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THE MAUSER MONTHLY  
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The newsletter for fans of Mauser rifles - the REAL "Rifleman's Rifle!"  
Editor/Publisher - Ward M. Clark, Aurora, Colorado, USA

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Reader's Comments

I bought an interesting Mauser '98 barrel in a bundle of barrels at an auction. It is a lightweight barrel in 5.6 x 52 (.22 Savage Hi-Power), a rimmed round. It has express flip-up sights and a built-in front sling swivel.

What is really interesting is that it has Nazi proofs. There are two Nazi eagles, one above a letter "N" and another above a letter "J". There is also the number "242" (factory code?), and a heart with the pointed end upward with a tree inside. On the side is the name "SEYFFARHILAUFG", or so I think, the tops of the letters are very light.

It sounds like this might be off of some custom rifle made for some VIP in Germany during the Nazi era. Has anybody heard of anything like this?

Michael Wuchitech  
Mikew127  
mjw@mcs.com

Ward:

Was thumbing through the latest SHOTGUN NEWS and found the following ad on page 153...TRIGGERGUARDS QUICK RELEASE FLOORPLATE. All steel construction, milled, with a custom release allowing the quick release of the floorplate for fast unloading and cleaning. all blued. Condition Very Good to Excellent.

Available for ;Swedish M94,96,38 Chilean 95 Spanish M93 Mexican short 98; Only \$14.95. Source Hunter's Lodge Corp. Sounds a lot better than those \$40 lumps of crud that we got from GPC doesn't it? Just thought someone might be interested. Have ordered two pieces and let them know that it is for sampling by a large network of Mauser aficionados. I hope that will ensure a little care on their part when it comes to selection. When I was at school, my roomie and I ordered a few things from Hunter's Lodge and were disappointed about 50% of the time with substandard quality and gross overgrading of condition. Forgive me if it sounds elitist but I am highly suspicious of ads that persist in spelling Cavalry as Calvary and putting little sidebars proclaiming "Jesus is Lord." will keep the network posted on sampling of parts and would put out a request for advice on scope mounts for pre 98's. I am a little apprehensive about trying to drill and tap the receiver over the chamber area and would appreciate suggestions on the safest way to do this. Those receiver rings are reputed to be harder than a bar hooker's heart.

Leyteno@aol.com

(Editor's response) Anybody got any suggestions? I've always just drilled and tapped for a standard Weaver or Redfield base. Even a Weaver side mount drills over the chamber area, just on the side. Maybe one of the mounts that replaces the rear sight leaf? Check out this issue's article by jphelps@handel.jlc.net (Joel Phelps), Mauser 96 Scope mounting info.

-ward

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Sporterizing the 96 Swedish - part 3 of 4  
by WClark1046@aol.com (Ward M. Clark)

Last month I described the receipt of the reworked barreled action from the Colorado School of Trades in Lakewood (for those of you who have asked, the School does not accept out-of-state work.) It was and is impressive. Having a Swede that cocks on opening is something to get used to, though.

I had obtained a Choate Machine Tool stock, a nicely turned out Monte Carlo style sporter stock with a matte black finish, sling swivels and a recoil pad fitted. I replaced the fixed swivels with a pair of Uncle Mike's QD swivel studs, as I am a regular user of Harris bipods, which attach to the QD stud on the fore end. The Choate stock was advertised as a "drop-in", and having installed these on stock M-38's I can testify that normally, they are. However my little Swede had three features that required additional inletting: the side scope mount, the Dayton Traister modular trigger, and the new bolt handle.

The Weaver side mount required removing material on the left hand side of the stock right at the receiver sidewall. I accomplished this with a Dremel flexible wand tool, some 150 grit wet-dry sandpaper and finally 00 steel wool. The stock had color impregnated all the way through the material, so no touch-up of the black finish was required.

Again with the Dremel, I removed a small amount of material from the bolt handle recess on the right hand side of the stock, deepening the recess by about .05". This to allow the new bolt handle to close fully. Finally, the modular trigger required the removal of quite a bit of material on the interior of the stock - I achieved this by simply using a round .10" rotary tool on the Dremel and hogging out around the stock trigger recess until the trigger functioned freely when the action was fitted to the stock.

