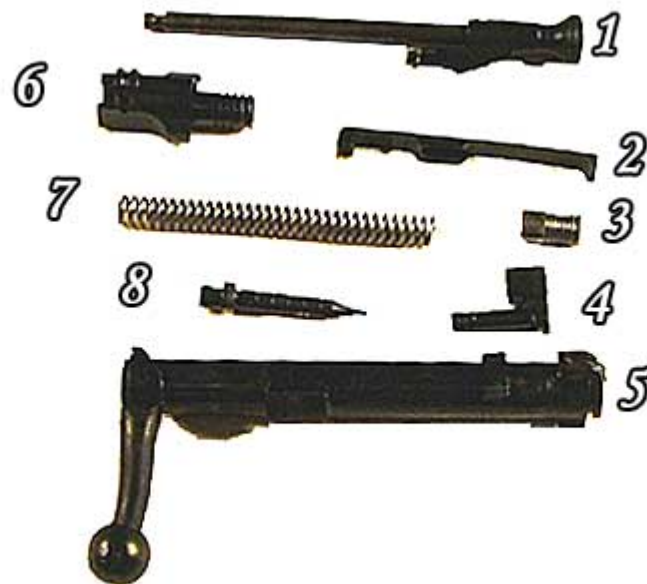




Disassembly & Reassembly of the U.S. Model 1903 Springfield Bolt

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Number	Part Description
1	Firing Pin
2	Extractor
3	Firing Pin Sleeve
4	Lock (Safety Lever)
5	Bolt Body
6	Bolt Sleeve
7	Main Spring
8	Striker

1) Place the magazine cut-off in the center position between off and on (as



shown in figure 1).



2) Cock the bolt. There are three ways to cock the bolt:

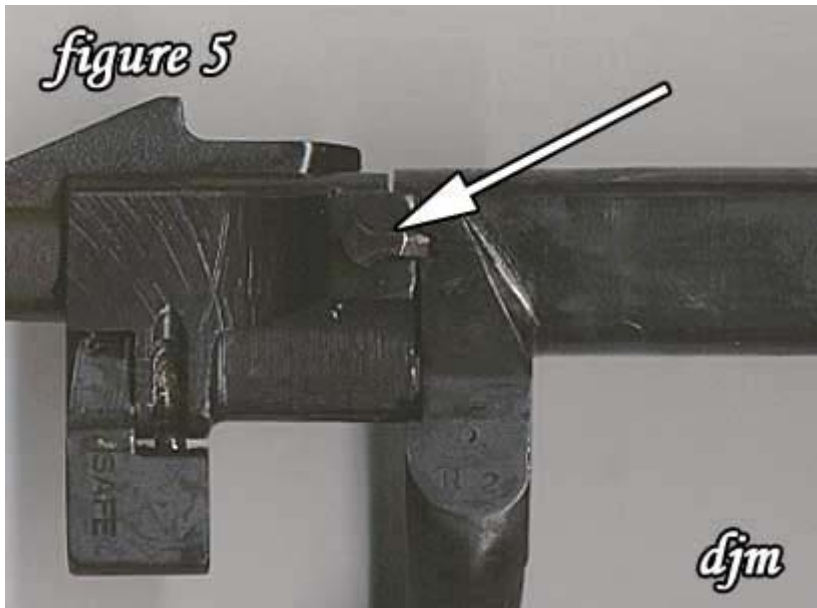
1. Pull the bolt to the rear but do not pull out of the receiver and then close the bolt.
2. Pull back on the cocking piece until it cocks and locks back and into place.
3. Open the bolt raising the bolt handle until it strikes the left side of the receiver.

3) Rotate the safety lock to the center position located between the "safe" and "ready" positions.



