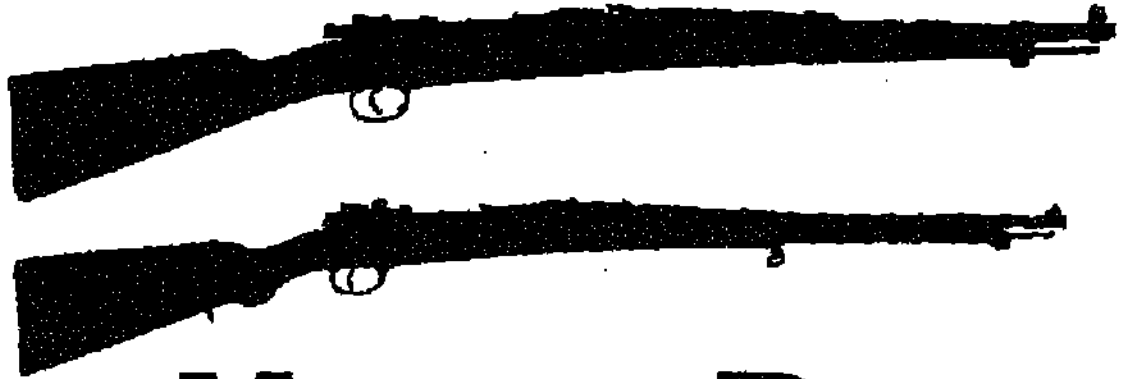




Century  
International  
Arms Inc.

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**Mauser Rifles**

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**IMPORTANT!**

**READ THIS MANUAL FIRST!**

# SAFETY FIRST!

**F**irearms can be dangerous and can cause serious injury or death. Proper and safe firearms handling is the responsibility of anyone who touches or uses a firearm. Safety has to be the primary consideration of anyone using a firearm.

When purchasing a firearm, you assume responsibility for its safe use, storage and transportation. Particularly, it is critical that firearms be kept from unauthorized use, and this includes children. Your responsibility also includes, but is not limited to, the need to protect yourself and others from injury resulting from the misuse or abuse of a firearm.

- At all times, treat firearms as though they are loaded.
- Always be aware of where the muzzle is pointed.
- At all times, carry your firearm in a way that will preclude accidental injury to yourself or others in the event you should stumble, fall, or drop the firearm.
- Before shooting, make certain the barrel has no obstructions.
- Do not allow a firearm or ammunition to be left unattended. Secure both the firearm and ammunition from access by unauthorized people, including children.

- When shooting, always be certain that the area beyond the target, including the backstop, is clear and safe. Also make certain that shots fired present no safety hazards for yourself, or others.
- Always use both ear and eye protection when shooting.
- Always use factory loaded ammunition designed for and intended to be used in the firearm you are shooting. It must be the proper caliber and type for your firearm.
- Always understand the proper operation of your firearm, and never allow the firearm to be used by anyone who does not understand how to use the firearm properly and safely.
- Never pass a firearm to another person unless the action is open and the firearm is in an unloaded and safe condition. Never put your finger into the trigger guard until you are ready to shoot.
- When not using the firearm, ensure that it is unloaded.
- Store your firearm unloaded and in an area which is secure from unauthorized access. Further, store ammunition separately, and in an area secure from unauthorized access.

# HISTORY & TECHNICAL DATA

The Mauser turnbolt rifle is the most famous military design in the world. Most nations of the world have, at one time or another, armed their troops with a Mauser rifle design, or a close variant of one of the Mausers. These rifles are the results of the design genius and manufacturing acumen of German brothers Peter and Paul Mauser.

Although there are a number of differences between the pre-1898 Mauser models and the host of Model 98 variants, operation of these rifles is the same. They feature two massive locking lugs on the front of the bolt, as well as a huge claw extractor which also is an integral part of what is known as "controlled feeding." This means that the cartridge is totally controlled as it is pushed from the magazine into the chamber – so controlled that the rifles work just as well when used upside down as when used normally.

