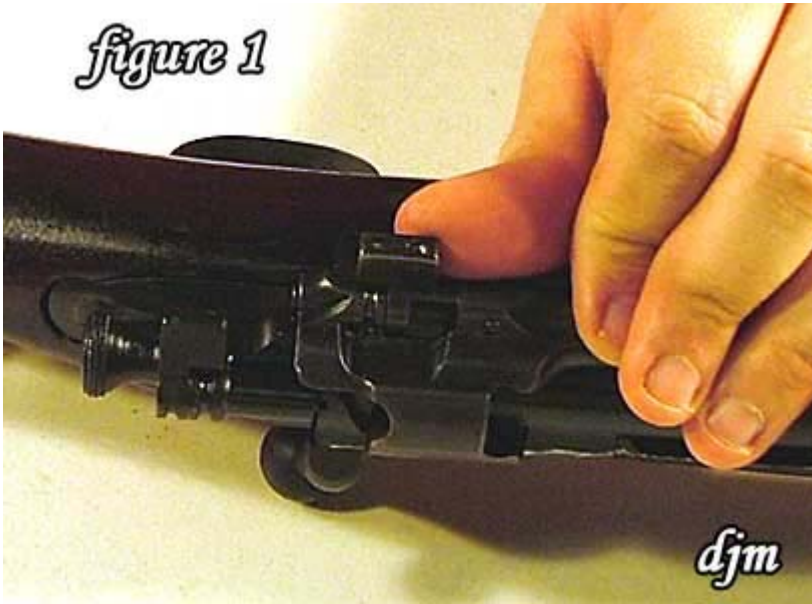




Disassembly & Reassembly of the U.S. Model 1903A3 Rifle

[Adobe PDF Downloadable Version of Article](#)

figure 1

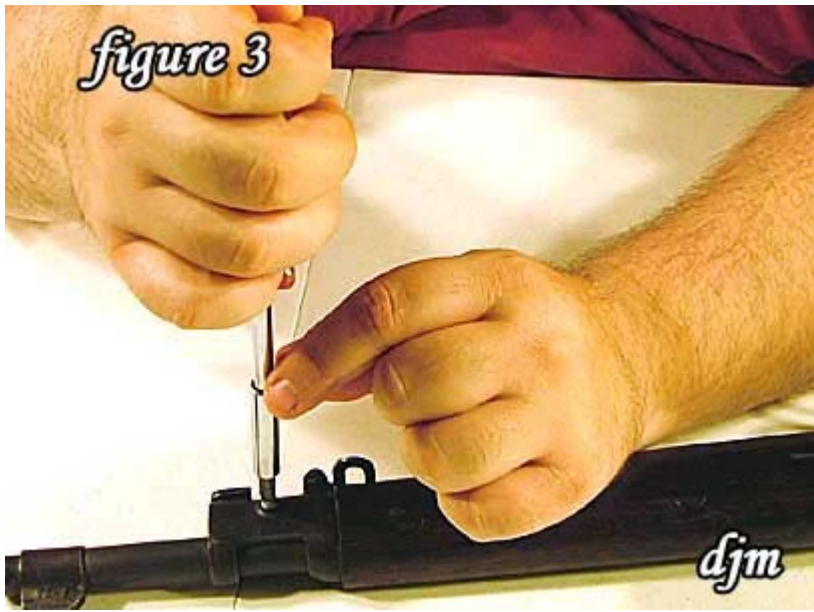


1) Place the magazine cut-off in the center position between off and on (as shown in figure 1).

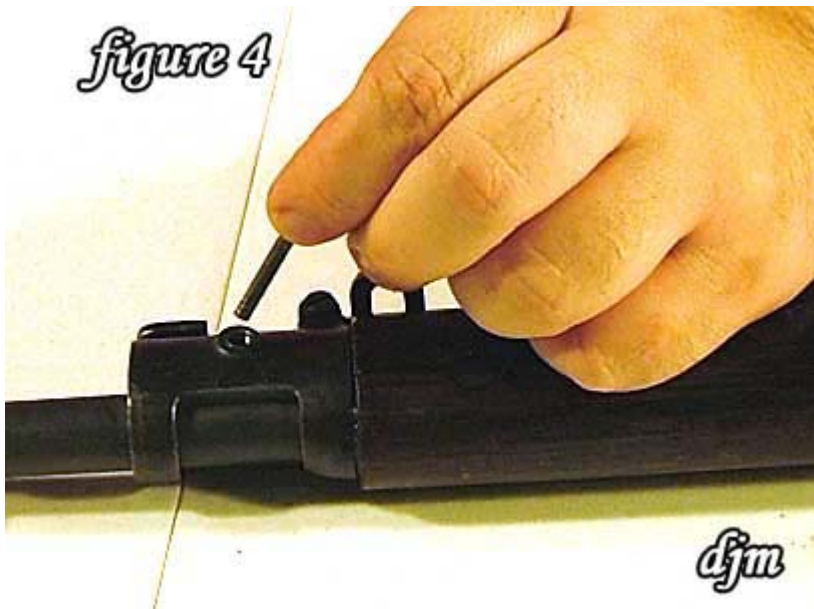
figure 2



2) Remove the bolt.

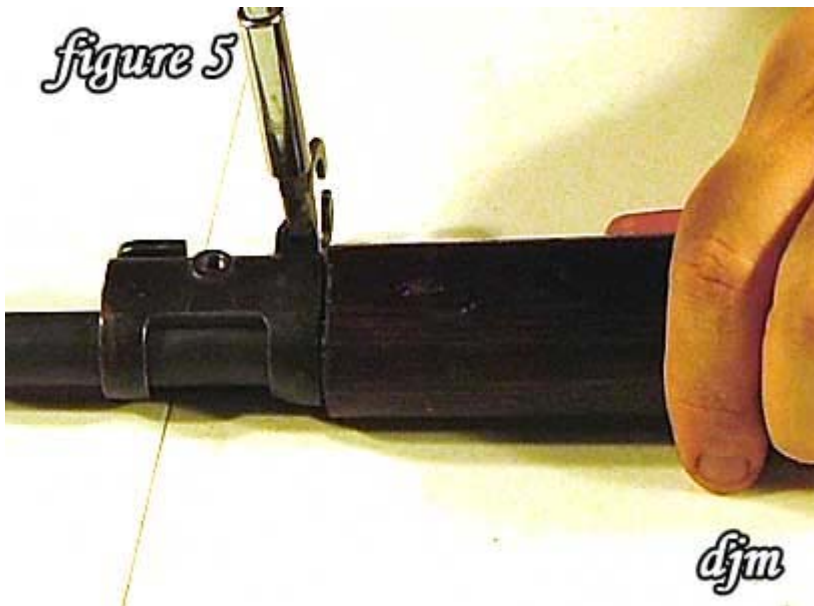


3) Unscrew upper band screw.