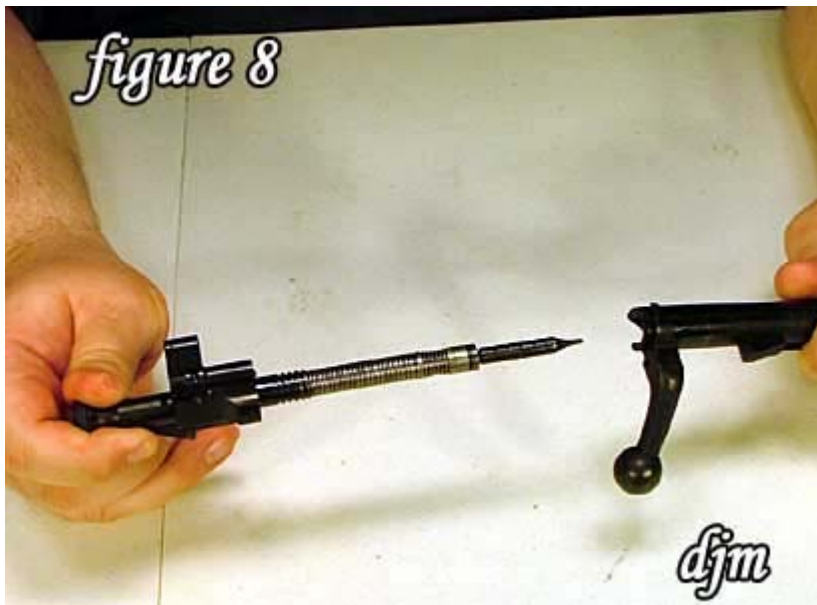
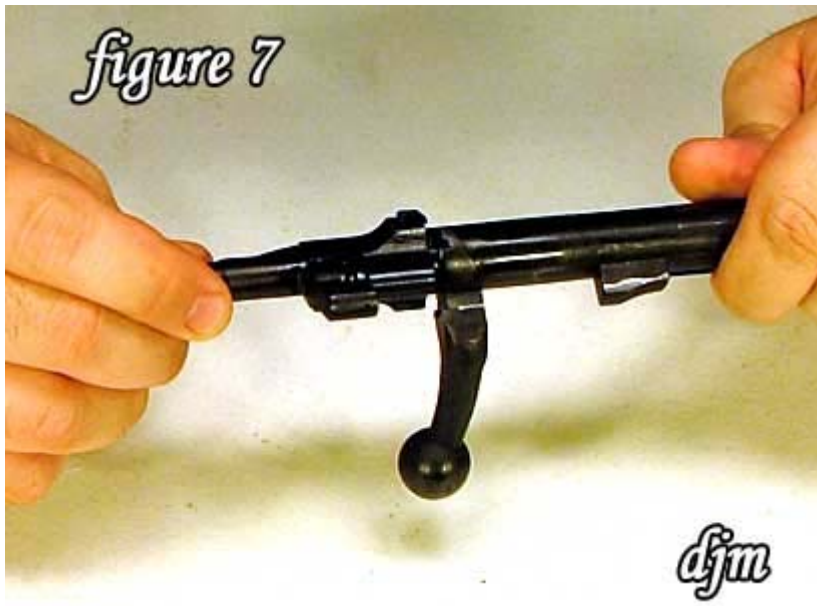
4) Remove the bolt.

5) Figure 5 shows bolt sleeve lock.



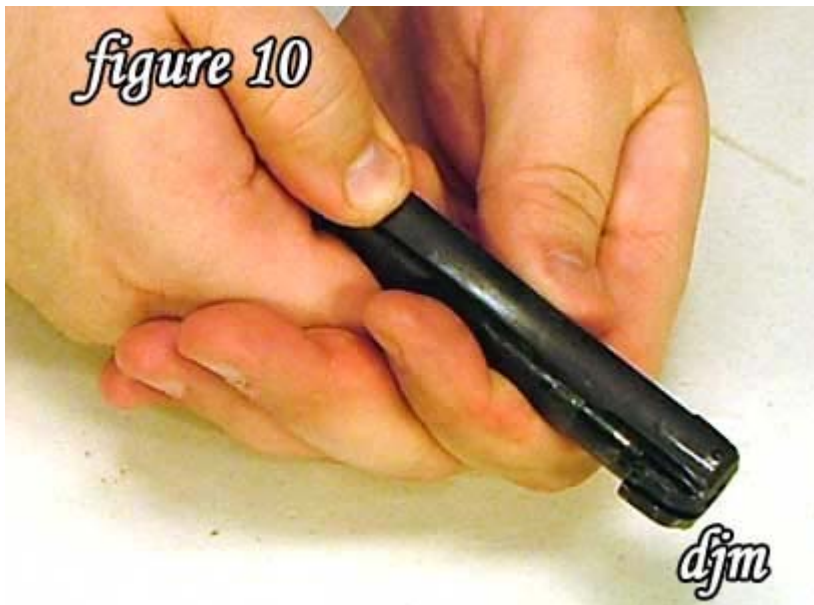
6) Depress the bolt sleeve lock and turn the bolt sleeve left or counter-clockwise.

