

Witchell's Mausers



Owner's Manual
for the
Care and Use of



The Legendary

German Mauser 98K of WWII
in
8mm Mauser Caliber

Mauser: the Crown Jewel of Bolt Action Rifles!

This Owner's Manual should always accompany the rifle and be transferred with it upon change of ownership. Become thoroughly knowledgeable with the instructions contained here and review the entire booklet each time you intend to use your rifle.

This rifle must be thoroughly cleaned before use.

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Mauser 98K Parts Identification

This illustration is intended to identify all exterior component parts for easy reference as you go through this owners manual in detail.

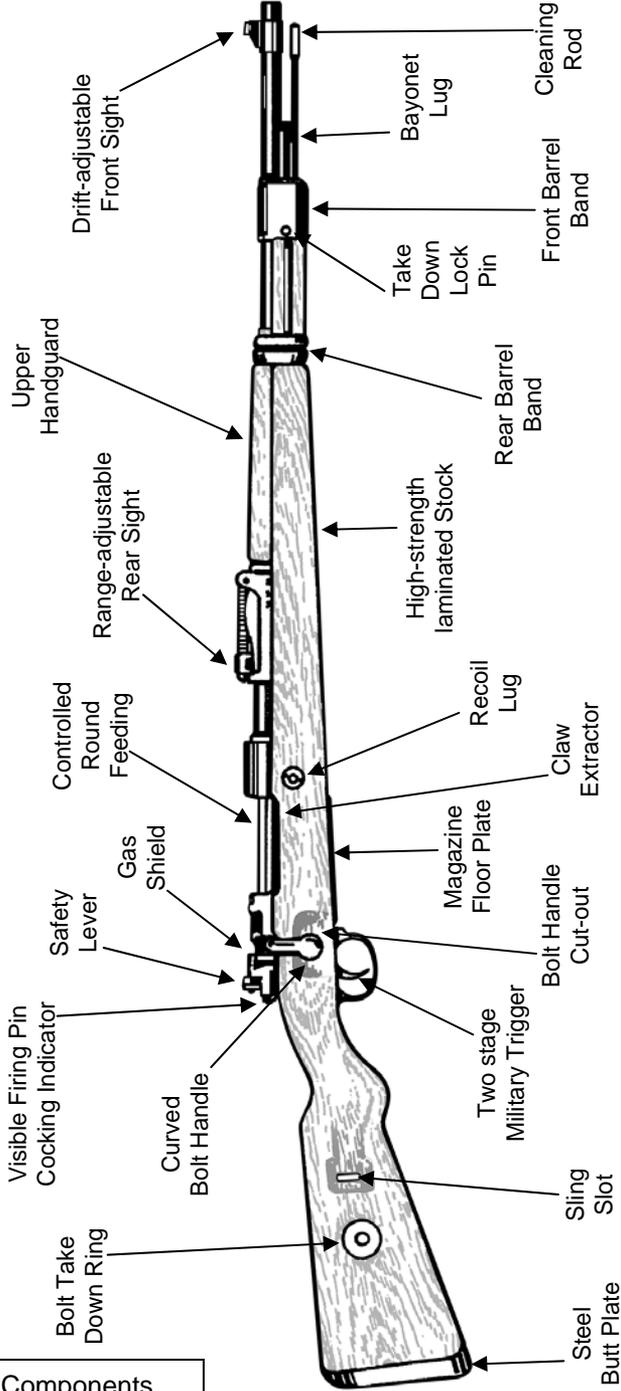


Fig 1 – Exterior Components

German Mauser K98 Rifle

CONTENTS

Responsibility	3
Congratulations	4
A Little Mauser K98 History.....	4
Characteristics and General Description.....	5
Specifications	6
Safety	7
Safety Lever Functions.....	7
Loading.....	9
Sights.....	9
The Correct Sight Picture	10
Trigger	10
Firing.....	11
Government Safety Warnings	11
Unloading Your Rifle	12
Cleaning Your Rifle	
Disassembly	12
Reassembly	16
Re-Cocking the Bolt	17
Removing the Stock from the Barreled Action	18

Responsibility

As a responsible firearms owner, **you must read this Owner's Manual** thoroughly and become completely comfortable with it **before you handle your rifle!** Then examine your rifle carefully after you've read this manual and make sure you understand all of the basics associated with it.

Your rifle is well made and will give you a lifetime of reliable service, security and pride of ownership. You, the owner, must use it intelligently, keep it clean and call us with any questions.

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Congratulations

on your purchase of a world-class rifle representing the leading edge of firearms technology in its day. While that day was long ago, the Mauser K98, also called 98K, is the basis of virtually all modern bolt-action rifles, even today.

German manufacturing involved a coded system to conceal the identity of the many factories that produced the rifles for the German military. In addition, the year of manufacture is stamped into the receiver ring of every K98 rifle.