After the stock was mounted and the action screws torqued down, the barrel free-floated from the fore end tip back to the first step from the receiver ring. Keep in mind that I used the issue barrel. I mounted a Simmons 3X9X32mm scope in the Weaver mount, and I had a very trim little sporter. My daughter was very pleased as well.

Next month - range work and load development!

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Mauser 96 Scope mounting info  
by jphelps@handel.jlc.net (Joel Phelps)

I have used two home grown methods to mount scout scopes on Mauser 96's. One replaced the rear sight leaf with a mounting block that accepted conventional sight bases. The other involved removing the rear sight completely and using a Contender sight base directly attached to the barrel. Attaching the base directly to the barrel works especially well since the eyepiece of my Leupold 2X pistol scope just barely clears the receiver ring. This eliminates the need for lace on cheek pieces etc.

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BTW, I also chopped my M96 barrel to 22" and grafted on a front sight and muzzle protector from an Argentine built 1909 carbine (These 1909's are really nifty looking but mine had a stock that looked like it was made in China). The final item was bedding the action and floating the barrel - while retaining the hand guard and full length wood.

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The Federal Ordnance 98/03 - a Mauser hybrid?  
by Mikew127@aol.com

Being a do-it-your-selfer, I enjoy looking over tables at guns shows for interesting looking parts. At one show, I found a receiver for a very unusual Mauser variant. It was a Federal Ordinance (FedOrd) model 98/03. It is a Mauser '98 receiver that was designed to use a Springfield '03A3 bolt.

At first glance, it looks like a Mauser '98 with a rear receiver bridge off of a Springfield '03. The front looks like a large ring Mauser, except for a gas port on the left side (ala Springfield '03A3). The top of the receiver is factory drilled and tapped for telescopic sights.

The receiver appears to be investment cast, instead of forged. There is a casting seam on the left side of the receiver wall, and the receiver has a black dull texture that is common of investment cast metal. On the front receiver ring is a Birmingham England proof mark.

There is no thumb slot on the left side of the receiver wall, and instead of an extractor box, there is a blued, machined metal assembly approximately the same size bolted to the side with an allen screw. The rear portion of this assembly has a push button bolt release. This unit also contains the extractor.

The bottom of the receiver has a smooth stud cast in it just behind the magazine well. This stud is 5/16 inch diameter by 5/16 inch long and flat on the magazine well side. I don't know what the purpose of this is, since it gets in the way of a standard Mauser trigger, and of the Parker Hale target trigger assembly that came with it. The Parker Hale trigger assembly needs a 1/8 inch notch cut into it for clearance.

The inside of the breech looks like a Springfield '03. The barrel is tightened to bear on the shoulder of the barrel like a Springfield '03 instead of the barrel face as a Mauser '98 does. The breech does use Mauser '98 threads. The instructions tell you that have to back the shoulder of a commercial '98 barrel (one with a shoulder) off so it is 0.715" as opposed to 0.645" for a standard large ring Mauser '98.

Inside of the rear of the receiver, there is a slot like a Mauser '98 has for the third locking lug, except that it is too shallow (hasn't been machined out?)

This a new receiver with the original installation instruction sheet. The dealer got this receiver from an estate sale. The instructions sheet that came with it identify it as a Federal Ordinance 98/03 Receiver, and they specify a '03A3 bolt with a modified striker assembly.

They instruct you to modify the striker assembly as follows:

- Cut the knob of the cocking piece off, and unscrew the remaining portion. Machine the remaining firing pin assembly down, thread it, screw on the new cocking piece and put in a locking set screw.

The only reason that I can think of for using a Springfield '03 bolt is cost. It is still easy to buy surplus '03A3 bolts (without the firing pin assembly), still in the wrapper for \$9.00 - \$10.00.

The instructions probably specified a Springfield '03A3 bolt because early Springfield '03's had the gas port on the right side of the receiver. Later Springfield '03's had the gas port on the left side of the receiver. The receiver had the gas port on the left side.