4) Remove the upper band screw.

5) Loosen the stacking swivel screw. It is all right to remove the stacking swivel and stacking swivel screw from the rifle if you desire. For the sake of these instructions we chose not to.



6) If the upper band is stuck in place use a wooden dowel to tap it forward. Otherwise slide the upper band forward.

Note: We do not cover the removal of either the front or rear sight assemblies so you will not be able to remove the upper or lower band from the rifle's barrel on the 1903, 1903A1, and the 03A3.

7) On 1903 rifles (1903 and 1903A1) you can loosen and remove the rear lower band screw and lower band swivel.

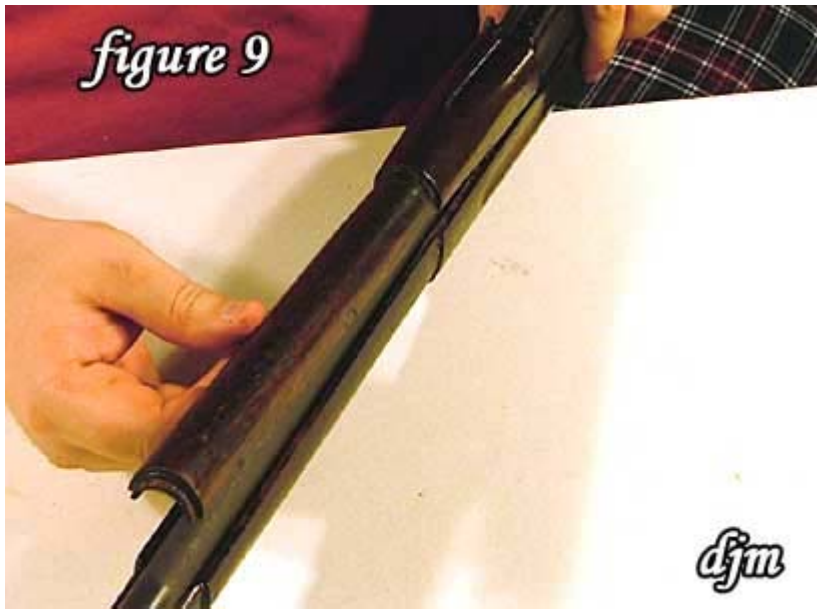
03A3 and 03A4 rifles have a tapered rear lower band screw that should not be removed, but only loosened.



8) Depress lower band spring and slide the lower band forward.

9) Slide the hand guard forward and off of the barrel. If there are clip springs on the bottom of the hand guard, do not attempt to remove them.

Note: The 03A3 rifle also has a removable hand guard ring that can be slide forward as well.



10) Depress floor plate catch and at the same time slide the floor plate to the rear.

11) Remove floor plate, magazine spring, and follower.



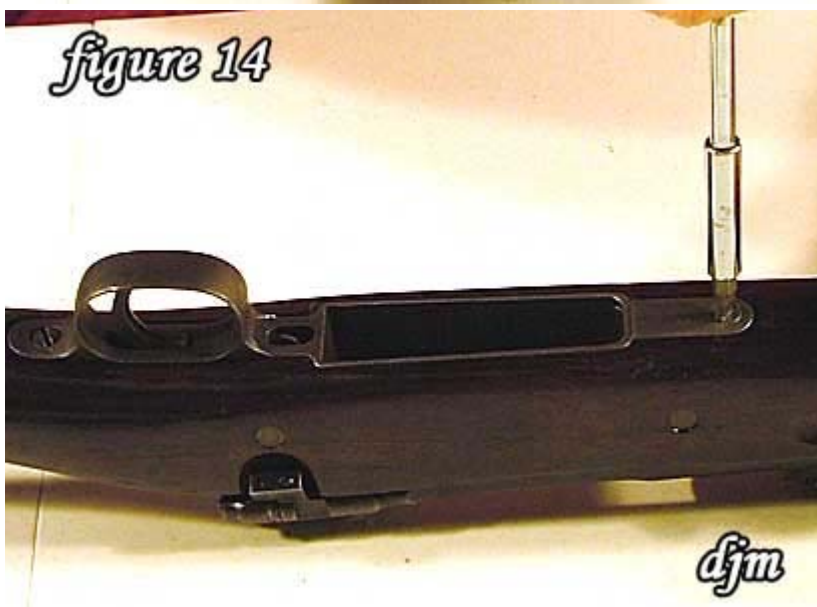
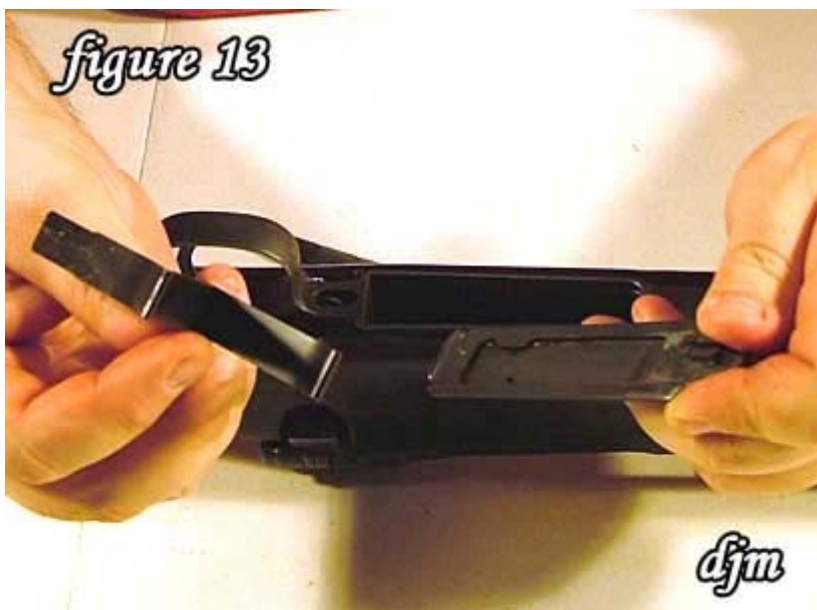
figure 11