The Mauser K98 is available in three distinct models. They are:

Infantry Model

SS Model

Sniper Model

The Infantry Model has matching serial numbers on all normally numbered parts. It also has German military acceptance marks of various sizes throughout the rifle, even on some small parts. The German military was extremely sensitive about quality and had a highly refined quality control system. After all, this was intended to be a world-class combat rifle.

The SS Model is an Infantry rifle that has special markings and a unique history. These rifles were built by and for the German SS (Gestapo) in the Mauthausen concentration camp near the Steyr factory in Steyr, Austria. Because captives built it under close supervision, the Gestapo had extreme quality control over every step in manufacturing.

The Sniper Model K98's were selected at the final production QC point and then fitted with a sniper scope. Selection was based on having the tightest manufacturing tolerances, which would therefore make the most accurate rifles.

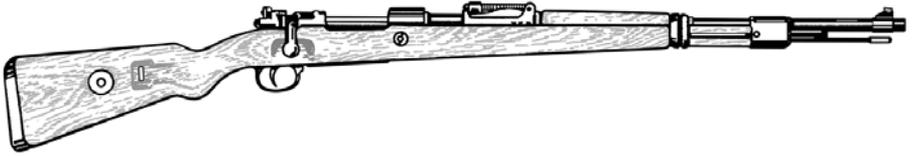
All three models are operationally identical. Parts are generally interchangeable between models, except for the sniper scopes.

A Little Mauser K98 History:

Much has been written about the genius of Paul Mauser and his brother Wilhelm and their invention of the famous Mauser rifle. It is the forerunner of virtually every modern bolt action rifle made in the 20th Century. Many books have been written about Mauser rifles. Even today, most bolt action rifles are based on the principles of the Mauser brothers, regardless of the brand.

Your rifle, a Mauser 98K, was built before or during WWII. It was manufactured in preparation for a renewed and rearmed German military after the Treaty of Versailles was renounced. After the war the production of semi-automatic and full-automatic rifles in Europe then rendered bolt action rifles functionally obsolete for the main body of an army. During the long decades since that time, your rifle was stored in a combat ready condition, just in case.

German Mauser K98 Rifle



Your rifle is in near-new condition and shows only 'garrison marks'. These are handling and storage marks accumulated over the years together with the preservatives of the day that, in some cases, tended to change the hue and wear of the bluing. Over the years the preservative affected the color of the wood in different ways so that no two rifles are exactly alike.

Your rifle was recently 'honorably discharged' from the military and is now a civilian! The K98 rifle is a very strong rifle, originally designed for the rigors of combat. As such it provides you with an excellent platform for sporterizing or you can use it for hunting just as it is. Its 8mm Mauser caliber is ballistically similar to our .30-'06 Springfield.

It is a functionally new rifle. It has preservative in it and on it.
Before use, it must be thoroughly cleaned and examined by you.

You must assure that the rifle is clean, complete and normally functional as described in this manual. Please pay particular attention to the section on cleaning your rifle, as well as Safe Handling.

As an owner, that responsibility rests with you.

Characteristics and General Description of your Rifle:

The Mauser 98K is a shoulder mounted, trigger actuated, striker fired, magazine fed, bolt action rifle. It is designed to be fired from the shoulder only, not in any other position, whether standing, sitting or prone.

The rifle is equipped with features that were standard for the time and are still considered 'advanced' today. It has, for example, 'controlled round feeding', a long, heavy claw extractor, two heavy-duty front locking lugs and an additional safety lug built into the rear of the bolt. It also has a superb gas shield. The long claw extractor serves as a bolt guide along with a built-in bolt guide that is built into the body of the bolt. The bolt body has gas escape ports to handle cartridge failure. It is generally accepted that it has the best safety mechanism ever designed. Your rifle is quite possibly the strongest bolt action rifle ever built.

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Your rifle is now a ‘civilian’ and, as such, is perfect for collecting, target shooting, big game hunting, or sporterizing. **It is a rarity** because of its like-new condition for its age.

Note: Some rifle models may come with the original leather accessories including a sling, ammunition pouch and belt hanger for the bayonet scabbard. The leather is 50 years old and has varying degrees of color and age marks. You can easily make it look its best with any good commercial leather cleaner, shoe polish or leather preservative.

Your rifle was once a complete battle ready ‘soldier’. It is now a ‘civilian’.

