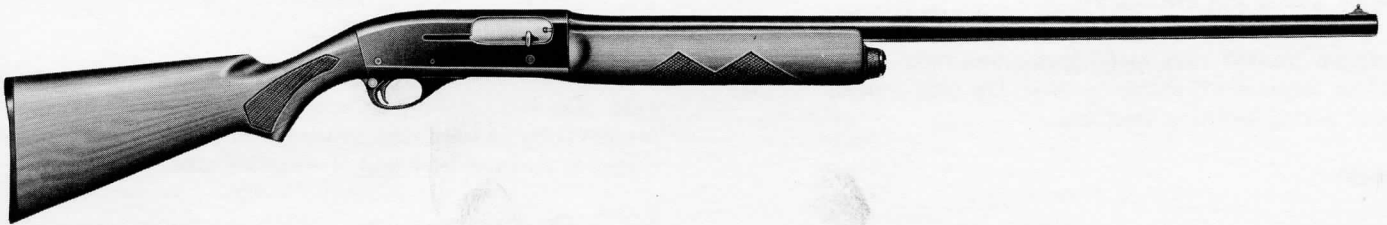


# REMINGTON FIELD SERVICE MANUAL

The Remington Model 11-48 is a recoil operated shotgun with a tubular magazine. This model is chambered for 2 3/4" length shells in light or heavy loads and is available in 12, 16, 20, 28 and 410 gauge.

NOTE: All instructions included in this supplement for the 12 and 20 gauge also apply to the model Mohawk 48.



**CAUTION:** make certain there are no shells in either chamber of barrel or magazine of gun before handling or shipping.

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Send all guns for factory service and inquiries on service and parts to  
**REMINGTON ARMS COMPANY, INC.**  
 Arms Service Division  
 Ilion, New York 13357

## MODEL 11-48 & SPTS. 48

### DISASSEMBLY

#### Take Down:

**Open Bolt**, push barrel slightly rearward into receiver to relieve pressure at fore-end, hold back and unscrew magazine cap. Release barrel and remove fore-end and barrel including friction piece from magazine tube. If desired to pack the arm in a gun case, replace fore-end over magazine tube, press it down to hold recoil spring, then screw on the magazine cap.

#### Recoil Spring and Friction Ring:

Remove friction ring, recoil spring and recoil spring cap by sliding forward off magazine tube. On later models, remove recoil spring and ring assembly.

#### Stock:

Unscrew two butt plate screws, remove butt plate, unscrew action spring tube nut. Pull stock off rearward including nut and washers.

#### Breech Block and Slide:

Pull out operating handle and push breech block and slide forward out of receiver.

#### Breech Block and Slide Components:

Push out link pin from slide and remove right and left link from slide. Push out firing pin retaining pin from breech block and remove firing pin and firing pin retaining spring from breech block. Dismount slide from breech block. Drive out locking block pin from slide and remove locking block. Depress extractor plunger, lift out extractor and remove extractor plunger and extractor spring from breech block.

#### Trigger Plate:

Cock hammer, push out front and rear trigger plate pins and lift trigger plate out of receiver.

#### Trigger Plate Components:

Remove carrier pivot tube with trigger plate pin detent spring, front; remove carrier unit, carrier dog follower and carrier dog follower spring. Drive out hammer pin and remove disconnector. Uncock hammer. Remove hammer, hammer plunger and hammer spring. Remove trigger plate pin bushing with trigger plate pin detent spring, rear. Remove sear spring, drive out sear pin and remove sear. Remove safety switch spring retaining pin, safety switch spring, safety switch plunger and safety switch.

#### Shell Latch:

Remove shell latch from receiver

#### Friction Piece:

Compress slightly and remove from barrel lug.

#### Carrier Latch:

Screw carrier latch pin puller into carrier latch pin and remove carrier latch pin from receiver. Remove carrier latch unit and carrier latch button from receiver.

#### Action Spring:

Push action spring plug into tube and drive out action spring plug pin; carefully release action spring and remove action spring with action spring plug and action spring follower attached from action spring tube.

#### Magazine Spring and Follower:

Pry out magazine spring retainer from front end of magazine tube. (Do this carefully so as to control magazine spring and prevent it flying from tube.) Remove magazine spring and slide magazine follower from end of magazine tube.

**NOTE:** Do not remove magazine follower on Sportsman-'48.

### ASSEMBLY

#### Action Spring:

Place action spring plug into one end of spring and action spring follower into other end. Place action spring into action spring tube at rear end of receiver with action spring follower forward. Compress action spring into tube, align pin hole in action spring plug with hole in end of action spring tube. Drive in action spring plug pin flush with sides of tube.

#### Stock:

Slide stock over action spring tube. Place action spring tube nut washer (with spurs forward), action spring tube nut lock washer and action spring tube nut over end of action spring tube in stock. Screw action spring tube nut on to action spring tube until tight. Place butt plate on rear end of stock and fasten with two butt plate screws.

#### Magazine Spring and Follower:

Drop magazine follower into magazine tube, closed end down. Place magazine spring into tube. Place magazine spring retainer over free end of magazine spring. Feed spring carefully into tube until magazine spring retainer is against front end of tube. Tap retainer into tube flush with front end.

#### Carrier Latch:

Place carrier latch button into hole in right side of receiver with flange on inside of receiver. Place carrier latch over carrier latch button and into slot in right side of receiver. Press in. Align pin holes and insert carrier latch pin with round end forward into receiver, being sure it is below bolt guide track.

#### Breech Block Components:

Place extractor spring into hole in rear of extractor slot in right side of breech block. Insert small end of extractor plunger into extractor spring. Place rear end of extractor into extractor slot against extractor plunger. Push extractor rearward and in until down in breech block. Assemble right and

left links into slots at rear end of slide (with front end hump downward and rear ends together). Insert link pin in slide. Place locking block over slide and insert locking block pin. Assemble breech bolt onto slide, insert firing pin and firing pin retractor spring through hole in rear end of breech bolt and through slot in locking block, and push firing pin through hole in front of breech bolt. Align firing pin retaining pin clearance with hole and insert firing pin retaining pin.

#### **Breech Block:**

Place breech block into receiver at front end through barrel extension opening (link end in first). Slide rearward, aligning links with action spring follower. Insert operating handle into breech block.

#### **Trigger Plate Components:**

Assemble sear with sear pin and sear spring, hammer with hammer pin and stake right end of hammer pin. Assemble hammer spring and hammer plunger. Cock hammer. Assemble disconnecter. Assemble carrier dog follower spring and carrier dog follower. Assemble carrier unit with carrier pivot tube and spring. Assemble trigger plate bushing, rear. Assemble safety switch, safety switch plunger and safety switch spring with safety switch spring retaining pin.

**NOTE:** Assemble new style disconnecter with new style hammer pin.

#### **Shell Latch:**

Insert shell latch in recess in left side of receiver and insert trigger plate pin, front until end is even with inside surface of latch.

#### **Trigger Plate:**

While pressing rear end of shell latch into receiver slot insert trigger plate unit in receiver and push in trigger plate pin front and insert trigger plate pin rear.

#### **Recoil Spring and Components:**

Place recoil spring with capped end up on magazine tube. Assemble friction ring to tube in position for type of load to be used. Always place Recoil Spring on magazine tube with tight end next to receiver. On newer models, assemble recoil spring and ring assembly.

#### **Barrel:**

Pressing carrier latch button, open action until bolt catches in rear position. Assemble friction piece in rear end of barrel guide ring. Insert breech end of barrel into receiver and barrel guide ring over magazine tube.

#### **Fore-end:**

Push barrel rearward into receiver about one inch or more, slide fore-end over magazine tube and over fore-end support. Holding barrel back into receiver enough to take tension off fore-end, screw magazine cap on front end of magazine tube.

## **FITTING NEW PARTS AND ADJUSTING**

#### **Action Spring:**

Remove two butt plate screws, butt plate, action spring tube nut, action spring tube nut lock-washer, action spring tube nut washer, and Stock. Drive out action spring plug pin. Withdraw action spring plug, action spring, and action spring follower from action spring tube.

#### **Barrel Assembly:**

It is not advisable to attempt removal of barrel extension from the barrel. Complete barrel assemblies, including barrel, barrel extension, sight and barrel guide may be obtained from the factory. When supplied these barrel assemblies will be headed to a normal locking block. It is expected that they will be interchangeable with assemblies already on gun. However, in some cases it may be necessary to use a different locking block to obtain the correct headspace. (See **Locking Block**). Care should be taken to provide the minimum headspace which will allow the action to lock with a minimum size shell in the chamber.

#### **Breech Block:**

Remove magazine cap, fore-end, barrel, and operating handle. Slide breech block unit forward out of receiver. Drive out fire pin retaining pin, remove firing pin, firing pin retractor spring. Pry out extractor and remove extractor plunger and extractor spring. Dismount breech block from slide and replace with new one, then reassemble parts in reverse order. After reassembling new breech block, check headspace to insure closing action with shell in chamber. There should be a slight tension of extractor on the shell at point of ejection (when the action is opened about 3").

#### **Butt Plate:**

Remove old butt plate and lay on new butt plate. Put in butt plate screws and tighten snugly. (Do not strip threads in stock by screwing too tightly.) File margin to match outline of stock.

