

RIFLE, 7.62MM, FN, C1A1

Modification Instruction

LOCKING MECHANISM

SUMMARY

By Supply

1. This instruction details the modification procedure to be followed when the locking shoulder is noted to be loose, indicated by the bolt moving to the right end of the receiver in the bolt.

NOTE

Inspection teams are NOT to be used to check for loose locking shoulders.

2. This instruction supersedes CF DNE Manual, Weapon C, RIF Rifle 1 Issue 1 dated 10 Dec 64 which will be rescinded.

GENERAL

ITEMS AFFECTED

1. All Rifles, 7.62MM, FN, C1A1.

ATTENTION

1. This instruction will be quoted as the authority.

ACTION REQUIRED

By Rifle

1. Request maintenance services when required.

By Unit and Field Line Level Maintenance Organizations

1. Carry out this instruction.

1. NA.

STORAGE REQUIRED

1. See Fig. 1.

MAN-POWER CLAIMING REQUIRED

1. Estimated man hours per equipment: 10 hours.

DETAIL

10. Proceed as follows:

- a. Before carrying out this modification, carefully examine the locking shoulder hole in the bolt. If the hole is elongated the rifle will be forwarded for replacement of the bolt.
- b. Remove the locking shoulder and grind a bevel on the top front edge approximately 3/16 in. deep at a 15° angle. See Fig. 3.
- c. Replace the locking shoulder and make the rifle fully adjacent to the bevel on the locking shoulder. See Fig. 1 and 4. The point of the state is to be 3/16 in. to 1/8 in. from leading edge of the barrel on the locking shoulder.

NOTE

The point to be a maximum of 3/16 in. from edge of locking shoulder groove.

10. The barrel of the rifle is to be (Fig. 1) and is to be (Fig. 1). A bevel on the leading edge of the bolt, the forward edge being approximately 3/16 in. from the gas block.

11. The locking shoulder is to be (Fig. 1) and is to be (Fig. 1). A bevel on the leading edge of the bolt, the forward edge being approximately 3/16 in. from the gas block.

NOTE (Fig. 1)

10. A locking bevel is to be (Fig. 1) and is to be (Fig. 1). A bevel on the leading edge of the bolt, the forward edge being approximately 3/16 in. from the gas block.

11. The locking bevel is to be (Fig. 1) and is to be (Fig. 1). A bevel on the leading edge of the bolt, the forward edge being approximately 3/16 in. from the gas block.

10. The barrel of the rifle is to be (Fig. 1) and is to be (Fig. 1). A bevel on the leading edge of the bolt, the forward edge being approximately 3/16 in. from the gas block.

11. The locking shoulder is to be (Fig. 1) and is to be (Fig. 1). A bevel on the leading edge of the bolt, the forward edge being approximately 3/16 in. from the gas block.

12. The locking bevel is to be (Fig. 1) and is to be (Fig. 1). A bevel on the leading edge of the bolt, the forward edge being approximately 3/16 in. from the gas block.

13. At the rear of the magazine cavity within the receiver is a locking shoulder which is to be (Fig. 1) and is to be (Fig. 1). A bevel on the leading edge of the bolt, the forward edge being approximately 3/16 in. from the gas block.



Figure 1 - Detail of Rifle Locking Mechanism

- A - Locking shoulder
- B - Safety catch
- C - Receiver
- D - Locking bevel
- E - Magazine

- F - Locking bevel
- G - Receiver
- H - Locking bevel
- I - Magazine

Slr Rifle Manual

JR Anderson



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