Rifle Specifications — German K98 Mauser

Action Type:	Large Ring Mauser Bolt Action, Striker fired, Magazine fed, with Long Claw Extractor.
Action Bedding:	Pillar Bedding with locking screws and Cross-bolt Recoil Lug
Magazine Capacity:	5, with Controlled Round Feeding.
Caliber:	8mm Mauser (also described as 8x57JS Mauser or 7.9mm)
Bullet Diameter:	0.323"
Barrel Length:	23½ "
Rifling:	4 groves, right twist.
Rear Sight:	Standard V-notch, adjustable to 2,000 Meters.
Front Sight:	Inverted V, forming a clean sight picture.
Stock Material:	Oil-resistant Laminated Wood
Over-All Length:	43.5"
Weight:	8.9 lbs. +/-

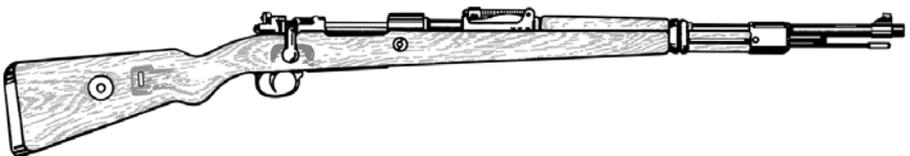
German Mauser K98 Rifle

Safety:

Safety is your responsibility and your primary concern. Of course, you know the basic handling rules governing the use of any firearm. Nevertheless, we repeat them here:

1. Never point this rifle at **anything** you are not willing to destroy, even if it is not loaded. This rifle fires the powerful 8mm Mauser cartridge. You must know what you're doing.
2. Don't load or fire this rifle until you are thoroughly familiar with it and all of its handling characteristics. If you don't understand something or need to ask a question, please call us.
3. Don't handle or clean this rifle without assuring yourself and those around you that the rifle is empty and safe.
4. Don't load your rifle or shoot it until you have examined it completely and know that it is clean, complete, safe and fully functional.
5. Don't put or keep a live round in the chamber unless the safety is on.
6. If you have been drinking or have been using any drugs, prescription or not, put the rifle away and come back another day. You won't perform to the standard of the rifle, you could get in trouble or, worse yet, hurt yourself or someone near you.

This Rifle is NOT a Toy. Be Careful.



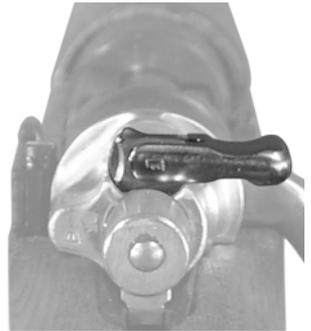
Safety Lever Functions:

Your rifle has one of the most advanced safety mechanisms in existence, even today. It is generally recognized that no other rifle safety is as good, no matter the brand or the cost.

The safety lever is located on the top rear of the bolt. It has three positions; full left, middle and full right.

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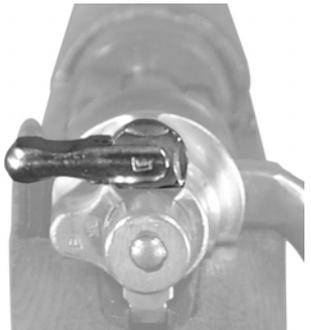
1. **Fully safe position:** Same as the ‘full right’ position. With the lever easily swung over to the full right position, the rifle cannot be fired, and the bolt cannot be opened. The rifle is fully safe.
2. **Safe-unload position:** Same as ‘vertical’ or ‘middle’ position. With the lever standing straight up, the rifle cannot be fired but the bolt can be opened for unloading. If you change your mind and choose not to shoot, you can safely unload you rifle without putting it in the fire position (unlike many newer designs). If you attempted to fire your rifle in the ‘safe-unload’ position, you would quickly see that the vertically standing safety lever would interfere with the sights and at the same time, the trigger is disabled! You have an advanced hunting rifle, even by today’s standards!
3. **Fire position:** Same as ‘full left’ position. With the safety lever in the full left position, the rifle is ready to fire. **It will fire if the trigger is pulled.**



1. Right: Safe & Locked



2. Vertical: Safe & Unlocked



3. Full Left: Fire

As an added feature, you can tell if your rifle is ‘cocked’ by just looking at it; without even picking it up! Just look at the rear of the bolt and see how far the firing pin base protrudes rearward from the gas shield. If it protrudes about a half inch, you **know** it is cocked, so be extra careful. If it protrudes only one quarter inch, you know it is not cocked. The difference is easy to see or even feel, in the dark.

Caution: A decocked rifle with a live round in the chamber is NOT a safe condition. An accidental blow could fire the rifle. **Always use the safety lever**

German Mauser K98 Rifle

Loading:

There are two ways to load your rifle. Put the safety lever in the straight up (middle) position before you do anything.

1. The fastest way to load is to have ammunition on 'stripper' clips. Notice that there is a cut-out in the top rear receiver designed specifically for stripper clip loading. With the bolt open, simply fit the loaded clip into the cut-out and then smartly 'strip' the cartridges into the empty magazine as far as you can push them. There is a cutout provision in the left rear of the receiver to allow room for your thumb to push the cartridges down into the magazine. The stripper clip will then be standing empty. You can lift it out by hand or when you close the bolt, it will be pushed up and out of the rifle.
2. The simplest way is to simply open the bolt and push cartridges into the magazine, one at a time. Simple, fairly quick, and very easy.

