

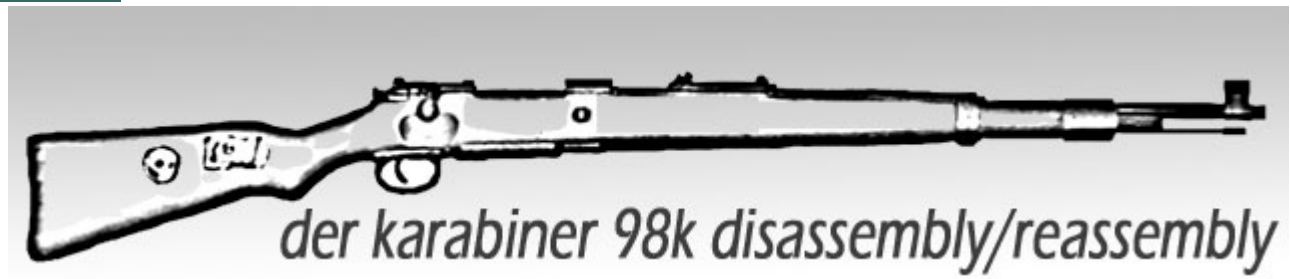
Collecting and Shooting the Military Surplus Rifle



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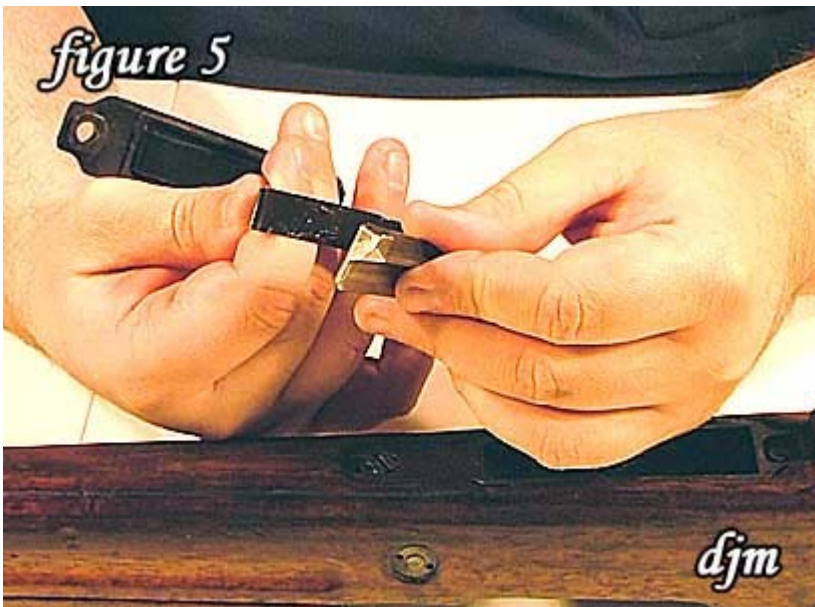
1) With the rifle pointed in a safe direction, open the bolt and make sure the rifle is not loaded.

2) While holding the bolt stop out, remove the bolt from the receiver.



3) Depress the magazine floor plate catch.

4) Slide the magazine floor plate to the rear and out.

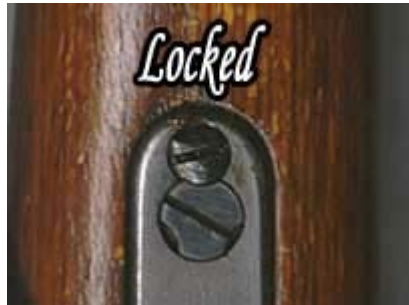


5) Slide the magazine spring out of the slot in the bottom of the magazine follower.

6) Slide the magazine spring out of the slot in the bottom of the magazine floor plate.



Locking Screws



Most 98 type Military Mausers have locking screws that lock the trigger guard screws in place. The two figures to the left show the positions of the locking screws.



7) Unlock the locking screw. Unscrew the forward guard screw.

8) Remove the forward guard screw.



9) Unlock the locking screw.
Unscrew the rear guard
screw.

10) Remove the rear guard
screw.



11) Remove the trigger guard.

If the guard is difficult to remove you can turn the rifle over and tap the guard out from the top using a wooden dowel.