#### **Carrier:**

Remove trigger plate pin, front; trigger plate pin, rear; and trigger plate unit from receiver. Cock hammer and put on safe. Remove carrier pivot tube and carrier unit from trigger plate. Drive out carrier dog pin and remove carrier dog. After reassembling carrier dog and carrier dog pin to new carrier, stake right end of carrier dog pin. When trigger plate unit is reassembled to receiver and the action operated by hand, the carrier should raise a shell until it is snug against the inside upper surface of the extension but not so tight as to prevent the shell feeding into chamber. (See **Carrier Dog**.) Also check lower position of carrier to see that it does not prevent shells entering receiver from magazine. It may be necessary to adjust the front end downward very slightly.



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### Carrier Dog:

Remove trigger plate pin, front; trigger plate pin, rear, and trigger plate unit from receiver. Cock hammer and push safety switch ON SAFE. Remove carrier pivot tube and carrier unit from trigger plate. Drive out carrier dog pin and remove carrier dog. Select proper carrier dog. (These are supplied in the following sizes: A,B,C,D,E; E being the one which raises the carrier to the highest position.) Reassemble new carrier dog and carrier dog pin. Stake right end of carrier dog pin. When trigger plate unit is reassembled to receiver and the action operated by hand the carrier should raise the shell until it is snug against the inside top surface of the extension but not so tight as to prevent the shell feeding into the chamber.

### Carrier Dog Follower:

Remove trigger plate pin, front; trigger plate pin, rear; and trigger plate unit from receiver. Cock hammer and push safety switch to ON SAFE. Remove carrier pivot tube, carrier unit and carrier dog follower from trigger plate, replace with new follower and reassemble parts in reverse order.

### Carrier Dog Follower Spring:

Remove trigger plate pin, front; trigger plate pin, rear; and trigger plate unit from receiver. Cock hammer and push safety switch ON SAFE. Remove carrier pivot tube, carrier unit, and carrier dog follower from trigger plate. Remove carrier dog follower spring. Replace with new one and reassemble parts.

### Carrier Latch:

Remove operating handle and breech bolt. Remove trigger plate pin, front; trigger plate pin, rear; and trigger plate unit from receiver. Screw special tool (Part No. 18916) into end of carrier latch pin and withdraw it from receiver. Remove carrier latch from receiver. Select a new carrier latch having the same identification letter as one removed. After new latch is assembled, front end should be flush or under wall of receiver, to permit free passage of shell from magazine into receiver. Reassemble trigger plate unit. With action closed, rear of carrier latch must clear carrier by from .005" to .025". Select proper size latch to provide this clearance. With action closed, move carrier upward to see that front end of carrier latch overlaps shell by 1/16" to 3/32". Bend carrier latch at front end, if needed, to attain this engagement.

### Carrier Latch Button:

Remove operating handle and breech block. Remove trigger plate pin, front; trigger plate pin, rear; and trigger plate unit from receiver. Screw special tool into end of carrier latch pin and withdraw it from the receiver. Remove carrier latch and carrier latch button from receiver. After new button is assembled, the front end of the carrier latch should be flush or under wall of receiver to permit free passage of shell from magazine into receiver. File button, if needed.

### Carrier Latch Pin:

Remove operating handle and breech block. Remove trigger plate pin, front; trigger plate pin, rear; and trigger plate unit from receiver. Screw special tool (Part No. 18916) into end of

carrier latch pin and withdraw it from receiver. When reassembled, be sure upper end is the threaded one and is driven below shell track.

### Disconnecter:

Remove trigger plate pin, front; trigger plate pin, rear; and trigger plate unit from receiver. Cock hammer. Push safety switch ON SAFE. Push out carrier pivot tube. Remove carrier and disconnecter. If gun will not fire with new disconnecter, it may be necessary to grind off .005" to .010" from the camming surfaces at the points "A" and "B". (See Fig. 1)

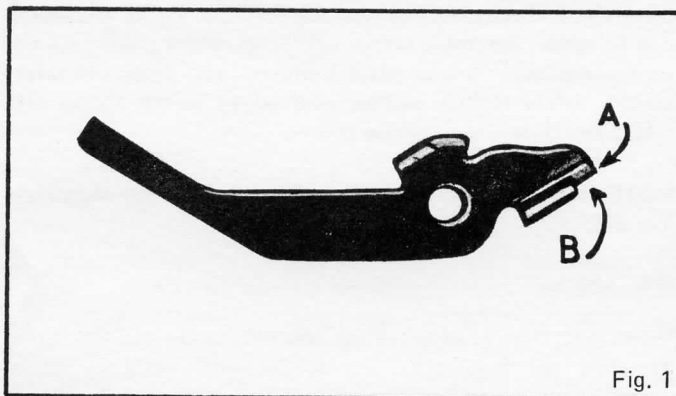


Fig. 1

**NOTE:** Be sure rear end of disconnecter is beneath connector.

### Ejector:

Remove magazine cap, fore-end and barrel from action. Heat extension around ejector to melt braze material and remove ejector. Clean out ejector slot, place new ejector flush with rear end of barrel extension and braze.

**NOTE:** Care should be taken while heating to braze so as to heat only the extreme rear end of barrel extension.

### Extractor:

Remove barrel and trigger plate unit. Pull out operating handle and remove breech bolt unit from receiver. Depress extractor plunger, lift out extractor from breech bolt. After reassembling new extractor, check to see that there is a slight tension on the head of the shell when the action is open about 3 inches. Also, check feeding up into chamber. If feed up is too hard, round lower corner on extractor claw. Check freedom of movement of extractor.

### Extractor Plunger:

Remove barrel and trigger plate unit from receiver. Pull out operating handle, and push breech bolt and slide forward out of receiver. Depress extractor plunger, lift out extractor and remove plunger, and replace.



**Extractor Spring:**

Remove barrel and trigger plate unit from receiver. Pull out operating handle and push breech bolt and slide forward out of receiver. Depress extractor plunger, lift out extractor, remove extractor plunger and extractor spring, and replace.

**Firing Pin:**

Remove barrel and trigger plate unit from receiver. Pull out operating handle and push breech bolt and slide forward out of receiver. Remove firing pin retaining pin, firing pin, and firing pin retractor spring from breech bolt. After replacing firing pin, check freedom and protrusion. With slide forward and pin pushed forward against slide, front end of pin should protrude from .037" to .052".

**Firing Pin Retractor Spring:**

Remove barrel and trigger plate unit from receiver. Pull out operating handle and remove breech bolt unit through front of receiver. Remove firing pin retaining pin, firing pin, and firing pin retractor spring from breech bolt. Replace parts in reverse order.

**Fore-end:**

Remove magazine cap and fore-end from receiver. This part has been fitted to a standard gun at the factory and usually fits any other gun without alteration, except in some cases the barrel may rub upon the wood. Material may be removed a little at a time from the barrel seat until the wood entirely clears the barrel.

**Hammer:**

Remove trigger plate unit from receiver. Release hammer. Lift up carrier and drive out hammer pin. After replacing new hammer, check pull and fit of safety.

**Hammer Spring Follower:**

Remove trigger plate unit from receiver. Remove carrier pivot tube, carrier and disconnecter from trigger plate. Drive out hammer pin and remove hammer and hammer spring follower. Replace with new part and reassemble.

**Hammer Spring:**

Remove trigger plate unit from receiver. Remove carrier pivot tube, carrier, disconnecter from trigger plate. Drive out hammer pin and remove hammer, hammer spring follower and hammer spring. Replace with new part and reassemble.

**Locking Block:**

Remove barrel and trigger plate unit from receiver. Remove operating handle and push breech bolt and slide forward out of receiver. Remove firing pin retaining pin, firing pin and firing pin retractor spring from breech bolt and breech bolt from slide. Remove right and left link from slide. Drive out locking block pin and remove locking block from slide. Replace with a new locking block bearing the same identification letter as

the old one. Letters are AA, A and B with the AA size being the longest or providing the tightest or minimum headspace. Use the size block that will provide a minimum headspace and still allow the action to lock up on a maximum size shell.

**Magazine Follower:**

On the Model 11-'48, pry out magazine spring retainer, remove magazine spring and magazine follower. On the Sportsman-'48, it is necessary to remove the magazine spring retainer and magazine spring, then insert a mandrel and hammer out the indentations in the magazine tube to remove the magazine follower. In order to limit the Sportsman to 3-shot capacity the indentations must be restruck after assembly of new follower.

**Magazine Spring:**

Pry out magazine spring retainer and remove magazine spring.

**Magazine Spring Retainer:**

Pry out magazine spring retainer.

**Recoil Spring:**

Remove friction ring and recoil spring with recoil spring cap. Replace with new spring with tighter end of spring toward receiver. Replace cap over forward end of spring.

**Safety Switch:**

Remove trigger plate unit from receiver. Drive out safety switch retaining pin. Remove safety switch spring, safety switch plunger and safety switch from trigger plate. On **right-hand safety switch** assemble safety switch with red band on left side of trigger plate. Try safety switch to determine freedom and function.

**Safety Switch, Left Hand:**

For left - hand safety switch see attached instruction sheet.

**Safety Switch Spring:**

Remove trigger plate unit from receiver. Drive out safety switch spring retaining pin and remove safety switch spring. Replace with new spring.

**Safety Switch Plunger:**

Remove trigger plate unit from receiver. Drive out safety switch retaining pin and remove safety switch spring and safety switch plunger. Replace with new plunger.

