

INDEX

UNITED STATES MAGAZINE RIFLES - MODELS 1892 - 1896 - 1898

PARTS BY PATTERN, MODEL AND VARIATION

<u>Barrel/Sight Group</u>	<u>Page</u>
Barrel	1
Front Sight Blade	1
Front Sight Pin	2
Front Sight Stud	2
Rear Sight Assemblies	2
Model 1892	2
Rear Sight Base	2
Rear Sight Base Spring	2
Rear Sight Leaf	3
Rear Sight Joint Pin	3
Rear Sight Slide Block	3
Rear Sight Slide Cap	4
Rear Sight Slide Cap Screw	4
Rear Sight Slide Catch	4
Rear Sight Slide Catch Spring	4
Rear Sight Base Screw, front	4
Rear Sight Base Screw, rear	4
Model 1896	5
Rear Sight Base	5
Rear Sight Base Spring	5
Rear Sight Leaf	5
Rear Sight Joint Screw	5
Rear Sight Slide	5
Rear Sight Slide Cap	6
Rear Sight Slide Spring	6
Rear Sight Slide Pin	6
Rear Sight Slide Screw	6
Rear Sight Slide Cap Screw	6
Rear Sight Base Screw, front	6
Rear Sight Base Screw, rear	6
Model 1898	7
Rear Sight Base	7
Rear Sight Base Spring	7
Rear Sight Leaf	7
Rear Sight Joint Pin	7
Rear Sight Slide	7
Rear Sight Slide Plunger	8
Rear Sight Slide Plunger Spring	8
Rear Sight Slide Screw	8
Rear Sight Slide Pin	8
Rear Sight Eyepiece	8
Rear Sight Eyepiece Screw	8
Rear Sight Eyepiece knob	9
Rear Sight Eyepiece Knob Pin	9
Rear Sight Base Screws, front & rear	9

	<u>Page</u>
Model 1901	9
Rear Sight Base - Fixed	9
Rear Sight Base - Movable	10
Rear Sight Base Bushing	10
Rear Sight Base Screw, front	10
Rear Sight Base Screw, rear	10
Rear Sight Base Spring	10
Rear Sight Base Spring Screw	10
Rear Sight Movable Base Locking Lever	11
Rear Sight Movable Base Locking Lever Screw	11
Rear Sight Joint Pin	11
Rear Sight Leaf Spring	11
Rear Sight Leaf	11
Rear Sight Slide	12
Rear Sight Slide Cap	12
Rear Sight Drift Slide	12
Rear Sight Drift Slide Stud	12
Rear Sight Slide Cap Screw	12
Rear Sight Slide Screw	12
Rear Sight Slide Pin	12
Model 1902	13
Rear Sight Base	13
Rear Sight Base Spring	13
Rear Sight Leaf	13
Rear Sight Joint Pin	13
Rear Sight Eyepiece	14
Rear Sight Eyepiece Screw	14
Rear Sight Eyepiece Knob Pin	14
Rear Sight Eyepiece knob	14
Rear Sight Peep Plate	14
Rear Sight Slide	15
Rear Sight Slide Shoe	15
Rear Sight Slide Plunger Spring	15
Rear Sight Slide Plunger	15
Rear Sight Slide Screw	15
Rear Sight Slide Screw Pin	15
Rear Sight Peep Plate Screw	16
Rear Sight Base Screw, front & rear	16
<u>Receiver/Bolt/Magazine Group</u>	17
Receiver	17
Bolt	23
Sleeve	25
Securing Stud	26
Securing Stud Rivet	26
Extractor Screw	26
Extractor Rivet	26
Cocking Piece	27
Firing Pin	27
Striker	28
Main Spring	28

	<u>Page</u>
Extractor	29
Extractor Pin	30
Extractor Spring	30
Safety Lock	30
Safety Lock/Spindle	30
Safety Lock Pin	31
Safety Lock Spring	31
Safety Lock Spring Spindle	31
Ejector	31
Ejector Pin	31
Guide Lip	32
Guide Lip Rivet	32
Side Plate	33
Side Plate Screw	34
Gate	34
Hinge Bar Pin	36
Hinge Bar Head	36
Magazine Spring	37
Carrier	37
Follower	38
Follower Pin	38
Cut-Off	38
Cut-Off Spring	39
Cut-Off Spring Spindle	39
Trigger	39
Trigger Pin	40
Sear	40
Sear Spring	40
 <u>Stock/Mounting Group</u>	
Stock	41
Handguard	43
Handguard Springs, front & rear	44
Handguard Rivets, front & rear	44
Guard	45
Guard Screw, rear	45
Guard Screw, front	45
Butt Plate	45
Butt Plate Cap	46
Butt Plate Cap Spring	46
Butt Plate Cap Spring Screw	46
Butt Plate Cap Pin	46
Butt Plate Screw, large	47
Butt Plate Screw, small	47
Ram Rod	47
Ram Rod Stop	48
Cleaning Rods, first & second sections	48
Cleaning Rod Head, third section	48
Butt Swivel	48
Butt Swivel Pin	48
Butt Swivel Plate	48
Butt Swivel Screws, front & rear	49
Upper Band	49

	<u>Page</u>
Upper Band Screw	50
Stacking Swivel	50
Stacking Swivel Screw	50
Lower Band Swivel	50
Lower Band Swivel Screw	50
Lower Band	50
Lower Band Pin	50

Barrel/Sight Group

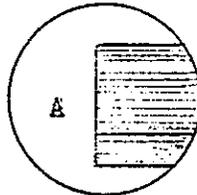
BARREL

Pattern 1 - Model 1892



Parts List

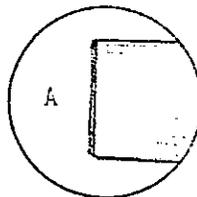
- A Muzzle
- B Tenon/threads
- C Rear sightscrew holes



Flat muzzle

Pattern 2 - Model 1896/98

Model 1896 Changes



Rounded/crowned muzzle

Special Note: Most Model 1892 rifles were retrofitted with Model 1896 barrels.

FRONT SIGHT BLADE

Pattern 1 - Model 1892, Variation 1



Base thicker than blade - Height of top above axis of bore - 0".82.

Pattern 2 - Model 1892, Variation 2



Base thicker than blade - June 20, 1894 - Height of top above axis of bore increased to 0".85.

Pattern 3 - Model 1896



Model 1896 Changes - Thickness made 0".05 throughout and shape of top changed.

Pattern 4 - Model 1898



Model 1898 Changes - Height of sight increased.

Barrel/Sight Group

FRONT SIGHT PIN

Pattern 1, Model 1892



Short/non-tapered pin

Pattern 2, Model 1896/98

Model 1896 Changes —

Length increased and taper changed



FRONT SIGHT STUD

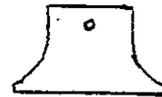
Pattern 1, Model 1892

Front View

Wide sight slot

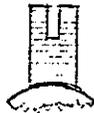


Side View



Pattern 2, Model 1896/98

Model 1896 Changes -- Narrow (0".05) sight slot

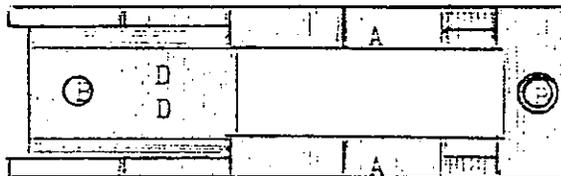


REAR SIGHT ASSEMBLIES

Pattern 1, Model 1892

11 Parts

Rear Sight Base



Top View

Parts List

- A Sides
- B Screw holes
- C Hinge Ears
- D Undercut spring slots
- E Joint pin hole



Left Side

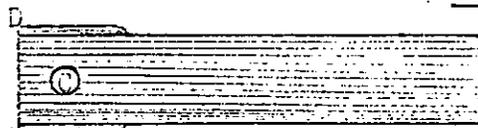
Rear Sight Base Spring



Side View

Parts List

- A Meel
- B Point
- C Screw hole
- D Tencns

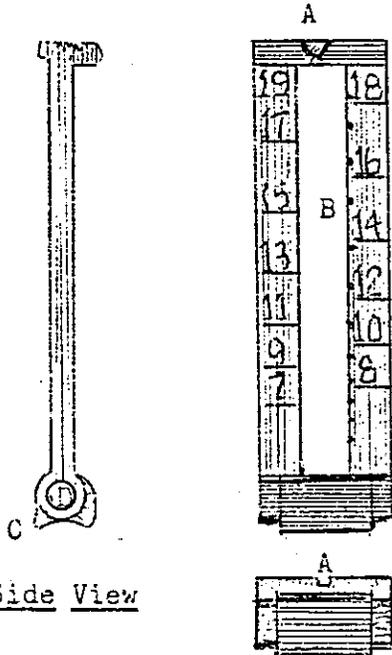


Top View

Barrel/Sight Group

REAR SIGHT ASSEMBLIES

Rear Sight Leaf



Parts List

- A Sight notch
- B Slide binding notches
- C Hinge arm
- D Sight pin hole

Face View

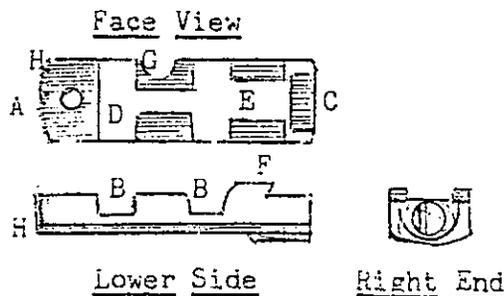
Side View

Rear End View

Rear Sight Joint Pin



Rear Sight Slide Block



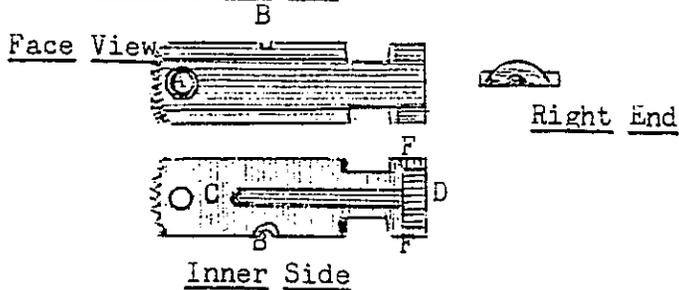
Parts List

- A Slide-cap screw hole
- B Leaf cuts
- C Catch heel groove
- D Catch hook groove
- E Catch spring hole
- F Slide cap shoulders
- G Sight notch - front
- H Knurling

Barrel/Sight Group

REAR SIGHT ASSEMBLIES

Rear Sight Slide Cap



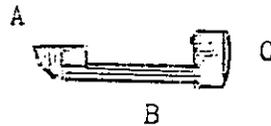
Parts List

- A Screw hole
- B Sight notch
- C Catch spindle groove
- D Catch heel groove
- F Shoulders

Rear Sight Slide Cap Screw



Rear Sight Slide Catch



Parts List

- A Hook
- B Spindle
- C Heel

Rear Sight Slide Catch Spring



Rear Sight Base Screw, front



Rear Sight Base Screw, rear



Barrel/Sight Group

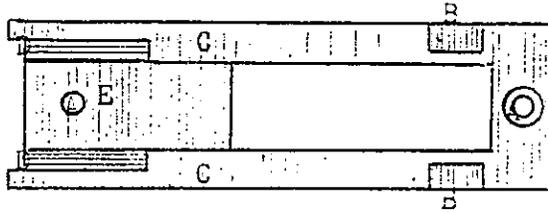
REAR SIGHT ASSEMBLIES

Pattern 2 - Model 1896

12 Parts

Rear Sight Base

November 26, 1895 -- Model 1892 (sight) became obsolete and Model 1896 (sight) adopted.