12) Unscrew the cleaning rod.



13) Remove the cleaning rod.



14) I use a quick clamp to depress the band spring so I can have my hands free.



15) Tap the forward band forward.

16) Slide the forward band off of the barrel.



17) Remove the band spring.

18) Slide the rear band forward.



19) Remove the rear band.

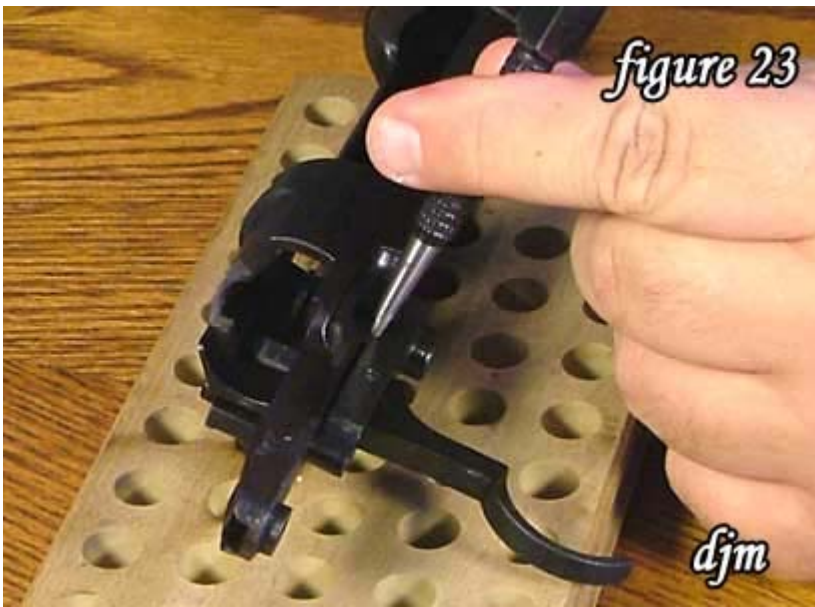
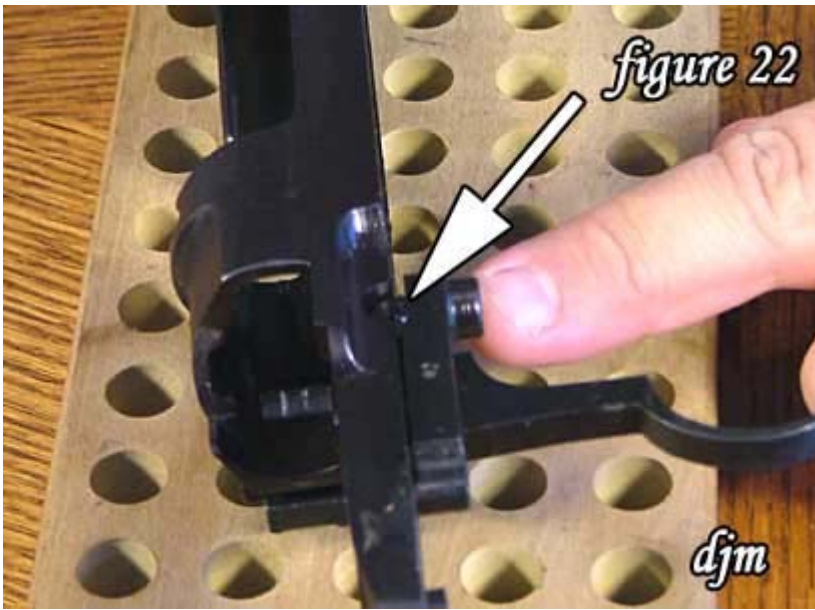


20) Remove the handguard.