**Sear:**

Remove trigger plate unit from receiver. Set hammer forward, push out carrier pivot tube, remove carrier unit, carrier dog follower, carrier dog follower spring, disconnecter and sear spring. Drive out sear pin and remove sear. After reassembling new sear, check safety and weight of pull. Recommended minimum trigger pull is 3-1/2 lbs.

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### Sear Spring

Remove trigger plate unit from receiver. Let hammer forward and remove sear spring. Replace spring.

### Shell Latch:

Remove trigger plate unit and shell latch from receiver. Replace with new latch and reassemble trigger plate unit. With barrel pushed rearward, shell latch should engage head of shell by 1/32" to 1/16". With barrel forward shell latch should clear rim of shell.

### Slide:

Remove trigger plate unit from receiver. Remove operating handle and push breech bolt and slide forward out of receiver. Remove firing pin retaining pin, firing pin, firing pin retractor spring from breech bolt, and breech bolt from slide. Remove link pin and right and left link from slide. Drive out locking block pin and remove locking block from slide. Replace with new slide and reassemble.

### Stock:

Unscrew two butt plate screws, remove butt plate. Unscrew action spring tube nut and pull stock off rearward, including nut and two washers. Reassemble new stock. There should always be a little clearance between the stock and receiver at edges of joint; otherwise, stock may split.

**TRIGGER ASSEMBLY** is factory listed as part of the Trigger Plate Assembly. It is composed of the trigger, connector, right; connector, left; and connector pin.

**NOTE: FACTORY SERVICE IS REQUIRED FOR ALL TRIGGER ASSEMBLY RELATED PROBLEMS. RETURN THE TRIGGER PLATE ASSEMBLY OR THE FIREARM TO THE FACTORY FOR SERVICE.**

### Trigger Plate Unit:

Remove trigger plate pin, front; trigger plate pin, rear; and trigger plate unit from receiver. Assemble new unit and inspect for general functioning of all components. The trigger plate unit includes carrier.

**NOTE:** Action spring tube and magazine tube are brazed to the receiver and it is recommended that they be replaced at the factory.

### FITTING NEW PARTS AND ADJUSTING (Revision)

Replacement parts to correspond and interchange with the original components will be supplied as long as supply is available. Listed herein are the revised parts and the procedure necessary to convert old style parts.

**NOTE:** See interchangeability chart supplied with this section.

### Breech Bolt:

No change is necessary in disassembly or assembly except Remove trigger plate assembly for better reassembly of free ends of links to action spring follower. For conversion of old style 4 feet or 2 feet breech bolt, see interchangeability chart.

**NOTE:** A new style firing pin retaining pin (longer) is used with the 2 feet bolt and current model.

### Carrier:

No change necessary in disassembly or assembly except: Remove one of two trigger plate detent springs, front before removing carrier pivot tube. For conversion to new style carrier, reassemble a new style carrier pivot tube, carrier dog washer, carrier dog and carrier dog follower spring.

**NOTE:** The additional trigger plate pin detent spring front, cannot be used on old style carrier. If new carrier is used with old slide, remove part of shell guide on carrier to permit shell to load into magazine.

### Carrier Dog:

A common carrier dog has been designed that will interchange with all letter size carrier dogs.

**NOTE:** Fit new style carrier dog follower spring with new style carrier dog.

### Carrier Dog Follower Spring:

This new spring is longer, which prevents catch in carrier dog when carrier is operated. No change is necessary in reassembling components.

### Carrier Latch:

No change is necessary in disassembly or reassembly. To convert old style latches, change old style slide and breech bolt (see interchangeability chart).

**NOTE:** No adjustment is necessary on rear of new style latch for carrier clearance if new style carrier assembly is fitted.

### Disconnecter:

No change in disassembly or reassembly, except: Drive out hammer pin to remove disconnecter (left to right). For Conversion, remove stud on trigger plate used for reassembling old style disconnecter and reassemble new style disconnecter with new style hammer pin. (See Fig. 2)

Restake right end of Hammer pin flush with right side of trigger plate. (This will insure free passage of carrier.)

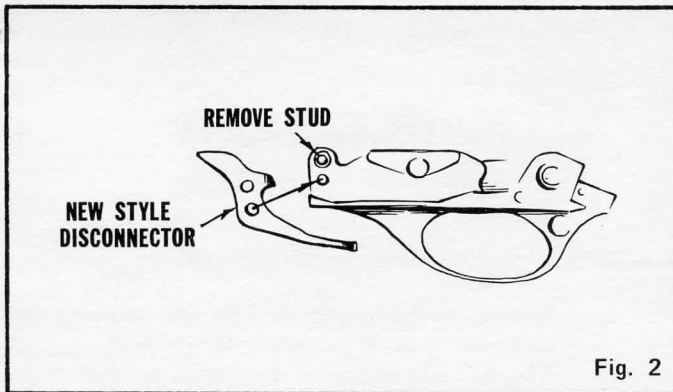


Fig. 2

**NOTE:** Not necessary to grind new style disconnecter for proper function as outlined in original text.

#### Hammer:

No change in disassembly or reassembly except: New style disconnecter is also removed with new style hammer pin. If necessary to convert old style hammer, install new sear also (see interchangeability chart).

#### Hammer Spring

No change necessary in disassembly or reassembly. The new style spring places hammer under greater tension to prevent the possibility of misfires due to light blow of hammer.

#### Locking Block:

No change is necessary in disassembly or reassembly. A radius cut must be made on new style locking block to work freely in the original 2 feet or 4 feet breech bolt. (See Fig. 3)

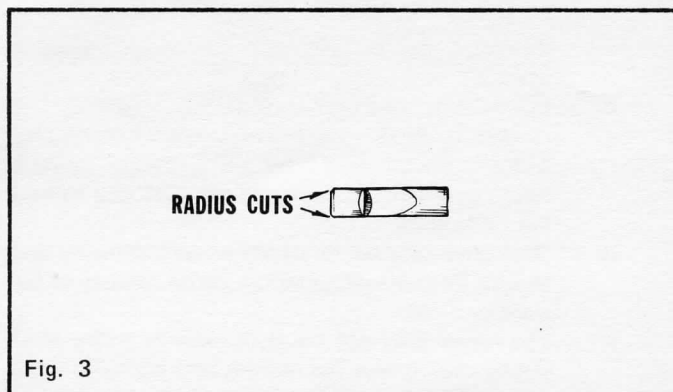


Fig. 3

#### Recoil Spring and Ring Assembly:

Remove barrel (with friction piece in guide ring) from receiver. Remove recoil ring and spring assembly by sliding forward off magazine tube. To convert for the new Self-Compensating Recoil Reducer System (see interchangeability chart) proceed as follows: Remove friction piece from guide ring of barrel. Recut angle in guide ring (where friction piece locates) from 30° to 15°. In other words, lengthen the incline. (See Fig. 4)

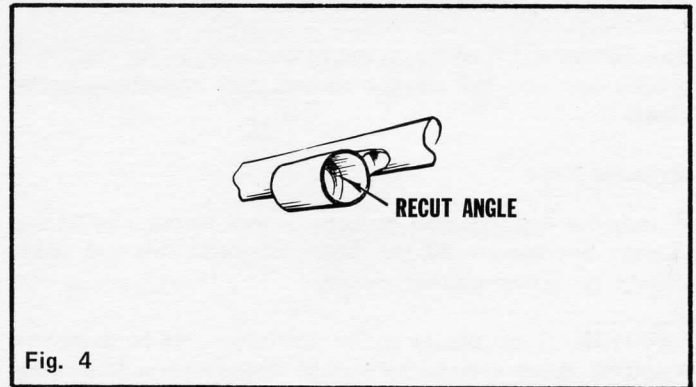


Fig. 4

#### Safety, Left Hand:

Special trigger guards designed to assemble safety to operate from the right side of the trigger plate are available at the factory.

#### Sear:

No change is necessary in disassembly or reassembly.

#### Shell Latch:

No change is necessary in disassembly or reassembly. On 12 and 16 gauge guns, if converting to shell latch with stud attached, it may be necessary to install new style carrier as old style carrier will bind on studded shell latch when assembling barrel to receiver. In the 12 gauge receiver only, it is also necessary to remove a portion of slide rail for shell passage if new style shell latch is fitted. (See Fig. 5)

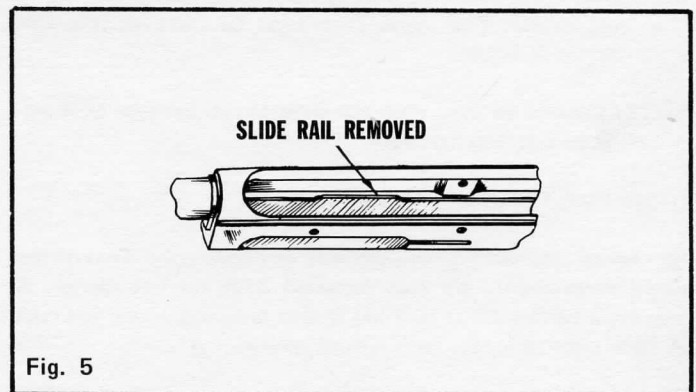


Fig. 5

**NOTE:** See interchangeability chart.



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### Slide:

No change is necessary in disassembly or reassembly. For conversion, three types of slides are supplied in 12 gauge model, two in 16 and 20 gauge. ( see **interchangeability chart**). The following components are not listed in the original Manual but have been changed or added to the current models:

### Firing Pin Retaining Pin:

This component is of longer design and supplied for the 2 feet breech bolt and the current model. (See **interchangeability chart**).