figure 12

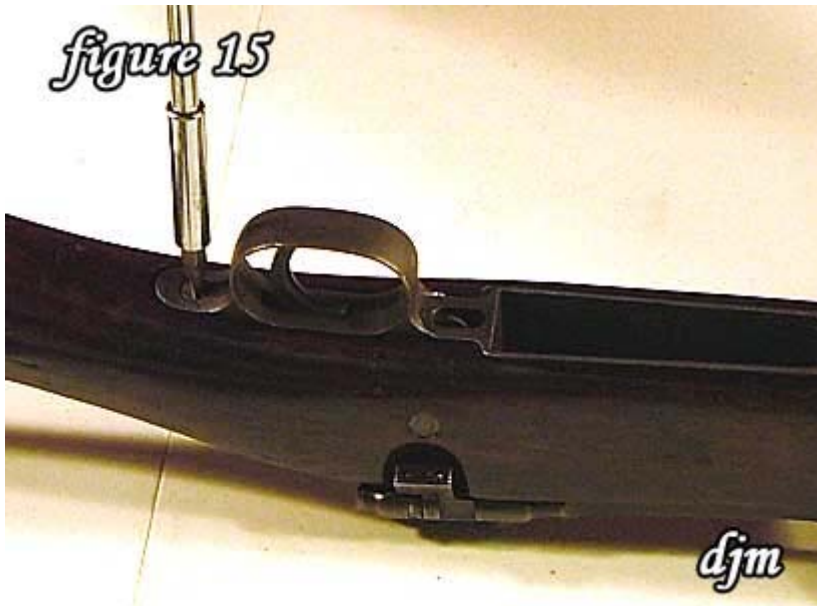
12) Separate follower from magazine spring.

13) Separate floor plate from magazine spring.



14) Loosen front guard screw.

15) Loosen rear guard screw.



16) Remove the rear guard screw.



17) Remove the front guard screw.



18) If necessary to tap on front and rear of trigger guard to loosen for removal. Remove the trigger guard.

Not Pictured: To remove the floor plate catch and spring drive out the floor plate catch pin.

19) Figure 19 shows the 03A3 and 03A4 stamped metal trigger guard (with non-removable floor plate) being removed from the rifle.



20) Figure 19 shows the 03A3 and 03A4 magazine spring and follower being removed from the rifle. Note that the magazine spring just rests against the bottom of the trigger guard/floor plate and is not attached. The 1903 and 1903A1 instructions above for disassembling the follower and magazine spring are the same with the 03A3 and 03A4 rifles.

21) Separate the barrel and receiver from the stock.



figure 21



figure 22

22) Loosen the cut-off screw until it disengages the spindle.

23) Insert a small flat blade screw driver and pull the cut-off spindle out.



figure 23



figure 24

24) Remove the cut-off spindle.

25) Remove the cut-off.



figure 25

djm



figure 26

djm

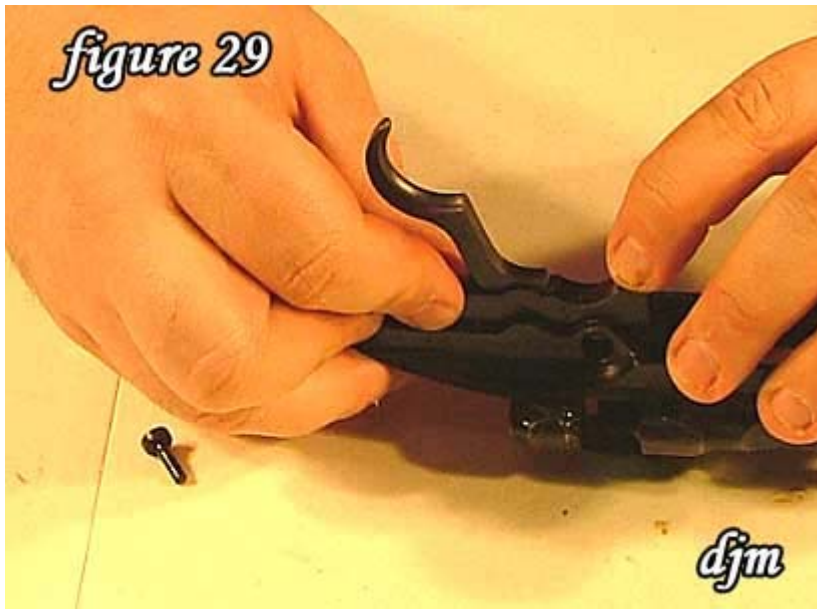
26) Remove the plunger.

27) Remove the spring.



28) Remove the sear pin by driving it out with a punch.

29) Remove the sear, sear spring, and trigger.