The integral box magazines of Mauser rifles hold five rounds in a staggered order. The magazine can be loaded with single cartridges, or via the use of stripper clips which fit into a slot at the front of the rear receiver ring.

Because Mauser rifles have been used so universally, they occur in a wide variety of chamberings. Most common among cartridges used in the military Mausers are 6.5x55mm, 7x57mm, 7.62x53mm (.308 Winchester), 7.62x63mm (.30/06 Springfield), 7.65x53mm, and 8x57mm.

The three-position wing safety located in the bolt sleeve at the rear of the bolt also locks the bolt shut when in the "safe" mode. When the safety lever is rotated to the left, the rifle is in the "fire" mode. When the safety lever is rotated all the way to the right, it is in the "safe" mode. When the lever is in the middle position, the bolt assembly can be disassembled.

# DISASSEMBLY

To disassemble a Mauser rifle, ensure the rifle is unloaded, pull the bolt to the rear and then pull outward on the bolt release lever which is located on the left rear of the receiver. This allows the bolt to be removed. Figure #1.

To strip the bolt, the procedure is only slightly different for the pre-98 and the 98 designs. In either event, it is necessary to place the safety lever in the middle (perpendicular) position while the unloaded rifle has the bolt closed and striker cocked. Next, remove the bolt from the receiver by opening the bolt, pulling it all the way to the rear and then pulling outward on the bolt release lever on the left rear of the receiver. This allows the bolt to be removed.

Once removed, hold the bolt body in one hand, and with the other hand, unscrew (counter-clockwise) the bolt sleeve. On pre-98 Mausers, it is simply a matter of unscrewing the sleeve. Figure #2. On Model 98s, it is necessary to depress the sleeve stop enough to allow the sleeve to be

Figure 1

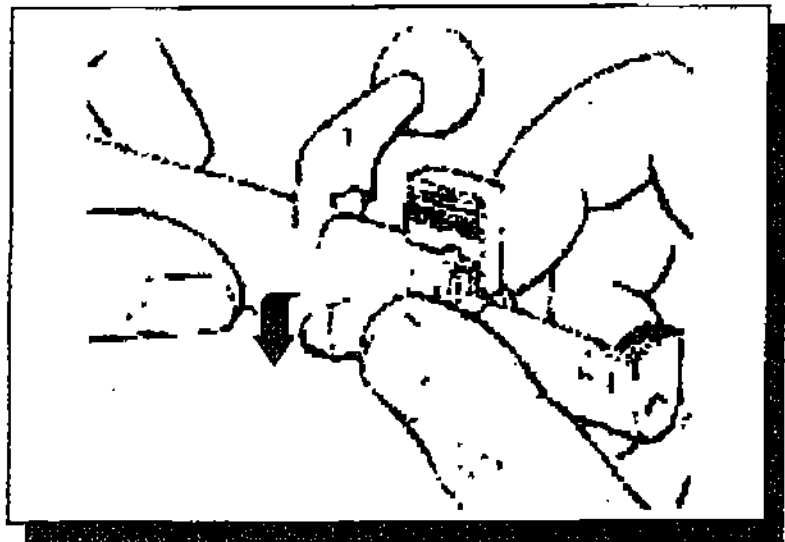
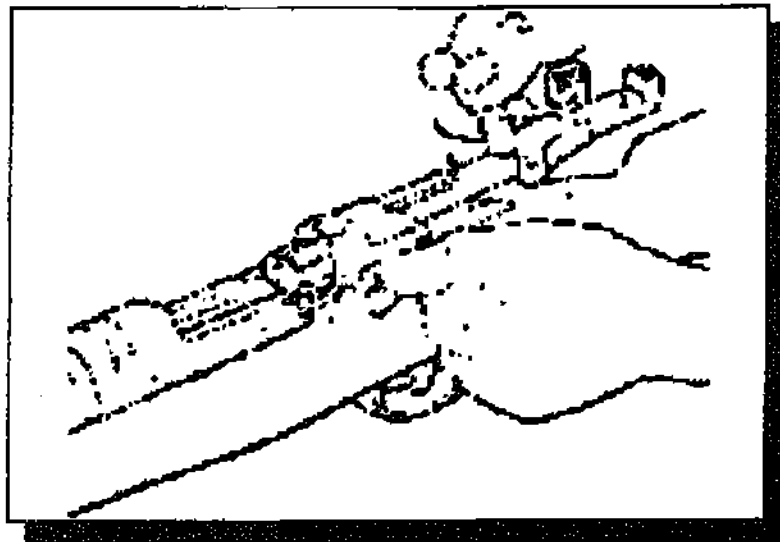
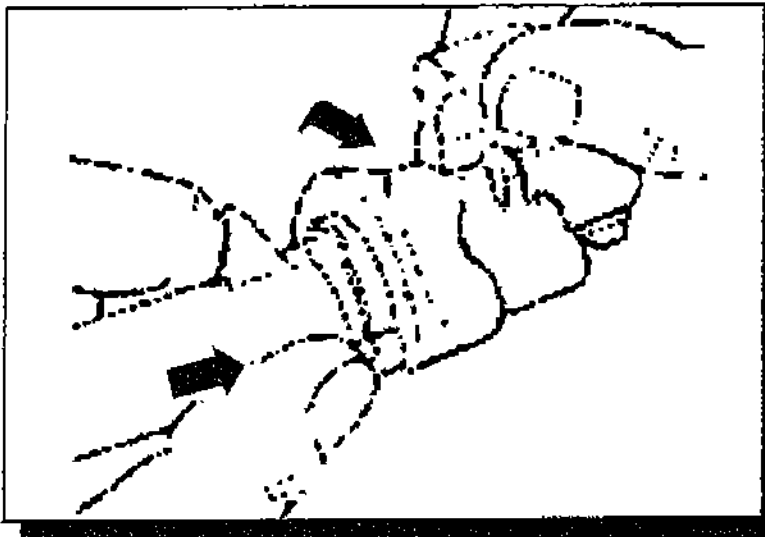