### Magazine Cap:

A universal cap common to both 5-shot Model 11-'48 and 3-shot Sportsman-'48 has been designed. This will interchange on either current model.

**CAUTION:** If substituted on the Sportsman-'48 (with shorter magazine tube) exercise care when disassembling from magazine tube as magazine retainer may be free of magazine tube and held only by magazine cap.

### Hammer Pin:

No change necessary in disassembly or reassembly except disconnector will also be removed with hammer pin. For conversion to new style disconnector, use new style hammer pin. Restake right end of pin flush with right side of trigger plate to prevent carrier interference with a possible loose and protruding hammer pin.

### Links, Right and Left:

No Change is necessary for disassembly or reassembly for installation or conversion.

### Carrier Dog Washer:

No change is necessary in disassembly or reassembly to install new component. The above part must be installed if a new style carrier is fitted.

**NOTE:** Cannot be used with old style carrier because of thicker wall at carrier dog location.

### Trigger Plate Pin Detent Spring Front:

No change necessary in disassembly or reassembly. Two of the above components are now supplied with current carrier. A new style carrier pivot bushing is also supplied which has cuts on both ends to locate both detent springs.

**NOTE:** It is impossible to use both detent springs with old style carrier because of thicker walls.

### Carrier Pivot Tube:

No change necessary for disassembly or reassembly, except: Remove one trigger plate pin detent spring, front, before removing carrier pivot tube. This current component has cuts in

both ends for location of the additional trigger plate pin detent spring, front.

**NOTE:** Cannot be used in old style carrier.

## MALFUNCTIONS

### Cause and Correction

#### 1. Action fails to go forward with barrel off.

- a. The rib on the bottom of slide may catch on cam of carrier latch. If so, replace carrier latch.
- b. The left side of carrier may catch on shell latch. If so, left side of carrier may be ground to clear latch.

**NOTE:** Take care to prevent action from springing forward when barrel is off as this may deform receiver or operating handle.

#### 2. Gun fails to fire. Check for:

- a. Broken firing pin.
- b. Hammer held by paper disk from shotshell lodged in hammer slot.
- c. Disconnector broken or incorrectly assembled.
- d. If gun has been refitted with a new barrel, breech bolt, slide, or locking block, check to see that locking block engages in notch in barrel extension. If it does not, the action will not close sufficiently to allow firing pin to protrude sufficiently to fire. A smaller locking block may be required.

#### 3. Action fails to eject fired shell.

- a. Extractor may be lost, broken, or claw chipped or worn.
- b. Ejector may have been broken.
- c. If gun is fired with heavy loads when friction brake is set for light loads and extractor spring is weak, extractor may bounce off shell and cause a failure to eject.
- d. Shell latch may be out of adjustment allowing shell to feed from magazine before barrel reaches its forward position.
- e. The barrel does not travel through its entire recoil stroke. See below for reasons and corrections for this failure.

#### 4. Barrel does not complete its rearward stroke. When this happens fired shell remains in chamber.

- a. Friction ring may be set for heavy loads with light loads being fired.
- b. The magazine tube may be too dry or dirty. If so, wipe tube and brake clean and add a small amount of oil. Excess oil is undesirable because it will allow excessive kick.

- c. If a rib or muzzle device has been added to barrel, these additions may absorb enough of the energy of barrel to prevent its proper function. In this case, it will be necessary to replace recoil spring with a lighter one which may be obtained from factory.

**5. Shell fails to feed from magazine to chamber.**

- a. Check shell latch for correct dimension and engagement with shell. With barrel pushed rearward about 1" shell latch should engage head of shell by from 1/32" to 1/16". With barrel in forward position, shell latch should clear rim of shell.
- b. Check carrier latch for proper engagement. With action closed, carrier latch should engage head of shell by from 1/16" to 3/32". With action open, and barrel forward, carrier latch should clear rim of shell.
- c. Check tension of carrier latch spring. It should be sufficient to cause latch to operate when action is opened by hand with a shell in magazine.
- d. Shell may catch on end of carrier. If so, it may be necessary to bend front end of carrier downward slightly. Care should be taken not to excessively bend carrier as it will cause failure to properly feed into chamber.
- e. Front end of shell hangs on bottom or right side of face of chamber. (Stems chamber). Usually this indicates that carrier is not raised high enough and may be corrected by installing a higher carrier dog.
- f. Shell binds in top of barrel extension. This usually indicates that carrier is raised too high in action and a lower carrier dog should be used.

**6. If new parts have been assembled, in addition to the above items, the following should be checked:**

- a. Breech bolt may catch on ejector. If so ejector may be filed off slightly to clear.
- b. Locking block may catch on rear of barrel extension. If so, increase angle on inside rear of extension by filing or grinding.
- c. Barrel extension may bind in back of receiver. If so, note position of bind and grind off barrel extension.
- d. Shells may feed up hard under extractor. If so, stone bottom edge of extractor claw slightly.
- e. Shells may load hard in magazine. This may be caused by an excess engagement of carrier latch on shell when action is closed.
- f. Excessive headspace may be corrected by use of a longer locking block or too little headspace by use of a shorter locking block. It is not generally advisable to attempt to alter breech bolt, barrel, or barrel extension.

The gun failures affected by the revision are indexed with the same paragraph number and letter that appeared before each item in original Manual.

**Gun Failure 1—a**

The cause is the same. The correction in current model is—adjust or replace carrier latch.

**Gun Failure 2—c**

The old style disconnecter may also be too short and cause no blow on the firing pin by hammer falling prematurely. The disconnecter may be too short and not disconnect.

**Gun Failure 3—c**

The failure is the same, but for different reasons, namely: excessive lubrication on magazine tube or short recoil spring.

**Gun Failure 3—d**

The failure is unlikely to occur with new style shell latch.

**Gun Failure 4-a**

This failure cannot occur with new style Self Compensating Recoil Reducer System.

**Gun Failure 5—e**

The correction for this failure is different, namely: fit new carrier. This is unlikely to occur with new style carrier.

**Gun Failure 5—f**

The correction for this failure is also different, namely: fit new carrier. It is unlikely to occur with new style carrier dog.

**MODEL 11—'48 (28 Gauge)**

**DISASSEMBLY**

**NOTE:** The disassembly of the 28 gauge Model 11—'48 is similar to the 12, 16 and 20 gauge model, with the following exceptions:

**Recoil Spring Ring Assembly:**

(With barrel assembly and fore-end removed): Remove recoil spring ring and recoil spring by sliding forward off magazine tube.

**Shell Latch:**

**NOTE:** Breech bolt assembly must be in gun and held in position by barrel (or held back by hand) before shell latch can be disassembled properly. Cock hammer. Drive out front and rear trigger plate pins. Remove trigger plate assembly from gun. Turn shell latch free of channel in side of receiver and flat on slide for removal.

Cont. on page 10

## INTERCHANGEABILITY CHART

11-48	SPORTSMAN-48	MODEL-11-48 & SPORTSMAN-48 12-16 & 20 GA. COMPONENT PART INTERCHANGEABILITY			
5,000,001 TO 5,026,000	3,000,001 TO 3,027,000	12 GA.	PART NO. 20225		
5,000,001 TO 5,026,000	3,000,001 TO 3,027,000	12 GA.	PART NO. 17508	17500	17457
5,026,001 TO 5,062,750	3,027,001 TO 3,065,500	12 GA.	PART NO. 20845		
5,026,001 TO 5,062,750	3,027,001 TO 3,065,500	12 GA.	PART NO. 18744	21085	18746
5,062,760 TO	3,065,500 TO	12 GA.	PART NO. 21795		20535
5,500,001 TO 5,509,000	3,500,001 TO 3,509,500	16 GA.	PART NO. 20226		
5,500,001 TO 5,509,009	3,500,001 TO 3,509,500	16 GA.	PART NO. 17509	17526	17458
5,509,001 TO 5,521,400	3,509,501 TO 3,527,400	16 GA.	PART NO. 20850		
5,509,001 TO 5,521,400	3,509,501 TO 3,527,400	16 GA.	PART NO. 18745	21086	18747
5,521,400 TO	3,527,400 TO	16 GA.	PART NO. 21800		20536
5,800,001 TO 5,804,700	3,800,001 TO 3,806,300	20 GA.	PART NO. 20227		
5,800,001 TO 5,804,700	3,800,001 TO 3,806,300	20 GA.	PART NO. 17509	17526	17458
5,804,701 TO 5,816,700	3,806,301 TO 3,821,800	20 GA.	PART NO. 20855		
5,804,701 TO 5,816,700	3,806,301 TO 3,821,800	20 GA.	PART NO. 18745	21086	18747
5,816,700 TO	3,821,800 TO	20 GA.	PART NO. 21800		20536
MODEL & SERIAL NUMBERS					

