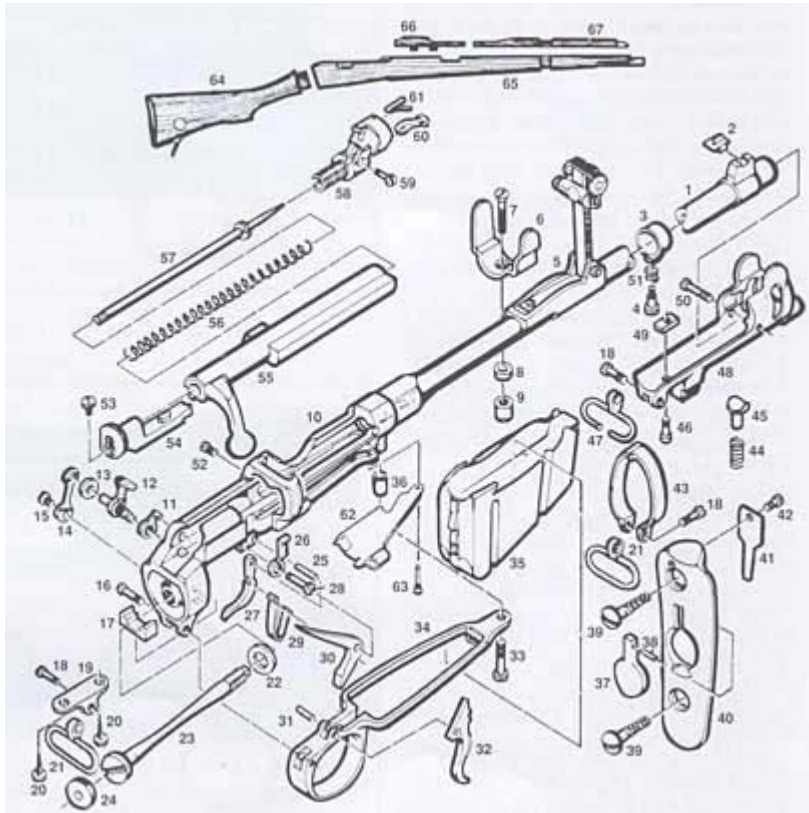


British Enfield #2 MK IV Training Rifle Disassembly and Reassembly Instructions



British Enfield #2 MK IV Training Rifle Parts Legend

1	Barrel	35	Magazine
2	Front sight blade	36	Trigger guard bushing
3	Inner band	37	Buttplate trap
4	Inner band screw	38	Buttplate trap pin
5	Backsight assembly	39	Buttplate screw
6	Backsight protector	40	Buttplate
7	Backsight protector screw	41	Buttplate trap spring
8	Fore-end collar	42	Buttplate trap spring screw
9	Protector nut	43	Outer band
10	Action Body	44	Fore-end stud spring
11	Safety catch	45	Fore-end stud
12	Locking bolt	46	Back nose cap screw
13	Safety catch washer	47	Piling swivel
14	Safety spring	48	Nose cap
15	Safety spring screw	49	Nose cap nut
16	Back trigger guard screw	50	Front nose cap screw
17	Stock bolt plate	51	Inner band screw spring
18	Swivel screw	52	Ejector screw
19	Butt swivel bracket	53	Striker screw
20	Swivel bracket screw	54	Cocking piece

21	Sling swivel	55	Breechbolt
22	Stock bolt washer	56	Mainspring
23	Stock bolt	57	Striker
24	Stock bolt wad	58	Breechbolt head
25	Magazine catch spring	59	Extractor screw
26	Retaining spring	60	Extractor
27	Magazine catch	61	Extractor spring
28	Retaining spring screw	62	Cutoff
29	Sear spring	63	Cutoff spring
30	Sear	64	Buttstock
31	Trigger pin	65	fore-end stock
32	Trigger	66	Rear handguard
33	Front trigger guard screw	67	Front handguard
34	Trigger guard		

***Numbers correspond with parts diagram above, not steps blow.**

Click on any of the small "Figure" images below to see a larger version of the image.

Disassembly Instructions



1) Point rifle in safe direction and remove the **magazine** from the rifle.



2) Open the bolt and pull to the rear of the **action body** (receiver).

Note: *Examine rifle to make sure it is unloaded.*



3) Rotate the **breechbolt head** counter clockwise until it locks.



4) Pull the **bolt assembly** out of rifle.

5) Remove the **front nose cap screw** from the **nose cap**.



6) Remove the **back nose cap screw** from the **nose cap**.



7) Remove the **nose cap**.



8) Remove the **Swivel screw**.



9) Remove the **sling swivel**.



10) The **outer band** is hinged and opens up to be removed as shown in **figure 10**.



11) Remove the **front handguard**.

12) Remove the **back trigger guard screw**.



13) Remove the front trigger guard screw.



14) Remove the trigger guard.



15) Remove the safety spring screw.



16) Remove the safety spring screw.



17) Remove the safety catch and locking bolt from the action body (receiver).

Note: *I recommend you leave the safety catch and locking bolt assembled.*



18) Remove both swivel screws from the swivel bracket.



19) Lift backsight blade (leaf) and lift out rear handguard (as shown in figure 19).



19a) Remove the **inner band screw**.



20) Pivot **action body** (receiver) and barrel out of the **fore-end stock** (front stock).



21) The **fore-end stock** will slide out of the **butt socket**.



22) Remove the two screws in the **buttplate**.



23) Remove the **buttplate**.



24) Using a thin coat hanger, make a straight piece with a small hook at one end (as shown in **figure 24**).