Figure 2

unscrewed. The bolt sleeve stop is a spring-loaded plunger located in the front of the bolt sleeve near the base of the bolt handle. Figure #3. For all Mausers, when the bolt sleeve is unscrewed, the sleeve and striker assembly come out of the bolt body as a single unit.

To disassemble the striker assembly further, place the point of the firing pin onto a soft wood surface and press downward on the bolt sleeve until the cocking piece is clear of the sleeve. Turn the cocking piece a quarter turn counter-clockwise and it can be lifted off. This allows the sleeve to slide off the firing pin, and for the spring to be

Figure 3



removed. Care needs to be taken when disassembling this unit, because you are working against the pressure of the striker spring, and unless the parts are held firmly, the spring can send parts flying. Wear safety eye protection. Reassembly is the reverse procedure, and there are no special tricks needed.

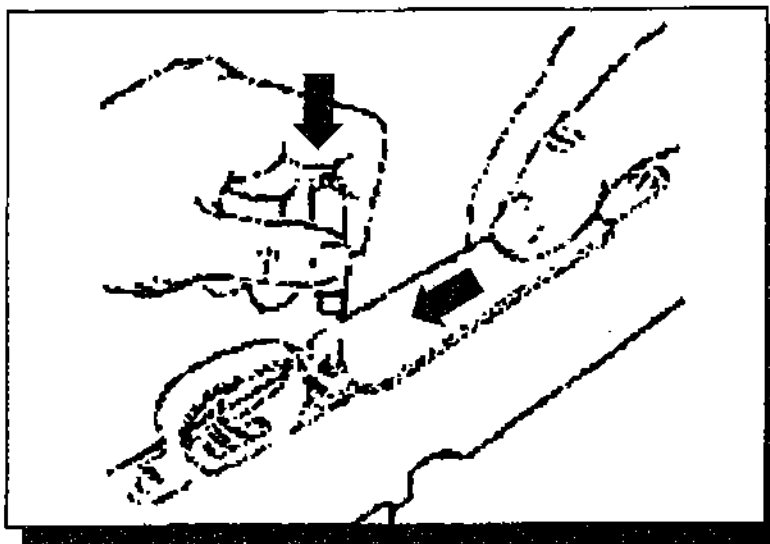


Figure 4

To disassemble the remainder of the rifle, first remove the nose cap and barrel band. Depending upon specific model, this will require some form of depressing a spring-loaded keeper which keeps the cap or band in place. On some rifles, this can be done with the thumb, while

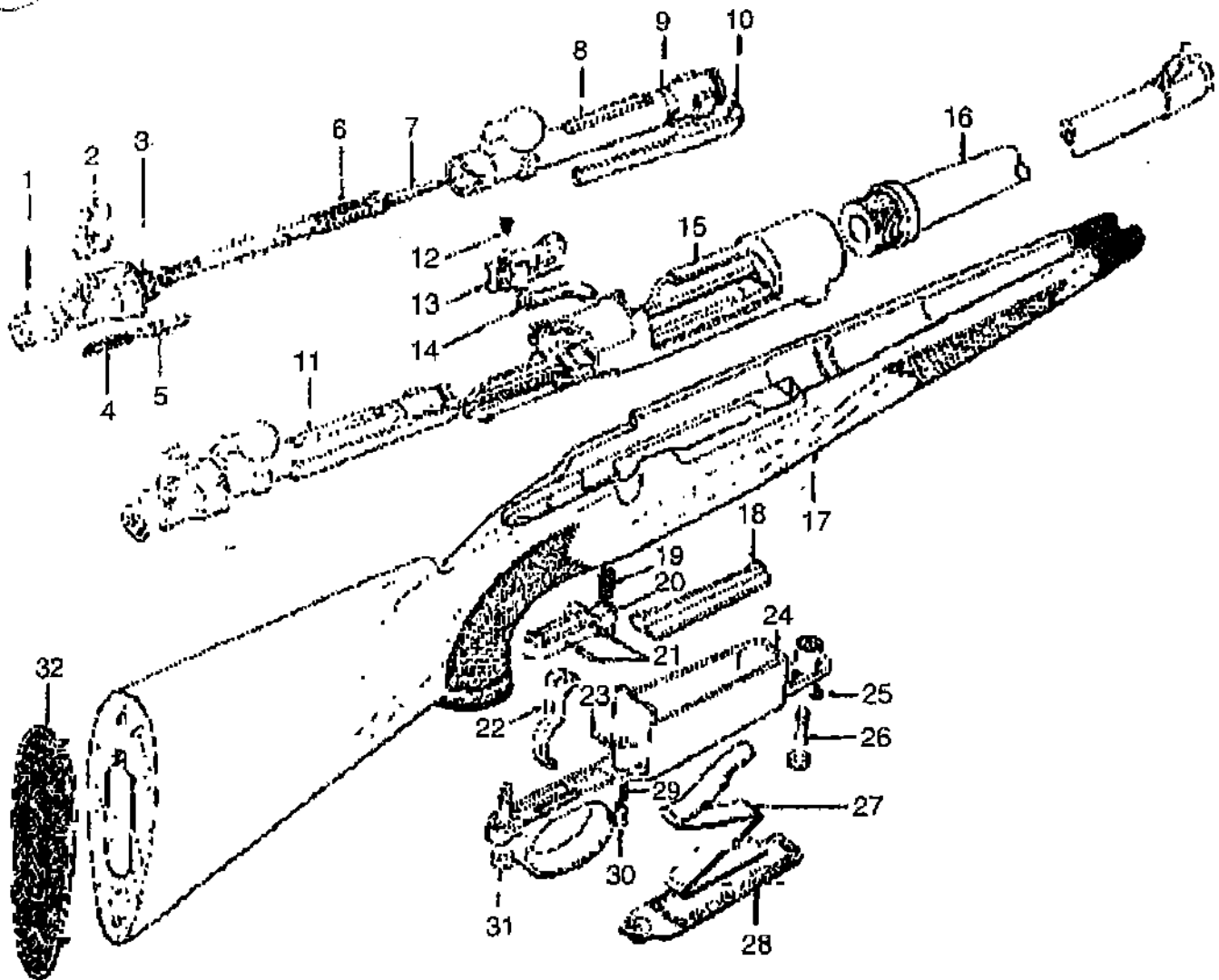
on others some kind of tool, like a screwdriver, is necessary to depress the keeper.