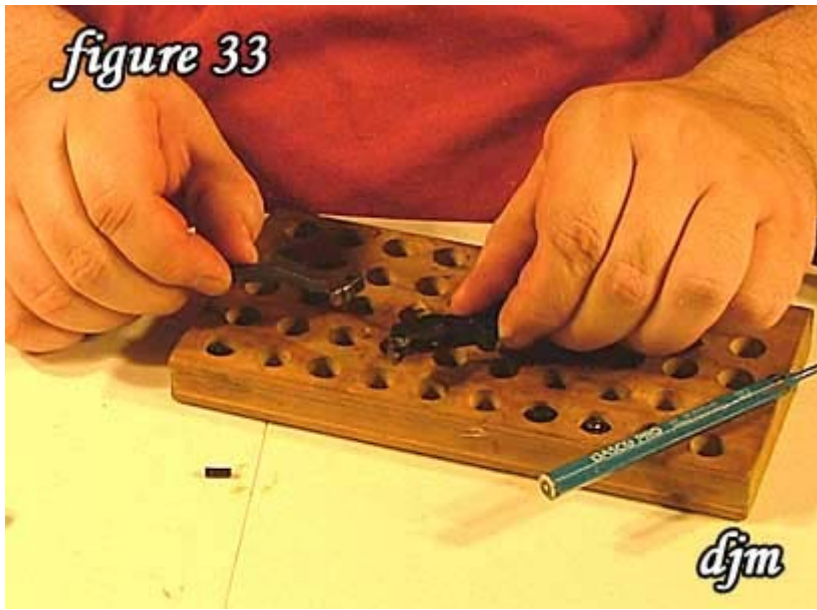
30) Separate the sear spring from the sear.

31) Using a punch drive out the trigger pin.



32) Remove the trigger pin.

33) Separate the sear and trigger.



34) Drive out the ejector pin from the top side. It has a slot cut into it giving the impression it is a slotted screw. It is not, you can turn it all day long and it will not unscrew.

35) Remove the ejector pin.



36) Remove the ejector.

Not pictured: The bolt stop assembly is located at the bottom of the receiver at the front of where the sear spring meets the bottom of the receiver. We really do not recommend removing the bolt stop and bolt stop spring. The pin and spring are a single assembly. They can be removed if necessary by inserting a small punch in the hole in the spring and drawing it out. Note that some 1903 and 190A1 rifles do not have a bolt stop.

37) Unscrew upper butt plate screw.



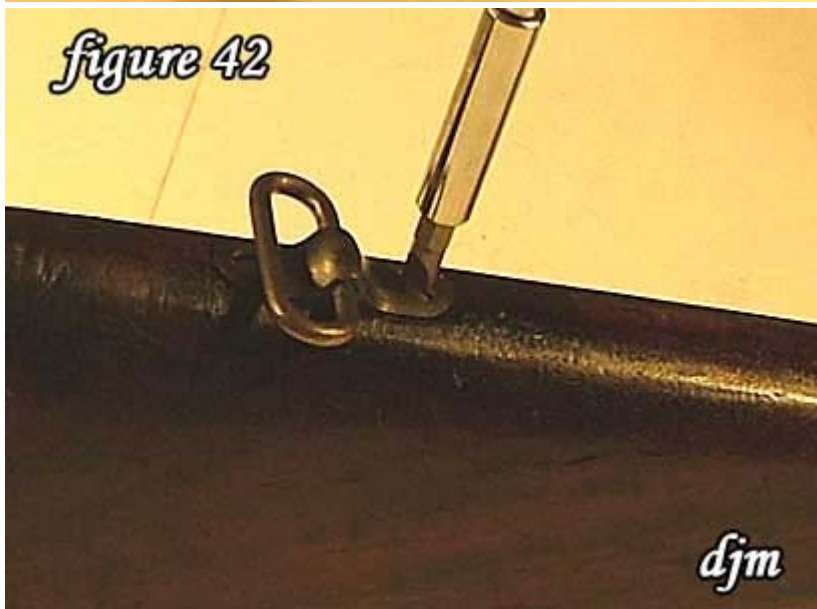
38) Remove the upper butt plate screw.

39) Unscrew lower butt plate screw.



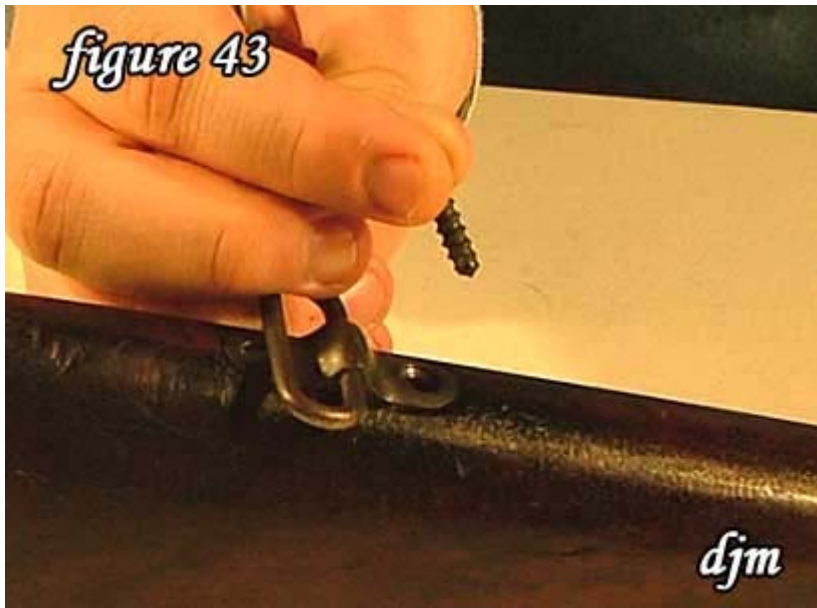
40) Remove the lower butt plate screw.

41) Remove the butt plate.

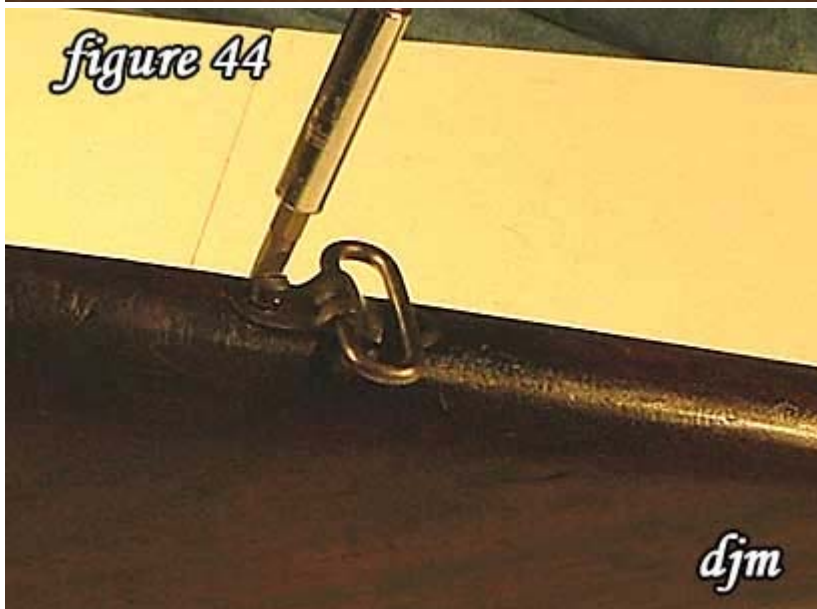


42) Unscrew the front rear swivel screw.