Top View



Left Side

Parts List

- A Screw holes
- B Ears
- C Sides
- D Rails
- E Undercut spring slots
- F Joint screw hole

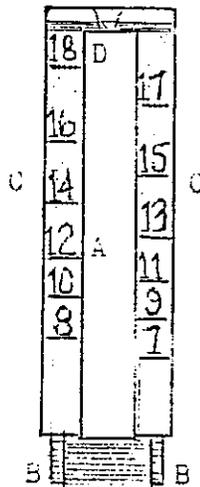
Rear Sight Base Spring



Parts List

- A Free end - point
- B Bevels
- C Screw hole

Rear Sight Leaf



Parts List

- A Slide slot
- B Joint screw hole
- C Arms
- D Sighting notch

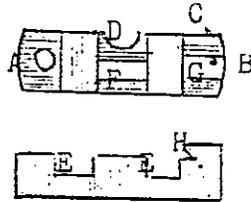
Rear Sight Joint Screw



Barrel/Sight Group

REAR SIGHT ASSEMBLIES

Rear Sight Slide



Parts List

- A Cap screw hole
- B Slide screw hole
- C Slide pin hole
- D Sighting notch clearance
- E Leaf slots
- F Spring slot
- G Cap tenon slot
- H Undercuts

Rear Sight Slide Cap



Parts List

- A Cap screw hole
- B Tenon
- C Bevels
- D Sighting notch

Rear Sight Slide Spring



Rear Sight Slide Pin



Rear Sight Slide Screw



Parts List

- A Head
- B Pin groove
- C Knurling

Rear Sight Slide Cap Screw



Rear Sight Base Screws, front & rear



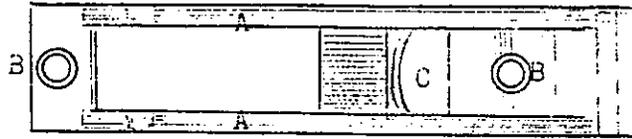
Barrel/Sight Group

REAR SIGHT ASSEMBLIES

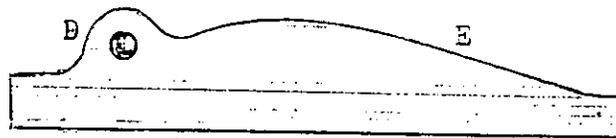
Pattern 3 - Model 1898

15 Parts

Rear Sight Base



Top View



Side View

- A Sides
- B Screw holes
- C Spring mortise
- D Joint pin hole
- E Elevation ramp

Rear Sight Base Spring

Side View



Top View

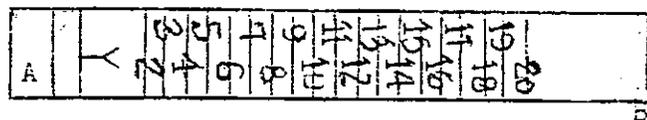


Parts List

- A Point
- B Mortise
- C Heel

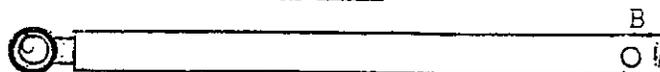
Rear Sight Leaf

Parts List



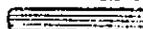
Top View

- A Hinge lug
- B Joint pin hole
- C Eyepiece screw hole



Left Side

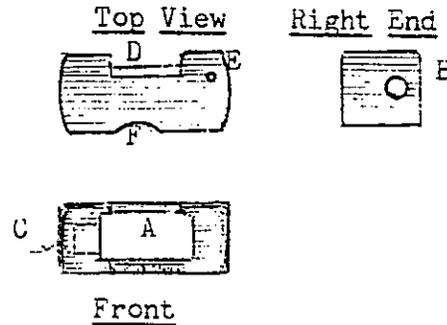
Rear Sight Joint Fin



Barrel/Sight Group

REAR SIGHT ASSEMBLIES

Rear Sight Slide



Parts List

- A Sight leaf hole
- B Binding screw hole
- C Slide binder/spring recess
- D Adjusting edge
- E Binding screw pin hole
- F Groove

Special Note: In the lefthand side of the slide there is a recess for the slide plunger spring and slide plunger.

Rear Sight Slide Plunger



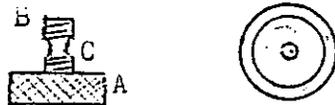
Parts List

- A Head/bearing
- B Spindle

Rear Sight Slide Plunger Spring



Rear Sight Slide Screw



Parts List

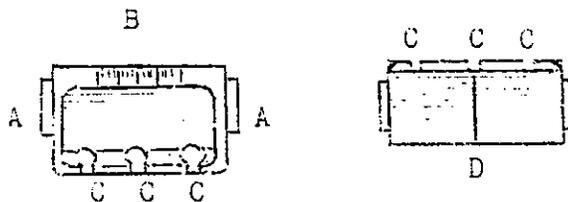
- A Head
- B Thread
- C Pin groove

Rear Sight Slide Pin



Special Note: Pin is tapered.

Rear Sight Eyepiece



Parts List

- A Ears
- B Graduations
- C Sight notches
- D Vertical line

Rear Sight Eyepiece Screw - Windage Adjustment



Parts List

- A Head
- B Threads
- C Tenon/pin hole
- D Contoured point

Barrel Sight Group

REAR SIGHT ASSEMBLIES

Rear Sight Eyepiece Knob



Parts List

- A Screw hole
- B Knurling
- C Pin hole

Rear Sight Eyepiece Knob Pin



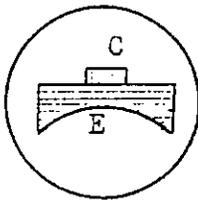
Rear Sight Base Screws, front & rear



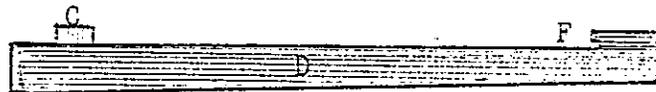
Pattern 4 - Model 1901

19 Parts

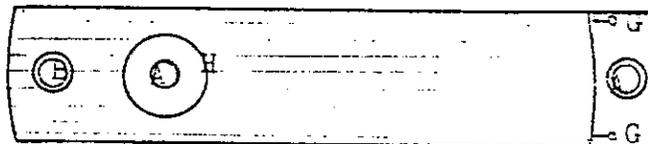
Rear Sight Base - Fixed



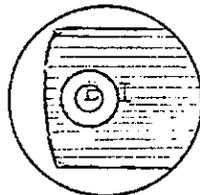
End View



Left Side View



Top View



Front End - Bottom View

Parts List

- A Screw holes
- B Cam screw hole
- C Retaining stud
- D Ease
- E Barrel contour
- F Movable base mortise
- G Zero windage index
- H Bushing recess
- I Locking lever (cam) screw recess

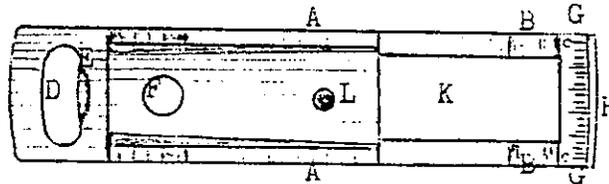
Barrel/Sight Group

REAR SIGHT ASSEMBLIES

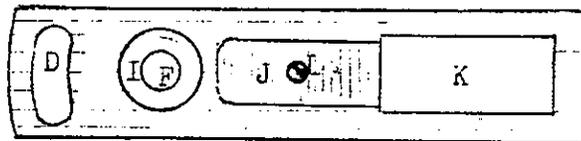
Rear Sight Base - Movable



Left Side View



Top View



Bottom View

Parts List

- A Elevation ramp
- B Ears
- C Joint pin hole
- D Windage limit profile
- E Cam bearing surface
- F Base screw/pivot hole
- G Windage graduations
- H Movable base tenon
- I Bushing recess
- J Leaf spring recess/mortises
- K Leaf spring opening
- L Leaf spring screw hole

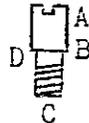
Rear Sight Base Bushing



Part List

- A Sight screw hole
- B Sight screw shoulder bearing

Rear Sight Base Screw, front



Parts List

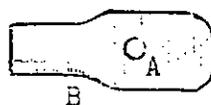
- A Head
- B Pivot
- C Threads
- D Shoulder

Rear Sight Base Screw, rear



Rear Sight Base Spring

Top View



Side View



Parts List

- A Screw hole
- B Friction bearing surface

Rear Sight Base Spring Screw



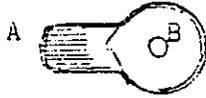
Barrel/Sight Group

REAR SIGHT ASSEMBLIES

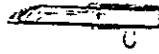
Rear Sight Movable Base Locking Lever

Parts List

- A Lever
- B Screw hole
- C Cam



Top View



Side View

Special Note: The bottom of the lever has a beveled shape so that a "camming" action will bind/lock the sight base - movable in the desired position to provide for windage adjustment.

Rear Sight Movable Base Locking Lever Screw

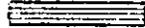
Parts List

- A Head
- B Threads
- C Point

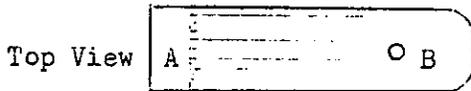


Special Note: The head of the screw has a distinct "concave" shape that is caused by grinding/filing to the contour of the bottom of the sight base - fixed. When assembled the point is riveted slightly.

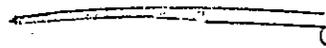
Rear Sight Joint Fin



Rear Sight Leaf Spring



Top View

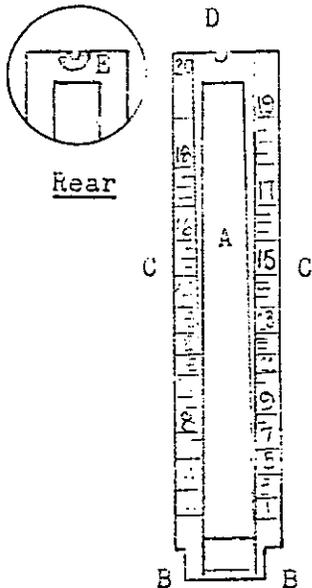


Side View

Parts List

- A Bearing
- B Screw hole
- C Bevels

Rear Sight Leaf



Rear

Front View



Right Side

Special Note: As the slide is moved up the folding leaf a right to left compensation is introduced to compensate for (bullet) drift.

Parts List

- A Slide slot
- B Joint pin hole
- C Arms
- D Sighting notch
- E Sight notch bevel

Barrel/Sight Group

REAR SIGHT ASSEMBLIES

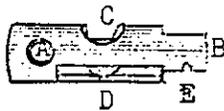
Rear Sight Slide



Parts List

- A Cap screw hole
- B Slide screw hole
- C Slide pin hole
- D Sighting notch clearance
- E Leaf slots
- F Cap Tenon slot
- G Tenon bevels

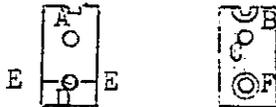
Rear Sight Slide Cap



Parts List

- A Cap screw hole
- B Tenon
- C Sighting notch bevel
- D Sighting notch
- E Slide pin hole

Rear Sight Drift Slide



Parts List

- A Sight notch
- B Sight notch bevel
- C Drift stud hole
- D Peep sight
- E Index marks
- F Peep sight bevel

Rear Sight Drift Stud



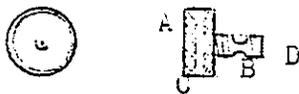
Special Note: The drift stud is assembled to the drift slide in manufacture.

Rear Sight Slide Cap Screw



Special Note: The screw is slightly riveted on the point end when the sight is assembled.

Rear Sight Slide Screw



Parts List

- A Head
- B Fin groove
- C Knurling
- D Point/binding surface

Rear Sight Slide Pin



Special Note: The pin is tapered with small end driven in from top - out from bottom of slide.