25) Inside the **buttplate trap** of the **buttstock** there is a small leather or felt called the **stock bolt wad** (as shown in **figure 25**)



26) Using the wire tool you manufactured, pull the **stock bolt wad** out of the **butt stock trap**, so you can remove the **stock bolt**.



27) Insert a large flat blade screw driver into the **butt stock trap**.



28) Using a pair of pliers, turn large flat blade screw driver counter clockwise while inserted into the **stock bolt**.



29) Remove **butt stock** from **butt socket** (as shown in **figure 29**).



30) Loosen the **retaining spring screw** and remove the **retaining spring**.



31) The **sear spring** and **sear** will fall out of the **action body**.

32) Drive out the **magazine catch pin** and then remove the **magazine catch**.



33) Figure 33 shows the **magazine catch pin** partially removed.

Reassembly Instructions



34) Using a punch as a guide, insert **magazine catch** and then push punch out as you drive in **magazine catch pin** from opposite side (as shown in **figure 34**).



35) Reinsert the **sear** and **retaining spring screw** (as shown in **figure 35**).



36) Insert **sear spring** while only connecting the longer side of the **sear spring** into the slot on the **sear**.

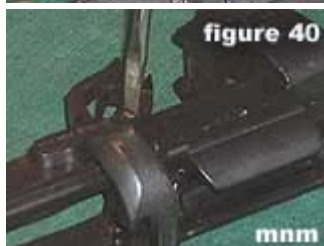


37) Insert a flat blade screwdriver between the **sear** and the **sear spring** and push until the short side of the **sear spring** connects into the slot on the rear of the **magazine catch** (as shown in **figure 37**).



38) **Figure 38** shows the punch pointing to the slot that the short end side of the **sear spring** needs to rest in.

39) Depress the **magazine catch** several times to make sure that the **sear spring** is inserted correctly.



40) Tighten the **retaining spring screw**.



41) Insert **butt stock** into the **butt socket** (as shown in **figure 41**).



42) Insert a large flat blade screw driver into the **butt stock trap**. Using a pair of pliers, turn large flat blade screw driver clockwise until **stock bolt** is tight.



43) Reinsert the **stock bolt wad** into the **butt stock trap** of the **butt stock**. Push the **stock bolt wad** all of the way down until it rest flat on the **stock bolt**.



44) Pivot the **fore-end stock** into the **butt socket** (as shown in **figure 44**).



45) Reposition the **inner band** so it is over the **inner band screw hole** in the **fore-end stock**.

46) Install the **inner band screw** and tighten.



47) Lift **backsight blade** (leaf) and reinstall the **rear handguard** (as shown in **figure 47**).



48) The **rear handguard** is held in place by metal springs on its underside. These springs slide easily around the **barrel** to hold the **rear handguard** in place.



49) **Figure 49** shows the already assembled **safety catch washer**, **safety catch**, and **locking bolt**.



50) **Figure 50** shows the **safety catch washer** (right) and the **safety spring** (left). Note at the top of each part; the **safety catch washer** has a channel that the corresponding guide on the **safety spring** fits into to.



51) **Figure 51** shows the rifle without the safety assembly installed.



52) **Figure 52** shows the rear view of the proper line up of the **safety catch** and **locking bolt** assembled before reinserting into the rifle.

53) Insert the assembled **safety catch** and **locking bolt**. Place the **safety catch washer** over the extended post of **locking bolt**. Make sure the side with the



channel faces out. Install the **safety spring** over the **safety catch washer**, making sure the guide fits into the channel. Reinstall the screw and hand tighten so the screw is snug, but the safety still functions easily.



54) **Figure 54** shows a punch pointing to the **sear**. The top of the **trigger** should be guided below the **sear** when installing the trigger/trigger guard assembly.



55) Install **trigger** and **trigger guard** while pivoting from behind.



56) Then push **trigger guard** down in front (as shown in **figure 56**).



57) Reinstall the **back trigger guard screw**.

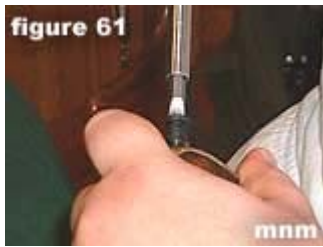


58) Tighten the **back trigger guard screw**.



59) Reinstall and tighten the **front trigger guard screw**.

60) Install the **buttplate**.



61) Insert and tighten both buttplate screws.



62) Reinstall front handguard. Make sure you install front under nose cap and then pivot backwards.



63) The outer band is hinged and opens up to be reinstalled (as shown in figure 63).



64) Reinstall the sling swivel.



65) Reinstall the Swivel screw.



66) Tighten the Swivel screw.

67) Slide the nose cap on (as shown in figure 67).



68) Reinstall and tighten the **back nose cap screw** in the nose cap.



69) Reinstall and tighten the **front nose cap screw** in the nose cap.



70) Reinstall and tighten both **swivel screws** in the **swivel bracket**.



71) Reinstall and tighten both **swivel screws** in the **swivel bracket**.



72) Reinsert the **bolt** into the **action body**.



73) Reinsert the **magazine**.

74) While rifle is unloaded, pointed in a safe direction, and the **bolt** is cocked, apply safety by pulling lever all of the way to the rear. Test trigger to make



sure safety is engaged.



75) While rifle is unloaded, pointed in a safe direction, and the **bolt** is cocked, apply safety by pulling lever all of the way to the rear. Try opening bolt to make sure safety is engaged.



76) Figure 76 shows the reassembled rifle.

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