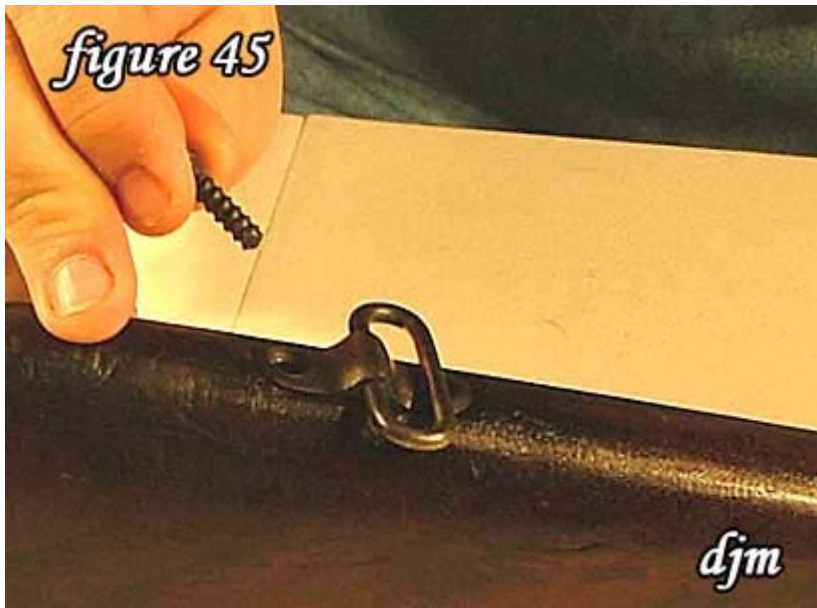
43) Remove the front rear swivel screw.



44) Unscrew the rear rear swivel screw.



45) Remove the rear rear swivel screw.



46) Remove the rear swivel.



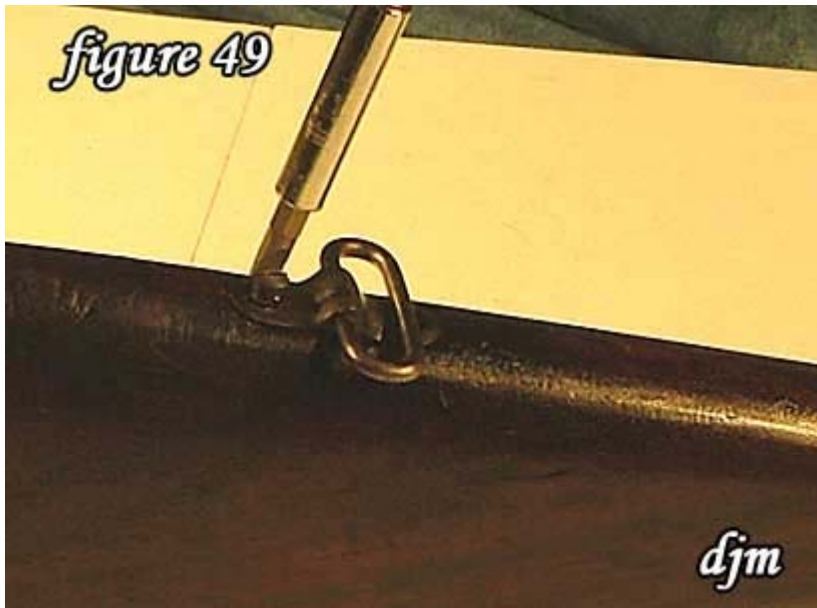
Reassembly Instructions

47) Replace the rear swivel.



48) Replace the rear rear swivel screw.

49) Tighten the rear rear swivel screw.



50) Replace the front rear swivel screw.

51) Tighten the front rear swivel screw.



52) Replace the butt plate.

53) Install the lower butt plate screw.



54) Tighten the lower butt plate screw.



55) Install the upper butt plate screw.



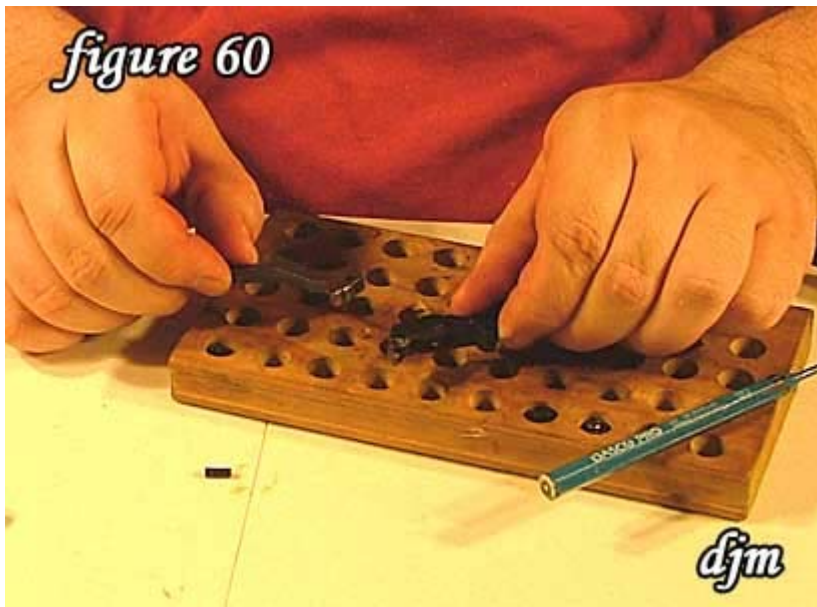
56) Tighten the upper butt plate screw.