You should practice with the safety lever until you are comfortable and sure of its three positions and how the different positions affect the rifle. When Paul Mauser designed the rifle, he successfully designed it to be 'soldier proof' (which really means combat-ready). You are holding one of the most copied designs in the firearms world! Your rifle is extraordinarily rugged, very accurate, and a joy to own.

Sights:

The sights of the rifle are adjustable from one hundred meters all the way out to 2,000 meters! In one hundred meter increments. At its rearmost setting the sight is set for one hundred meters. This is an ideal setting for hunting with open sights. For longer ranges, the sight can be adjusted simply by squeezing the two locking lugs together and sliding the sight up its ramp to the desired distance. At ranges beyond 200 yards, the rifle and the cartridge will perform admirably well, **but you won't**. The human eye just can't cut it for game animals or silhouette shooting without optical assistance at that distance.

The front sight provides you with 'windage adjustment'. In reality you'll use "Kentucky windage" once you set the front and rear sights in the way you like them for the particular style and weight of hunting bullet you are using. To adjust the front sight, start by taking the bolt out of the rifle and removing all ammunition from the area. Lay the rifle down on its side and support the front sight base securely because you will be 'tapping' on the

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sight alone; to move it in its groove. It is a dove-tailed friction fit and it will not move easily. However, not much movement will be required to make even large adjustments. Movement of the sight should only be done by using a small brass tool (rod) and tap the rod with a hammer using only light blows. **Be sure of what you are doing.** Do not scar or damage your rifle.

To move the impact point to the left, move the front sight to the right. To move the impact point to the right, move the front sight to the left. Just remember that slight movement of the sight means a lot of movement of the impact point out at 100 meters. Your rifle will be very accurate right out of the box. Do not adjust windage unless really necessary.

We suggest you limit yourself to what is comfortable for your eyes as far as distance is concerned. If you're tired, boozy or distracted, forget about shooting. Come back when you're alert, focused and ready to perform up to the ability designed into your rifle.

The Correct Sight Picture:

The rear sight has a 'V' notch, and the front sight has an inverted 'V' post. Simply match them up and make sure they are level and centered; the front in the rear and level. That forms the correct sight picture. The inverted 'V' post centered in the rear 'V' notch of the rear sight is the correct (and only) sight picture you should use.



Trigger:

Your rifle has a two stage 'military' trigger designed for safety and reliability. It requires that you practice with it to know it well. Its first 'stage' is simply a take-up stage and the second stage is the firing stage. You'll feel the trigger come to a definite firmness after you take-up the first stage and as you feel the firmness, you feel the trigger 'break', firing the rifle. To be as accurate as the rifle, you must learn the trigger and know when it will fire. It is simple and easy to learn, but it does require practice. If you shoot for group size, trigger control is paramount. Your rifle will perform, but only as well as you are able to hold it.

German Mauser K98 Rifle

Firing:

Your rifle is designed to fire only the 8mm Mauser cartridge. It is readily available and can be purchased where you bought the rifle.

Your rifle is a shoulder fired rifle and requires the use of two hands. It should not be fired in any other way. Grasp the semi-pistol grip in your right hand, and with your left hand, grasp the rifle as far forward as is comfortable for you. Bring the buttstock firmly to your shoulder and as high as is comfortable. You want to get a secure ‘weld’ between the stock and your cheekbone. In this way you have full control of the rifle and will be the most accurate. Remember, control is everything.

You must be certain of your target before you shoot. You must know where your bullet will go before you shoot, even if you miss, because you can’t call it back. Your bullet is very powerful and, depending on the type you choose to use, can have very high penetrating characteristics. You must be sure of the backstop for your bullet because you may shoot right through your target and hit something you weren’t intending to hit.

Hit or miss, the responsibility is yours. Be sure of what you are doing.

Government Safety Warnings:

WARNING

Discharging firearms in poorly ventilated areas, cleaning firearms, or handling ammunition may result in exposures to lead and other substances known to the State of California to cause birth defects, reproductive harm, and other serious physical injury. Have adequate ventilation at all times. Wash hands thoroughly after exposure.

NOTICE

If you leave a loaded firearm where a child obtains and improperly uses it, you may be fined or sent to prison or both.

In light of everything contained in this manual, keep three things in mind:

- 1. Be safe!**
- 2. Be careful!**
- 3. Have fun!**

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Unloading Your Rifle:

If you change your mind and choose not to shoot, just follow these simple instructions. Keep the rifle pointed safely down range. Raise the safety lever to the vertical position. (If the rifle is not cocked, lift the bolt handle first, and lower it again, then put the safety on.) Open the bolt and extract the loaded round. If there are cartridges in the magazine, you may unload the magazine by cycling all cartridges with the bolt while the safety lever is still in the vertical position. Just cycle the bolt for as many cartridges as remain in the magazine until the magazine is empty.

