down. If the hammer fails, return the pistol to the HK Service Department for service.

d. Disconnector and Trigger Test

1) With the pistol unloaded, cock the hammer. Push the slide rearward approximately 3/16 inches (2mm) and hold in that position while squeezing the trigger. If the hammer falls, return the pistol to the HK Service Department for service.

2) With the pistol unloaded, pull the slide rearward until the slide stop will engage. Squeeze the trigger and release the trigger while holding the hammer. If the hammer fails, return the pistol to the HK Service Department for service.

NOTE: When the trigger is pulled, apply pressure on the trigger during the hammer spring-back operation. If the hammer fails to move forward, return the pistol to the HK Service Department for service.
3) With the pistol unloaded, pull the slide rearward and engage the slide. Squeeze the trigger and release the slide forwards simultaneously. Release pressure on the trigger and the hammer should fall. If the hammer does not fall, return the pistol to the HK Service Department for service.

4) With the pistol unloaded and the trigger forward, apply thumb pressure to the cocked hammer. If the hammer lowers solely as a result of thumb pressure, return the pistol to the HK Service Department for service.

3.6 Function Firing

If any corrective action was accomplished, the pistol shall be function fired a full magazine prior to being cleaned and returned to service use.

A. Normal Cleaning

1. Clear the pistol!

2. Disassemble the pistol into the major assembly groups.

a. Slide -

   1) Scrub all internal surfaces of the slide using the nylon brush moistened with solvent.

   2) Remove all loose fouling from all surfaces using the nylon brush moistened with solvent.

b. Recoil/buffer spring assembly - remove all visible fouling using solvent, a nylon brush, a rag, and cotton swabs.

c. Barrel with locking block -

   1) Moisten the bronze bore brush with solvent and scrub the bore from chamber to muzzle at least six passes, back and forth. (Note: Repeat steps 1 and 2 until a cleaning patch can be pushed through the bore and emerge.

3.7 Cleaning - performed after each firing, or every twelve (12) months, or after any exposure to extreme environmental conditions such as heavy dew, rain, snow, mud, sand, dust, water, etc.

3.8 Cleaning - performed after each firing, or

4. If the pistol does not return to service, the HK Service Department for service should still be function fired a full magazine prior to being returned to service use.

Department for Service

Return the pistol to the HK Service department if the hammer returns to the forward position.

4. When the pistol unloaded and the trigger is pulled, the hammer does not return to the normal position, return the pistol to the HK Service Department for service.
3.8  Inspection

During and after cleaning the operator should inspect the pistol and its components for any irregularities that may cause problems during its operation. If any irregularities are noted, they should be corrected immediately and/or brought to the attention of the HK Service Department.

A. Visually Inspect the Pistol and Magazine for:

1. Damaged or missing parts
2. Improper assembly or function
3. Absence of free movement, where applicable
4. Absence of the motion, where applicable

B. Frame

1) Scrub all internal surfaces where carbon fouling is visible using the nylon brush moistened with solvent.
2) Using the rag and cotton swabs, remove loose fouling from all areas of the frame. scrub the top of the magazine, concentrating on the follower and feed lips. using the rag and cotton swabs, remove all loose fouling from all surfaces of the magazine. the magazine is disassembled for cleaning.

C. Magazine

1) The magazine is disassembled for cleaning.
2) Scrub the top of the magazine, concentrating on the follower and feed lips. using the rag and cotton swabs, remove all loose fouling from all areas of the magazine.

D. Magazine

1) The magazine is disassembled for cleaning.
2) Scrub the top of the magazine, concentrating on the follower and feed lips. using the rag and cotton swabs, remove all loose fouling from all areas of the magazine.

All parts of the HK Mark 23 can be immersed in any cleaning solvent that is safe to put your hands in. Cleaning all parts of the firearm with abrasive brushes may damage the finish. Use only cleaning solutions that are safe to put your hands in. Some cleaning solutions may damage the finish. All parts of the HK Mark 23 can be immersed in any cleaning solvent that is safe to put your hands in.
5. Unaccustomed looseness
6. Parts exhibiting signs of cracks, burrs, dents, or obvious signs of damage or stress
7. Presence of stops or tactile clicks in controls, where applicable
8. General overall cleanliness
9. Presence of proper lubrication
10. Presence of corrosion or degradation of surface finish
11. Rubber hammer spur for cracks or chips

**CAUTION**

If the rubber hammer spur is badly cracked or chipped, drop safety could be degraded. Pistol should be returned to HK Service Department for replacement.