MODEL & SERIAL NUMBER	11-48	SPORTSMAN-48	MODEL-11-48 & SPORTSMAN-48 12-16 & 20 GA. COMPONENT PART INTERCHANGEABILITY.			
5,000,001 TO 5,008,200	3,000,001 TO 3,010,000	12 GA.	PART NO. 18728	21195	20865	17469
5,008,200 TO	3,010,000 TO	12 GA.	PART NO. 17388	21100	20355	17469
5,500,001 TO	3,500,001 TO	16 GA.	PART NO. 18729	21125	20355	18740
5,500,001 TO	3,500,001 TO	16 GA.	PART NO. 17389	21101	20356	17470
5,800,001 TO	3,800,001 TO	20 GA.	PART NO. 18730	21126	20356	18741
5,800,001 TO	3,800,001 TO	20 GA.	PART NO. 17390	21101	20357	17470
5,000,001 TO	3,000,001 TO	12 GA.	PART NO. 18732	21126	20357	18741
5,500,001 TO	3,500,001 TO	16 GA.	PART NO. 17395	USE WITH SLIDES PART NO'S 21195 & 21100		
5,500,001 TO	3,500,001 TO	16 GA.	PART NO. 20665	USE WITH PART NOS. 21125 AND 18760		
5,800,001 TO	3,800,001 TO	20 GA.	PART NO. 17396	USE WITH SLIDE PART NO. 21101		
5,800,001 TO	3,800,001 TO	20 GA.	PART NO. 20666	USE WITH PART NOS. 21126 AND 18760		
5,000,001 TO	3,000,001 TO	12 GA.	PART NO. 17397	USE WITH SLIDE PART NO. 21101		
5,500,001 TO	3,500,001 TO	16 GA.	PART NO. 20667	USE WITH PART NOS. 21126 AND 18760		
5,800,001 TO	3,800,001 TO	20 GA.	PART NO. 17462	USE WITH SEARS PART NOS. 17517 & 18750		
5,000,001 TO	3,000,001 TO	12 GA.	PART NO. 18749	USE WITH SEAR PART NO. 18750		
5,500,001 TO	3,500,001 TO	16 GA.	PART NO. 17517	USE WITH HAMMER PART NO. 17462		
5,800,001 TO	3,800,001 TO	20 GA.	PART NO. 18750	USE WITH HAMMERS PART NOS. 17462 & 18749		
5,000,001 TO	3,000,001 TO	12 GA.	PART NO. 21160	USE WITH RECEIVER NO. 20510-11-48		
5,000,001 TO	3,000,001 TO	12 GA.	(PART NOS. SEE CATALOG)	USE WITH REMAINING ABOVE RECEIVER SERIAL NUMBERS		



**MODEL 11 – 48 (28 Gauge)**  
**DISASSEMBLY**  
 (Cont. from page 8)

**Breech Bolt Unit:**

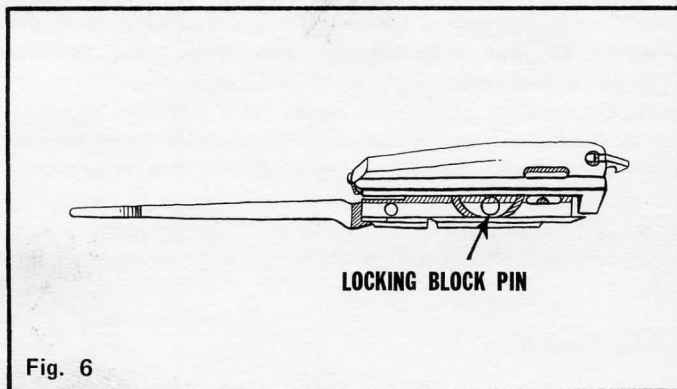
**NOTE:** This unit contains the breech bolt assembly, locking block, slide assembly, and both links.

**CAUTION:** The **shell latch** must be removed from the receiver before the above unit can be removed.

With trigger plate assembly, shell latch, and barrel assembly removed from gun: Push breech bolt slightly rearward and pull operating handle from breech bolt. Slide breech bolt unit forward until free of receiver.

**Breech Bolt Unit Components:**

Raise right side of breech bolt up and partially over locking block to expose locking block pin. (See Fig. 6)



Push out locking block pin from under raised breech bolt (left to right). Dismount breech bolt (with firing pin assembled), and locking block from slide. Push out link pin (flanged end first) and remove links from slide. Push in on firing pin, remove firing pin retaining pin from rear of breech bolt and remove firing pin and firing pin retractor spring from breech bolt. The removal of the extractor from the breech bolt can be done in the same way as explained in the 12, 16 and 20 gauge Model 11-'48 instructions.

**NOTE:** The slide is staked to hold the operating handle plunger and operating handle spring in operating position.

**Carrier Latch Assembly:**

With trigger plate assembly, shell latch, barrel, and breech bolt unit removed from gun: Hold carrier latch assembly under tension and drive out carrier latch pin. (See Fig. 7)

Remove carrier latch assembly and carrier latch button from receiver.

**Trigger Plate Components:**

The disassembly of components in the trigger plate is similar to procedure outlined for 12, 16 and 20 gauge Model 11-'48 with two exceptions, namely:

Remove trigger plate pin detent spring, front, from right side of carrier pivot tube and remove carrier pivot tube from right to left. The carrier dog washer is not used in the 28 gauge carrier assembly.

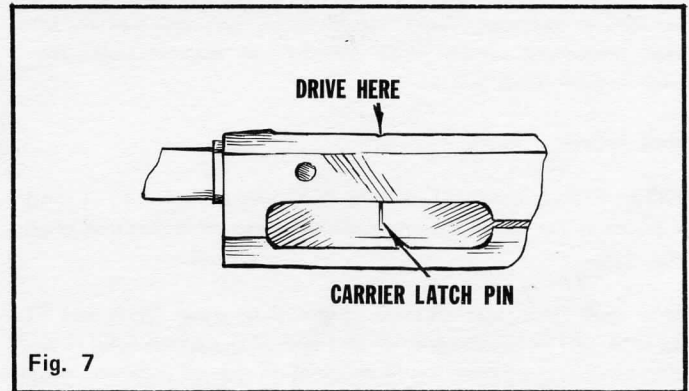


Fig. 7

**MODEL 11-'48 (28 Gauge)**  
**ASSEMBLY**

**NOTE:** Assembly of 28 gauge Model 11-'48 is similar to 12, 16 and 20 gauge models with the following exceptions; also, proper order of assembly is as listed below.

**Recoil Spring Ring Assembly:**

Slide recoil spring onto magazine tube. Slide recoil spring ring onto magazine tube and over recoil spring. Make certain recoil spring fits well up into recessed end of recoil spring ring.

**Carrier Latch Assembly:**

The reassembly of carrier latch assembly can be done in the same way as explained in 12, 16 and 20 gauge Model 11-'48' instructions, with one exception, which is as follows: Push in carrier latch pin from bottom rail of receiver until a click is felt as pin passes through carrier latch assembly. This indicates that pin is detented in proper position.

**Breech Bolt Unit Components:**

Assemble both links to slots in rear of slide (with straight sides on front end of links toward bottom of slide, and rear ends meetings). Align links with link pin hole in slide and insert link pin, with flanged end to seat flush into right side of slide. Push firing pin, with firing pin retractor spring assembled over front end, through hole in rear of breech bolt, and in hole in front of the breech bolt. Push firing pin forward in breech bolt until clearance cut in firing pin aligns with firing pin retaining hole in rear of breech bolt. Insert retaining pin from bottom of bolt. Assemble breech bolt to slide. Assemble locking block to slide (to straddle firing pin.) Holding locking block aligned with locking block pin hole in slide, raise right side of breech bolt up and partly over locking block to expose locking block pin hole. (See Fig. 6.) Insert locking block pin (flanged end to seat flush to right side of locking block) and lower breech bolt to slide.

**NOTE:** The assembly of extractor to breech bolt can be done in the same way as explained in 12, 16 and 20 gauge model 11-'48 instructions.

## MODEL 11-48 & SPTS. 48

### Breech Bolt Unit:

With shell latch, trigger plate assembly, and barrel removed: Place breech bolt unit into receiver at front end through barrel opening (link end first). Slide rearward, aligning links with action spring follower. Hold breech bolt rearward slightly and push operating handle into position in breech bolt. Release breech bolt gently.

### Shell Latch:

**NOTE:** Breech bolt assembly must be in gun and held in proper position by barrel before shell latch can be assembled properly.

Place shell latch flat on slide in gun with small front end fitted into slot between receiver and end of magazine tube. Raise latch to operating position in channel on side of receiver. Align hole in latch with front trigger plate pin hole in receiver and partially insert trigger plate pin, front, to locate and hold latch in proper position for trigger plate reassembly.

### Trigger Plate Components:

The assembly of components to trigger plate is similar to procedure outlined for 12, 16 and 20 gauge Model 11-'48, with **two** exceptions, namely;

Assemble carrier pivot tube to trigger plate from left to right (flanged head of tube to left side) and place trigger plate pin detent spring, front, in position over right end of tube.

The Carrier dog washer is not used on 28 gauge carrier assembly.

### MODEL 11-'48 (28 Gauge) FITTING NEW PARTS AND ADJUSTING

This section, concerning fitting and adjusting of new parts, is similar to the Model 11-'48-12-16 and 20 gauge Supplement (and Revision) except for the following. The interchangeability chart supplied with the Revision Supplement of the Model 11-'48-12, 16 and 20 gauge, **does** not apply to the Model 11-'48-28 gauge.

### Barrel Assembly:

It is not advisable to attempt removal of barrel extension from barrel as it is located and fitted very tightly at the factory and required perfectly formed fixtures to hold barrel without marring the browning, or deforming chamber. This assembly also includes barrel guide ring, sight, and ejector, which are brazed in the proper location. Complete barrel assemblies may be obtained at the factory and are expected to interchange and operate correctly.

