

# ***FRONT BOLT ACTION ASSAULT SHOTGUN***

## **SPECIFICATIONS:**

CATEGORY ..... IMPROVISED; NOTE: CAN BE  
MANUFACTURED COMMERCIALY  
CALIBRE ..... 410 TO 12 GAUGE; ADAPTABLE  
CAPACITY ..... 8 TO 10 ROUNDS, .410 CAL.  
OPERATION ..... SINGLE COLUMN MAGAZINE  
FEED, MANUAL BOLT ACTION-CAN  
BE MANUFACTURED FOR SEMI OR  
SELECTIVE FULL AUTOMATIC FIRE.

***REMARKS: THIS SHOTGUN IS A REMARKABLE  
IMPROVEMENT OVER CONVENTIONAL BOLT ACTION  
SYSTEMS. POSITIONING ITS BOLT ACTION OPERA TION IN  
FRONT PERMITS FASTER OPERATION, SINCE THE HAND  
THAT OPERATES THE TRIGGER DOES NOT LEAVE ITS  
POSITION. BOLT OPERATION AND MAGAZINE LOADING ARE  
ACCOMPLISHED WITH THE LEFT HAND. THE STRAIGHT  
STOCK CONFIGURATION ELIMINATES EXCESSIVE MUZZLE  
JUMP AND ALLOWS FASTER RECOIL RECOVERY. THIS  
SYTEM IS ADAPTABLE TO HIGH POWERED CENTER FIRE  
AMMUNITION.***

## **TO LOAD:**

Insert the loaded magazine in the receiver until the magazine catch snaps firmly. Magazine capacity will depend on the size and calibre of the weapon.

## **TO FIRE:**

The bolt handle operates the same as in a conventional bolt action system. Tilt the handle 45 degrees upward and pull it all the way towards you. Push the handle back to feed a round into the chamber from the

magazine. A spring operated firing pin will now engage the sear, ready to ignite the cartridge.

The trigger must be released after each shot. This releases the sear to engage with the firing pin lug.

## **SAFETY:**

A safety mechanism is incorporated to block sear movement when applied. The safety lever is operated by the same (left) hand that operates the bolt mechanism and loading.

## **CONSTRUCTION DETAIL:**

***BARREL:*** Improve the barrel (if no commercial barrel is available) from seamless tubing. An enforcement jacket should be employed to strengthen the barrel. Enforce the muzzle with steel sheet molded and formed as the front sight. Both the barrel enforcement jacket and muzzle front sight enforcement should be welded or brazed in place.

Another tube of smaller diameter containing the bolt extension where the bolt handle is housed should be brazed or welded on top of the barrel for solid mating.

***BOLT:*** The bolt must be of good quality steel. It requires some simple machining or can be built by hand, using assorted files, drills, and patience. It should feed reliably when operated.

The bolt is connected to the bolt extension or carrier by means of a connecting block. The bolt is pinned solidly to this block, while the bolt extension or carrier rotates freely when the bolt handle is tilted to load and extract empties. The sole bolt lock is the notch on the bolt extension tube where the bolt handle rests in its downward position.

***TRIGGER HOUSING FRAME:*** The trigger housing frame is a simple formed steel sheet 1/16 inch thick. Form it so that the magazine

can be inserted fully and easily when loaded.

*TRIGGER MECHANISM:* The entire trigger mechanism should be 3/8 inch thick, if possible. It will need spacers to fit properly inside the wide trigger housing.

*GRIP:* The grip is one piece construction made from plastic or wood stock. It is retained in place to the housing frame by a single screw mating with the cross bolt nut on the grip stock.

*RECEIVER REAR COVER - BUTT PLATE:* The receiver rear cover also acts as a butt plate, containing two steel plugs, which are brazed or welded in place. The plate is secured to the receiver by a pin connected to one of the plugs.