Barrel/Sight Group

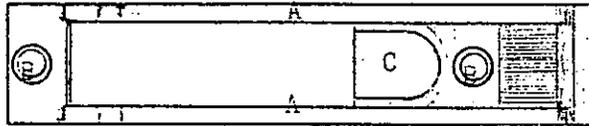
REAR SIGHT ASSEMBLIES

Pattern 5 - Model 1902

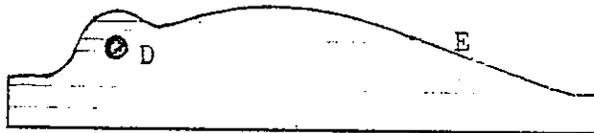
18 Parts

Rear Sight Base

Top View



Side View

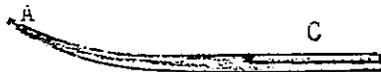


Parts List

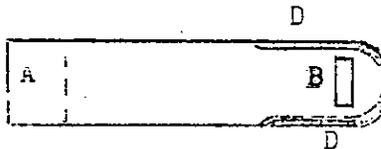
- A Side
- B Screw holes
- C Spring slot
- D Joint pin hole
- E Elevation ramp

Rear Sight Base Spring

Side View



Top View

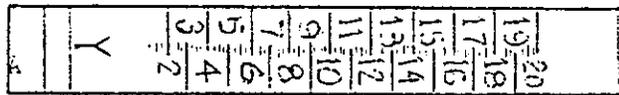


Parts List

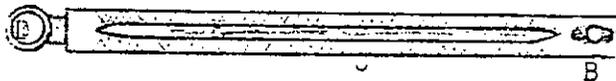
- A Point
- B Removal slot
- C Heel
- D Tenon

Rear Sight Leaf

Top View



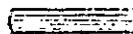
Left Side



Parts List

- A Hinge lug
- B Joint pin hole
- C Binding knurling
- D Eyepiece screw hole
- E Slide plunger groove

Rear Sight Joint Pin



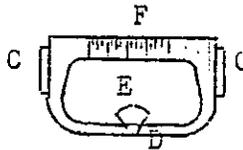
Barrel/Sight Group

REAR SIGHT ASSEMBLIES

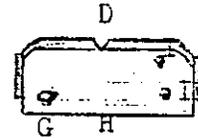
Rear Sight Eyepiece

Parts List

- A Hole
- B Slot
- C Ears
- D Open notch
- E Bevel/clearance
- F Graduations
- G Peep screw hole
- H Vertical line
- I Peep holding detents



Top View



Front View

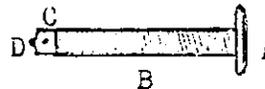


Side View

Rear Sight Eyepiece Screw - Windage Adjustment

Parts List

- A Head
- B Threads
- C Tenon/knob pin hole
- D Contoured point

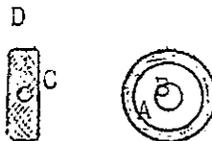


Rear Sight Eyepiece Knob Pin

Special Note: When installed the pin is slightly upset to prevent accidental removal.



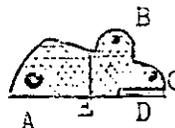
Rear Sight Eyepiece knob



Parts List

- A Undercut
- B Screw hole
- C Pin hole
- D Knurling

Rear Sight Peep Plate



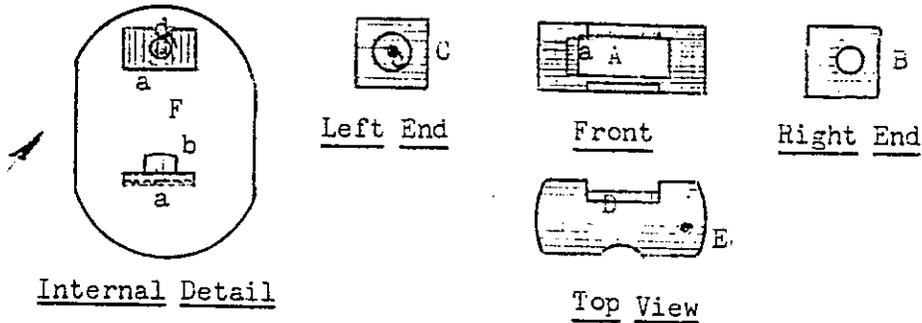
Parts List

- A Screw hole
- B Peep sight
- C Retaining detent
- D Finger grip
- E Vertical line

Barrel/Sight Group

REAR SIGHT ASSEMBLIES

Rear Sight Slide



Parts List

- | | |
|----------------------|--------------------------|
| A Sight leaf hole | D Adjusting edge |
| B Binding screw hole | E Binding screw pin hole |
| C Slide plunger hole | F Slide shoe |

Special Note: The slide shoe as illustrated in Internal Detail is assembled with the slide in manufacture. Close examination of the left side of the slide and the left inside shows this part.

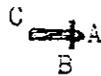
Rear Sight Slide Shoe Internal Detail

Rear Sight Slide Plunger Spring



- Internal Detail
- a Serrature
 - b Spindle
 - c Spring plunger hole
 - d Slide spring seat

Rear Sight Slide Plunger



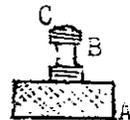
Parts List

- A Head/point
- B Flange
- C Spindle

Rear Sight Slide Screw

Parts List

- A Knurled head
- B Pin groove
- C Thread



Top View



End View

Special Note: The slide screw has a slot that will accommodate a shell rim to tighten.

Rear Sight Slide Screw Pin



Special Note: Pin is tapered

Barrel/Sight GroupREAR SIGHT ASSEMBLIESRear Sight Peep Plate ScrewRear Sight Base Screw, front/rearNotes on Rear Sights:

Model 1892: A "leaf type" sight that had a slide operated by a thumb-released catch. It had a step-sided base. Became obsolete on November 26, 1895.

Model 1896: A "leaf type" sight having a curved-sided base. The slide was held in place by a binding screw. Used initially from November 1895 until July 1899.

Model 1898: A "reclining leaf type" sight with a slide that rests on the inclined sides of the fixed sight base. The eyepiece has 3 distinctive sighting notches. was designed for use with the new 2200 fps ammunition. When breech over-pressures/barrel erosion/and, accuracy problems were encountered with this ammunition, it and the sight were discontinued. The Model 1896 sight was again used. Item of Interest: Sight bases with a variety of "caming-angles" may be seen -- these are the result of attempts to resolve ballistic problems inherent to the 2200 fps ammunition.

Model 1901: A combined "standing leaf/reclining leaf" sight. The leaf has a distinctive "gallows" profile in which a dual purpose slide/sight moves. As the slide is moved upwards/forward there is a right to left bias that corrects for drift. It has a movable/windage base that permits corrections for windage. The slide is held in place by a binding screw. It has open sight apertures for leaf up and down positions plus a "peep sight" for the leaf up position.

Model 1902: Very similar to the Model 1898 sight. Major external changes are the shape of the base and the deletion of the 3 sight notches in favor of a single notch and the addition of a "peep sight" plate that can be moved into place for use. Internally, there is a change in the shape of and method of mounting the leaf spring. As in the Model 1898, the slide is held in place by a binding screw. A "slot" for the rim of a shell case has been added to the end of the head of the binding screw to permit tightening. Additionally, a binding "shoe" has been added to the slide -- has a hole in the left end for the slide plunger.

Special Note: SEVERAL OF SIGHTS WITH MIXED PARTS -- ie., Model 1898/1902 bases/springs and leaf/slides and Model 1901/03 leaf/slides with Model 1902 bases.

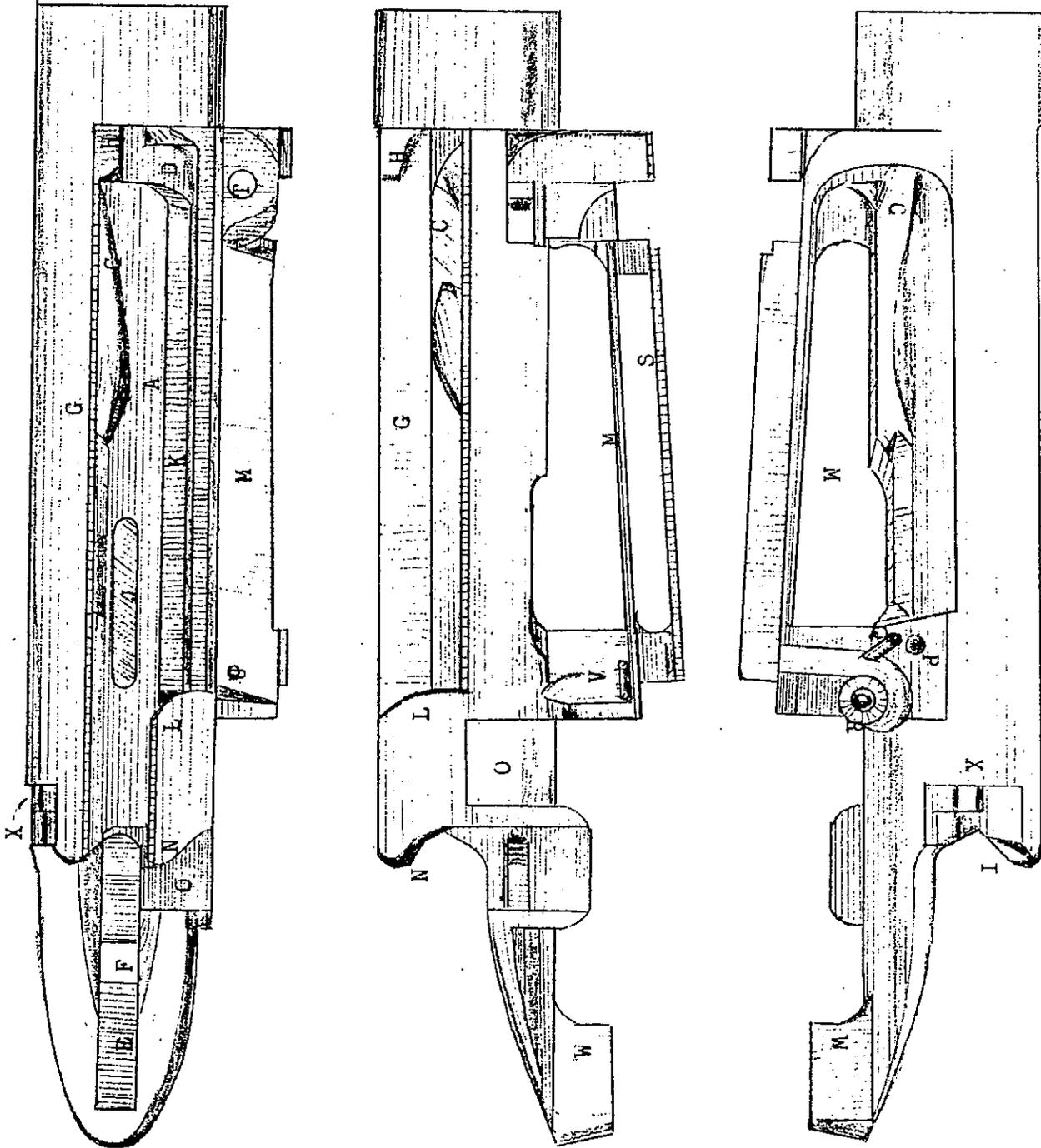
RECEIVER

Pattern 1 - Model 1892, Variation 1

Top View

Right Side

Left Side



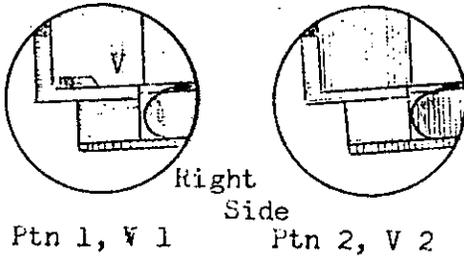
The Receiver views shown seven-eighths size.