### Breech Bolt:

With trigger plate assembly, shell latch, and barrel removed from gun: Pull out operating handle and remove breech bolt unit from receiver. Remove breech bolt component from breech bolt unit as described in paragraph 4, Disassembly section. After replacing breech bolt, reassemble components to

breech bolt and breech bolt to breech bolt unit in reverse order. Reassemble in reverse order also, the remaining assemblies to the gun. The replacement breech bolt is expected to interchange and operate properly with components and assemblies already in the gun.

### Carrier:

The disassembly and reassembly of this 28 gauge carrier differs from 12, 16 and 20 gauge as explained in the preceding sections of this supplement. This carrier, although somewhat different in shape from the 12, 16 and 20 gauge model, operates in a similar manner. The function of the 28 gauge carrier should be checked in the same manner as instructed for the 12, 16 and 20 gauge model.

**NOTE:** The 28 gauge carrier is not fitted with a carrier dog washer.

### Carrier Latch Assembly:

**NOTE:** This assembly includes the carrier latch spring riveted to carrier latch. The carrier latch assembly only may be removed from the gun as follows: Block action fully open, depress carrier, and while holding carrier latch under tension: Push out carrier latch pin from rail of receiver, free of ejection port rail. Remove and replace carrier latch assembly. Replace carrier latch pin from bottom receiver rail. With action closed, and carrier moved upward, carrier latch should overlap a shell by approximately 1/16". Replace carrier latch if needed to attain this engagement. The rear end of carrier latch should clear or be cammed back properly by carrier as it moves upward.

### Carrier Latch Pin:

Disassembly and reassembly requires no special tool as listed for the 12, 16 and 20 gauge model. A close fitting punch, pushing the pin from either direction, will accomplish this task.

### Locking Block:

The disassembly and reassembly of the 28 gauge locking block differs from the 12, 16 and 20 gauge, Model 11-'48. See the preceding sections of this supplement for instructions. A replacement locking block is expected to interchange freely and operate efficiently with the components and assemblies already in the gun.

### Recoil Spring Ring Assembly:

With barrel, (friction piece within guide ring of barrel), and fore-end removed: Remove recoil spring ring and recoil spring (which make up the above assembly) by sliding forward off magazine tube. Slide replacement recoil spring onto magazine tube. Slide recoil spring ring (with recessed end foremost) onto magazine tube and over recoil spring. Reassemble barrel, lubricate recoil spring ring assembly slightly, and check for proper bottoming of barrel extension in receiver as recoil spring ring assembly is compressed. Reassemble fore-end and magazine cap to gun.

**Shell Latch:**

With barrel and breech bolt unit in place: Remove trigger plate assembly from receiver. Turn shell latch free of channel in side of receiver and flat on slide for removal. Place replacement shell latch flat on slide. Raise latch to operating position in channel in wall of receiver and with small front end fitted into slot between receiver and end of magazine tube dropping ahead of slide. (See Fig. 8.)

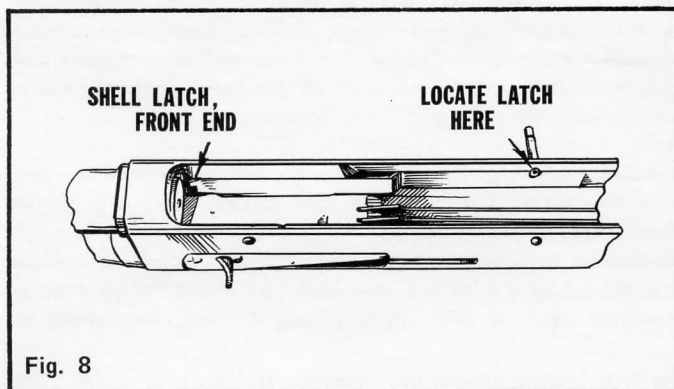


Fig. 8

Align hole in latch with front trigger plate pin hole in receiver, and partially insert trigger plate pin, front, to locate and hold latch in proper position for trigger plate reassembly.

**Check:** With barrel pushed rearward, shell latch should engage head of shell by approximately 1/32" to 1/16". With barrel forward, shell latch should clear rim on head of shell and release shell.

**Slide:** The slide can be disassembled and reassembled as mentioned in the preceding sections of this supplement. This slide operates in the same manner as the 12, 16 and 20 gauge Model 11-'48. The essential difference is in the shape of the front end, which is cut away from shell latch clearance. This makes it possible (and necessary) that the breech bolt unit (with the slide as a component) be assembled to receiver before shell latch is reassembled to the gun. A replacement slide is expected to interchange freely and operate efficiently with the components and assemblies already in gun.

**Grip Caps:** (Additional to the 28 Gauge) Remove old grip cap. Remove old glue residue from stock. Glue and reassemble replacement grip cap to stock. Glue and reassemble replacement grip cap to stock. Allow to dry, then file outline of replacement grip cap to match stock. Sand and touch up stock.

## MALFUNCTIONS

Any malfunctions that may occur with this 28 gauge Model 11-'48 will closely resemble those that could occur in the 12, 16 and 20 gauge Model 11-'48. These malfunctions and their corrections are listed in the original and revised version of the Model 11-'48 supplement.

**MODEL 11-'48 (410 Gauge)**

The design of the 410 Gauge, is similar (on a smaller scale) to the 28 Gauge, with the following exceptions. Otherwise the same instruction as listed for the 28 Gauge apply.

**Recoil Spring:**

The 410 Gauge model is designed for use with a recoil spring only. The recoil spring ring assembled to the larger gauges is not used. NOTE: A recoil spring of heavier design is available for compensated barrels.

**Friction Piece:**

The friction piece is not used as a component for the 410 Gauge model. This component is designed for use within the barrel guide ring of the larger gauges only.

## CYCLE OF OPERATION

The M/11-'48 Autoloading Shotgun utilizes the recoiling barrel principle to obtain its automatic action. Briefly, this principle may be summarized as follows:

The reaction from the force which accelerates the shot charge causes barrel to recoil into action. At end of recoil stroke, breech mechanism is retained while barrel is urged forward, pulling itself off fired case, ejecting case, and feeding into chamber a new shell from magazine. In detail, the action may be described as follows:

**LOCKING UP** — In normal position, ready for firing, the barrel is urged forward by a recoil spring, which is placed around magazine tube, and exerts its force upon barrel guide ring. The unfired shell is locked into breech of barrel by action of locking block which locates into a notch in barrel extension. The face of locking block contacts breech bolt and holds it against head of shell. The entire breech mechanism is forced forward into this locked position by action spring which exerts its force through links to slide.

The disconnecter is free from contact with links at its forward point and allows connector to follow into its lower position where front surface of connector, right, may engage rear notch on sear. The hammer is in cocked position, held there by engagement of its notch with front sear notch. The safety switch is pushed to the off position to allow passage of trigger through trigger slot.

A rib on the slide contacts a camming surface on carrier latch causing latch to assume a position so that its front end intercepts and holds the next shell in magazine.

**FIRING** — With parts arranged as described above, firing is accomplished by pulling on trigger, which causes the following train of events:

Pulling trigger rearward rotates its top section forward, carrying connector with it. The front surface of connector contacts sear notch rotating it about sear pin and disengaging sear from



## MODEL 11-48 & SPTS. 48

hammer notch. The hammer is urged forward by hammer spring until it strikes firing pin. Just before striking firing pin, the hammer spring plunger contacts and engaging surface on disconnector which causes disconnector to rotate and to prevent double firing.

As firing pin moves forward, pin strikes primer of shell, igniting powder load. The pressure set up by expansion of gases of the burning powder accelerates shot charge forward toward muzzle of barrel. A reactive force is exerted upon face of breech bolt through front section of bolt, through locking block to locking block notch in barrel extension. This causes barrel to accelerate rearward at a rate inversely proportional to ratio of weight of barrel to weight of shot charge multiplied by rate of acceleration of shot charge.

**RECOILING** — As barrel accelerates rearward it accelerates recoil spring and recoil spring ring rearward. Disposed between conical surface of inside of barrel guide ring and recoil spring ring is a cylindrical member having a slot through one side and having a special sintered brake material on its inside surface. This is called **friction piece**. As the force of acceleration of recoil spring and friction piece is exerted by barrel, the cones at each end of this friction piece cause it to be compressed against magazine tube. This action creates a friction force retarding rearward acceleration of barrel. The greater the acceleration of barrel, the greater will be accelerating force of friction member. This tends to cause a self compensating action which provides greater retarding forces for heavy loads than for light loads.

As the barrel and breech mechanism move rearward, the links push action spring down into action spring tube. The slide rides over front camming surface of disconnector to hold it so as to hold connector away from sear. The slide contacts the hammer, causing it to rotate rearward, compressing hammer spring, and pushing sear notch of hammer slightly beyond engaging notch on sear. The slide also cams carrier dog rearward, compressing carrier dog spring.

As barrel recoils, the camming lug on barrel extension disengages from forward end of shell latch, allowing shell latch to spring inward into a position to intercept head of shell in magazine. Further rearward motion of barrel causes rib on slide to disengage from cam on carrier latch, thus allowing carrier latch spring to rotate front end of latch out of engagement with shell in magazine. The shell then feeds rearward past carrier latch approximately .050" and is held on front end of shell latch. As carrier latch rotates by this spring action, its rear end engages top of carrier so as to hold carrier in down position.