---

**3.9 Lubrication**

All metal surfaces of the Mark 23 pistol have a special surface treatment that resists all types of corrosion including corrosion resulting from exposure to salt water. However, this surface treatment does not reduce friction between parts. Lubricant must be applied to the pistol.

Any type of high-quality, medium weight lubricant (oil or grease) specifically designed for use on firearms, such as Break-Free (C.L.P.), will work well on the Mark 23 pistol.

Do not use lubricants that boast of their ability to penetrate metal as these substances may deaden primers.

**A. Where and how much?**

- **No Lube** - surface is dry and not slippery to the touch
- **Light Lube** - (finger run across surface yields little or no lube)
- **Heavy Lube** - (finger run across surface yields a definite film)

**Plastic components**
- Plastic housing and spring
- All internal parts in slide and frame
- Bore chamber and exterior of barrel
- All metal parts (unless otherwise noted)

**B. Where and how much?**

- **No Lube** - (surface is dry and not slippery to the touch)
- **Light Lube** - (finger run across surface yields little or no lube)
- **Heavy Lube** - (finger run across surface yields a definite film)

**Plastic components**
- Plastic housing and spring
- All internal parts in slide and frame
- Bore chamber and exterior of barrel
- All metal parts (unless otherwise noted)

**3.9 Lubrication**

To replace hammer, the Mark 23 pistol should be returned to the Service Department for replacement. Drop safety could be degraded. Proceedings should be reviewed carefully.

**CAUTION**

If the rubber hammer spur is badly cracked or chipped, drop safety could be degraded. Pistol should be returned to HK Service Department for replacement.
Medium Lube - (finger run across surface yields some lube but lube does not run down surface when held in a vertical position)

- Barrel locking block
- Slide rails
- All operating controls
- Locking insert and guiding part
- Extractor

Heavy Lube - (lube runs down surface when held in a vertical position)

- No heavy lube is required on the Mark 23 pistol.

Reapply lubrication periodically during firing as it burns off from the heat. Apply lubricant using a shaving brush, cotton swabs, patches, or rag. A spray bottle also works well using compressed air to blow dust from the head. Apply lubricant using a shaving brush, cotton swabs, patches, or rag. A spray bottle also works well using compressed air to blow dust from the head.
NOTE

All windage and elevation adjustments are made using only the rear sight.

SECTION III - ADJUSTMENT OF SIGHTS

1. Windage adjustments - the battle sight zero of the Mark 23 pistol is easily adjusted by moving or replacing the rear sight.

- The amount of movement will depend on the individual shooter and the ammunition used.

2. Both iron and rear sights contain white circles (or cylindrical tritium capsules) that appear as dots to the operator. One dot is positioned on the rear sight post while the other stays at the rear sight notch. By moving the rear sight post to the left or right, the windage of the sights can be changed.

3. The rear sight zero of the Mark 23 pistol is also easily adjusted by moving or replacing the rear sight.

Adjustment - the battle sight zero of the Mark 23 pistol is easily adjusted by moving or replacing the rear sight.

1. Windage adjustments - the battle sight zero of the Mark 23 pistol is easily adjusted by moving or replacing the rear sight.

2. Elevation adjustment - the windage adjustment is used to change the position of the sight and the amount of windage and elevation adjustments made using only the rear sight.

3. The amount of movement will depend on the individual shooter and the ammunition used.

1. Windage adjustments - the battle sight zero of the Mark 23 pistol is easily adjusted by moving or replacing the rear sight.

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2. Elevation adjustment - the windage adjustment is used to change the position of the sight and the amount of windage and elevation adjustments made using only the rear sight.

3. The amount of movement will depend on the individual shooter and the ammunition used.
Always strike the sight on the sight base, not on the sight blades.

NOTE: The pistol is shipping 4 inches high at 25 meters. We want the pistol to shoot dead-on.