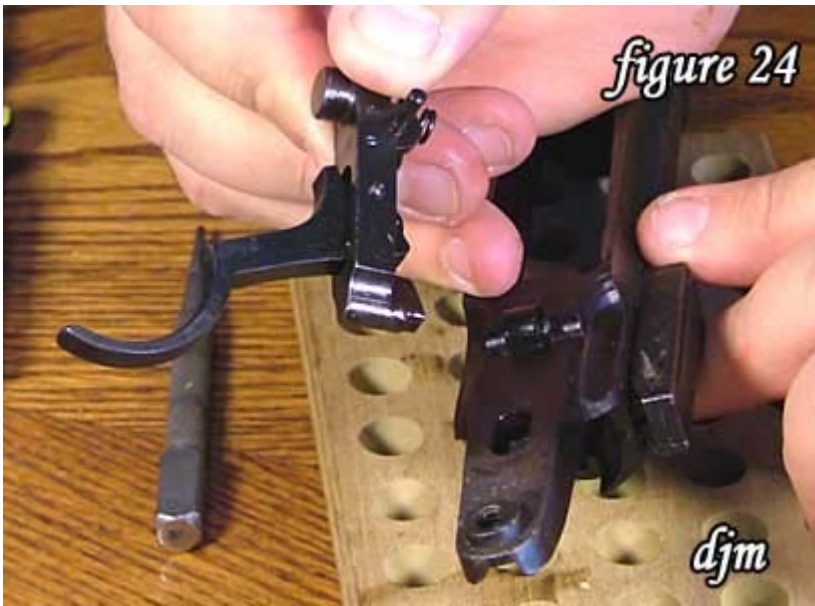
21) Lift the barreled receiver from the rifle stock.

22) Figure 22 shows the trigger assembly and the arrow points to the sear pin.



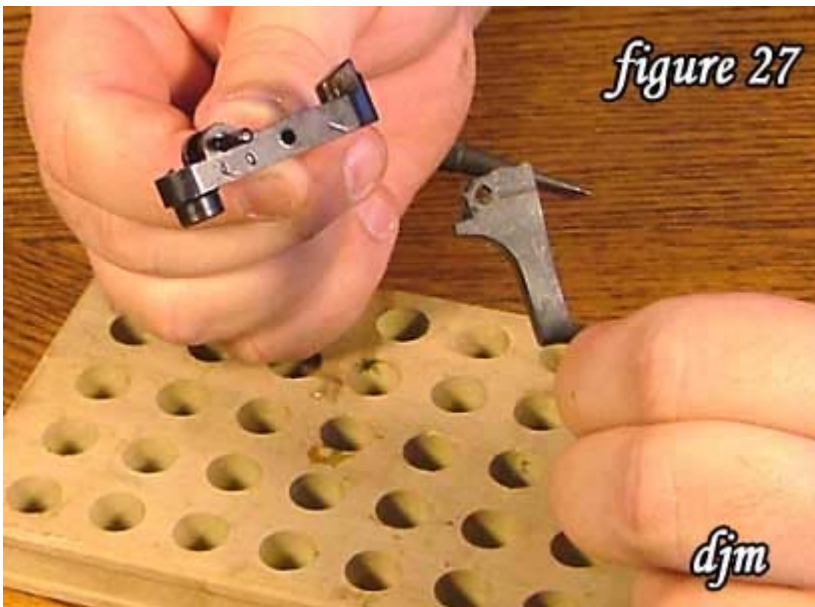
23) Using a punch, tap out the sear pin.

24) Remove the trigger assembly.



25) Remove the sear spring from the sear.

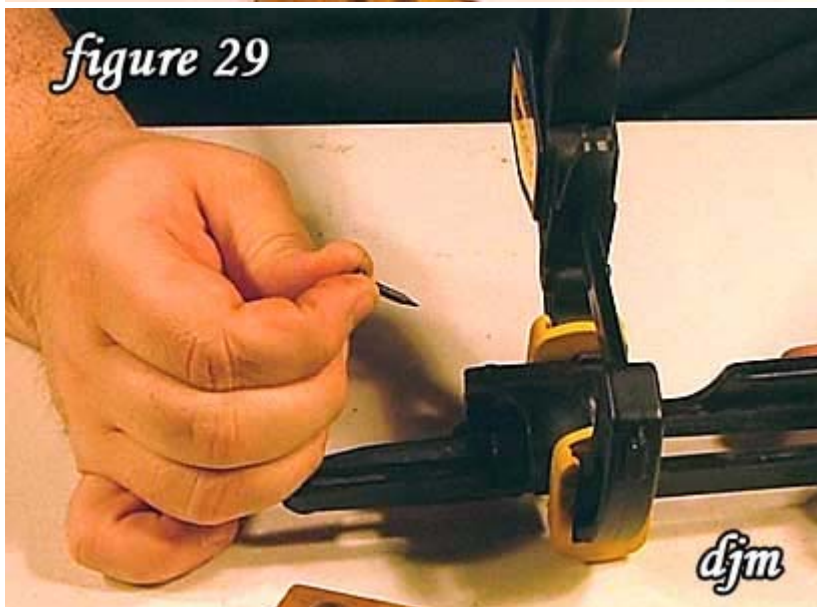
26) Using a punch, tap out the trigger pin.