#### PARTS LIST

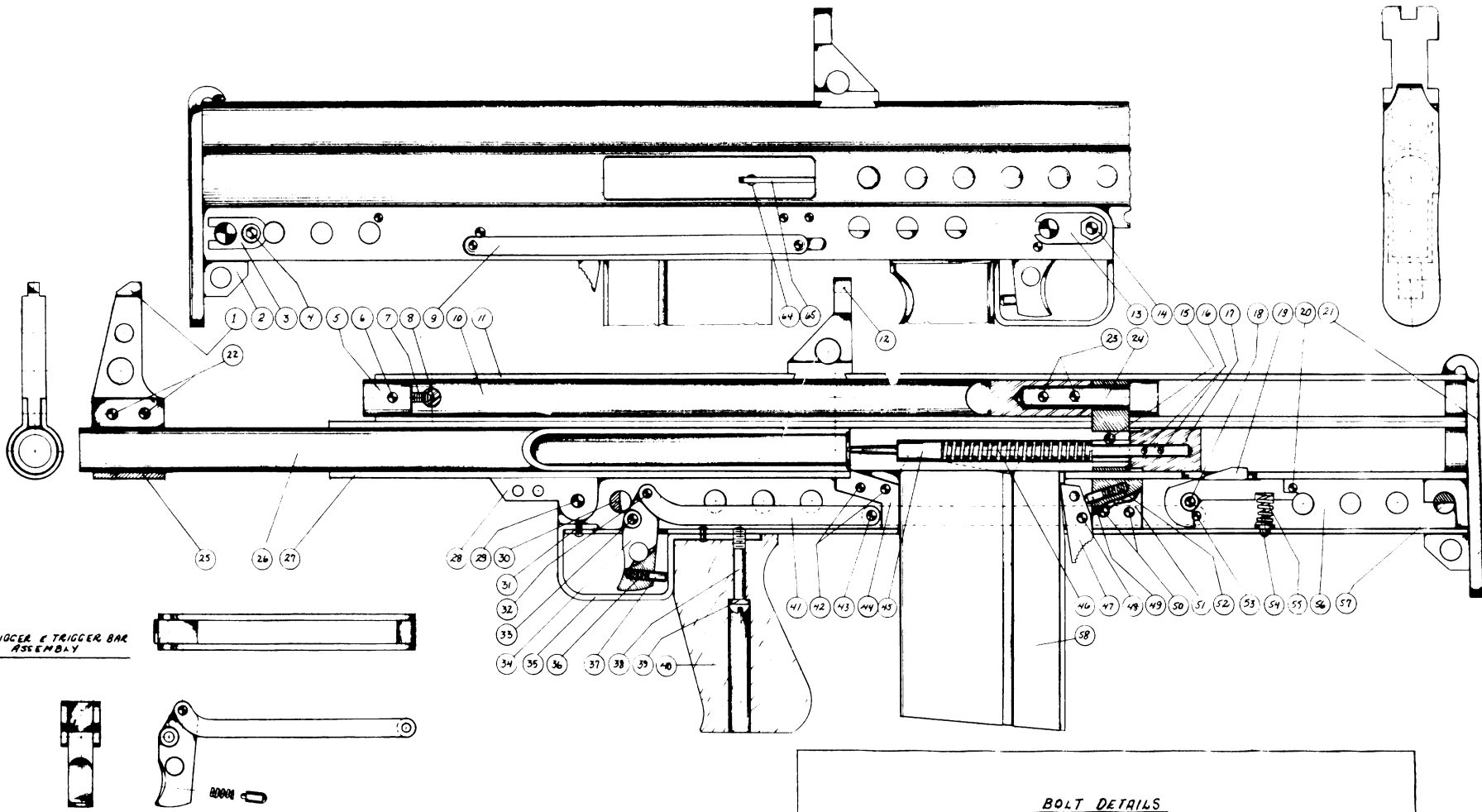
1. *Front sight*
2. *Receiver cover plate lug - secures rear portion of trigger housing (lug is brazed to plate)*
3. *Latch pin retaining plate*
4. *Latch pin retaining plate screw (hex type)*
5. *Cocking handle bolt tube plug*
6. *Plug retaining pin*
7. *Cocking handle retaining screw (headless)*
8. *Cocking handle*
9. *Trigger bar extension link (outside)*
10. *Cocking handle bolt*
11. *Cocking handle bolt tube - brazed to barrel jacket (can also be welded in place)*
12. *Rear sight*
13. *Safety lever retaining plate*
14. *Receiver pivot screw nut*
15. *Firing pin spring plug retaining pin*
16. *Pins connecting firing pin extension to base*
17. *Base of firing pin*