Elevation Adjustments - To adjust the vertical (up and down) impact of the projectile follow these steps below:

1. Clear the pistol!
2. Determine the amount of vertical change, in inches, that is required at 25 meters. Note the index mark on the rear sight and its relationship to the index mark on the slide.
3. Loosen and remove the rear sight retaining screw using a screwdriver.
4. With a small hammer and brass or soft metal drift punch, drift the sight completely out of either side of the dovetail groove.
5. Note the marking on the bottom of the rear sight. (The standard sight is unmarked).
6. Select a higher or lower rear sight from Figure 14.
7. Using the brass or soft metal punch and hammer, install the new sight into the dovetail groove.
8. Align the index marks of the rear sight and slide as noted in step 2 above.
9. After the index marks of the rear sight and dovetail groove.
10. Reinstall and tighten the rear sight retaining screw.
11. Confirm your battlesight zero by firing the pistol again.

Rear Sight Selection - The rear sight is marked with -6, -4, -2, unmarked, +2, +4, or +6. This marking represents the amount of vertical change in inches that occurs when that sight is exchanged with the sight originally installed in the pistol.

1. To RAISE the point of impact, install a higher rear sight.
2. To LOWER the point of impact, install a lower rear sight.

Example: The pistol is shipping 4 inches high at 25 meters. We want the pistol to shoot dead-on.

The rear sight is marked with -2. Remove the rear sight retaining screw using a screwdriver and remove the rear sight retaining screw using a screwdriver. Confirm your battlesight zero by firing the pistol again.
Figure 25 shows that the rear sight marked -4 would lower the point of impact two increments, or a total of 4 inches, from the standard unmarked rear sight removed from the pistol.

1. The battlesight zero of the Mark 23 pistol is set

2. Figure 14 shows that the rear sight marked +2 would raise the point of impact 2 inches from the standard unmarked (standard).

C. Zeroing

1. The battlesight zero of the Mark 23 pistol is set

2. Figure 14 shows that the rear sight marked +2 would raise the point of impact 2 inches from the standard unmarked (standard).

3. Each individual operator of the Mark 23 pistol can adjust the sights to their unique shooting style by adjusting the sights in accordance with the procedures in sub-paragraphs 1 - 3 above.

4. The pistol is fired from a machine rest at a target positioned 25 meters from the pistol. The pistol is zeroed point of aim, point of impact (POA/POI). This means the impact of the projectile on target will coincide with the point of aim (POA) and point of impact (POI). The meaning of the term "point of aim, point of impact" is described on page 42.

5. Each individual operator of the Mark 23 pistol can adjust the sights to their unique shooting style by adjusting the sights in accordance with the procedures in sub-paragraphs 1 - 3 above.

6. Obtain the exchangeable rear sight from the kit delivered with the pistol. The pistol is zeroed point of aim, point of impact (POA/POI). The meaning of the term "point of aim, point of impact" is described on page 42.

7. The pistol is fired from a machine rest at a target positioned 25 meters from the pistol. The pistol is zeroed point of aim, point of impact (POA/POI). This means the impact of the projectile on target will coincide with the point of aim (POA) and point of impact (POI). The meaning of the term "point of aim, point of impact" is described on page 42.

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## SECTION IV - TROUBLESHOOTING PROCEDURES

### 3.11 Operator Troubleshooting Procedures

<table>
<thead>
<tr>
<th>PROBLEM</th>
<th>SYMPTOM/CAUSE</th>
<th>REMEDY</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Round does not feed</td>
<td>Fouled magazine or pistol</td>
<td>Clean and lube pistol and magazine</td>
</tr>
<tr>
<td></td>
<td>Improperly assembled</td>
<td>Assemble correctly</td>
</tr>
<tr>
<td></td>
<td>Incorrect loading procedure</td>
<td>Load pistol in accordance with instructions</td>
</tr>
<tr>
<td></td>
<td>Guns should be used</td>
<td>Ensure magazine loaded</td>
</tr>
<tr>
<td></td>
<td>Guns should be used</td>
<td>Ensure magazine loaded</td>
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<td></td>
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</tr>
<tr>
<td></td>
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<td>Ensure magazine loaded</td>
</tr>
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<td></td>
<td>Guns should be used</td>
<td>Ensure magazine loaded</td>
</tr>
</tbody>
</table>

### NOTE

Always inspect the buffer spring retainer roll pin for drift. If not tightly seated and centered in the guide spring retainer hole, return to the HK Service Department for replacement.