The rearward movement of barrel is retarded by recoil reducer. However, there must be sufficient energy left in barrel to allow it to reach rear of receiver. As it does so, the rearward motion is stopped and the recoil spring tends to force barrel forward again.

**EXTRACTING & EJECTING** — As barrel tends to go forward, taking with it the breech mechanism, the carrier dog engages a notch in slide so as to retain it in rearward position. The barrel continues to be force forward and strips itself away from breech mechanism by rotating locking block out of engagement with locking notch in barrel extension. As barrel pulls away from breech bolt, extractor engages rim of shell and holds it against face of bolt. As barrel approaches its forward

position, the ejector, which is a small projection on inside surface of barrel extension, strikes head of shell at a position opposite extractor, throwing shell out of ejection port.

**FEEDING & CLOSING** — As barrel reaches its forward position, the camming lock on barrel extension re-engages with front end of shell latch causing shell latch to move out of engagement with shell in magazine. The magazine spring urges this shell rearward into action. As head of this new shell passes pivot point of carrier latch, it begins to wedge between surface of carrier latch and surface of shell latch and in so doing rotates carrier latch so that the front end again moves into position to intercept next shell. At the same time, rear end of carrier latch is disengaged from carrier.

Under influence of action spring, slide begins to move forward, rotating carrier dog, which in turn forces rear end of carrier down and front end up, thus raising new shell into a position so that its forward end will enter chamber. As carrier reaches correct upward position, the bolt face in its forward travel contacts head of shell, thus driving it home, into chamber.

As the breech mechanism reaches its "home position", the action spring continues to force slide forward, carrying with it the locking block. Since face of locking block is brought up against rear surface of front end of breech bolt at a point above pivot point of block, forward action of slide causes block to rotate upward into locked position in locking notch of barrel extension. As the slide moves forward, rib on slide again engages camming surface on rear of carrier latch so as to maintain latch in a position to intercept head of shell in magazine. As slide moves forward, it allows hammer to rotate forward until its notch is engaged by sear, leaving it in a cocked position.

At forward end of slide stroke, the rear end of slide and link become disengaged from front of disconnector, thus allowing tail of disconnector to rotate downward, and dropping connector into position to again connect with notch of sear. As soon as the shooter's finger is released from trigger, the bottom of trigger moves forward, top moves rearward, and gun is again ready for firing. This action may be repeated by pulling trigger as many times as there are shells in magazine.

**LOCKING OPEN** — After feeding last shell from magazine into chamber, the next cycle of operation differs from that described above in that as action reaches its rearward position, a new shell does not feed out of magazine and so carrier latch is not cammed out of engagement with carrier. In this condition, barrel then feeds forward as usual, but breech mechanism is held in rearward position through action of carrier dog in notch of slide, thus indicating that gun is empty. If it is desired to close action with gun empty, it is only necessary to press in on carrier latch button which protrudes from right side of receiver, thus rotating carrier latch in same manner as is done by a new shell feeding from magazine. The carrier is then allowed to move upward and action to close.

**UNLOAD WITHOUT FIRING** — For manual operation of gun, without firing, shells may be loaded and fed from magazine to chamber, and ejected in following manner:

First, shells are loaded into magazine in regular manner. The breech mechanism may be moved rearward by a rearward action on operating handle. Since barrel is in forward position, shell latch is held out of engagement with shell and the shell head abutts against carrier latch. Thus, as soon as rib on slide disengages from camming surface on carrier latch, latch spring moves latch out of engagement with the shell allowing one shell to move out of magazine. As it does so, it wedges between carrier latch as in automatic operation, moving latch into position to intercept second shell and to release carrier. If operating handle is released from rearward position, action will snap forward under influence of action spring, raising shell through movement of carrier dog and carrier, and pushing it into chamber by action of bolt. All other actions such as cocking hammer, releasing disconnecter, etc., are the same as in automatic operation.

Grasp operating handle and pull bolt rearward again. As bolt moves open it will extract unfired shell from chamber and carry it rearward until shell contacts ejector of the unmoved barrel extension. A rapid contact with ejector plus firm grip of extractor over head rim of shell will eject shell out of ejection port of receiver. By allowing bolt to close, next shell will be fed into chamber. Repeat this manual operation of bolt until gun is empty.

If it is desired to load chamber only, this may be done as follows:

**SINGLE LOAD** — Move action rearward by pulling on operating handle. Since there is no shell feeding out of the magazine, carrier is held in downward position by contact with rear stepping surface on carrier latch. In this manner, action will be held open. (This same action occurs when last shot is fired, during automatic operation.) A shell may then be dropped into receiver through ejection port with head of shell to rear. By pushing upon carrier latch button, protruding from right side of receiver, carrier latch is rotated out of engagement with carrier, thus allowing action to move forward under influence of action spring. The shell is raised by carrier dog and carrier, and forced home into chamber by face of bolt.

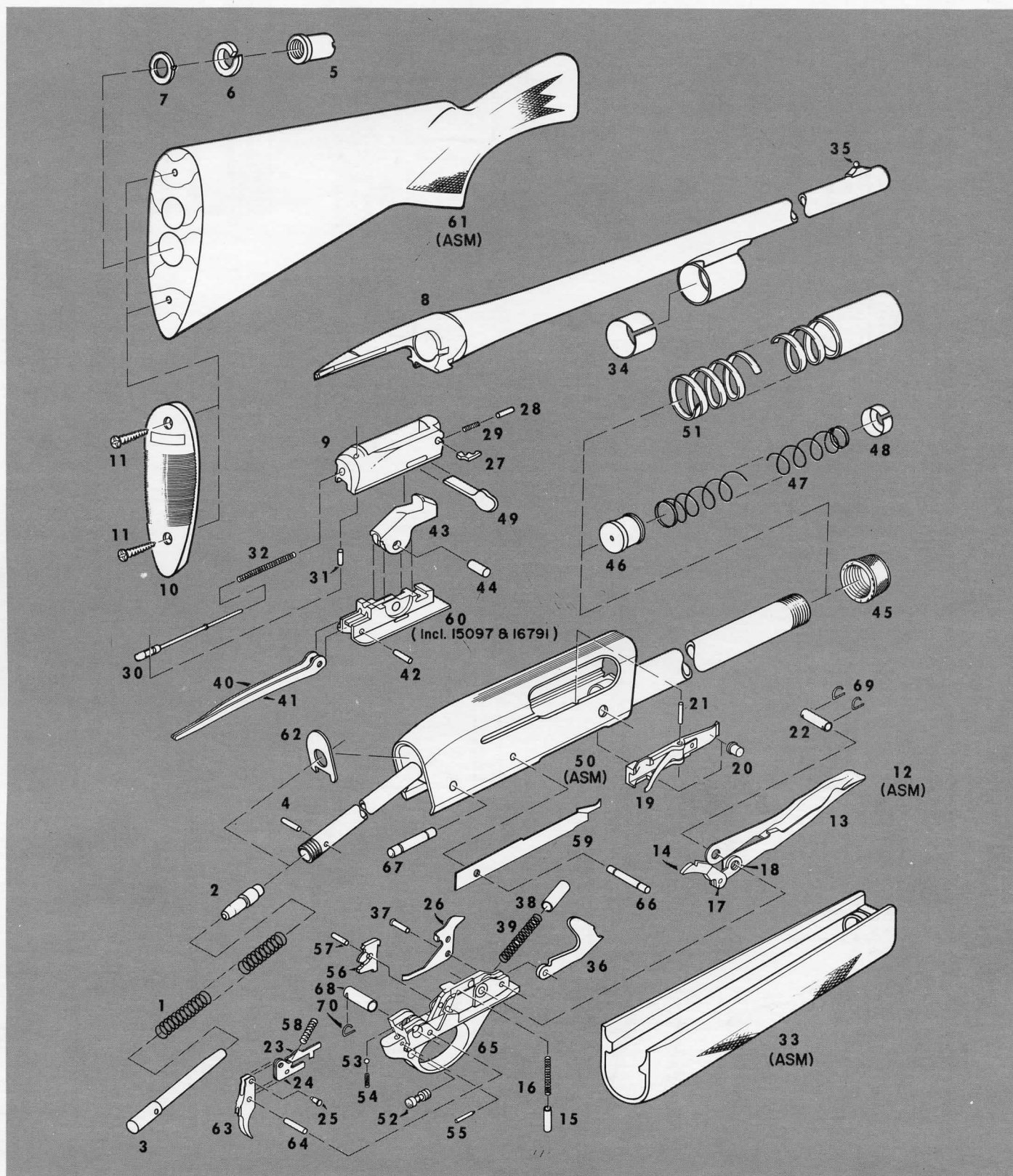
The trigger may be made inoperative by pushing safety switch into a position to engage rear edge of trigger, thus preventing it from moving trigger.