RECEIVER

Parts List

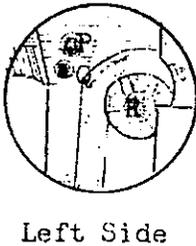
- | | |
|---------------------------|-----------------------------------|
| A Floor | L Locking shoulder/cam |
| B Magazine channel | M Magazine floor |
| C Bullet ramp | N Extracting shoulder |
| D Bolt locking lug recess | O Bolt handle body recess |
| E Cocking piece channel | P Side plate screw hole |
| F Sear nose cut | Q Ejector pin hole/head slot |
| G Left wall | R Sear seat |
| H Extractor spring lip | S Magazine spring groove |
| I Freeing cut | T Carrier arbor hole |
| J Ejector cut | U Guide lip rivet hole |
| K Guide rail | V Guide lip tenon groove |
| | W Trigger heel slot walls |
| | X Cut-off spring/spindle recesses |

Pattern 2 - Model 1892, Variation 2



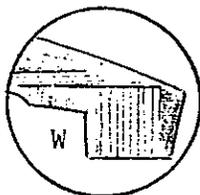
September 8, 1894 - Groove for guide lip tenon omitted.

Pattern 3 - Model 1892, Variation 3



January 28, 1895 - Slot for ejector pin head omitted.

Pattern 4 - Model 1892, Variation 4



May 27, 1895 - Walls of trigger heel slot omitted.

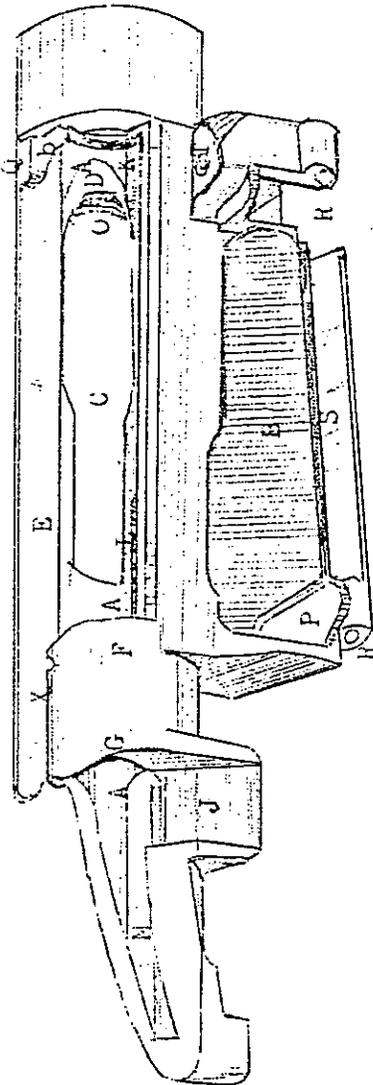
Receiver/Bolt/Magazine Group

RECEIVER

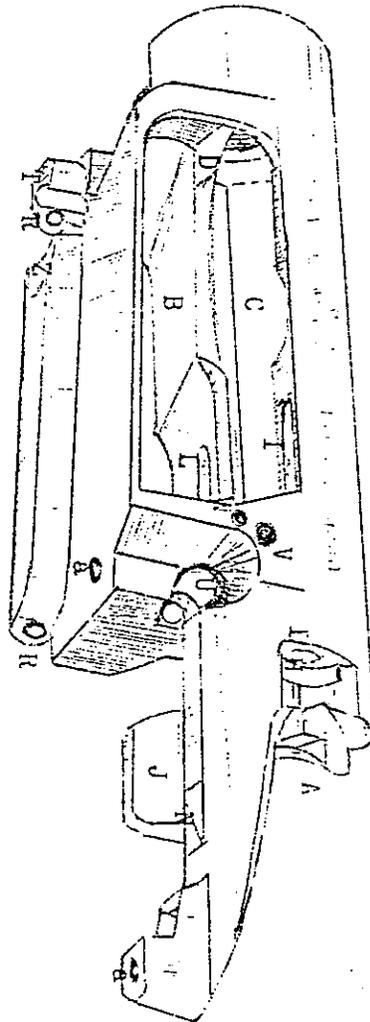
Pattern 5 - Model 1892, Variation 5

October 15, 1895 - Depth of Cut-off Spring Spindle
recesses increased.

Pattern 6 - Model 1896



Right Side

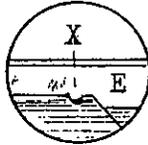


Left Side

RECEIVER

Parts List

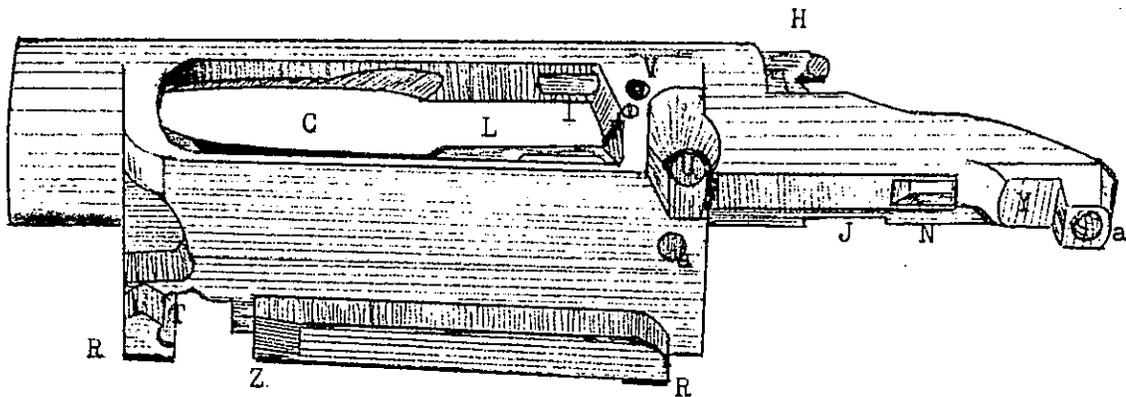
- | | |
|------------------------|----------------------------|
| A Bolt well | O Side plate tenon mortise |
| B Magazine | P Guide lip/rivet |
| C Magazine channel | Q Extractor spring lip |
| D Ramp | R Hinge bar holes |
| E Left wall | S Magazine spring channel |
| F Locking shoulder | T Carrier arbor hole |
| G Cocking shoulder | U Sear seat hole |
| H Cut-off recess | V Side plate screw hole |
| I Cut-off hole | W Ejector pin hole |
| J Bolt handle seat | X Extractor pin notch |
| K Locking lug recess | Y Trigger heel bearing |
| L Ejector seat | Z Hinge bar spring seat |
| M Cocking piece groove | a Guard screw holes |
| N Sear nose slot | b Extractor hook slot |



Model 1896 Changes --

-- Extractor pin notch added.

Pattern 7 - Model 1898



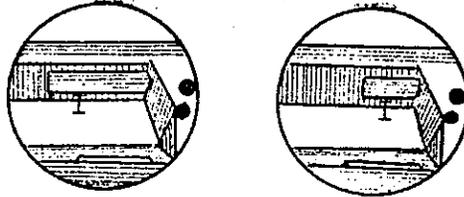
Parts List

Same as for Model 1896

RECEIVER

Model 1898 Changes --

-- Cut-off hole reduced 0".5 in depth and position slightly changed.

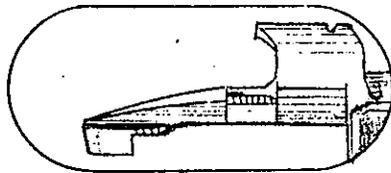


P 6 - M 896 P 7 - M '98

-- Width of mortise for side plate tenon increased 0".02.

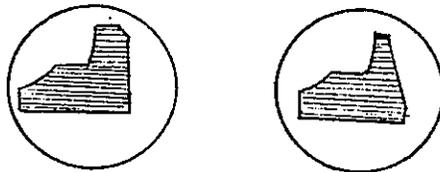
* See illustration at Side Plate.

-- That part of the Bolt handle projecting beyond tang omitted.



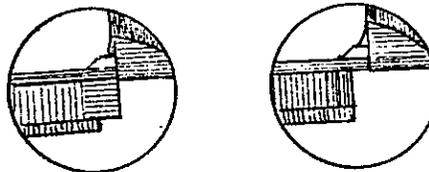
P 7 - M '98

-- Outside of right wall over gate beveled.



P 6 - M '96 P 7 - M '98

-- That part of the left wall of the magazine spring channel projecting beyond the bottom wall omitted.



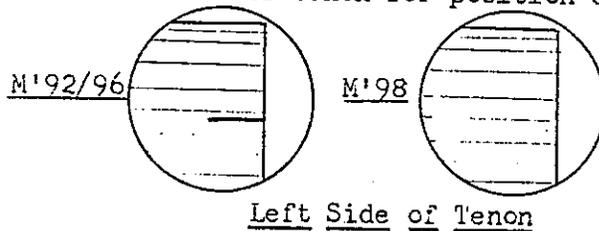
P 6 - M '96 P 7 - M '98

Receiver/Bolt/Magazine Group

RECEIVER

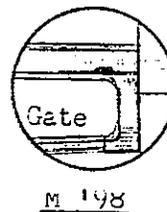
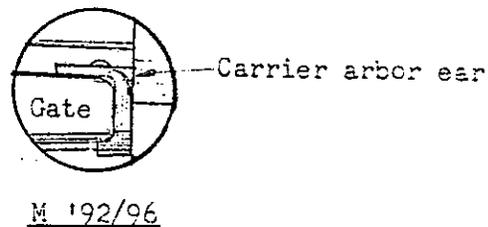
Model 1898 Changes --

-- Mark on side of tenon for position of barrel omitted.

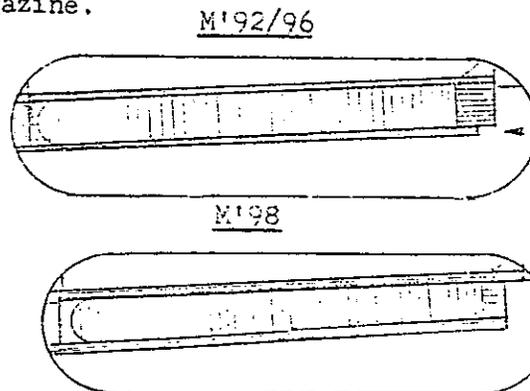


-- Top of carrier arbor ear lowered to project only slightly above top of gate.

Special Note: With the gate in place the carrier arbor ear extends noticeably above the front top of the gate on the Model 1892/96 arms. On the Model 1898 arms the carrier arbor ear is only slight above the top of the gate.



-- Bottom of magazine spring channel made parallel to bottom of magazine.

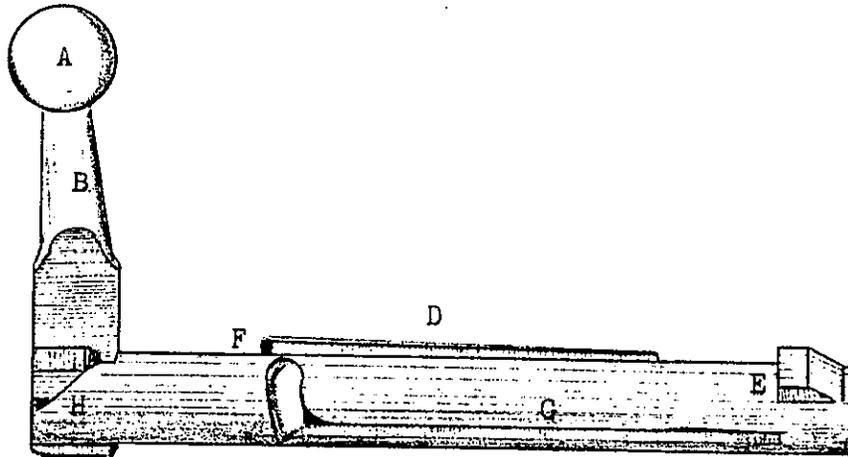


Special Note: On the Model 1892/96 arms there is a very slight (but definite) front to rear taper of the bottom of the magazine spring channel. On Model 1898 arms the bottom is straight which makes the bottom of the channel parallel to the bottom of the magazine.