Cleaning Your Rifle:

Your rifle has fifty years of preservative in it and on it. It must be thoroughly cleaned before use.

Disassembly:

- 1. Unload your rifle and remove all ammo from the area.**
- 2. Remove the Bolt.** (Rifles are shipped with the bolt already removed.)
Point the rifle in a safe direction. Put the safety lever in the vertical (upright) position. (If the rifle is not cocked, lift the bolt handle and lower it again to cock it, then put the safety on.) Open the bolt and pull it to the rear. It will stop against the bolt-stop.

On the left side of the rear part of the receiver is a spring loaded, hinged, release lever, which will release the bolt stop. It swings from the front, being hinged in the rear. Swing it all the way out and that will allow you to pull the bolt out of the rifle.

3. Remove the Magazine Floor Plate and Follower.

- Turn the rifle upside down so that you can see the magazine floor plate. At the rear of the floor plate, near the trigger guard you will see an opening that provides access to a small, spring loaded plunger. To remove the floor plate, use a brass rod that is about the size of the little button plunger and fully depress the plunger as far as it will go, about 1/8th inch. While holding the plunger depressed, slide the floor plate and the rod firmly rearward. The floor plate will move back about 1/8th inch only.
- Release the pressure on the plunger and the floor plate will come away from the rifle by the force of the follower spring.

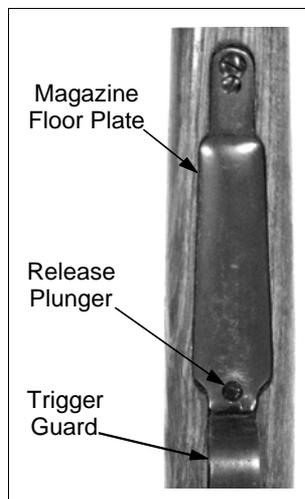


Fig 2 Magazine Floor Plate.

German Mauser K98 Rifle

Lift out the whole assembly as one piece, the floor plate, the follower spring and the follower. (We'll take it apart later.)

- c. Now thoroughly clean out the magazine well with a good quality solvent. Wipe clean the inside of the receiver (where the bolt goes) with solvent and make sure there is no trash or shipping material residue anywhere in the receiver or magazine well.
- d. Take the follower assembly apart for cleaning. Simply slide the flat spring out of the base of the follower and slide the other end out of the top inside of the floor plate. (Thou shalt pay close attention to what thou art doing as the spring will go back into the floor plate and the follower in only **the same way** they came out.) If you put it back together wrong, the follower may jam the cartridges during feeding and that is a bummer (it could also be dangerous!). Make sure you do it right! After you've cleaned all three parts, you can re-insert them into the rifle.

4. Clean the Barrel Thoroughly:

Use a good solvent and keep going at it until you get a clean patch through the barrel. Change patches every time; use one patch one time only. Look through the barrel from the breech end and the barrel should be sparkling clean with the spiral grooves clean and sharp! This is a tribute to the quality of your rifle. The cleaning rod under the barrel is screwed into position. It alone, is too short to clean the barrel. Soldiers, together, screwed two rods together, to make one long one and then cleaned both rifles as the rod is too short by itself. We suggest you simply buy a one piece rod to clean the barrel and leave the original one screwed in tight, right where it is (and where it belongs).

5. Clean the Receiver.

Thoroughly clean the trigger sear, the locking lug recesses, the slide ways and all of the surfaces inside the receiver.

6. Disassemble and Clean the Bolt:

The preservative grease inside the bolt will cause the rifle to fail to fire. To clean the bolt, you must become knowledgeable about its disassembly and reassembly. You may require some help here as this is somewhat difficult (it requires some strength in your hands and you are dealing with a very powerful firing pin spring, **so pay careful attention**).

- a. Check the position of the safety lever. It should be in the vertical (upright) position. If it isn't, put the bolt back in the rifle and close it. Swing the safety lever up to the vertical position. Then remove the bolt from the rifle and proceed.
- b. Separate the firing pin assembly from the bolt body as follows. Observe the small spring-loaded plunger on the rear of the bolt opposite the bolt handle. It is the Bolt Sleeve Lock Plunger. Grasp the bolt in your left hand and with

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your left thumb, push in the plunger. With your right hand, grasp and turn the whole rear assembly counter clockwise. After one or two complete turns, the rear assembly will turn easily without pressure on the locking plunger. Unscrew the assembly and lift the firing pin assembly out of the bolt body. You will likely find it covered with protective grease, which would likely cause a failure to fire. Soak both the entire empty bolt body and the firing pin assembly in solvent.

