

### M91~M98 Mauser Firing Pin Safety Function Check

Preassemble the bolt and verify unloaded chamber status before beginning this check. See figures 46~48. This basic safety function check is essentially the same for all M91~M98 Mauser rifle models.

1. Install the bolt assembly and close and cock the bolt. Rotate the safety lever to the *safe* position.
2. If safety lever cam/cocking piece pickup is stiff, or the lever won't engage, trial adjust the lever cam as discussed in figures 49 and 50.
3. M98 bolt check- if the bolt will open with the safety lever on, inspect the bolt lock cam at the end of the safety lever pivot stem and the cam notch in end of the bolt body. Replace worn or altered parts.

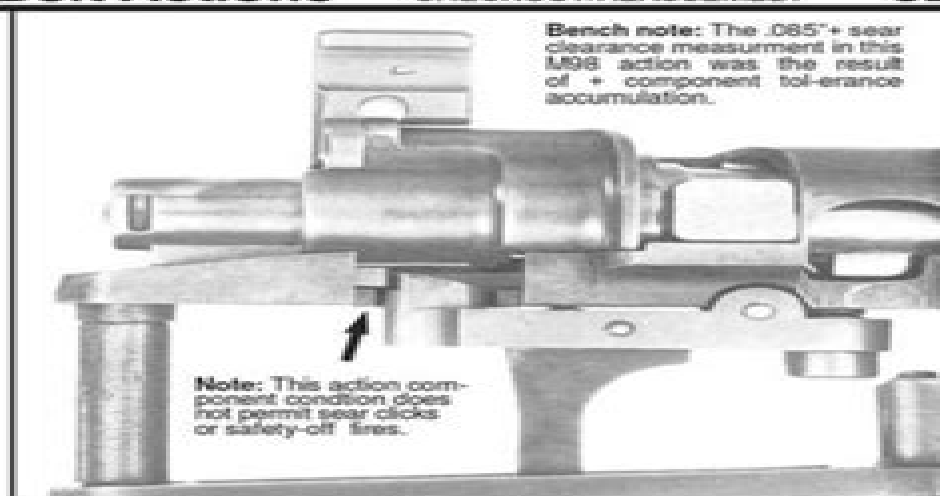
4. Then check cocking piece/trigger sear clearance. The easiest way to do this is to install a min. clearance sear gauge (made from a standard dim. sear body by soldering or *super gluing* a piece of .035" gauge stock to the sear face). Then check as follows:

1. Cock the bolt and place the safety lever in the safe detent. Then pull and release the trigger. The firing mechanism must not *sear click* or jump forward. Should this occur, clearance is less than gauge dim. But, If the trigger sear maintains cocking piece ledge engagement, and the trigger will cycle the trigger sear up/down without contacting or dragging the gauge on the cocking piece sear engagement ledge, clearance is greater than .035". With military type triggers and firing pin safety systems, .035" is suggested as a min. sear/cocking piece ledge clearance working specification. More than half of actions checked have had somewhat greater clearance. See example in figure 47.

2. If sear clearance is less than min., recheck with a serviceable, correct model type cocking piece.

3. If this doesn't eliminate the problem, a minus parts tolerance problem exists. Remedy by adjusting the cocking piece engagement ledge to .035"+ clearance on the mill and rehardening the ledge surface.

4. Always recheck sear clearance and function after cocking piece and/or trigger sear replacement.



**Figure 47-** Shows a cocking piece in a cutaway M98 action set back by rotating the safety lever to *disassembly* position. Cocking piece ledge/trigger sear clearance is .085" + in this action. In serviceable M98 actions, sear clearance is typically the same in both the *safety* and *disassembly* detents. In the safety lever disassembly position the bolt can be cycled to check both sear engagement and clearance.



**Figure 48-** Shows the trigger sear in a cutaway M98 action blocked by cocking piece ledge overtravel that occurred when the trigger was cycled while the safety lever was in the safe position. This condition was caused by an altered top cocking piece safety lever engagement corner which reduced cocking piece/trigger clearance to less than zero. Note that this disconnects and blocks the trigger sear.

# Mauser Rifle Shop Manual

**U.S. War Department**



## **Mauser Rifle Shop Manual:**

*The Redwood Stumper 2001-2009* Paul Feist, **American Rifleman**, 1929 **Gun digest** Ken Warner, 1975 The World's Work War Manual of the Great Conflict of 1914 World's work, Arthur W. Page, 1914 The Machine Gun: History, evolution and development of manually operated, full automatic, and power driven aircraft machine guns George M. Chinn, 1951 The series of books entitled *The machine gun* was begun with the belief that the next best thing to actual knowledge is knowing where to find it The research summarized within the covers of these volumes has been compiled by the Bureau of Ordnance Department of the Navy in order to place in the hands of those rightfully interested in the art of automatic weapon design the world's recorded progress in this field of endeavor Vol II p v **U.S. Rifles, Cal. .30, M1903, M1903A1, M1903A3 and M1903A4 Technical Manual** U.S. War Department, 1944-01-20 Born from the failures of the older Springfield Model 1892 99 Krag J rgensen in battles during the Spanish American War the newer Mauser action derived Springfield M1903 service rifle would go on to serve the U S military in WWI WWII and even the Korean conflict This 1944 technical manual is not for users but is rather a repair maintenance manual for use by ordnance specialists Every component of the rifle is outlined in great depth from the sights to the barrel and even the bayonets used Illustrated with copious fine detailed photos and diagrams it describes how to maintain or repair every aspect of each sub component of the rifle No detail is left out There is even an additional section on special maintenance for long term storage or very hot very cold climates If you own a vintage M1903 Springfield of any model this is the book you will want to own A terrific resource for the historian or for those with an interest in military arms Paragraph One in the manual states contains detailed instructions for disassembly assembly inspection maintenance and repair of the materiel listed below Additional descriptive matter and illustrations are included to aid in providing a complete working knowledge of the materiel These instructions are supplementary to those in Field Manuals and Technical Manuals prepared for the using arms Rifle U S cal 30 M1903 Rifle U S cal 30 M1903A1 Rifle U S cal 30 M 1903 A3 Rifle U S cal 30 M1903A4 Snipers Sight telescopic M73B1 Weaver No 330 C Bayonet M1905 Bayonet M1 Scabbard bayonet M3 Scabbard bayonet M1910 Scabbard bayonet M7 Sling gun M1907 Sling gun M1 Cover front sight **The War Manual [of] the World's Work**, 1914 The Mauser 98 Performance Tuning Manual David Watson, 2018-02-18 This book takes the reader through 161 pages and loads of photos of accurizing the classic Mauser 98 battle rifle from A Z Learn about History of how the rifle came about How to purchase and what to look for in a Mauser 98 Correct cleaning maintenance and testing Stocks bedding modifications and after market parts Barrel bolt and action modifications and tuning How to perform trigger jobs and replacement performance triggers Iron sights optics after market items and zeroing How to choose the right ammunition or hand load for this classic rifle Specialised shooting techniques suited to this classic rifle Trouble shooting for your Mauser 98 Special gunsmith techniques and tips to squeeze the most out of your Mauser 98 This book helps the reader to purchase clean restore tune modify and compete with this

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