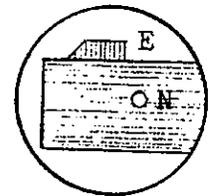
Receiver/Bolt/Magazine Group

BOLT

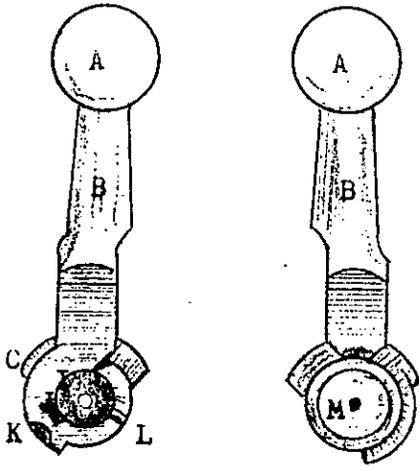
Pattern 1 - Model 1892, Variation 1



Right Side

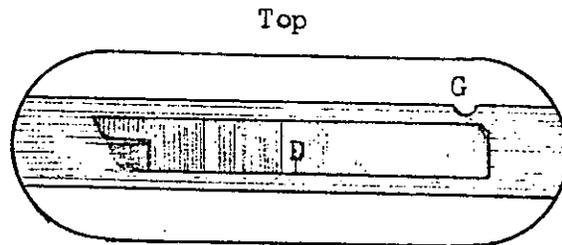


Left Side



Rear View

Front View



45° Right Rotation

Parts List

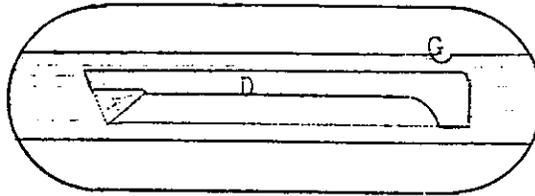
- | | | | |
|---|------------------|---|--------------------|
| A | Ball | H | Cocking cam |
| B | Handle | I | Bolt well |
| C | Handle collar | J | Slot |
| D | Guide rib | K | Safety notch |
| E | Locking lug | L | Cocking nose notch |
| F | Locking shoulder | M | Firing pin hole |
| G | Ejector groove | N | Gas port/hole |

Receiver/Bolt/Magazine Group

BOLT

Pattern 2 - Model 1892, Variation 2

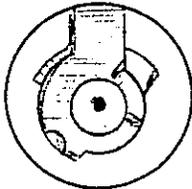
Top



45° Right Rotation

June 17, 1895 - About one-fourth of left side of guide rib removed.

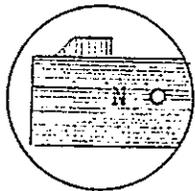
Pattern 3 - Model 1892, Variation 3



Rear View

June 29, 1895 - Slot for securing stud omitted.

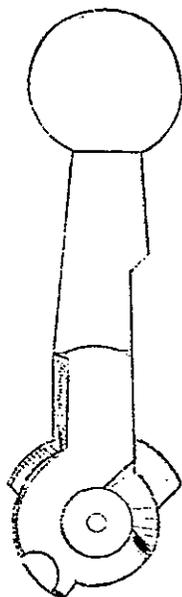
Pattern 4 - Model 1896



Model 1896 Changes --

Gas port/hole moved rearward 0",25.

Pattern 5 - Model 1898



Model 1898 Changes --

-- Length of flat surface on underside of handle increased.

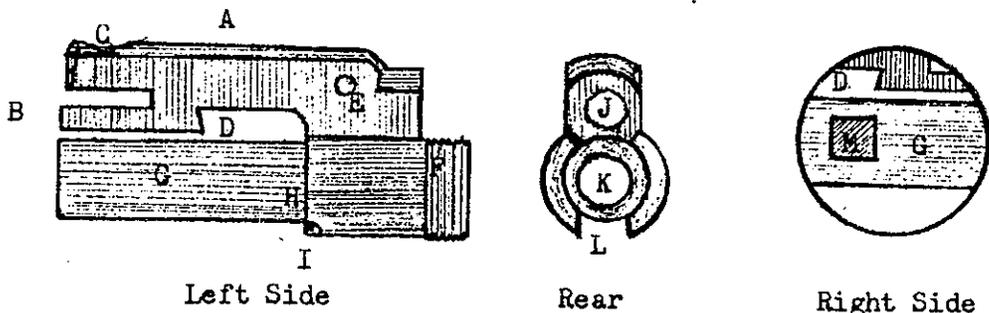
Special Note

The Model 1898 bolt can be used in a Model 1896 gun, but the Model 1896 bolt cannot be used in a Model 1898 gun.

Receiver Bolt/Magazine Group

SLEEVE

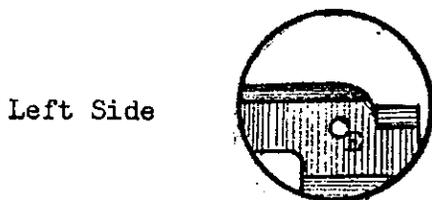
Pattern 1 - Model 1892, Variation 1



Parts List

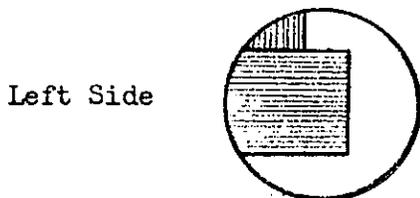
- | | | | |
|---|----------------------|---|----------------------------------|
| A | Extractor arm | H | Shoulder |
| B | Extractor slot | I | Dust space |
| C | Extractor screw hole | J | Safety lock spindle channel/hole |
| D | Bolt collar recess | K | Firing pin hole/well |
| E | Safety lock pin hole | L | Cocking piece lug slot |
| F | Cocking knurling | M | Securing stud |
| G | Barrel/spindle | | |

Pattern 2 - Model 1892, Variation 2



October 22, 1894 - Safety lock pin hole raised 0".03.

Pattern 3 - Model 1892, Variation 3



June 15, 1895 - Knurling omitted.

Pattern 4 - Model 1892, Variation 4

June 29, 1895 - Securing stud and rivet omitted.



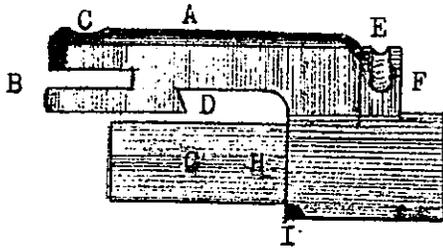
Right Side

Receiver/Bolt/Magazine Group

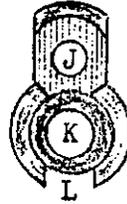
SLEEVE

Pattern 5 - Model 1896/98, Variation 1

Model 1896/98 Changes --



Left Side



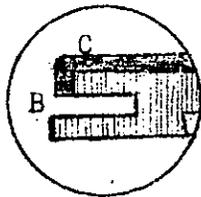
Rear

- Safety lock pin hole omitted
- Front end of barrel shortened 0".0345
- Thickness of extractor arm reduced 0".035
- Groove with recess at each end added for safety lock spring spindle

Parts List

- | | |
|-------------------------------------|----------------------------|
| A Extractor arm | G Barrel/spindle |
| B Extractor slot | H Shoulder |
| C Extractor screw hole | I Dust space |
| D Bolt collar recess | J Safety lock spindle hole |
| E Safety lock spring spindle groove | K Firing pin hole/well |
| F Safety lock seat | L Cocking piece lug slot |

Pattern 6 - Model 1896/98, Variation 2



Left Side

Countersink for screw head omitted, and lower part of rivet hole countersunk for rivet head.

SECURING STUD & RIVET

Model 1892



EXTRACTOR SCREW

Model 1892/96



EXTRACTOR RIVET

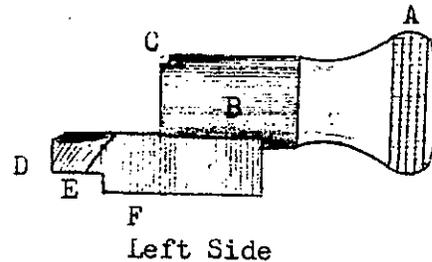
Model 1896/98



Receiver/Bolt/Magazine Group

COCKING PIECE

Pattern 1 - Model 1892, Variation 1



Parts List

- | | |
|----------------|--------------------|
| A Comb | D Cocking nose |
| B Body | E Cocking cam |
| C Safety notch | F Cocking shoulder |

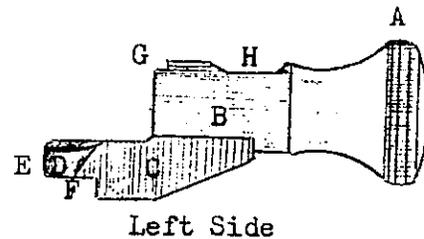
Pattern 2 - Model 1892, Variation 2

August 1, 1895 - Cocking piece made of high instead of low steel.

Pattern 3 - Model 1896/98

Model 1896 Changes --

--Rear part of lug beveled and locking notch added.



Parts List

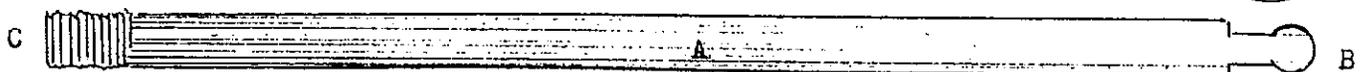
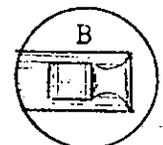
- | | |
|---------------|-------------------|
| A Comb | E Cocking nose |
| B Body | F Sear notch |
| C Lug | G Safety lock cam |
| D Cocking cam | H Locking notch |

FIRING PIN

Model 1892/96/98

Parts List

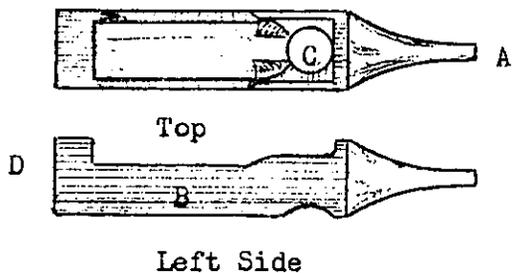
- | |
|-----------------|
| A Body |
| B Striker joint |
| C Thread |



Receiver/Bolt/Magazine Group

STRIKER

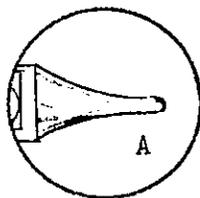
Pattern 1 - Model 1892, Variation 1



Parts List

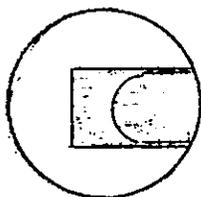
- | | |
|---------|---------|
| A Point | C Joint |
| B Body | D Face |

Pattern 2 - Model 1892, Variation 2



December 2, 1895 - Point rounded.

Pattern 3 - Model 1898



Model 1898 Changes --

--Rear part of body cut away rounded.

MAIN SPRING

Pattern 1 - Model 1892



Pattern 2 - Model 1896

Model 1896 Changes -- Length increased from 30½ to 33½ coils.

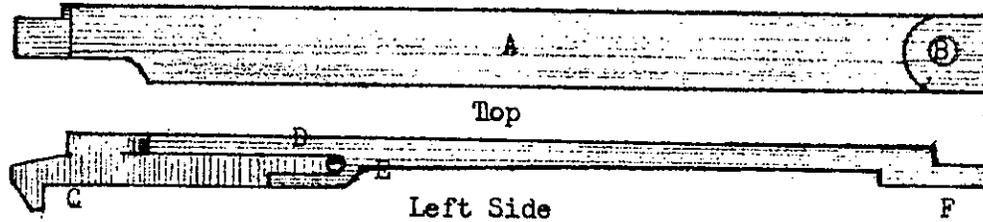
Pattern 3 - Model 1898

Model 1898 Changes -- Weight reduced from 18 to 22 pounds to 16 to 18 pounds.