- c. Notice that the bolt body has two gas vents in the bottom of the bolt body. These serve two purposes. First, they serve as the primary gas escape holes in case of a cartridge failure and second, they are two lubrication ports giving you access to the whole bolt internally because you won't want to take it apart very often.
- d. Clean the bolt body:
 - i. Swab the interior of the bolt body. Make sure there is no dried grease left inside.
 - ii. Clean all of the little nooks and crannies. A tooth brush is handy. Carefully inspect everything.
 - ii. Observe the long claw extractor. It should easily rotate around the bolt through the full range of its guide slot. Do not remove the extractor. Simply clean it. Restore it to its original position in line with the locking lug, otherwise you won't be able to get the bolt back into the rifle.
- e. Clean the Firing Pin Assembly:

Notice that the firing pin is in the cocked position, the very powerful firing pin spring being compressed and held in position by the safety lever. Do not attempt to release the safety. Normally this assembly can be cleaned without further disassembly. Soak the assembly in solvent and then wipe, brush, and blow it clean.

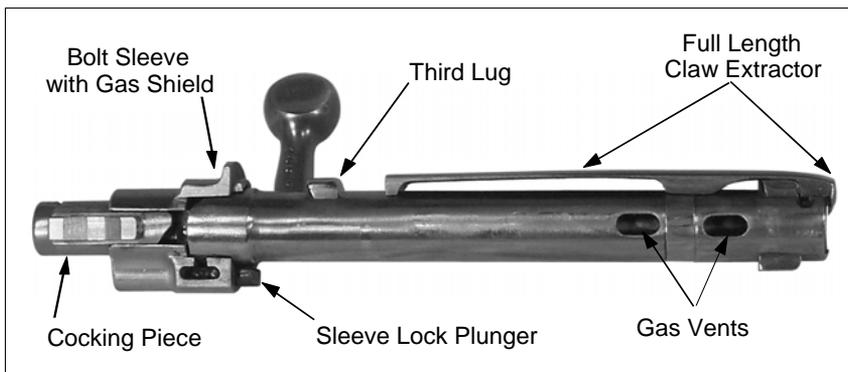


Fig 3. Bolt Assembly, Bottom View.

German Mauser K98 Rifle

Further disassembly is difficult and not normally necessary. Also there is some risk of bending the firing pin. Skip the following italicized steps unless you have a real reason to completely disassemble the Firing Pin Assembly.

- f. *Disassemble the Firing Pin Assembly, which consists of the Firing Pin, the **highly compressed** Firing Pin Spring, the Bolt Sleeve, and the Cocking Piece.*
 - i. **Caution:** Notice that the firing pin protrudes about 2" beyond the front of the compressed spring. **Be careful not to bend it when compressing the spring.** Do not apply force to the tip of the firing pin. It is best if you have a work table or a block of wood with a small hole into which the front of the firing pin will fit, right up to the squared off enlarged portion just in front of the spring. (If this is not available to you, do not proceed.)
 - ii. **Caution:** From this point on you will be dealing with a highly compressed and powerful spring. **You must wear eye protection.** If you don't have it, stop the procedure until you get eye protection because you will be decompressing and compressing the spring (in the re-assembly process).
 - iii. **Compress the spring:** With the firing pin inserted into the work table hole, firmly grasp the bolt sleeve while leaving the cocking piece free to move. This takes considerable pressure and strength. Exert downward pressure on the bolt sleeve, compressing the spring until the cocking piece can be freely turned 90 degrees in either direction (you may well need some help here).
 - iv. **Remove the cocking piece:** With the cocking piece turned 90 degrees, you can slowly relax your downward pressure on the spring tension and the whole assembly will come apart. The firing pin and its spring will come apart (you can see how powerful it is) as well as the bolt sleeve and safety lever. Swing the safety lever over to full right (otherwise it won't come off) and then pull it straight back. It will come right out.
 - v. Now you can clean everything in detail. You won't want to disassemble the bolt too often (for obvious reasons). You can see that the firing pin and its spring live deep inside the bolt body so you want a light film of oil over the entire surface of all parts; especially inside the bolt body. Never use grease inside the bolt, it could cause a failure to fire.
- g. *Re-assemble the firing pin assembly.*

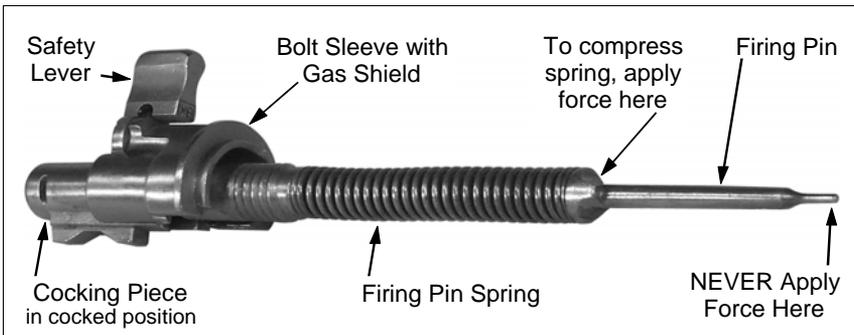


Fig 4 - Firing Pin Assembly.