7) Unscrew the bolt sleeve from the bolt body.



8) Remove bolt sleeve from bolt body.

9) Rotate extractor to the right or clockwise until it is out of its groove at the front of the bolt.



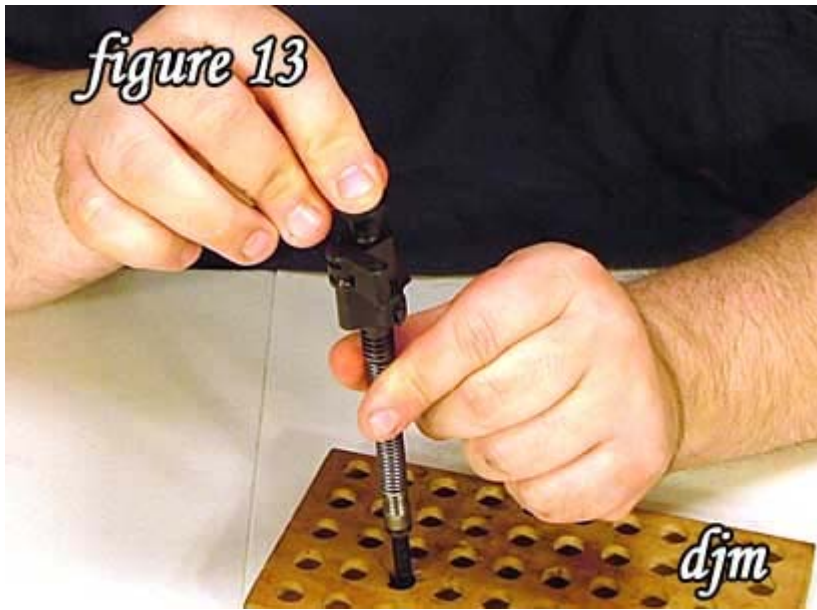
10) Push forward at the base of the extractor.

11) Push extractor forward until it clears the front of the bolt as shown in figure 11.



12) Remove the extractor and set both parts aside.

13) There are several methods for performing the following task. Caution: Make sure not to pinch your skin in main spring or cocking piece as they move forward. Place the point of the striker on a piece of wood. Draw the cocking piece back while pushing down with other hand on bolt sleeve. Rotate safety lever to "ready" position. Slowly allow the cocking piece to move forward to its fullest position and allow the main spring to