27) Separate the trigger and sear.

28) It is easier to remove the bolt stop screw if the bolt stop is held in place.

Unscrew the bolt stop screw.



29) Remove the bolt stop screw.

30) Separate the bolt stop from the receiver.



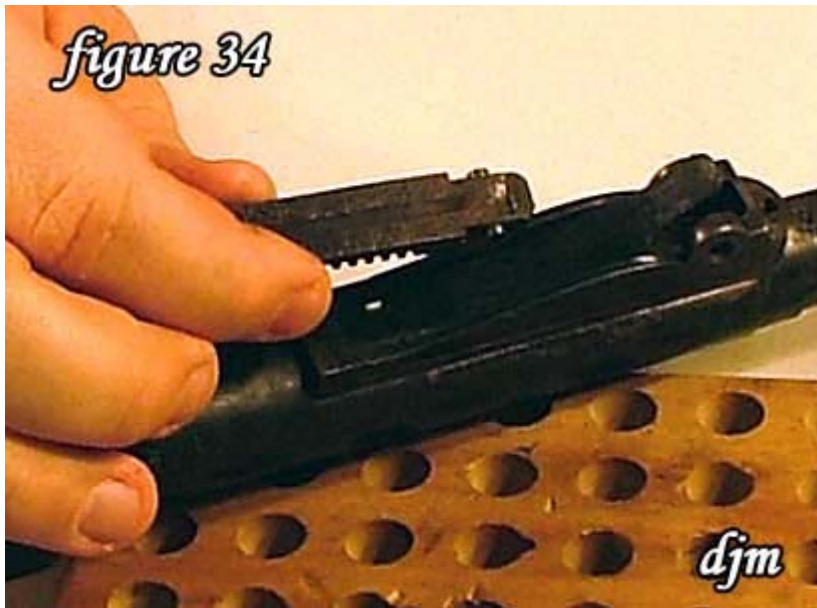
31) Using a punch, tap out the rear sight pin.

32) Remove the rear sight pin.



33) Place a flat blade screw driver in the indentation at the forward part of the rear sight leaf.

34) Remove the rear sight leaf.

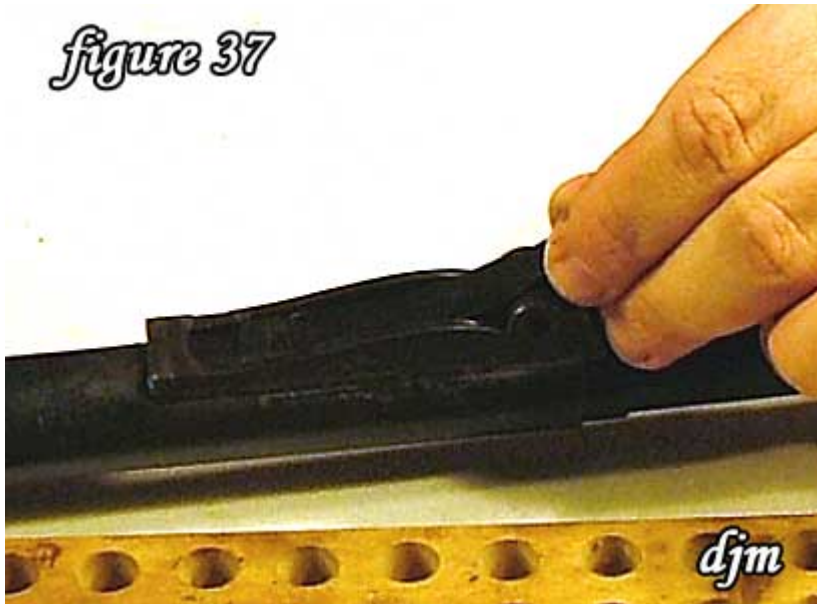


35) Tap the rear sight leaf spring forward.