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- i. *Insert the safety lever into the bolt sleeve with the lever going in at the full right position (otherwise it won't go) and then swing it up to the vertical position and keep it there during bolt assembly. The vertical safety position is necessary for bolt assembly, and in that position it can be used as an additional surface to apply force when compressing the firing pin spring in the next step.*
- ii. *Put the firing pin spring back onto the firing pin and put the firing pin tip into the worktable hole. Slide the bolt sleeve assembly over the rear of the firing pin. It can go on only two ways, because the firing pin has flat sides.*
- iii. *While you hold the spring almost fully compressed, install the cocking piece over the firing pin. It too will slide on two different ways, but after you rotate it to lock it on, the sear must be oriented so that it slides into the corresponding slot in the bolt sleeve.*
- iv. *Make sure the safety lever is in the vertical position. If it is not, compress the spring again and turn the safety lever to the vertical position. The bolt is now 'cocked' because the spring is compressed and ready for installation into the bolt body.*

Now that you have seen some of the internal parts, you can appreciate the superior engineering and extra strength built into your rifle. Now you can begin the reassembly process.

Reassembly:

1. Reassemble the bolt: Make sure the firing pin assembly is 'cocked' with the safety lever in the vertical position. Insert the firing pin assembly into the bolt body and turn it clockwise until the bolt sleeve stop plunger engages the bolt body and prevents further rotation. On the final one or two turns, it may be necessary to compress the plunger so it will clear the bolt handle.
2. Re-install the Magazine Follower Assembly. Fit the follower through the magazine well. Notice that the front of the floor plate has a lip cut into the leading edge. This lip will fit into the front of the lower edge of the magazine well when assembled. There is a similar arrangement at the rear of the floor plate around the plunger hole. To assemble it, position the floor plate slightly to the rear of the assembled position, press down on the rear of the floor plate to compress the plunger, and slide the floor plate forward so that both the front and rear lips of the floor plate engage the slots in the magazine well. The plunger should spring into the hole in the rear of the floor plate, thereby locking the floor plate in place. Only moderate pressure is required to do so.
3. From the top, make sure the follower is in position and moves up and down freely. Its job is to lift cartridges so it must be free.
4. Re-insert the bolt assembly into the rifle. Make sure the claw extractor is lined up with the right-hand locking lug, or it will not go in. After the bolt is started into the rifle, but before you can close it further, you may have to

German Mauser K98 Rifle

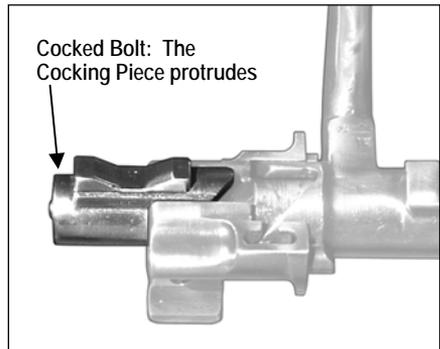
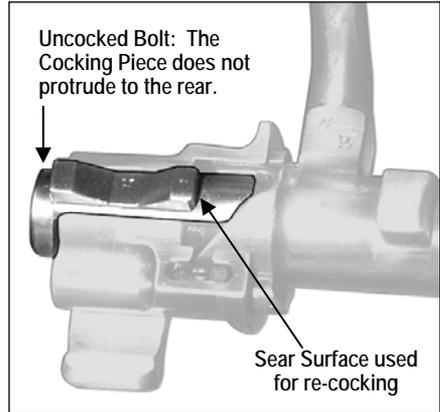
depress the magazine follower. Confirm the proper working of all functions: bolt open and close, safety lever in all positions, and trigger.

5. Wipe all sections of the rifle free of preservative grease in and around the rear sight and the forward metalwork. Carefully wipe away all preservative grease and lay on a thin film of oil; even on the wood.

Re-Cocking the Bolt

If the bolt is not cocked, you will not be able to either disassemble the bolt or put it in the rifle to cock it. If you try to put an uncocked bolt into your rifle, you will probably succeed in putting an ugly scar on the wood stock just behind the rear tang, because the gas shield will dig into the wood! Remember, two things are required before putting the bolt into the rifle: (a) the bolt must be cocked, preferably with the safety lever vertical, and (b) the gas shield must be screwed all the way onto the bolt body and locked by the plunger.