Receiver/Bolt/Magazine Group

EXTRACTOR

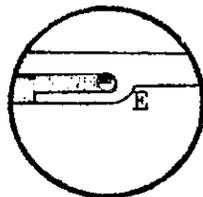
Pattern 1 - Model 1892, Variation 1



Parts List

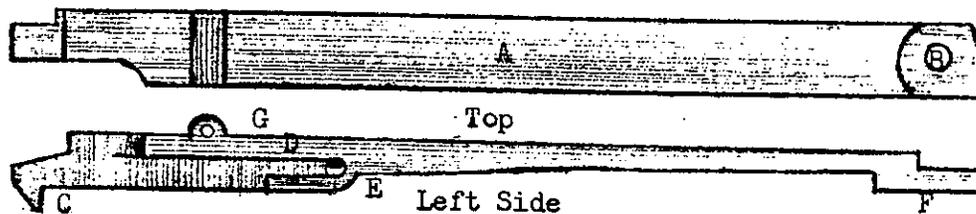
- | | |
|--------------|----------------------------------|
| A Body | D Extractor spring slot |
| B Screw hole | E Hole for extractor spring stud |
| C Hook | F Heel |

Pattern 2 - Model 1892, Variation 2



September 3, 1895 - Depth of extractor spring pivot hole increased 0".028.

Pattern 3 - Model 1896/98, Variation 1

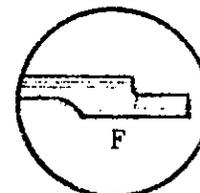


Parts List

- | | |
|--------------|----------------------------------|
| A Body | D Extractor spring slot |
| B Screw hole | E Hole for extractor spring stud |
| C Hook | F Heel |
| | G Extractor pin lug |

Pattern 4 - Model 1896/98, Variation 2

January 25, 1896 - Fillet added at junction of underside of body and heel.



Receiver/Bolt/Magazine Group

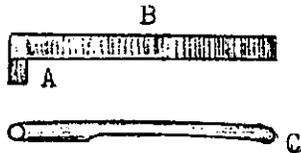
EXTRACTOR PIN

Model 1896/98



EXTRACTOR SPRING

Model 1892/96/98

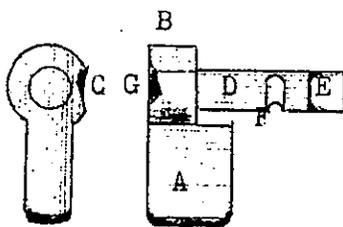


Parts List

- A Stud
- B Body
- C Point

SAFETY LOCK

Pattern 1 - Model 1892



Parts List

- A Thumb piece
- B Body
- C Cocking piece groove
- D Spindle
- E Bolt notch
- F Pin groove
- G Cam

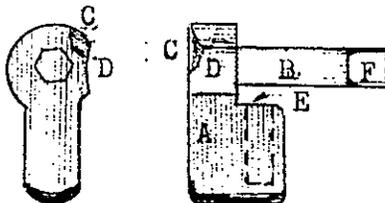
Pattern 2 - Model 1892



October 22, 1894 - Depth of safety lock pin groove reduced 0".03.

SAFETY LOCK/SPINDLE

Model 1896/98



Model 1896 Changes --

- Thickness of thumb-piece increased.
- Thumb-piece and spindle made separate.
- Spring and spring spindle added.
- Safety lock pin groove omitted.

Parts List

- A Thumb-piece
- B Spindle
- C Cam
- D Cocking piece groove
- E Spring spindle hole
- F Bolt collar notch

Receiver/Bolt/Magazine Group

SAFETY LOCK PIN

Model 1892

Omitted in Model 1896



SAFETY LOCK SPRING

Model 1896/98

Added in Model 1896



SAFETY LOCK SPRING SPINDLE

Model 1896/98

Added in Model 1896



Special Note

The Model 1896/98 Safety Lock consists of the Thumb-piece, Spindle, Spring and Spring Spindle. These parts are assembled in manufacture.

EJECTOR

Pattern 1 - Model 1892

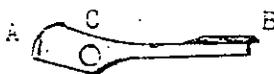
Parts List



- A Heel
- B Point
- C Pin hole

Item of Interest: The early M'92 ejectors have a very distinct bearing ring milled around the pin hole.

Pattern 2 - Model 1892/96/98

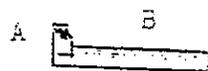


No bearing ring milled around pin hole.

EJECTOR PIN

Pattern 1 - Model 1892, Variation 1

Parts List



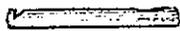
Flat headed

- A Head - with notch for withdrawing
- B Spindle

Receiver/Bolt/Magazine Group

EJECTOR PIN

Pattern 2 - Model 1892, Variation 2



Hook headed

Pattern 3 - Model 1896/98

Model 1896 Changes

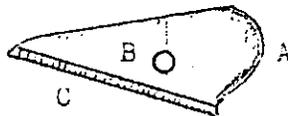


Knob headed

GUIDE LIP

Pattern 1 - Model 1892, Variation 1

Top



Parts List

- A Lip
- B Rivet hole
- C Tenon



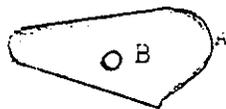
Rear

Pattern 2 - Model 1892, Variation 2

September 8, 1894 - Tenon to enter groove in receiver omitted.

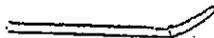
Parts List

Top



- A Lip
- B Rivet hole

Rear

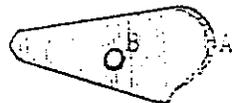


Pattern 3 - Model 1896/98

Model 1896 Changes --

-- Thickness increased.

Top



Rear



GUIDE LIP RIVET

Model 1892/96/98

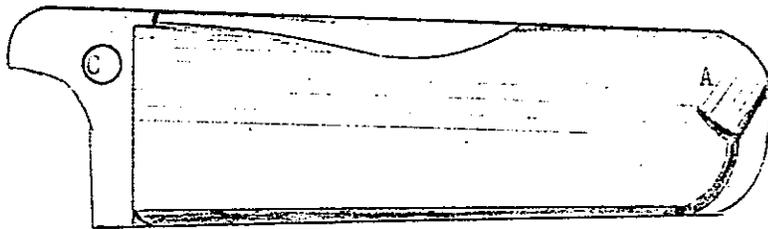


Receiver/Bolt/Magazine Group

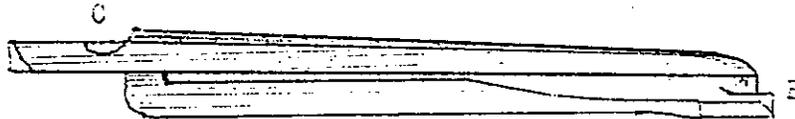
SIDE PLATE

Pattern 1 - Model 1892, Variation 1

Parts List

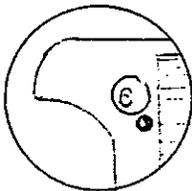


- A Ramp
- B Lip/tenon
- C Screw hole



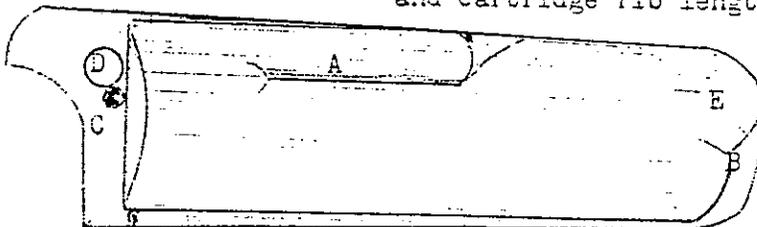
Pattern 2 - Model 1892, Variation 2

January 28, 1895 -- Hole for ejector pin head added.



Pattern 3 - Model 1896

Model 1896 Changes -- Thickness of upper half increased and cartridge rib lengthened.



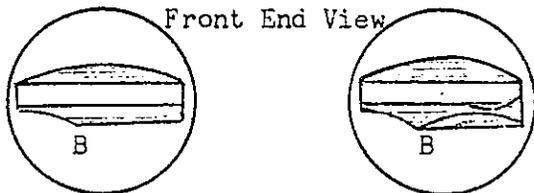
Parts List

- A Rib
- B Tenon
- C Pin hole recess
- D Side plate screw hole
- E Ramp

Receiver/Bolt/Magazine Group

SIDE PLATE

Pattern 4 - Model 1898



Ptn 3 - M'96

Ptn 4 - M'98

Model 1898 Changes --

Thickness of tenon increased
0".02.

Special Note: Mortise for tenon
in receiver also increased 0".02.

SIDE PLATE SCREW

Pattern 1, Model 1892, Variation 1



Pattern 2, Model 1892, Variation 2



June 1, 1894 -- Shortened in length one thread.

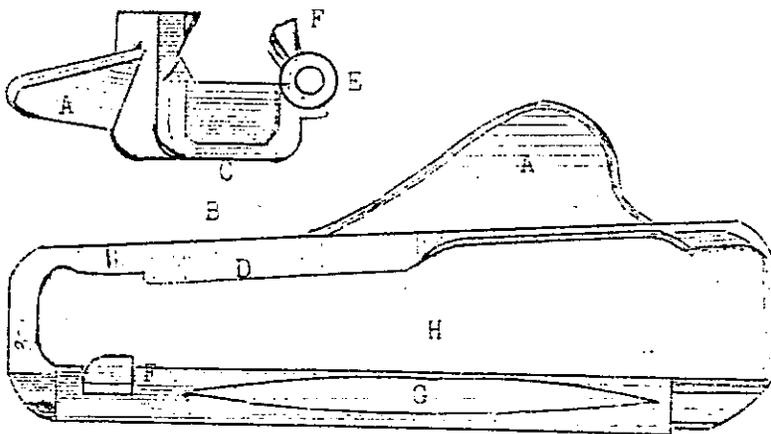
Pattern 3, Model 1896/98



Model 1896 Changes -- Threads extend almost to
head.

GATE

Pattern 1, Model 1892, Variation 1



Face View - Lug Rotated 90° Left

Parts List

- A Thumb piece
- B Top
- C Back
- D Face
- E Hinge
- F Lug
- G Spring surface
- H Well

Special Note: The gate should
have a serial number stamped
on the face in front of the lug
that is the same as the serial
number on the receiver.

Receiver/Bolt/Magazine Group

GATE

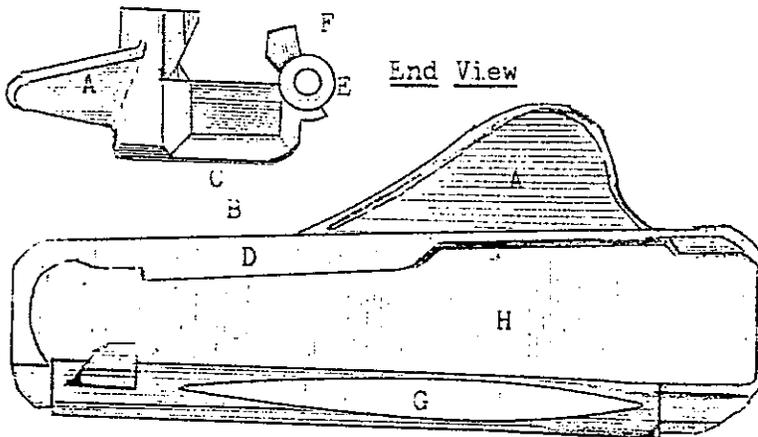
Pattern 2 - Model 1892, Variation 2



April 1, 1895 -- Length of lug reduced 0".0065.