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*NOTE*
<table>
<thead>
<tr>
<th>Problem Symptom / Cause</th>
<th>Remedy</th>
</tr>
</thead>
<tbody>
<tr>
<td>Slide does not lock</td>
<td>1. Fouled barrel locking block or slide. Clean and lubber barrel locking block and fully forward slide.</td>
</tr>
<tr>
<td>4. Pistol does not fire</td>
<td>5. Little or no sign of firing pin strike. Return pistol to the HK Service Department for service.</td>
</tr>
<tr>
<td>5. Pistol does not fire</td>
<td>6. Faulty ammunition. Return pistol to the HK Service Department for service.</td>
</tr>
<tr>
<td>PROBLEM</td>
<td>SYMPTOM/CAUSE</td>
</tr>
<tr>
<td>---------</td>
<td>---------------</td>
</tr>
<tr>
<td>6. Cartridge does not extract</td>
<td>Fouled or missing O-ring</td>
</tr>
<tr>
<td></td>
<td>Damaged or improperly assembled</td>
</tr>
<tr>
<td></td>
<td>Broken or damaged extractor</td>
</tr>
<tr>
<td></td>
<td>Damaged or missing O-ring</td>
</tr>
<tr>
<td>7. Operating controls do not function as described</td>
<td>Damaged or improperly assembled</td>
</tr>
<tr>
<td></td>
<td>Broken or damaged extractor spring</td>
</tr>
<tr>
<td></td>
<td>Damaged or missing O-ring</td>
</tr>
<tr>
<td></td>
<td>Fielded or damaged chamber</td>
</tr>
<tr>
<td></td>
<td>Fouled or corroded ammunition</td>
</tr>
<tr>
<td></td>
<td>Rifled or damaged barrel</td>
</tr>
<tr>
<td>8. Accuracy degradation</td>
<td>Damaged or missing O-ring</td>
</tr>
<tr>
<td></td>
<td>Damaged or improperly assembled</td>
</tr>
<tr>
<td></td>
<td>Broken or damaged extractor</td>
</tr>
<tr>
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<tr>
<td></td>
<td>Fielded or damaged chamber</td>
</tr>
<tr>
<td></td>
<td>Fouled or corroded ammunition</td>
</tr>
<tr>
<td></td>
<td>Rifled or damaged barrel</td>
</tr>
<tr>
<td>Position No.</td>
<td>Item Description</td>
</tr>
<tr>
<td>-------------</td>
<td>-----------------</td>
</tr>
<tr>
<td>1</td>
<td>extractor</td>
</tr>
<tr>
<td>2</td>
<td>extractor spring</td>
</tr>
<tr>
<td>3</td>
<td>rear sight retaining screw</td>
</tr>
<tr>
<td>4</td>
<td>rear sight, 6.3mm standard (unmarked)</td>
</tr>
<tr>
<td>5</td>
<td>rear sight, 5.5mm (-4)*</td>
</tr>
<tr>
<td>6</td>
<td>rear sight, 5.9mm (-2)*</td>
</tr>
<tr>
<td>7</td>
<td>rear sight, 6.7mm (+2)*</td>
</tr>
<tr>
<td>8</td>
<td>rear sight, 7.1mm (+4)*</td>
</tr>
<tr>
<td>9</td>
<td>rear sight, 7.5mm (+6)*</td>
</tr>
<tr>
<td>10</td>
<td>front sight</td>
</tr>
<tr>
<td>11</td>
<td>firing pin</td>
</tr>
<tr>
<td>12</td>
<td>firing pin spring</td>
</tr>
<tr>
<td>13</td>
<td>firing pin block</td>
</tr>
<tr>
<td>14</td>
<td>firing pin block spring</td>
</tr>
<tr>
<td>15</td>
<td>firing pin retaining pin</td>
</tr>
<tr>
<td>16</td>
<td>extractor pin</td>
</tr>
<tr>
<td>17</td>
<td>slide</td>
</tr>
<tr>
<td>18</td>
<td>barrel</td>
</tr>
<tr>
<td>19</td>
<td>O-ring</td>
</tr>
<tr>
<td>20</td>
<td>recoil spring</td>
</tr>
<tr>
<td>21</td>
<td>ejector</td>
</tr>
<tr>
<td>22</td>
<td>sear</td>
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<tr>
<td>23</td>
<td>sear spring</td>
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<tr>