□  
Unfortunately, Federal Ordinance has gone out of business, so I cannot get any information about this action from them.

Has anyone else out there ever heard of an action like this? I remember hearing that Parker Hale sold investment cast actions based on the Mauser '98 some time ago. With the British proofs, I wonder if there could be a connection?

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Trigger Guard Assemblies; Restoration by Arc welding  
- Leyteno@aol.com

Bought a trigger guard assembly from Gun Parts and got a badly pitted and very rusty hunk of junk? Maddier than hell and feel that you've been had? Fear not, for the same was done unto me and the following solution was found. No way I was going to get in a hassle with these people as they will never see me again anyway.

I boiled the assembly in a very strong baking soda solution to remove the big chunks and then simmered in a citric acid solution of 2 tbsp citric acid per quart of water and removed most of the surface crud and corrosion. Rinsed in a baking soda solution again to remove a faint yellowish sheen and placed in plain boiling water for a few minutes. This came out of the pot and dried almost instantly. With my trusty Dremel tool I used a steel brush to touch up a few spots and dig the corrosion out of some of the deeper pits. Took it to a friend who is a true artist with an arc welder who popped tiny amounts of metal into the pits and ground the weld spots flush. Back to the Dremel tool using 400 grit paper to smooth things out and finished with a felt wheel and jewellers' rouge. Shines like a mirror and I can hardly wait to see what it looks like after bluing. Total cost to me? About \$10.00US and some old welding and brazing rods that I had no use for. Worth it? You betcha!

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Descriptions of the Various Mauser Rifle types -  
Jwrawles@aol.com (Jim Rawles)

For full details on Mausers, see the book Mauser Bolt Rifles by Ludwig Olson. But here is a description of smokeless powder era (but still pre-1899 antique) Mausers, in a nutshell:

Model 1891: Single column magazine (5 rd.) that protrudes below the stock (like on a Carcano), small ("tab") extractor, small ring diameter barrel, usually chambered in 7.65 mm Argentine Mauser (also sometimes called 7.65 Belgian Mauser. You may also see it labelled as 7.65x53 or 7.65x54. This is a relatively hard to find cartridge. None of the major North American manufacturers load for it. Ballistically, it is a good cartridge (about like a .300 Savage). Right now, the only maker of soft nose (boxer primed) 7.65 Argentine ammo is Norma. It sells for about \$25 a box. There is also quite a bit of Berdan primed (non-corrosive) original Argentine military full metal jacket ("ball") available. It is packed in boxes of 15 rounds, and sells for only about \$6 a box.

Model 1893/1894/M1895/M1896. This was the first modern-style Mauser action. Used by Brazil, Chile, Sweden, Spain, Turkey, and several other countries. Double column magazine (5 rd.) that does not protrude. It has a full length extractor that is much larger than that of the M1891. (It is very similar to the Model 1898 extractor).

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An aside: This is the same extractor that Winchester just put back on its Model 70 rifle. (They had this style extractor on their pre-1964 model 70s.) They are touting it a some radical new development called "Positive Feed". Actually, the guys at Winchester just re-adopted a 102 year old Mauser design. (Those dweebs!)

□  
The Model 1893 through 1896 were essentially low-pressure actions. Like the M1891, they are small ring Mauser actions. Most are chambered in 7 x 57 Mauser or 6.5 x 55 (Swedish) Mauser, which are relatively low-pressure smokeless cartridges. However, many of these guns (mainly Turkish contract 1893s and a few Spanish and Chilean Model 1895s) were re-heat treated and arsenal upgraded to 8 x 57 mm Mauser, .308, and even .30-06. These particular ones are perfectly safe rebarrel and to shoot in moderate pressure chamberings like: .250 Savage, .300 Savage, 6.5 x 55 mm (Swedish) Mauser, .35 Remington, and 7x57 mm. Some folks still re-barrel re-heat treated examples Model 1893/94/95/96s to higher pressure chamberings like .243, 6mm Remington, .257 Roberts, and .308. I used to do this as well, but have discontinued making up these rifles due to concerns about liability lawsuits. (Even if it was a remote possibility, I wanted to err on the side of caution.)