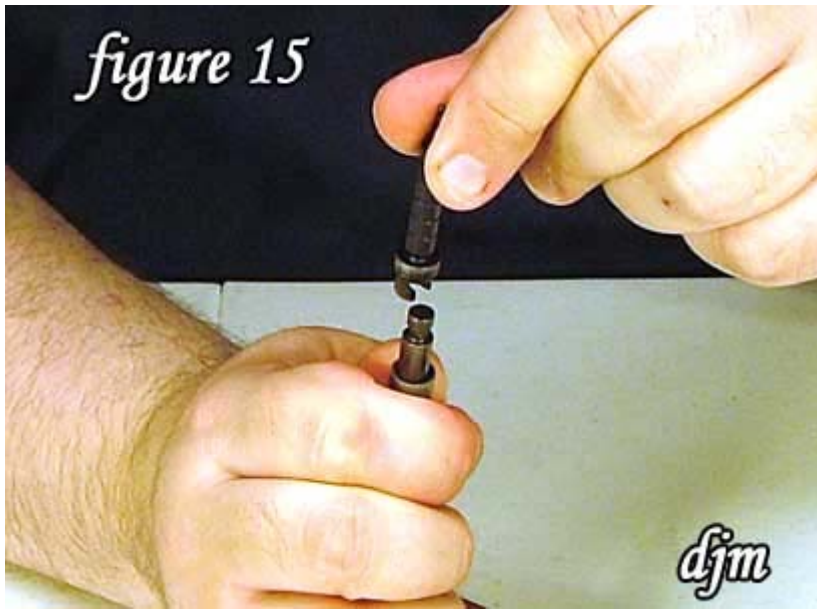


expand and the bolt is no longer cocked.



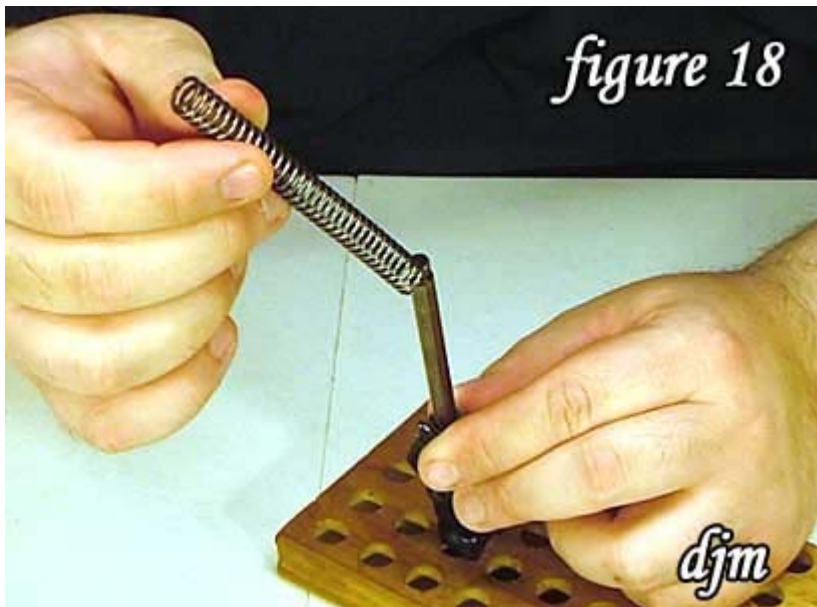
14) With the cocking piece firmly resting against a surface, pull back on the firing pin sleeve.

15) Remove the striker by pulling it to the side as shown in figure 15.