18. *Sear pin with spacers on both sides*
19. *Sear*
20. *Sear stop pin*
21. *Receiver cover plate*
22. *Front sight retaining pins*
23. *Pins connecting cocking handle bolt to bolt carrier securing bolt*
24. *Bolt carrier securing bolt*
25. *Base of front sight - brazed to barrel*
26. *Barrel - brazed to barrel*
27. *Barrel jacket (to support strength of barrel if commercial barrels are not accessible)*
28. *Receiver connecting lug - welded or brazed to jacket*
29. *Receiver / trigger housing connecting screw*
30. *Safety lever pin*
31. *Trigger guard rivet (2)*
32. *Trigger bar connecting pin*
33. *Trigger pin with spacers on both sides*
34. *Trigger*
35. *Trigger guard*
36. *Trigger plunger spring*
37. *Plunger spring*
38. *Grip screw*
39. *Steel washer for screw*
40. *Grip stock (one piece - wood)*
41. *Trigger bar (2 pr.)*
42. *Feed ramp retaining pins*
43. *Trigger bar / trigger bar extension connecting pins (riveted)*
44. *Feed ramp (insert - formed plate)*
45. *Firing pin*
46. *Firing pin spring*
47. *Magazine catch*
48. *Catch pin*
49. *Catch plunger*
50. *Magazine catch plunger assy. base pins - riveted*
51. *Base for plunger assembly (steel plate)*
52. *Magazine catch plunger spring*
53. *Trigger bar extension / sear connecting pin*
54. *Sear spring retaining bolt*
55. *Sear spring*
56. *Trigger housing frame - formed steel sheet*