# REMINGTON FIELD SERVICE MANUAL

View No.	NAME OF PART	View No.	NAME OF PART
1	Action Spring	50	Receiver Assembly — (Restricted)
2	Action Spring Follower	51	Recoil Spring and Ring Assembly
	Action Spring Follower Assembly	52	Safety Switch
3	Action Spring Plug	53	Safety Switch Detent Ball
4	Action Spring Plug Pin	54	Safety Switch Spring
5	Action Spring Tube Nut	55	Safety Switch Spring Retaining Pin
6	Action Spring Tube Nut Lock Washer	56	Sear
7	Action Spring Tube Nut Washer	57	Sear Pin (also used for old style Hammer Pin)
8	Barrel Assembly, PLAIN (26"-28"-30")	58	Sear Spring
	Breech Bolt Assembly, Complete	59	Shell Latch
	Breech Bolt Assembly	60	Slide
9	Breech Bolt	61	Stock Assembly
10	Butt Plate	62	Stock Bearing Plate
11	Butt Plate Screw		Trigger Assembly (Restricted)
12	Carrier Assembly	63	Trigger — (Restricted)
13	Carrier	64	Trigger Pin
14	Carrier Dog	65	Trigger Plate, R.H.
15	Carrier Dog Follower		Trigger Plate, L.H. (not shown)
16	Carrier Dog Follower Spring		Trigger Plate Assembly, R.H.
17	Carrier Dog Pin		Trigger Plate Assembly, L.H. (not shown)
18	Carrier Dog Washer	66	Trigger Plate Pin, Front
19	Carrier Latch Assembly	67	Trigger Plate Pin, Rear
20	Carrier Latch Button	68	Trigger Plate Pin Bushing
21	Carrier Latch Pin	69	Trigger Plate Pin Detent Spring, Front
	Carrier Latch Pin Puller (not shown)	70	Trigger Plate Pin Detent Spring, Rear
	Carrier Latch Rivet		
	Carrier Latch Spring		
22	Carrier Pivot Tube		
23	Connector, Left — (Restricted)		
24	Connector, Right — (Restricted)		
25	Connector Pin (Restricted)		
26	Disconnecter		
27	Extractor		
28	Extractor Plunger		
29	Extractor Spring		
30	Firing Pin		
31	Firing Pin Retaining Pin		
32	Firing Pin Retractor Spring		
33	Fore-end Assembly		
	Fore-end Detent (not shown)		
	Fore-end Detent Spring (not shown)		
34	Friction Piece		
35	Front Sight (for Vent Rib use No. 18796)		
	Front Sight (Ivory Bead)		
	Front Sight Retaining Pin VENT RIB (not shown)		
36	Hammer		
37	Hammer Pin		
	Hammer Pin Washer		
38	Hammer Plunger		
39	Hammer Spring		
40	Link, Left		
41	Link, Right		
42	Link Pin		
43	Locking Block		
44	Locking Block Pin		
45	Magazine Cap		
46	Magazine Follower		
	Magazine Plug-Wood (3 Shot) (not shown)		
47	Magazine Spring		
48	Magazine Spring Retainer		
49	Operating Handle		
	Operating Handle Plunger		
	Operating Handle Spring		



# REMINGTON FIELD SERVICE MANUAL

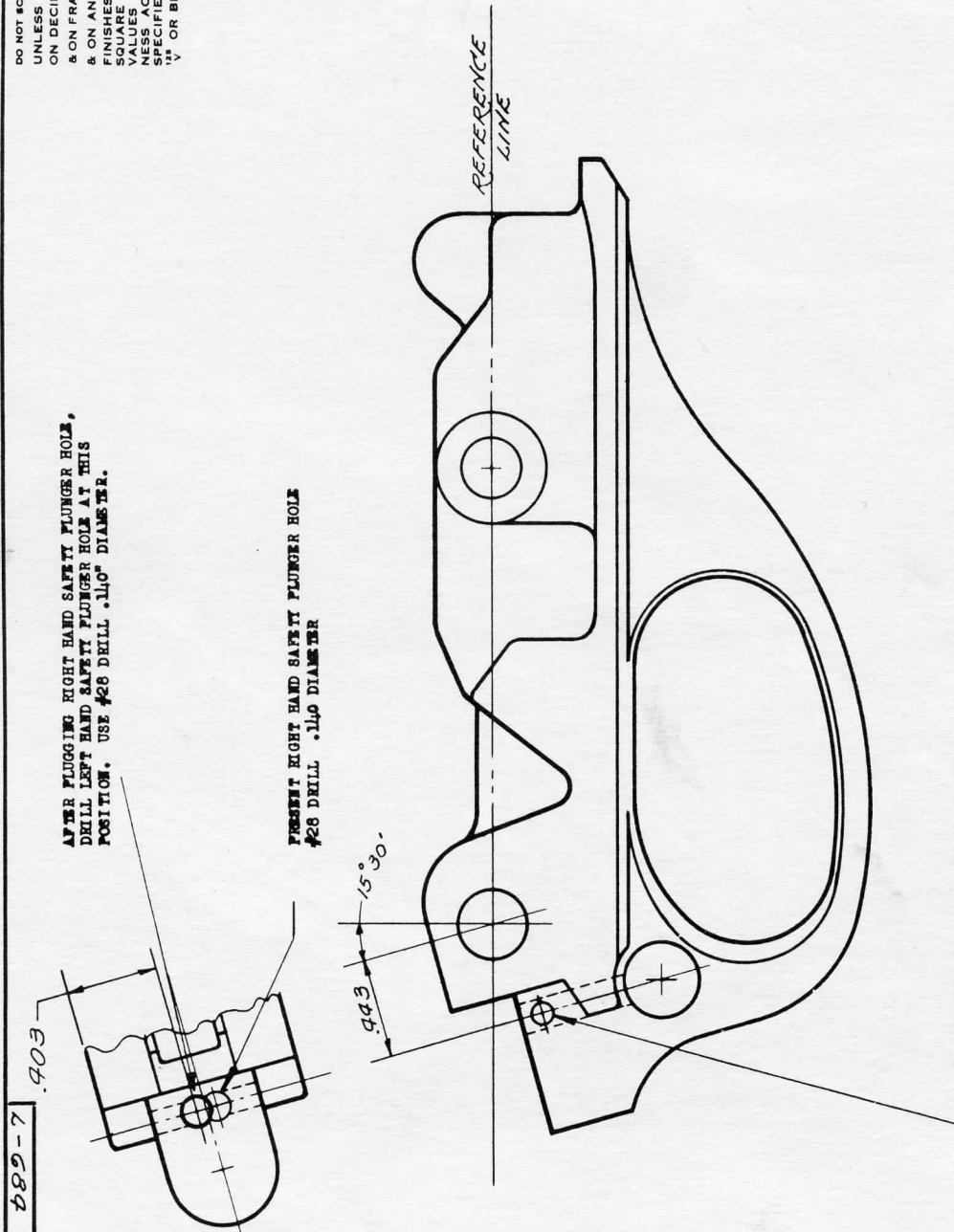


ALTERATIONS			
LET.	WAS	REFERENCE	BY

DO NOT SCALE THIS DRAWING: WORK TO FIGURES  
UNLESS OTHERWISE NOTED. TOLERANCES  
ON DECIMAL DIMENSIONS ARE  $\pm .005$   
& ON FRACTIONAL DIMENSIONS  $\pm \frac{1}{64}$   
& ON ANGULAR DIMENSIONS  $\pm .00750^\circ$   
FINISHES ARE DESIGNATED BY ROOT MEAN  
SQUARE (RMS) SURFACE VALUES. SURFACE  
VALUES ARE THE MAXIMUM ALLOWABLE  
UNLESS ACCEPTABLE. UNLESS OTHERWISE  
SPECIFIED, FINISH ROUGHNESS TO BE  
"V" OR BETTER.

AFTER PLUGGING RIGHT HAND SAFETY PLUNGER HOLE,  
DRILL LEFT HAND SAFETY PLUNGER HOLE AT THIS  
POSITION. USE #28 DRILL .110" DIAMETER.

PRESENT RIGHT HAND SAFETY PLUNGER HOLE  
#28 DRILL .110 DIAMETER



SAFETY SPRING RETAINING PIN HOLE  
#38 DRILL .102" DIAMETER  
REDRILL AFTER PLUGGING SAFETY PLUNGER HOLE.

- TO CONVERT RIGHT HAND SAFETY TO LEFT HAND SAFETY
1. DRIVE OUT SAFETY SPRING RETAINING PIN.
  2. REMOVE SAFETY SPRING, PLUNGER, AND SAFETY.
  3. PLUG SAFETY PLUNGER HOLE WITH 7/16" LONG PIN  
FITTED TO BE TIGHT DRIVE FIT IN HOLE  
.110"-.115" DIAMETER.
  4. DRILL NEW SAFETY PLUNGER HOLE AS SHOWN. USE  
#28 DRILL, .110"-.115" DIAM. FOR FINISHED HOLE.
  5. REDRILL SAFETY SPRING RETAINING PIN HOLE.
  6. USE #38 DRILL, .102" DIAM.
  7. REASSEMBLE SAFETY WITH RED HAND TO RIGHT OF GUARD.  
REASSEMBLE SAFETY SPRING PLUNGER, SPRING, AND  
RETAINING PIN.

MODEL	PART USE	QUAN.	LIST	SEE
11-48				
MATERIAL	HEAT TREATMENT	SURFACE TREATMENT		
DESIGNED BY DATE	DRAWN BY DATE	INDEX BY DATE	CHECK BY DATE	
	H.M.R.	6/1/49		
TITLE	SCALE		APPR. BY DATE	
L.H. SAFETY CONVERSION	2 x 5/16"		LR-63-49	
NUMBER	SUPERSEDES-REFERENCE			
L-684				
THE REMINGTON ARMS CO. INC.				
TECHNICAL DEPT.-ARMS DIV.				

L-684

TFB-1 REV.