57) Insert ejector.



58) I have found that you can take a small punch or jewelers screw driver hand insert it to hold ejector in place from the top. Then take the ejector pin and push the tool out from the bottom.

59) Lightly tap the ejector pin in place. If the ejector does not move freely then you have over tightened (pushed the pin in too far). If this happens then light drift the pin back a hair from the top to bottom.



60) Insert trigger into sear.

61) Insert trigger pin.



62) Tap trigger pin into place.



63) Insert sear spring into well in top of sear.



figure 63

djm

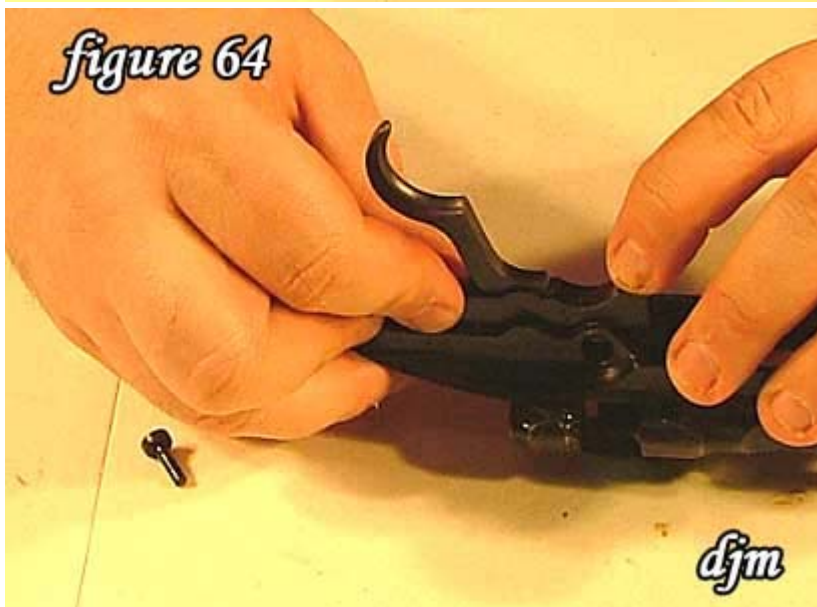
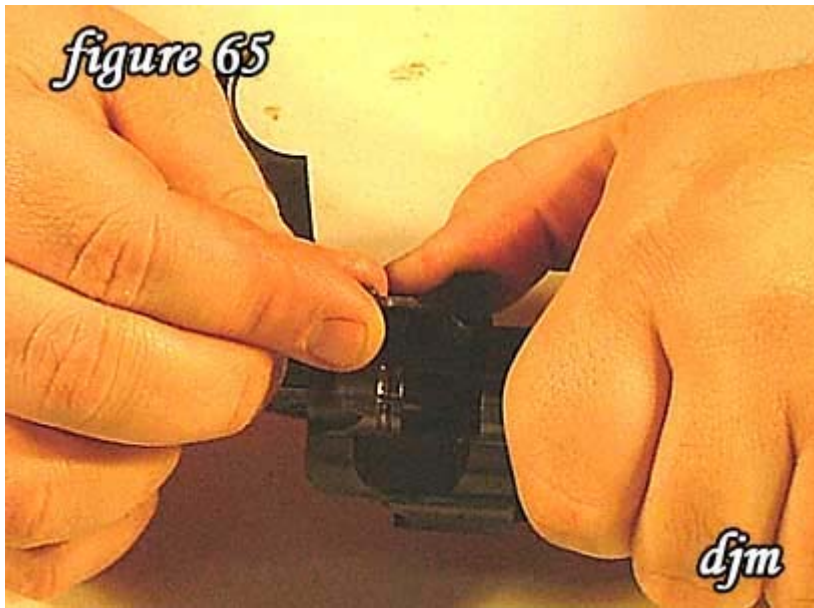


figure 64

djm

64) Insert trigger, sear, and sear spring into receiver. Compress sear spring so the sear pin holes align.

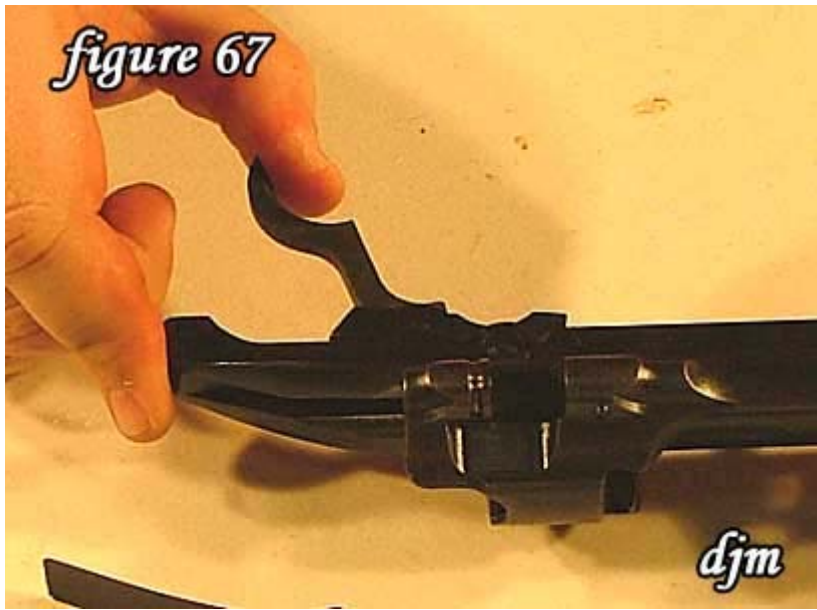
65) Insert sear pin from left side of sear.



66) Push sear pin all the way into place.



67) Test trigger to make sure it moves freely without binding.