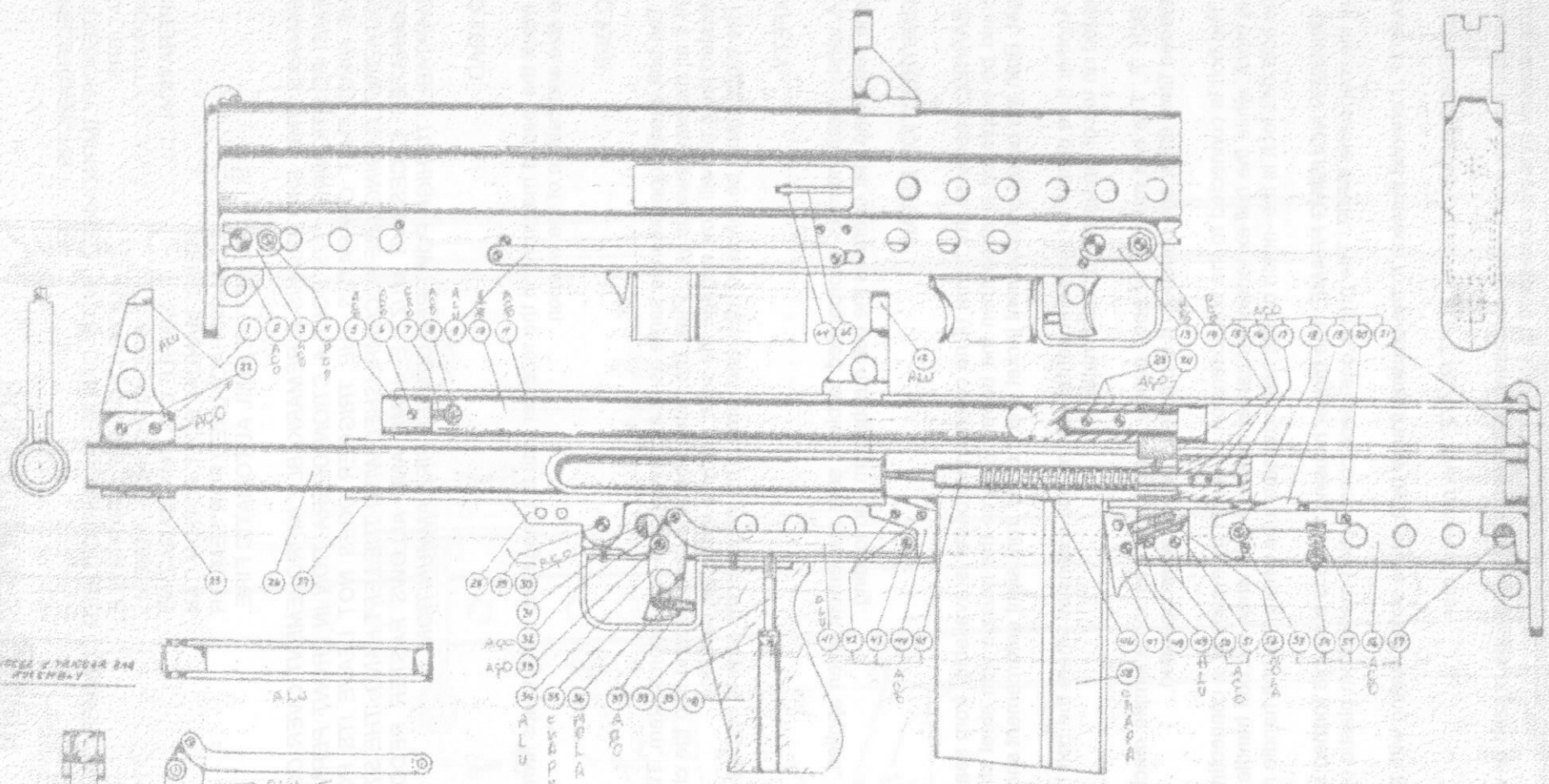
57. *Latch lever pin*
58. *Magazine assembly - (improvised) depending on calibre & capacity required.*
59. *Steel washer*
60. *Cocking handle knob retaining pin*
61. *Cocking handle knob*
62. *Feed ramp pin plate*
63. *Screw (hex type) retaining ejector*
64. *Extractor spring (coil type)*
65. *Extractor*

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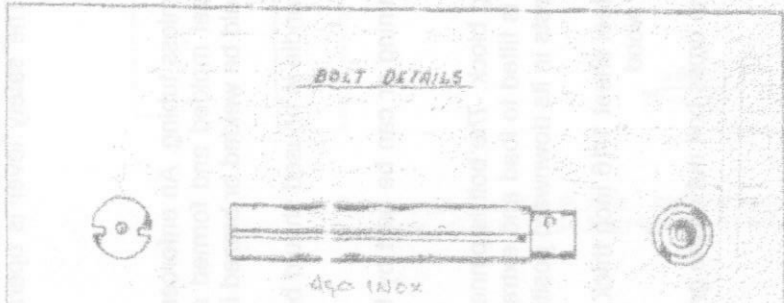
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2. *Receiver cover plate lug - secures rear portion of trigger housing (lug is brazed to plate)*
3. *Latch pin retaining plate*
4. *Latch pin retaining plate screw (hex type)*
5. *Cocking handle bolt tube plug*
6. *Plug retaining pin*
7. *Cocking handle retaining screw (headless)*
8. *Cocking handle*
9. *Trigger bar extension link - positioned on both sides of receiver (outside)*
10. *Cocking handle bolt*
11. *Cocking handle bolt tube - brazed to barrel jacket (can also be welded in place)*
12. *Rear sight*
13. *Safety lever retaining plate*
14. *Receiver pivot screw nut*
15. *Firing pin spring plug retaining pin*
16. *Pins connecting firing pin extension to base*
17. *Base of firing pin*
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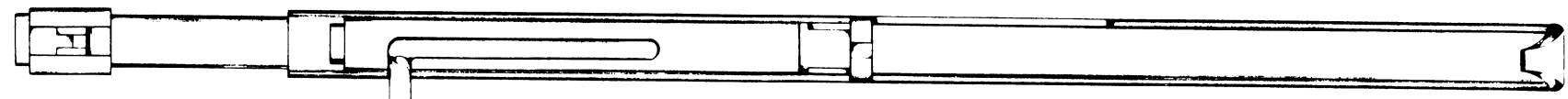
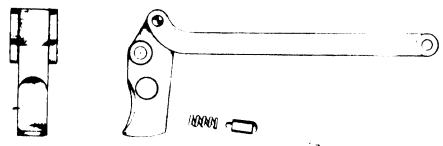
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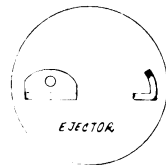
TRIGGER & TRIGGER BAR ASSEMBLY