36) Remove the rear sight leaf spring from the base.



Reassembly Instructions



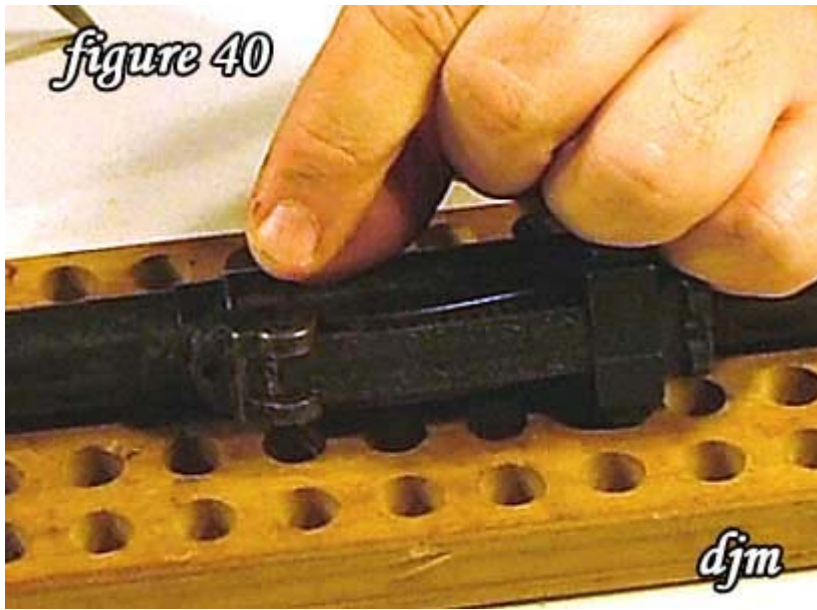
37) Install the rear sight leaf spring into the sight base.

38) Tap the rear sight leaf spring to the rear.



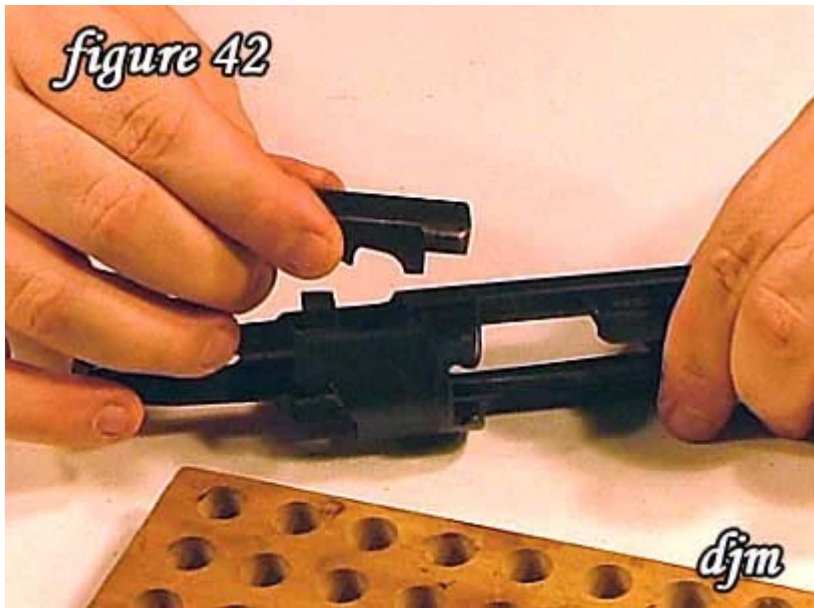
39) Place a flat blade screw driver in the indentation at the forward part of the rear sight leaf. Push down on the rear sight leaf with the screw driver while pushing the rear sight leaf forward. When you release pressure the leaf should stay held in place by the rear sight leaf spring.

40) Insert the rear sight pin.