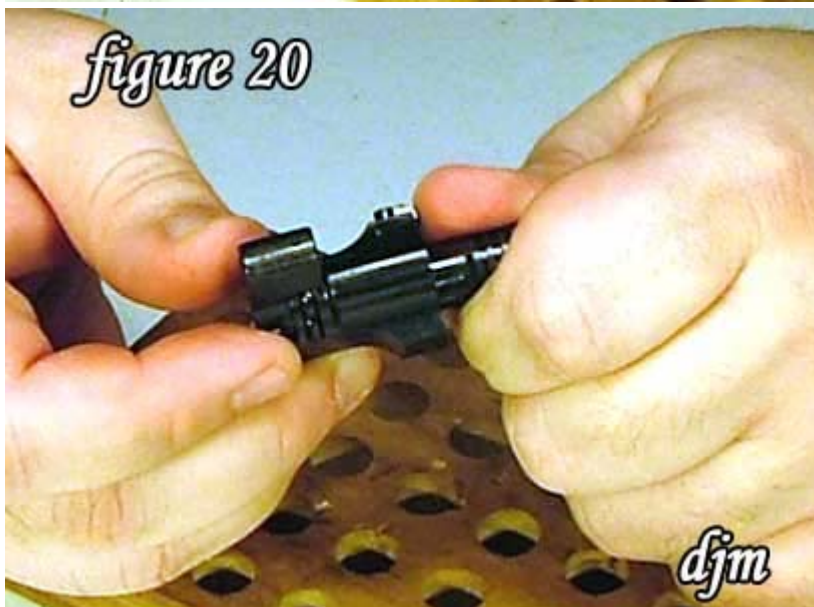
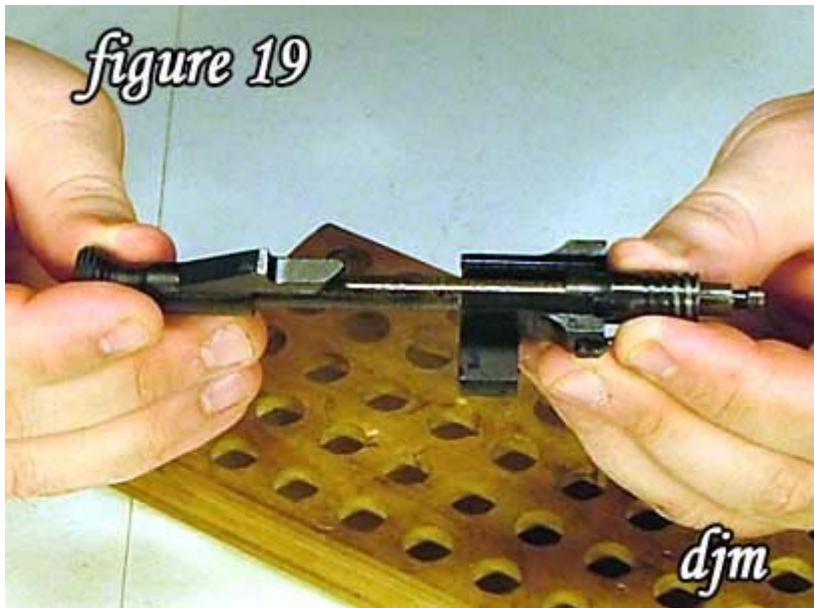
16) Allow the main spring to expand slowly.

17) Remove the firing pin sleeve.



18) Remove the main spring.

19) Pull the firing pin out of the bolt sleeve.



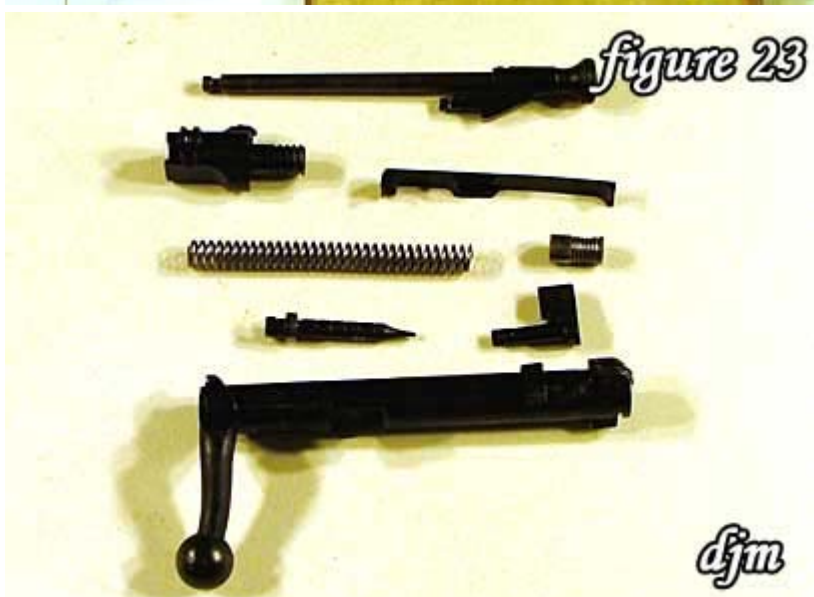
20) Rotate the safety lock to the center position located between the "safe" and "ready" positions.

21) Strike the front of the safety lever and it will become unseated as shown in figure 21.