<td>24</td>
<td>sear actuator</td>
</tr>
<tr>
<td>25</td>
<td>disconnector</td>
</tr>
<tr>
<td>26</td>
<td>sear axle</td>
</tr>
<tr>
<td>27</td>
<td>roll pin (right safety lever)</td>
</tr>
<tr>
<td>28</td>
<td>right safety lever</td>
</tr>
<tr>
<td>29</td>
<td>sear block</td>
</tr>
<tr>
<td>30</td>
<td>decocking lockout</td>
</tr>
<tr>
<td>31</td>
<td>hammer axle</td>
</tr>
<tr>
<td>32</td>
<td>hammer, complete</td>
</tr>
<tr>
<td>33</td>
<td>trigger pin</td>
</tr>
<tr>
<td>34</td>
<td>slide release lever, complete</td>
</tr>
<tr>
<td>35</td>
<td>magazine housing (12-rd magazine)</td>
</tr>
<tr>
<td>36</td>
<td>magazine housing (10-rd magazine)*</td>
</tr>
<tr>
<td>37</td>
<td>follower (10 &amp; 12-rd magazine)</td>
</tr>
<tr>
<td>38</td>
<td>locking plate (12-rd magazine)</td>
</tr>
<tr>
<td>39</td>
<td>locking plate (10-rd magazine)*</td>
</tr>
<tr>
<td>40</td>
<td>floor plate (12-rd magazine)</td>
</tr>
<tr>
<td>41</td>
<td>floor plate (10-rd magazine)*</td>
</tr>
<tr>
<td>42</td>
<td>magazine spring (12-rd magazine)</td>
</tr>
<tr>
<td>43</td>
<td>magazine spring (10-rd magazine)*</td>
</tr>
<tr>
<td>44</td>
<td>magazine (12-rd with LE markings), complete*</td>
</tr>
<tr>
<td>45</td>
<td>magazine (10-rd), complete*</td>
</tr>
<tr>
<td>46</td>
<td>magazine spring (12-rd magazine)</td>
</tr>
<tr>
<td>47</td>
<td>magazine spring (10-rd magazine)*</td>
</tr>
<tr>
<td>48</td>
<td>locking insert (molded into frame)</td>
</tr>
<tr>
<td>49</td>
<td>trigger guard insert (molded into frame)</td>
</tr>
<tr>
<td>50</td>
<td>guiding part (molded into frame)</td>
</tr>
</tbody>
</table>
The Mark 23 pistol was designed to operate best using two types of .45 ACP caliber ammunition. They are:

A. M1911 230 grain Ball
B. Commercially Manufactured 185 grain +P Jacketed Hollow Point (JHP)

**WARNING**
The use of incorrect ammunition in the pistol could result in damage to the pistol and/or injury to the operator or bystanders.

**DO NOT USE**
- Reloaded, remanufactured, or military surplus (foreign or outdated) ammunition
- Ammunition loaded in aluminum cartridge cases
- Cracked, split, dirty or corroded cases
- Ammunition assembled with corrosive primer and/or propellant
- Ammunition assembled with cracked, split, or corroded cases
- Ammunition loaded in aluminum cartridge cases
- Ammunition exposed to oil, grease, water, or direct sunlight. Remove contaminants if possible before use and cool down ammunition exposed to direct sunlight or heat (Exposure to sources of heat could raise the chamber pressure of the cartridge above safe limits).

**WARNING**
Heckler & Koch specifically disclaims any responsibility for any damage or injury that should occur because of, or as a result of, the use of factory, remanufactured, or reloaded ammunition or cartridges other than those for which the pistol was originally chambered for.

**NOTE**
If after reviewing this manual you still have questions, please contact your HK dealer or telephone the Heckler & Koch Customer Service Department. Please address any suggested changes or improvements to HK Creative Services Department.