Once the cap and band have been removed, the upper handguard will come off. On some models, it simply lifts off. On others, it may be necessary to raise the rear sight and turn the handguard enough to clear the sight.

To remove the barreled action from the stock, remove the front and rear bolts on the bottom metal. The rear bolt is just aft of the rear of the trigger guard, and the front bolt is just fore of the magazine floorplate. When these two bolts have been removed, the barreled action can be lifted up and out of the stock. Also, the magazine assembly can be removed from the bottom of the stock. This is as far as the rifles normally need to be disassembled for cleaning and maintenance. Reassembly is the reverse procedure, and there are no surprises.

To disassemble the magazine, first remove or lower the magazine floorplate. Figure #4. Different models have varying types of catches, but all involve the pushing down of some form of button or catch to allow the floorplate to come off or rotate open. Sometimes the floorplates are stuck with dried oils and can be challenging to remove. But they do open.

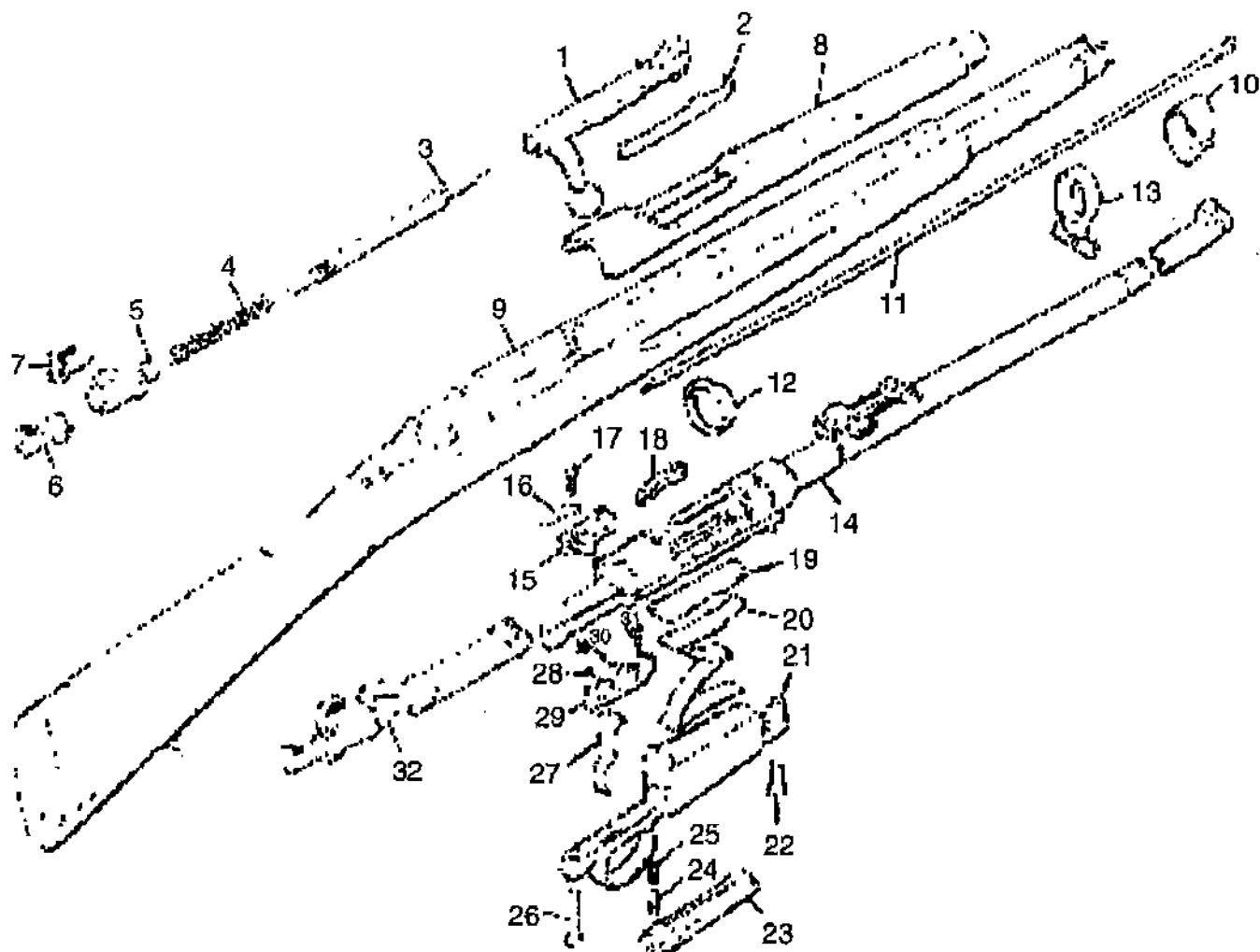
# Mauser 98 — Parts Legend



- |                            |                           |                                |
|----------------------------|---------------------------|--------------------------------|
| 1. Cocking piece           | 12. Bolt stop screw       | 23. Latch retainer pin         |
| 2. Safety catch            | 13. Bolt stop and spring  | 24. Magazine and trigger guard |
| 3. Bolt sleeve             | 14. Ejector               | 25. Lock screw                 |
| 4. Bolt sleeve stop spring | 15. Receiver (stripped)   | 26. Front guard screw          |
| 5. Bolt sleeve stop        | 16. Barrel                | 27. Magazine follower spring   |
| 6. Firing pin spring       | 17. Stock                 | 28. Magazine floorplate        |
| 7. Firing pin              | 18. Magazine follower     | 29. Magazine latch spring      |