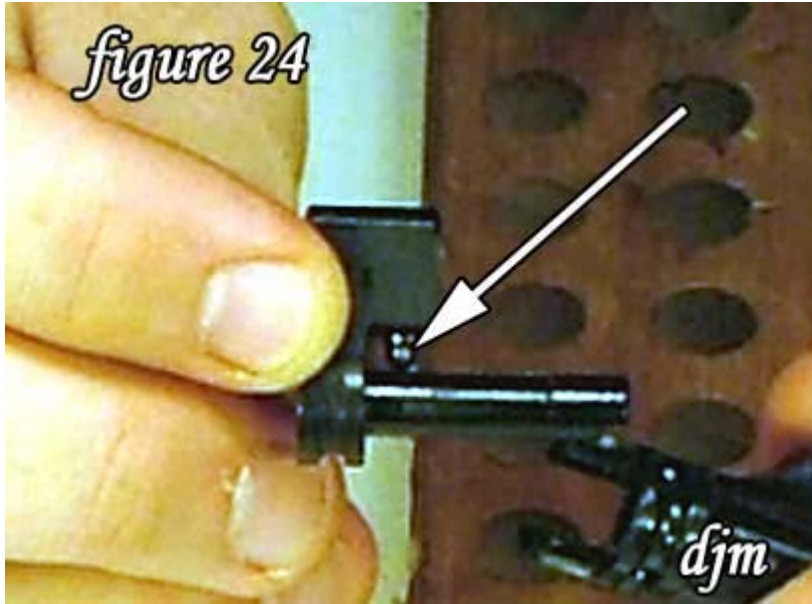
22) Remove the safety lever.

Not Pictured: Only if needed to be replaced, drive out the bolt sleeve lock pin from the top with a punch. Remove the bolt sleeve clock pin and spring.



23) Figure 23 shows the disassembled 1903/03A3 bolt.

Reassembly Instructions



24) Figure 24 shows the safety lock plunger.

Not Pictured and only if you removed the bolt sleeve lock pin and spring: Drive in the bolt sleeve lock pin and spring from the bottom with a punch.



25) Insert the safety lever's spindle into its hole in the back of the bolt sleeve. Push it as far forward as it will go. Rotate the safety lock to the center position located between the "safe" and "ready" positions.

26) Using a small flat blade screwdriver compress the safety lock plunger until it can slip over the top of the sleeve and into its slot.



27) Push safety lever completely forward.

28) Figure 28 shows the extractor collar and the bottom of the extractor. Rotate the extractor collar until it is lined up as pictured in figure 28.



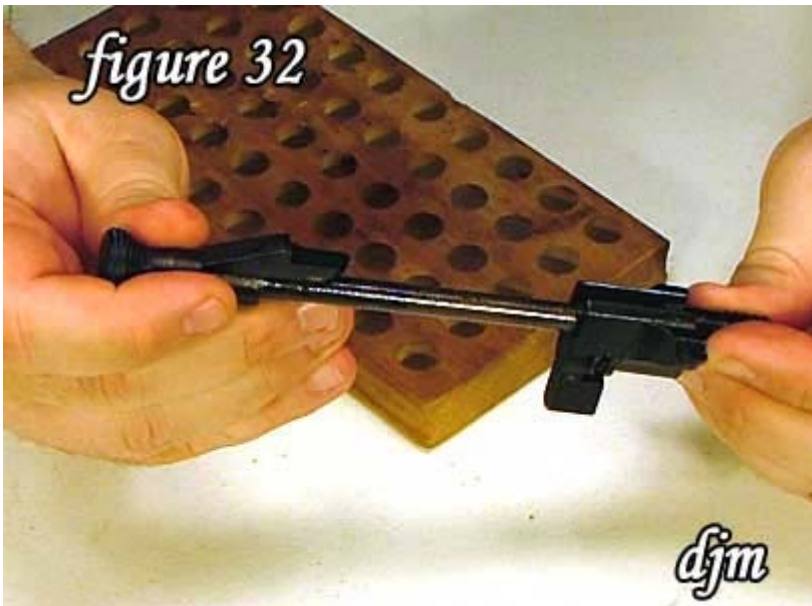
29) Compress collar and slide the extractor onto the collar.