Larry Ellis was nice enough to provide the following info on the Chilean contract Model 1895 Mausers produced by Ludwig Loewe of Berlin and DWM:

Contrary to popular belief, the M1895 "Chilean" did \*not\* have a third safety lug like the Model 1898 Mausers. To quote Olson's "Mauser Bolt Rifles":

"... Another feature of the Chilean Model 95 action was a shoulder on the receiver a few thousandths of an inch behind the bolt handle. The bolt handle would engage this shoulder and serve as a safety lug if the locking lugs would let go." The third locking lug (or in the case of the Chilean M95, the receiver shoulder) comes into play only \*after\* there has been a catastrophic failure of the bolt. They are intended to protect the shooter from being hit in the face by the bolt after both locking lugs have been sheared off. This arrangement was not considered an adequate safety feature and was replaced by the third locking lug on the Model 1898 Mauser. (See description below.)

If you want to build a sporter on the M1893/94/95/96 type action, I recommend the Model 1893 receivers that were originally made in Oberndorf, Germany under contract for the Turkish government. These are currently available at very reasonable prices from Century International. Production for this contract ended in 1897, so ALL of these receivers are legally antique. (I'd be happy to send anyone who requests it a hard copy of a BATF letter that confirms this, and also states that sporterizing or re-barreling or re-chambering them does not change their exempt status.)

The M1893 Turkish actions are currently the best choice because they are as I already stated, very inexpensive, and because they were all made before 1898, and because they were re-heat treated in the 1930s, when they were arsenal rebarreled from 7.65 mm Belgian Mauser to 8 x 57 Mauser. This makes them a bit stronger than other pre-1899 Mausers.

Because 1893/94/95/96-series rifle production spanned the the legal "antique" threshold (Dec. 31, 1898--under the U.S. Gun Control Act of 1968), not all of them are legally antique. Some of them, like the Swedes, are clearly marked on the receiver bridge with the year of manufacture. So are many of the Mausers made in Spain. I wish that they all were, because it would make identifying "antiques" vs. "moderns" a lot easier.

The Model 1898 Mauser was a slight improvement over the M1893-to-1896. It uses a "large ring" barrel (about .20 inches larger diameter in the thread diameter), and virtually all M1898s are high pressure actions. Most are also about .30 inches longer in bolt throw than the M1893/95 series, making them capable of accepting very long cartridges (like .270 and .30-06). Combined, this has made the model 1898 a natural for building sporters for the North American market for many years. This was the most successful Mauser, with total production of over 100 million rifles. It also had the largest number of variations.

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 At one time or another almost all the world powers have produced a copy of the M98. Countries which have produced significant numbers of M98 Mausers include Germany, the Czechs, The Yugoslavs, Hungary, Belgium, Austria, Spain, Argentina, Mexico, China, and the United States. Most of the visible differences between the M1895 series rifles and the M1898 are in the bolt. The M98 cocks on opening (unlike the M88 and M93 which cocked on closing); the gas ports in the bolt were enlarged, the front portion of the bolt shroud was extended to form a larger gas shield, a locking device was added to the bolt shroud to prevent the shroud from unscrewing during firing, a third locking lug (the "safety lug") was added to the bolt, and the shape of both the firing pin and the interior of the bolt body were changed to prevent the tip of the firing pin from protruding through the bolt face unless the bolt was fully closed.

The Model 1896 was originally made for the round nose m/1894 6.5x55 mm bullet. It was replaced by a pointed bullet in 1941. Since the sights were for the round nose the rectangular aluminum plate was added to show how the point of aim, and the distance markings on the sights, had to be changed.