| 8. Bolt (stripped)         | 19. Sear spring           | 30. Magazine latch             |
| 9. Extractor collar        | 20. Sear                  | 31. Rear guard screw           |
| 10. Extractor              | 21. Sear and trigger pins | 32. Buttplate                  |
| 11. Bolt (complete)        | 22. Trigger               |                                |



# Swiss Mauser — Parts Legend



- |                               |                                  |                      |
|-------------------------------|----------------------------------|----------------------|
| 1. Bolt with extractor collar | 12. Lower band                   | 23. Floorplate       |
| 2. Extractor                  | 13. Upper band                   | 24. Floorplate catch |
| 3. Firing pin                 | 14. Barrel and receiver          | 25. Catch spring     |
| 4. Firing pin spring          | 15. Bolt stop                    | 26. Rear guard screw |
| 5. Bolt sleeve                | 16. Ejector                      | 27. Trigger          |
| 6. Cocking piece              | 17. Bolt stop screw              | 28. Sear             |
| 7. Safety                     | 18. Bolt stop and ejector spring | 29. Trigger pin      |
| 8. Handguard                  | 19. Follower                     | 30. Sear pin         |
| 9. Stock                      | 20. Magazine spring              | 31. Sear spring      |
| 10. Handguard band            | 21. Trigger guard                | 32. Assembled bolt   |
| 11. Cleaning rod              | 22. Front guard screw            |                      |



# LOADING & UNLOADING

To load Mauser rifles, open the bolt by lifting the bolt handle up, then pull the bolt all the way to the rear until it stops. Ammunition can be loaded one cartridge at a time, or from stripper clips which hold five rounds. The rifle is loaded from the top by pushing cartridges into the magazine when the bolt is open.