30) Push the extractor to the rear of the bolt. Slightly lift the front of the extractor so it clears the front of the bolt. Push the extractor to the rear of the bolt until extractor is aligned with groove cut into bolt.



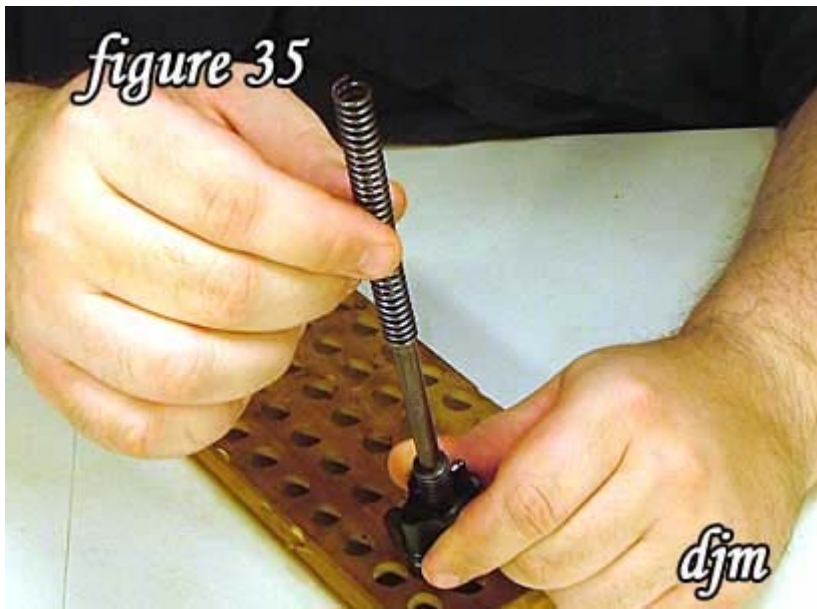
31) Rotate the extractor to the left or counter-clockwise until it enters the groove.

32) Insert the firing pin into the bolt sleeve.



33) Figure 33 shows the position of the sear notch/lug as it rest in the bolt sleeve.

34) Rotate the safety lever to the "ready" position. This allows the firing pin to move forward in the bolt sleeve as far as possible.



35) Place the main spring on the firing pin.

36) With the cocking piece firmly resting against a surface, compress the main spring and install the firing pin sleeve.



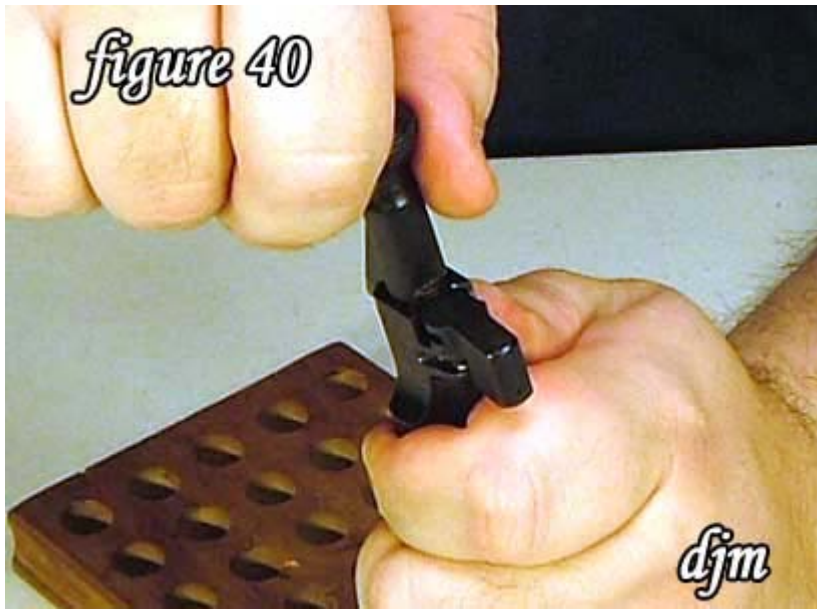
37) With the cocking piece firmly resting against a surface, compress the main spring and firing pin sleeve and install the striker onto the firing pin.