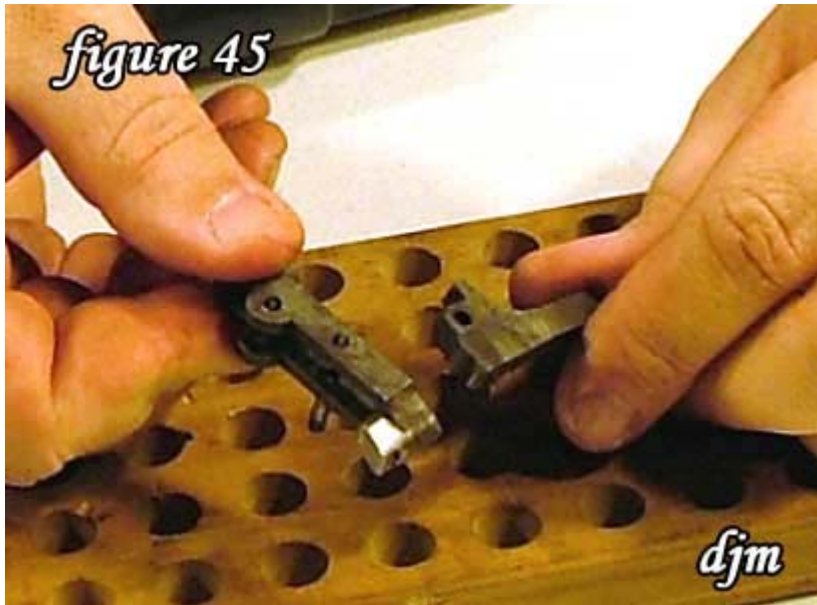
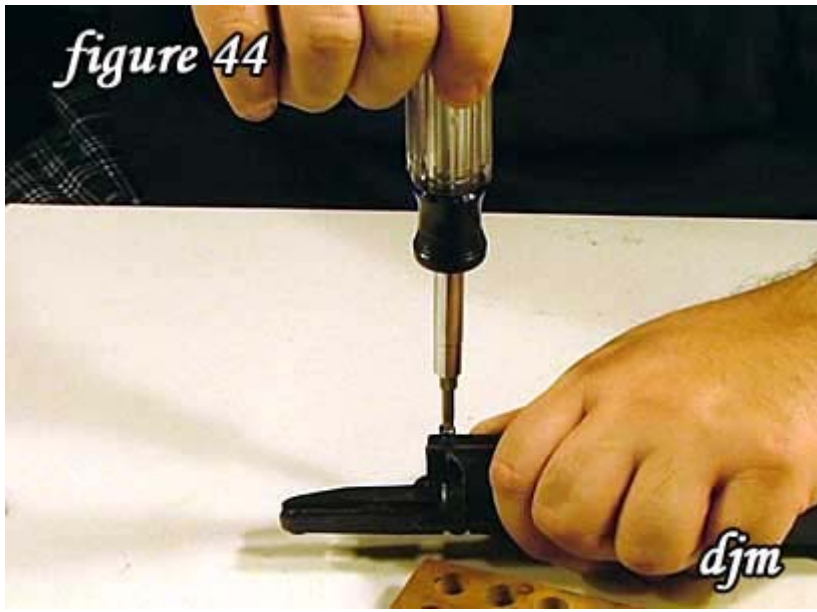
41) Tap the rear sight pin in place.

42) Install the bolt stop.



43) Install the bolt stop screw.

44) Tighten the bolt stop screw. Open and close the bolt stop a couple of times to make certain it is correctly installed and not binding.



45) Assemble the sear and trigger.

46) Install the trigger pin and with a punch, tap in the trigger pin.



47) Install the sear spring.

48) Position trigger assembly on receiver as shown in figure 48. Using quick clamps, hold the trigger assembly in place so your hands can be left free to tap in the sear pin.



49) Insert the sear pin

50) Using a punch lightly tap it back into place.