Side View of Lug

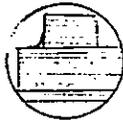
Pattern 3 - Model 1892, Variation 3 - Model 1896



Parts List

- A Thumb piece
- B Top
- C Back
- D Face
- E Hinge
- F Lug
- G Spring surface
- H Well

Face View - LUG rotated 9° Left



October 8, 1895 --

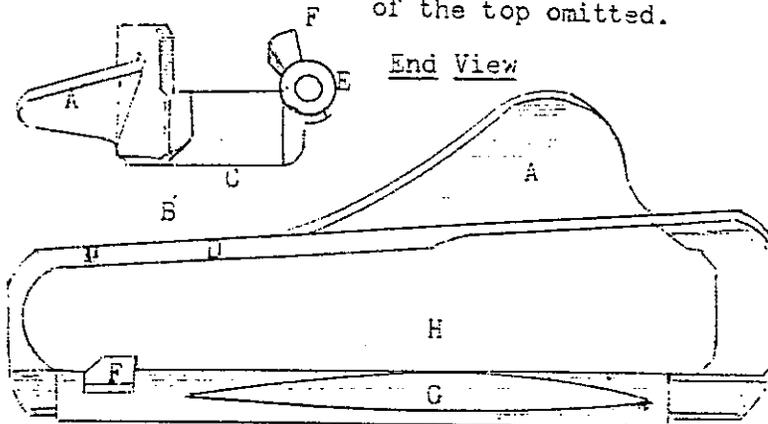
-- Fillet added at junction of hinge and lug.

Side View of Lug

-- Shape of exterior and interior of front end changed.

Pattern 4 - Model 1898

Model 1898 Changes -- Curvature of exterior and shape of interior at rear end changed, and the bevel on the front part of the interior of the top omitted.



Parts List

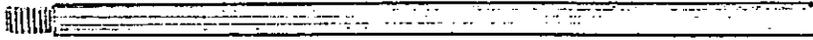
- A Thumb piece
- B Top
- C Back
- D Face
- E Hinge
- F Lug
- G Spring surface
- H Well

Face View - LUG Rotated 9° Left

Receiver/Bolt/Magazine Group

HINGE BAR PIN

Pattern 1 - Model 1892, Variation 1



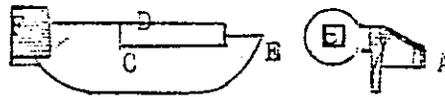
Pattern 2 - Model 1892, Variation 2 - Model 1896/98

July 15, 1895 -- Blued instead of spring tempered.

HINGE BAR HEAD

Pattern 1 - Model 1892, Variation 1

Parts List



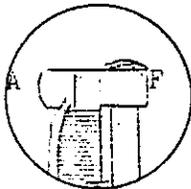
Rear View

End View

- A Thumb piece
- B Hinge bar hole
- C Spring
- D Spring lug
- E Point
- F Head

Special Note: Hinge bar pin and hinge bar head are assembled in manufacture into hinge bar.

Pattern 2 - Model 1892, Variation 2

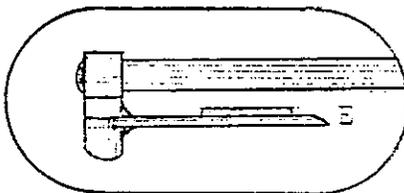


Rear View

May 11, 1895 -- Right rear edge rounded.

Special Note: Rounding is caused by a change in the manner in which hinge bar pin is attached to hinge bar head - ie., riveting with a rounding of the pin head instead of earlier flush/square appearance of Pattern 1.

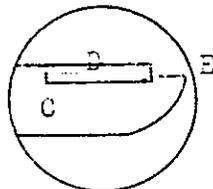
Pattern 3 - Model 1892, Variation 3



Rear View

June 4, 1895 -- Fillet added at junction of spring and head.

Pattern 4 - Model 1896/98



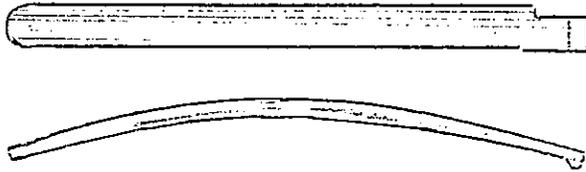
Rear View

January 30, 1896 -- Width of lug on spring reduced 0".03.

Receiver/Bolt/Magazine Group

MAGAZINE SPRING

Model 1892/96/98

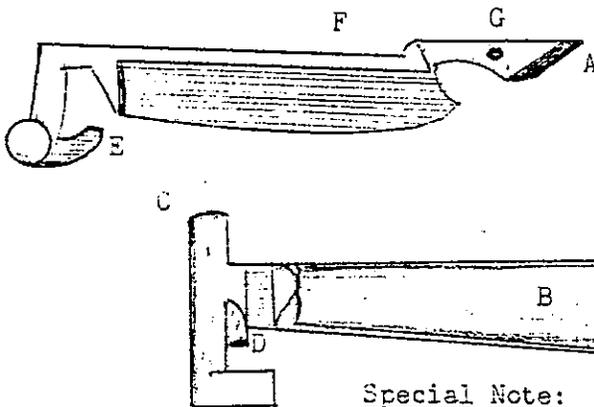


Part List

A Lip

CARRIER

Pattern 1 - Model 1892, Variation 1



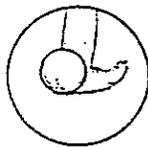
Parts List

A Point
 B Face
 C Arbor
 D Cam
 E Heel
 F Back
 G Follower pin hole

Special Note: On the bottom of the carrier immediately adjacent to where the face joints the arbor arm there is a Serial Number that should be the same as the SN on the receiver.

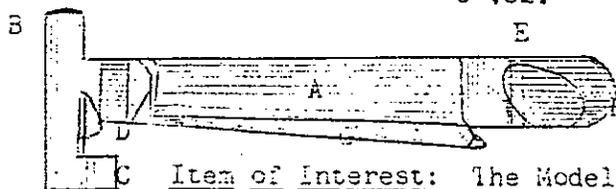
Pattern 2 - Model 1892, Variation 2

March 4, 1895 -- Magazine spring lug (heel) shortened.



Pattern 3 - Model 1898

Model 1898 Changes -- Arbor made perpendicular to top and shortened 0".02, and distance between lug and bottom side of body decreased 0".02.



Special Note: The Model 1898 Carrier is peculiar to the Model 1898 arms, and is not interchangeable with previous models.

Item of Interest: The Model 1898 Carrier has a very distinct "rib" that extends along the bottom of the curved face.

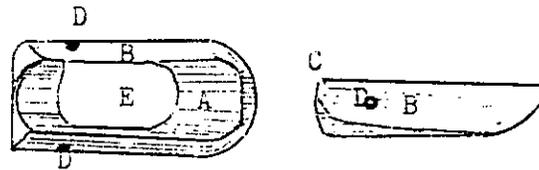
Parts List

A Curved face
 B Arbor
 C Heel
 D Cam
 E Follower pin hole
 F Point
 G Rib

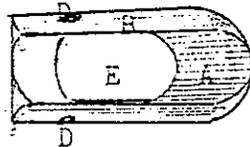
Receiver/Bolt/Magazine Group

FOLLOWER

Pattern 1 - Model 1892



Pattern 2 - Model 1896/98



Parts List

- | | | |
|--------|------------|-----------|
| A Face | C Back | E Opening |
| B Top | D Fin hole | |

Follower Fin

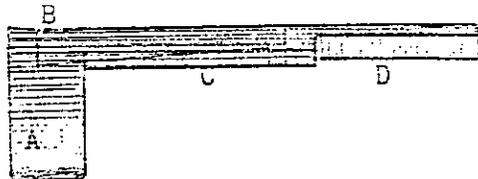
Model 1892/96/98



Special Note: The follower is assembled to the carrier by the follower pin.

CUT-OFF

Pattern 1 - Model 1892, Variation 1



Parts List

- | |
|-----------------|
| A Thumb piece |
| B Spring slot |
| C Spindle body |
| D Spindle point |

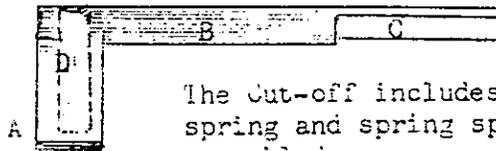


Pattern 2 - Model 1892, Variation 2

July 15, 1895 -- Blued instead of spring tempered.

Pattern 3 - Model 1892, Variation 3 - Model 1896

Parts List



The Cut-off includes the spring and spring spindle assembled.

- | |
|----------------------------|
| A Thumb piece |
| B Spindle |
| C Point |
| D Cut-off spring hole/well |

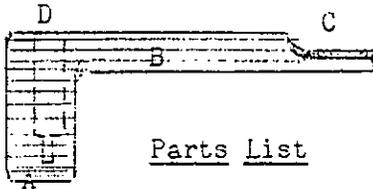
April 30, 1895 -- Thickness of thumb piece increased 0".015 and slot for flat spring replaced by spring spindle hole.

Receiver/Bolt/Magazine Group

CUT-OFF

Pattern 4 - Model 1898

Model 1898 Changes --



Parts List

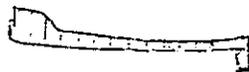
- A Thumb-piece
- B Spindle
- C Point
- D Spring spindle hole/well

Flattening of spindle reversed, length of spindle decreased 0".5, rear upper edge of thumb-piece beveled and fillet added at junction of spindle and thumb-piece.

Special Note: The Model 1898 Cut-off is peculiar to the Model 1898 arms, and is not interchangeable with previous models.

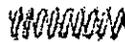
CUT-OFF SPRING

Pattern 1 - Model 1892, Variation 1



April 30, 1895 -- Omitted.

Pattern 2 - Model 1892, Variation 2 - Model 1896/98



April 30, 1895 -- Flat replaced by spiral pattern.

CUT-OFF SPRING SPINDLE

Pattern 1 - Model 1892/96/98, Variation 1

April 30, 1895 -- Added.



Pattern 2 - Model 1892/96/98, Variation 2

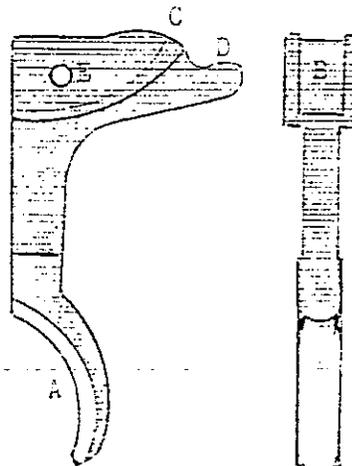
August 6, 1895 -- Length increased 0".013.

TRIGGER

Pattern 1 - Model 1892, Variation 1

Parts List

- A Finger piece
- B Sear recess
- C Half pull bearing
- D Blade
- E Pin hole



Receiver/Bolt/Magazine Group

TRIGGER

Pattern 2 - Model 1892, Variation 2 - Model 1896/98

April 2, 1894 -- Case-hardened in water instead of in oil.

Item of Interest: Parts that are quenched in oil during the casehardening process will have a dark, almost black, finish while those that are quenched in water during the casehardening process will have brilliant coloration when in mint state.

TRIGGER PIN

Pattern 1 - Model 1892, Variation 1



Special Note: The pin is tapered. In assembling the small end is driven in

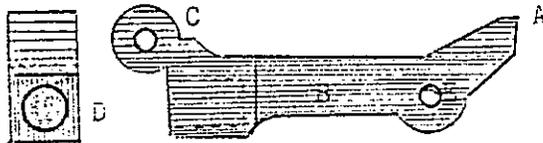
Pattern 2 - Model 1892, Variation 2 - Model 1896/98

from the right and upset on the left.

November 15, 1895 -- Length reduced 0".045.

SEAR

Pattern 1 - Model 1892, Variation 1



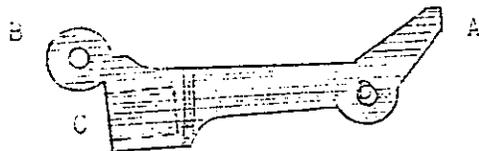
Parts List

- A Nose
- B Body
- C Hinge
- D Sear spring hole
- E Trigger pin hole

Pattern 2 - Model 1892, Variation 2

October 25, 1895 -- Made of low steel instead of high steel.