38) Allow the firing main spring to move forward and the firing pin sleeve to slide over the rear of the striker.

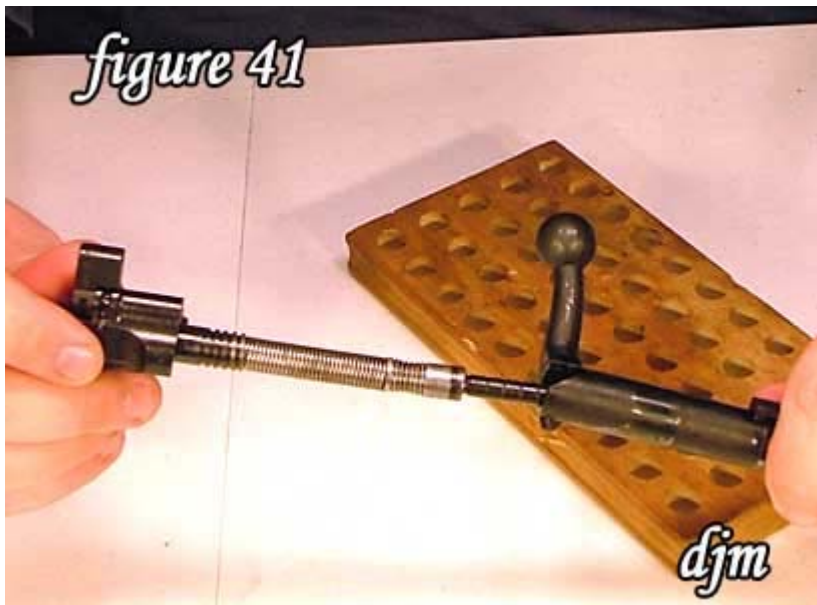


39) Place the tip of the striker against a piece of wood. Pull back on the cocking piece.

40) With the cocking piece pulled back, rotate the safety lock to the center position located between the "safe" and "ready" positions.



41) Insert firing pin into bolt body.



42) Rotate the bolt sleeve to the right or clockwise.

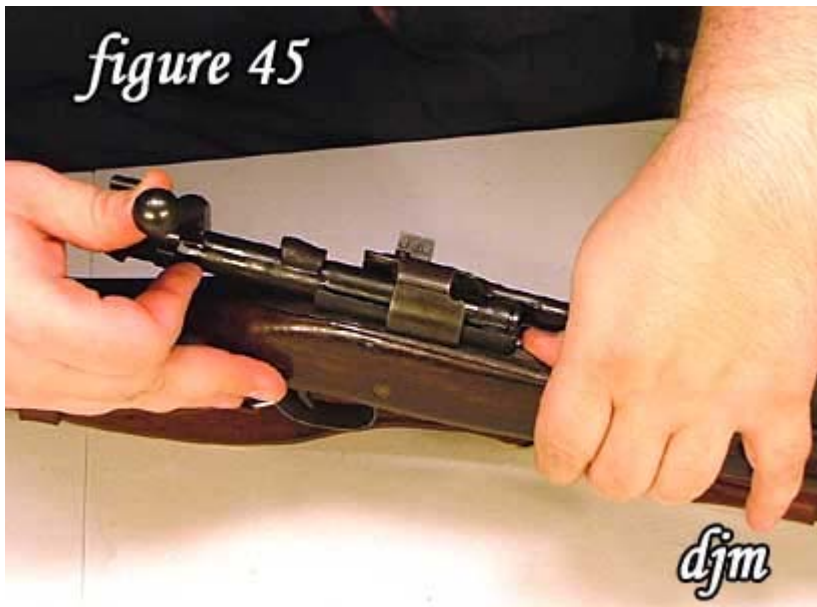


43) Depress bolt sleeve lock and rotate the bolt sleeve into its locked position.

44) Place the magazine cut-off in the center position between off and on (as shown in figure 44).



45) Depress magazine follower and insert bolt.



46) Push bolt handle fully forward and close.



47) Rotate safety lever to "ready" position.

48) Place the magazine cut-off in the "off" position (down as shown in figure 48).



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