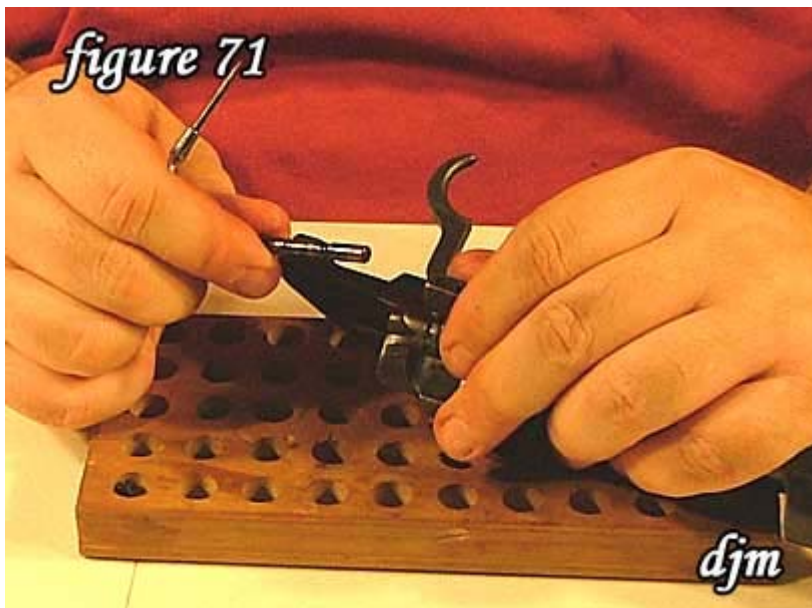
68) Insert plunger spring into cut-off.

69) Insert plunger into cut-off.



70) Insert the cut-off.

71) While the compressing plunger and holding cut-off in place so holes align, insert the cut-off spindle.



72) Tighten cut-off screw till it engages the spindle and holds the cut-off in place.

73) Return the barrel and receiver to the stock.

Note: In the 03A3 and 03A4 rifle if you have removed the removable hand guard ring, this part needs to be slid back into place before installing the stock.



figure 73

djm



figure 74

djm

**74) (1903 and 1903A1)
Replace tapered end of
magazine spring into slot of
the bottom of the floor plate.**

**75) Insert the other end of
the magazine spring into the
follower.**



76) Insert the trigger guard into the rifle.

Not Pictured: Install the floor plate catch and spring by driving in the floor plate catch pin.

77) Figure 77 shows the 03A3 and 03A4 magazine spring and follower being installed in the rifle. Note that the magazine spring just rests against the bottom of the trigger guard/floor plate and is not attached. The 1903 and 1903A1 instructions above for reassembling the follower and magazine spring are the same with the 03A3 and 03A4 rifles.



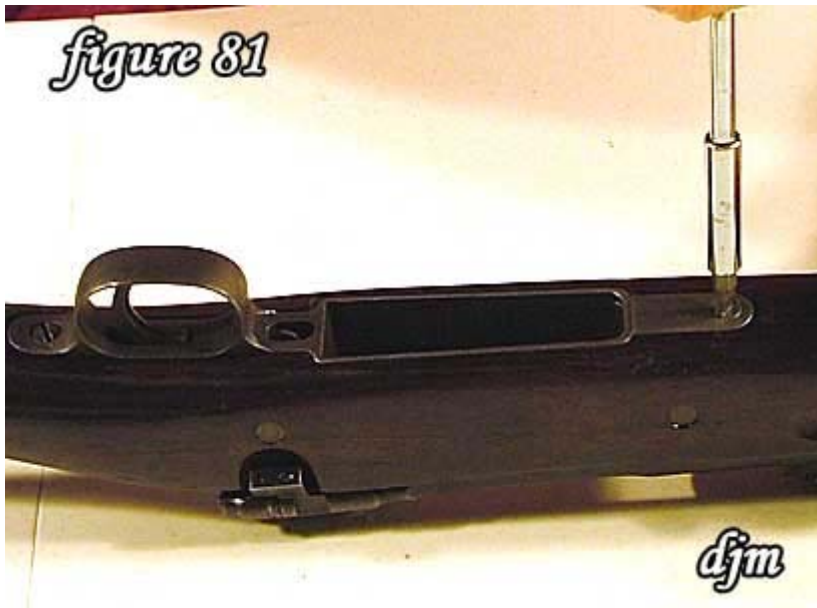
78) Figure 78 shows the 03A3 and 03A4 stamped metal trigger guard (with non-removable floor plate) being installed into the rifle.

79) Return front guard screw.



80) Return the rear guard screw.

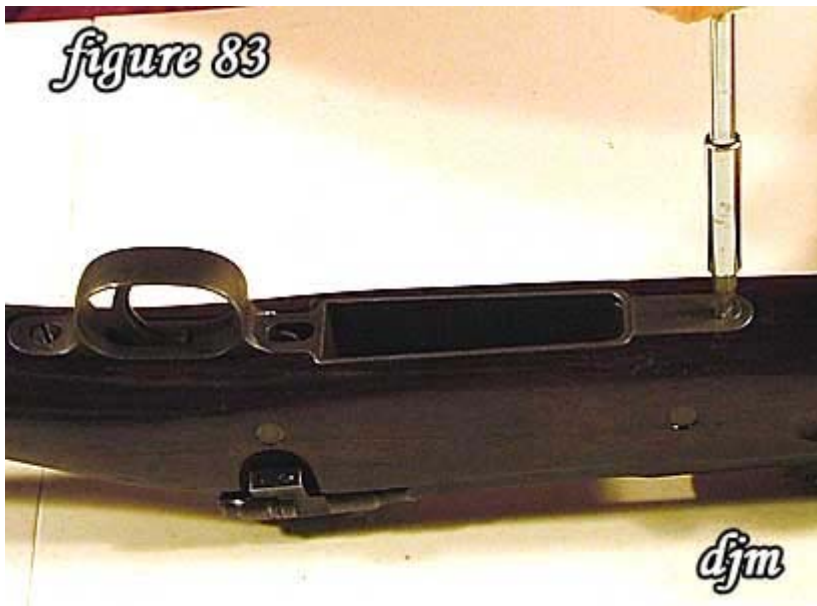
81) Slightly tighten the front guard screw.