After loading the cartridges into the magazine, the rifle is loaded by pushing the bolt forward. Watch to see that the bottom of the bolt head pushes the top cartridge in the magazine forward. As the bolt goes forward, it will push the cartridge in front of it, chambering the round as the bolt is moved all the way forward. When the bolt is fully forward, turn the bolt handle down.

Mauser rifles, depending upon model, may cock when the bolt is opened (Model 98s) or when the bolt is closed (pre-98s). To close the bolts on pre-98s, it takes noticeable force to push the bolt all the way forward, because that is when the striker is cocked. But it never should be difficult to close the bolt. If the bolt does not close smoothly, inspect the ammunition, barrel, chamber and action for any obstructions or debris and do not attempt to fire the rifle until any problems have been eliminated. Also make certain that the proper ammunition is being used.

To fire the rifle, pull rearward on the trigger. Then extract and eject the fired cartridge case. To do this, simply cycle the action.

To unload a Mauser rifle, it is necessary to open the bolt and pull it all the way to the rear, removing any cartridge or case that may have been in the chamber. Next, push on the catch that holds the magazine floorplate in place and open or remove the floorplate. This allows any other cartridges in the magazine to fall out. Or, the magazine can be emptied by cycling the action until there is no ammunition remaining in the rifle. If this procedure is used, use extreme caution and assure that the muzzle is pointed in a safe direction. Also if this procedure is used, first move the safety lever to the middle (perpendicular) position.

# CARE & CLEANING

Because Mauser rifles were designed to be used by militaries around the world in all climates, they require little special care and cleaning. When not in use, it is wise to store these rifles in a cool, dry place. Exposed metal surfaces should be coated with some form of oil or grease to prevent rust.

To clean the Mauser rifle, remove the bolt from the action and assure that the rifle is completely unloaded. First it is necessary to clean the bore. To accomplish this, it is necessary to have a cleaning rod long enough to go through the full length of the barrel and to have cloth patches (these can be made from cotton or cotton-blend cloth and should be large enough to rub against the bore of the rifle as they are pushed by the cleaning rod, but not so large as to cause severe resistance when used).

Chronologically, a patch soaked with powder solvent should be used first. Any of the commercially available solvents will work well if non-corrosive ammunition has been used. If the ammunition used has corrosive priming, it is necessary to neutralize the salts which are by-products of firing. This can be done with solvents designed specifically for corrosive priming, or liberal use of soap (or detergent) and water will work. Ammonia-based window cleaners also work well.

Once the barrel has been swabbed thoroughly with solvent/cleaner (it might take several passes with more than one patch to accomplish this), the bore should be dried with a clean patch (or patches) and then if the rifle is to be stored, the bore should be coated with a thin oil.

Other metal parts in the action and magazine can be cleaned with the same materials and in the same sequence, and the remainder of the exposed metal parts (like barrel, buttplate and sights) can be cleaned and then given an oil coating.

Periodically, it is also good to clean the bore with some form of solvent that removes any copper fouling left when the jacketed bullets are shot. There are copper de-fouling solvents available commercially, or any strong ammonia-based cleaner can be used.

## **LIABILITY**

Mauser rifles are classified as firearms and could cause harm or death if not used in a proper manner. They are sold by us with the specific understanding that we are not legally responsible in any manner for their improper use, negligent handling or improper resale under local laws and/or regulations. Century International Arms, Inc. and its successors and assigns shall not be held liable for the malfunctioning of the firearm or for physical injury or property damage resulting in whole or in part from including, but not limited to, (a) criminal or negligent discharge, (b) improper or careless handling, (c) unauthorized modifications, (d) defective, improper, hand loaded or reloaded ammunition, (e) corrosion, (f) neglect, (g) other influences beyond our immediate or direct control. This limitation applies regardless of whether liability is asserted on the basis of contract, negligence or strict liability (including any failure to warn). Under no circumstances shall Century International Arms, Inc., be liable for incidental or consequential damages, such as loss of use of property, commercial loss or loss of earnings or profits.



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