"Sikte for trubbkula" means "Sights for round-nose bullets"  
 "Skjutning med spetskula" means "Shooting with pointed bullets"  
 "Avstand" means "Distance"  
 "Sikte/Rp" (Rp is short for Riktpunkt) means "Sights/Point of Aim"

The figures, i e "100-250 300/-3" mean that at an actual distance of 100 to 250 meters you should use the 300 meter scale on the sights, and aim low (I'd say 3 decimeters, or 1 foot low), since the higher velocity of the pointed bullet means a flatter trajectory. At an actual distance of 400 meters you should use the scale for 500 meters and aim dead-on, and so on.

It seems like the M1896's, with sights for round-nose bullets, were fitted with the aluminum plate during the war, while the Model 1938 carbines (those made after 1941 at least) had sights made for the pointed bullets, and had yellow decals (or aluminum plates) on the stock indicating point of aim for shooting with round-nose bullets.

A round brass disk in the stock tells the exact measurement of the bore. It has a scale that goes from 6.46 mm up to 6.59 mm. The exact bore diameter is marked on the disc with a small triangular mark. The state of the barrel, in three steps, 1, 2 and 3 could also be indicated.

In closing, antique Mausers are fun to shoot, historically interesting, and incredibly well built. They exhibit true Old World craftsmanship! They are also a relative bargain--especially compared to Colts or Winchesters made in the same era. A rifle with comparable fit and finish if built today would cost well over \$1,000. Unlike many other pre-1899 rifles, most M1891 and later Mausers are perfectly safe to shoot, and chambered in modern, smokeless powder, high velocity cartridges.

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| e-mail: Jwrawles@aol.com | - Anonymous                          |

Let me know if you'd like my UPDATED and expanded catalog of shootable antique guns (primarily pre-1899 production "No FFL" Mausers and Winchesters), gun accessories (mainly clips and magazines), ammunition, backpacks, sleeping bags, waterproof gun/gear cases, and coins. (Due to AOL e-mail length restrictions, you'll get the catalog in two parts.) You can also now read my new shareware novel, The Gray Nineties. It is piece of speculative survival fiction about a socio-economic collapse and its aftermath. Hard copies are \*NOT\* available, but you can download a soft copy of the entire text free of charge from the web site at:

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Publisher's Comments

Anyone considering buying a M-1916 Spanish Mauser chambered for the .308 (CETME)? I did, about two years ago. I handload all my ammo, using (roughly) .300 Savage loads. The old gun shoots great - averages 3-4" groups at 100 yards with all issue equipment.

Here's the down side. A few months ago I decided to part with the old Spaniard and put the equity into another project. I followed my usual method - Denver has huge gun shows, at least once a month, so I stuck a "For Sale" sign and the barrel of the old piece and walked it around the show.

I had a lot of people interested. A lot of folks wanted to look at a bolt action .308 for a \$100. However, being the honest and forthright guy that I am, I always asked them, "Do you handload?" They would ask why, and I would explain how the old '93 action was not up to full-house .308 loads, about the .300 Savage loads, offer to provide some data for loads the old gun liked, and so on. At this point they invariably lost interest.

Apparently the greatest appeal of an inexpensive .308 is the vast amount of cheap surplus ammo currently available. I even have a few boxes of Norinco steel-cased .308 ammo around someplace that I bought to run through a friend's FAL. Of course it is all NATO spec, full-power, 52,000 cup ammo, not the 40,000 cup CETME loading.

The point of this whole story? I have decided to keep the M-1916. I don't want to lay awake at night wondering if the bozo I sold it to at a show decided to ignore my warning, stuff the old gun full of full-power ammo, and get messed up by a catastrophic failure of the bolt or receiver ring. Maybe I will find another died-in-the-wool Mauser nut (like all of you readers) to buy the old gun, accepting the load limitation. My advice to all of you? If you are thinking of buying one of these guns, plan on keeping it. The resale potential is not good. Pick up one of the same rifles in 7X57mm, and you can use factory ammo and the resale is better. I gave my Dad a M-1916 in 7X57mm with a scope mounted, and he rolls coyotes over at 150 yards with no trouble.

Enjoy the newsletter - keep those stories and articles coming!

wClark1046@ aol.com (ward M. Clark)  
Aurora, Colorado.on the sights, had to be changed.

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