1. Turn the bolt upside down and identify the cocking piece and the sear surface as pictured to the right.
2. Hook the forward side of the sear surface on something substantial, like the underside of your workbench, as shown to the right.
3. Pull on the bolt body so that the cocking piece comes out of the bolt body/gas shield. You'll have to pull hard, you are compressing the firing pin spring.
4. When the cocking piece is out far enough, rotate the safety lever to the vertical position. The bolt is now cocked.
5. Before putting the bolt into the rifle, also make sure that the bolt sleeve/gas shield is fully screwed onto the bolt body and the stop plunger engages the bolt body as described on page 16.



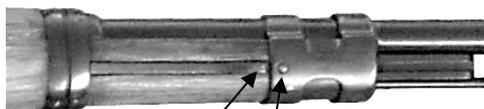
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Removing the Stock from the Barreled Action

Our recommendation is: **Do Not remove the stock!** You run the risk of damaging or scratching something. There is normally no need to remove it. There are no parts needing service. Normal attention to gun care will go a long way toward preservation and will also prevent rust between the wood and the metal.

If you must, here is how to do it:

1. Safety First!
 - a. Make sure the rifle is unloaded and remove all ammunition from the area.
 - b. Remove the bolt with the safety lever in the upright position as described on page 12.
 - c. Check the chamber to make sure there is not a round in the chamber.
 - d. Remove the magazine floor plate, spring, and follower as described on pages 12 & 13.
2. Remove the cleaning rod by simply unscrewing it and pulling it straight out.
3. Remove the wide front barrel band. Notice that it is connected to the narrow rear barrel band by a steel bar that is actually a long spring located between the barrel bands on the right side. The forward end of this spring has a pin that engages the front barrel band. On the spring, just aft of the front barrel band, there is a raised surface. Pressing on this surface will depress the spring, which will disengage the pin from the front barrel band, which will then allow the front barrel band to be tapped forward and removed. Be Careful NOT to Scratch wood or metal when removing the band!



Depress Spring Here. Until Pin releases the band.

Depress the spring with a suitable tool, such as large vice-grips or a C-clamp. Whatever tool you use, protect your rifle with a heavy cloth or a piece of leather so the tool does not actually touch the rifle. This will prevent scarring the wood or metal of the rifle. Engage the raised surface of the long spring and encircle the stock just behind the barrel band. Exert enough pressure until you see that the locking pin is out of its hole in the front barrel band.

German Mauser K98 Rifle

With the spring depressed, gently tap the band forward, using a brass punch or a wooden block to make sure you do not scratch anything. Tap it completely off and remove it. It is not difficult.

4. Release the tool compressing the spring and lift the spring out.
5. Tap the rear barrel band off just like the front one. BE CAREFUL not to scratch the wood. You may have to tap a little on one side and then a little on the other side.
6. The Upper Handguard will fall away when the rear barrel band is removed.
7. Remove the Trigger Guard/Magazine Well. It is held in place by two large screws and two locking screws. Remove the locking screws and remember where they came from. They are NOT interchangeable. The front lock screw goes only in the front locking hole and the rear lock screw only goes in the rear-locking hole. Remove the front and rear screws from the trigger guard.

Grasp the trigger guard and lift it out of the stock. It will come straight out. Lift the stock away from the action and barrel. It will lift right off. If it is tight, wiggle it back and forth as you lift.

8. Separate the stock from the barreled action, if they haven't already fallen apart. There is a steel cylindrical spacer associated with the rear trigger guard screw inside the rear screw hole in the stock. Do NOT lose it! It is vital for accuracy. The equivalent front spacer is actually 'built-in' to the front of the trigger guard; therefore you can't lose it.

If you wish, you may take out the trigger assembly. Do so by driving out the trigger hinge pin around which the trigger 'rotates'. Naturally it doesn't 'rotate' very much, about 10 degrees. The hinge pin comes out easily but still must be driven out with a small punch.

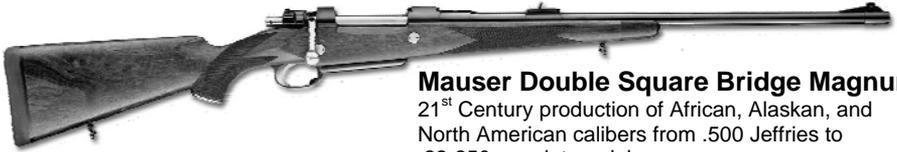
Once out, the trigger frame and assembly will literally fall out of the receiver; it is that well designed. It has a small coil spring that lives in a small cavity in the trigger frame. The spring is small and easy to lose. It is also expensive to replace so be careful. The spring is the trigger return spring. Without it the rifle will fail.

Congratulations...you have now stripped the Mauser Model K98.

To Reassemble, simply reverse the procedure.

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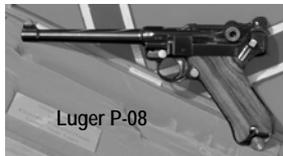
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