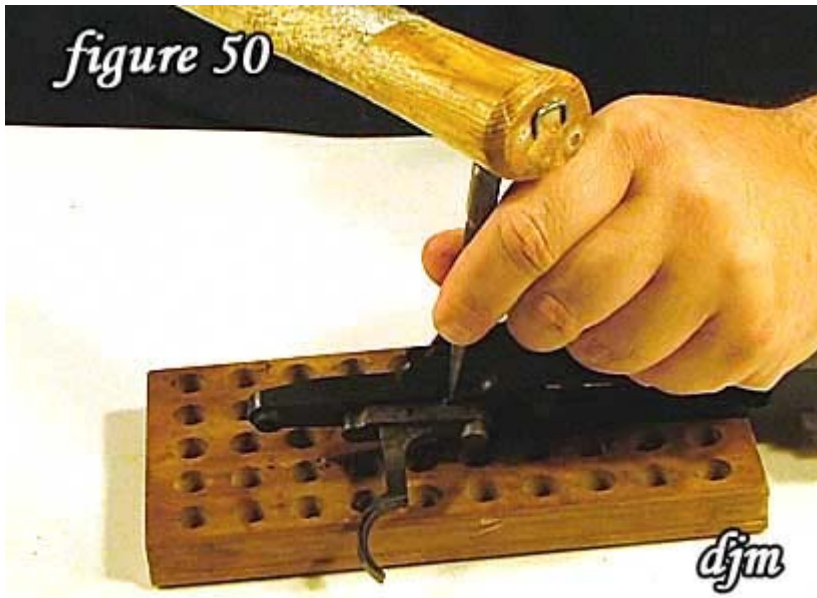


figure 50



figure 51

51) Test the trigger to ensure it is assembled correctly and there is not binding.

52) Insert the barreled receiver into the rifle stock.



53) Replace the handguard.

54) Slide the lower band onto the barrel. Make certain to have the sling loop on the left side of the carbine.



55) Slide the lower band into place.

56) Install the band spring.



57) Using a quick clamp hold the band spring in place so your hands can be free to install the forward band.

58) Slide the forward band onto the barrel.



59) Tap the forward band into place. Using a hickory hammer handle is a great non-marring tool for tapping parts into place.

60) Figure 60 shows the forward band and the band spring engaged and locked.



61) Slide the cleaning rod into the carbine.

62) Hand tighten the cleaning rod.



63) Replace the trigger guard.

64) Install the forward guard screw.



65) Install the rear guard screw.

66) Tighten the forward guard screw partially.



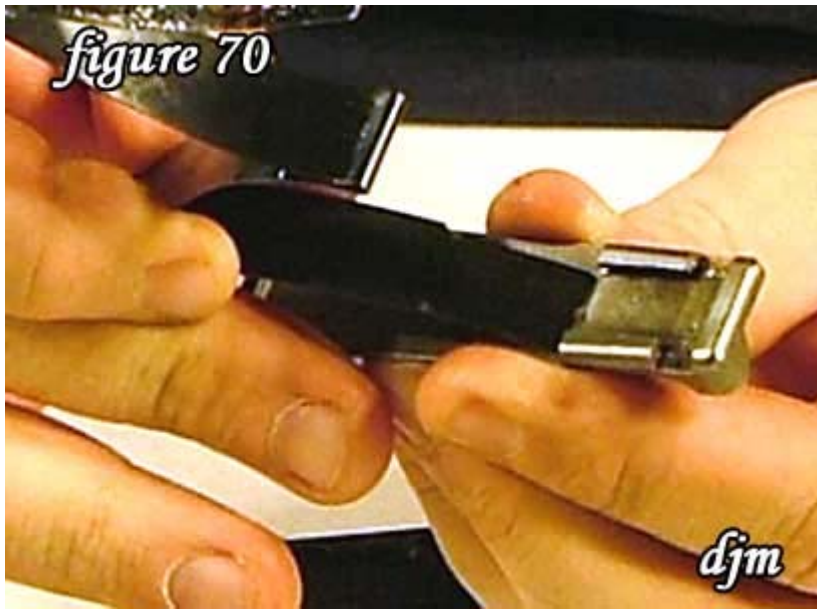
67) Tighten the rear guard screw partially.

68) Tighten the forward guard screw fully. Lock the locking screw.



69) Tighten the rear guard screw fully. Lock the locking screw.

70) Slide the tapered part of the magazine spring into the magazine follower.



71) Slide the other end of the magazine spring into the magazine floor plate.

72) Install the magazine floor plate and follower.



73) Hook the front of the magazine floor plate into the groove in the front of the magazine well and then lock the magazine floor plate into place.

74) Depress the magazine follower and insert the bolt.



75) Close the bolt and you are finished reassembling the 98k carbine.

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