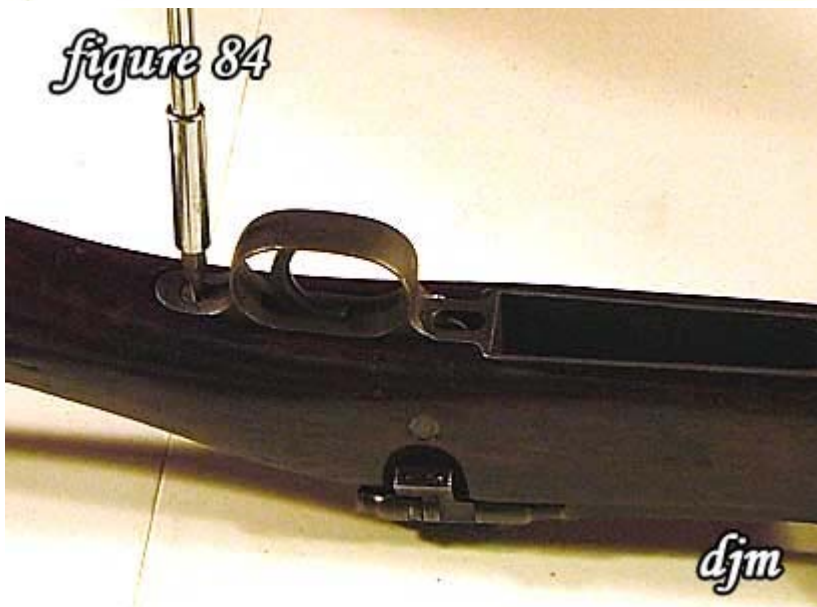
82) Slightly tighten the rear guard screw.



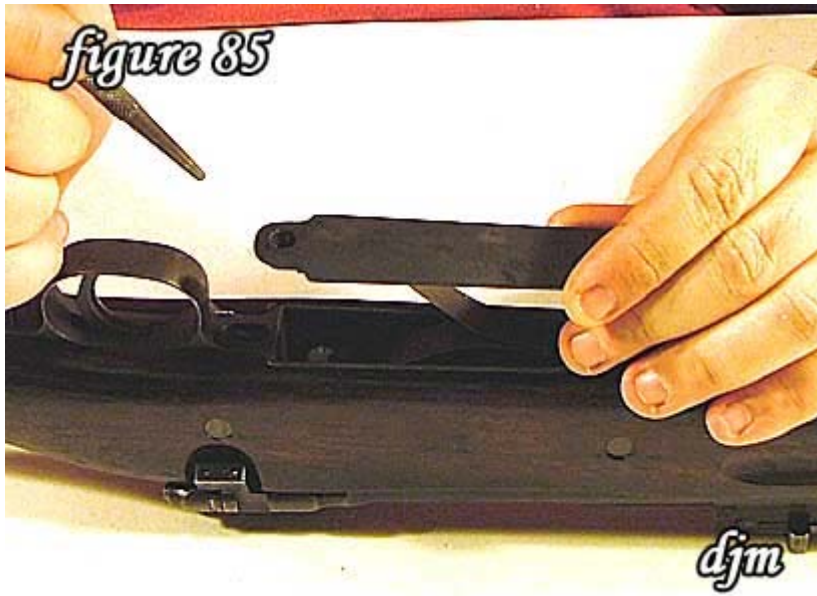
83) Fully tighten the front guard screw.



84) Fully tighten the rear guards screw.



85) (1903 and 1903A1) Insert floor plate, magazine spring, and follower.



86) (1903 and 1903A1) Snap floor plate in place.



87) Slide the hand guard to the rear of the barrel. If a 03A3 or 03A4 rifle seat hand guard into hang guard ring.



88) Depress lower band spring and slide the lower band back into place.



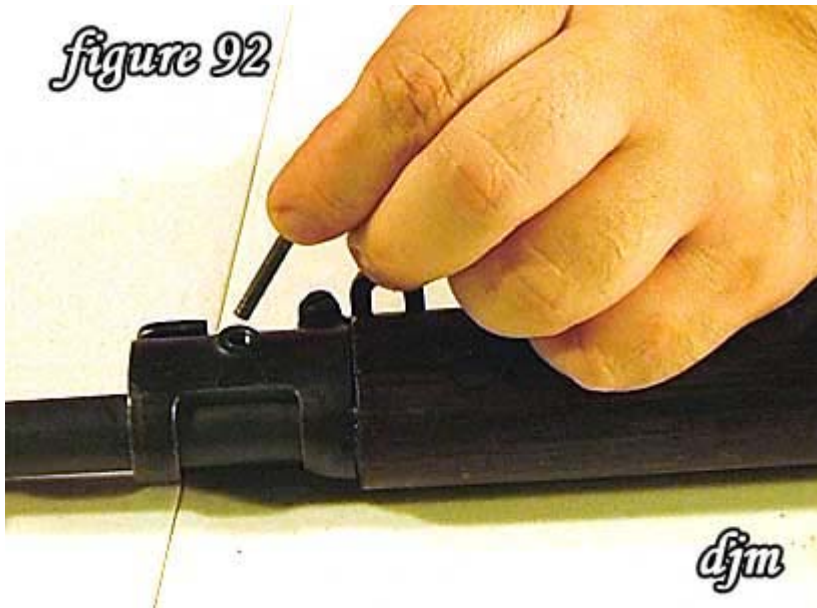
89) Tighten the rear lower band screw.

90) Slide upper band back into place.



91) Tighten the stacking swivel screw.

92) Insert the upper band screw.



93) Tighten the upper band screw.

94) Place the magazine cut-off in the center position between off and on (as shown in figure 94).



95) Depress the magazine follower and insert the bolt.

96) Slide the bolt forward and close. Turn cut-off to off (down). You have completed the disassembly and reassembly of the 1903, 1903A1, or 03A3 rifle.



[Adobe PDF Downloadable Version of Article](#)