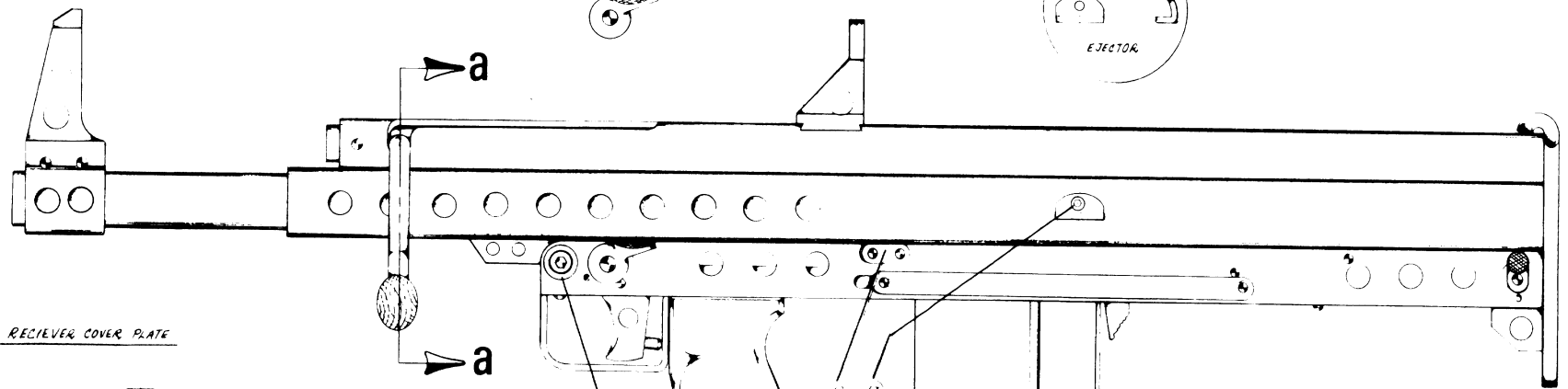
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ASSEMBLY



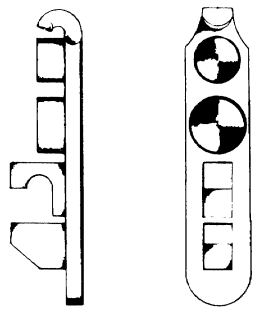
SAFETY LEVER  
COMPONENT



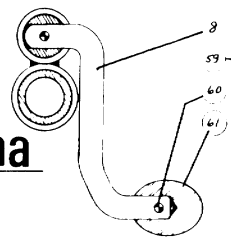
EJECTOR



RECEIVER COVER PLATE



SECTION-aa



62 63



RECEIVER COVER PLATE RETAINING LEVER;  
ALSO RECEIVER DISASSEMBLY LATCH LEVER