Pattern - Model 1892, Variation - Model 1896/98



November 26, 1895 --

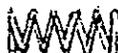
Nose shortened 0".005.

Parts List

- A Nose
- B Hinge
- C Spring hole
- D Trigger pin hole

SEAR SPRING

Model 1892/96/98



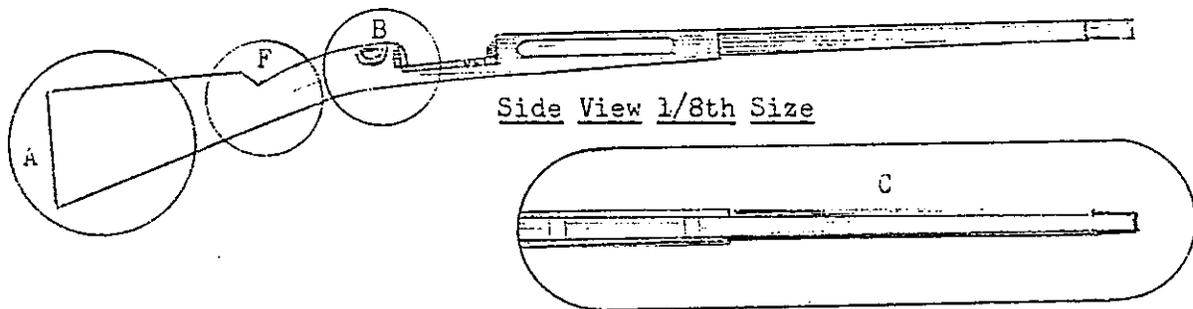
Stock/Mounting Group

STOCK

Pattern 1 - Model 1892, Variation 1

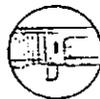
Key Features

- A Flat/solid butt
- B Distinctive inletting for bolt handle seat
- C Solid barrel channel with no lightening channels
- D Hole inletted for ramrod stop
- E Ramrod channel inletting
- F Thin wrist/small

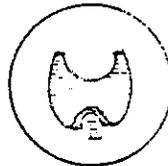


Side View 1/8th Size

Top View Forearm 1/8th Size



Top View Receiver Inletting
1/8th Size



Front View Forearm Tip
1/2 Size

Pattern 2 - Model 1892, Variation 2

Special Note: When the Model 1892 arms were upgraded to Model 1896 standards the Pattern 1 stocks were modified as follows:

- Toe of butt rounded
- Butt drilled for cleaning rods/oiler and lightening hole
- ramrod channel filled with doweling

Stock/Mounting Group

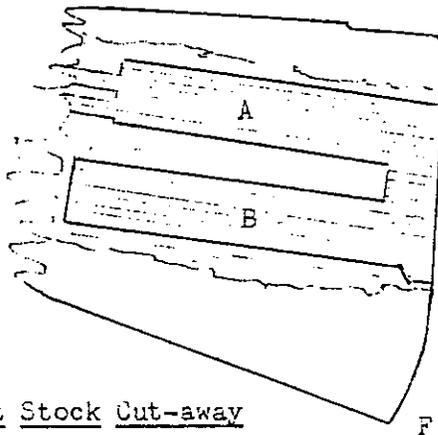
STCCA

Pattern 3 - Model 1896, Variation 1

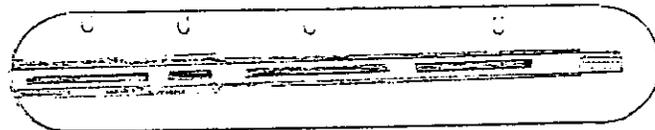
Model 1896 Changes --

- D -- Wrist/small enlarged.
- F -- Toe rounded.
- A/B -- Two holes, 1" in diameter, to decrease weight, and three small holes for cleaning rods drilled in butt.
- C -- Channels cut under barrel to decrease weight.
- E -- Ramrod groove and stop slot omitted.

Item of Interest: Although the weight of stocks will vary according to the density of the wood the Model 1892 stock is listed as weighting 2.153 pounds. The lightening efforts at the butt and barrel channel resulted in the Model 1896 having a listed stock weight of 1.840 pounds.



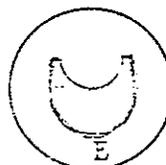
Butt Stock Cut-away



Top View of Barrel Channel



Wrist



Front View of Tip

Item of Interest: After being mated for a period of time the lightening channels will cause a distinctive pattern to appear in the blueing on the bottom of the barrel. This can serve as a key identifying factor in determining if "early" Model 1892 arms were ever stocked with later Model 1896 stocks.

Stock/Mounting Group

STOCK

Pattern 4 - Model 1896, Variation 2

Late Model 1896 Changes --

-- Oiler seat cut between large holes.

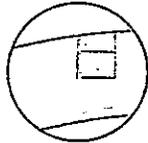
Special Note: The 1898 copy of, "Description and Rules for the Management of the U. S. Magazine Rifle and Carbine" list the addition of the oiler seat as occurring at the same time as the earlier changes. There are however a large number of stocks that have 1896 cartouche dates and have the two large holes and no cut for the oiler.

Pattern 5 - Model 1898

Model 1898 Changes --

-- Bolt handle seat changed.

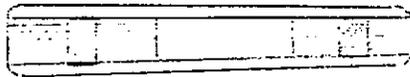
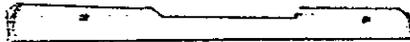
Special Note: The Model 1898 stock is peculiar to the Model 1898 arms, and is not interchangeable with previous models.



Bolt Handle Seat

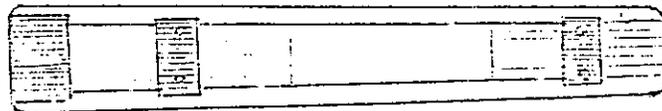
HANDGUARD

Pattern 1 - Model 1892



Special Note: Short handguard that extends to the rear only to the receiver tenon.

Pattern 2 - Model 1896



Model 1896 Changes --

Extended rearward over tenon of receiver and heads of rivets countersunk deeper.

Stock/Mounting Group

HANDGUARD

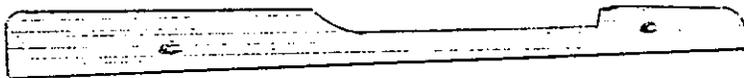
Pattern 3 - Model 1898, Variation 1

For Model 1898 & 1902 Rear Sights



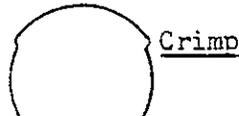
Pattern 4 - Model 1898, Variation 2

For Model 1901 Rear Sights



HANDGUARD SPRINGS

Pattern 1 - Model 1892



Pattern 2 - Model 1896/98



Model 1896 Change --

Crimp omitted.

HANDGUARD RIVETS - Front & Rear

Pattern 1, Model 1892



Pattern 2, Model 1896/98



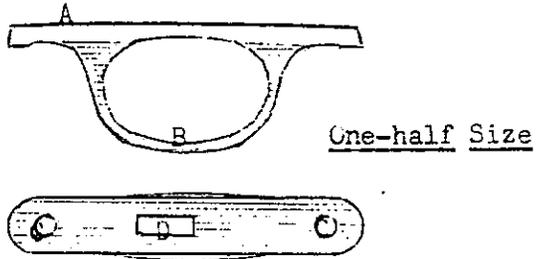
Model 1896 Change --

Rivet shortened.

Stock/Mounting Group

GUARD

Model 1892/96/98



Parts List

- A Plate
- B Bow
- C Screw holes
- D Trigger hole

GUARD SCREW REAR

Model 1892/96/98

One-half size



GUARD SCREW FRONT

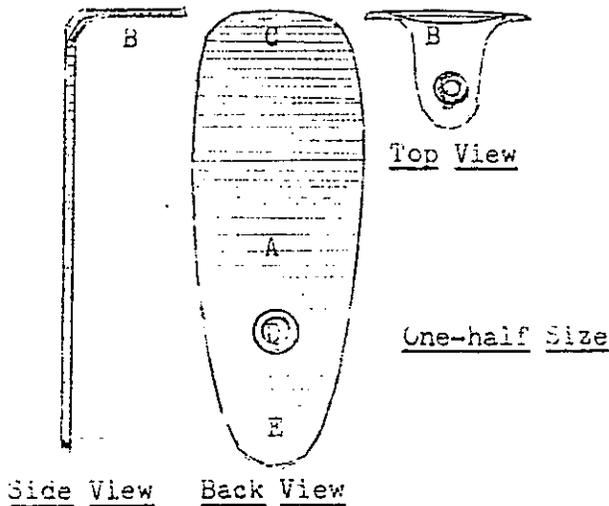
Model 1892/96/98

One-half size



BUTT PLATE

Pattern 1 - Model 1892



Features

- Thin
- Straight

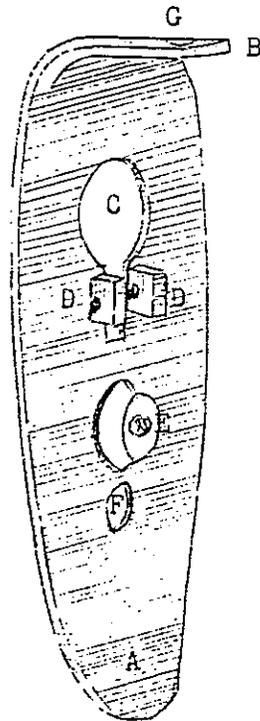
Parts List

- A Body
- B Tang
- C Heel
- D Screw holes
- E Toe

Stock/Mounting Group

BUTT PLATE

Pattern 2 - Model 1896/98, Variation 1 - Model 1892 Retro-Fit



Model 1896/98 Changes --

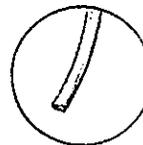
- Thickness increased 0".04.
- Toe rounded.
- Cap hole, cap ears and spring lug added.

Parts List

- A Toe
- B Tang
- C Cap hole
- D Cap ears
- E Spring lug
- F Large butt plate screw hole
- G Small butt plate screw hole

Item of Interest: There is a notch cut into edge of cap hole to facilitate opening of the cap.

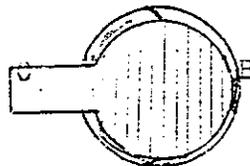
Pattern 3 - Model 1896/98, Variation 2



Thickness increased.

BUTT PLATE CAP

Pattern 1 -



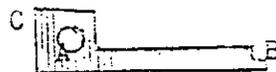
Model 1896/98, Variation 1 - Model 1892 Retro-Fit

Model 1896 Changes: Butt plate cap added.

Parts List

- A Fin hole
- B Thumb notch
- C Heel

Pattern 2 - Model 1896/98, Variation 2



Thickness increased to match thickness of butt plate

BUTT PLATE CAP SPRING

Model 1896/98



Model 1896 Changes --

Butt plate cap spring added

BUTT PLATE CAP SPRING SCREW

Model 1896/98



Model 1896 Changes -- Butt plate cap spring screw added.

BUTT PLATE CAP PIN

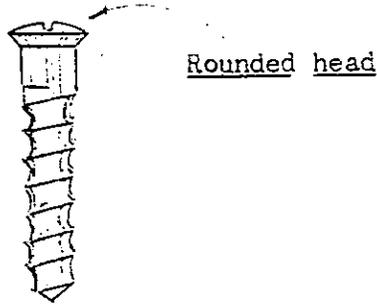
Model 1896/98

Model 1896 Changes -- Butt plate cap pin added. Page 14

Stock/Mounting Group

BUTT PLATE SCREW - Large

Pattern 1 - Model 1892



Rounded head

Pattern 2 - Model 1896-98 - Model 1892 Metro-Fit



Model 1896 Changes —

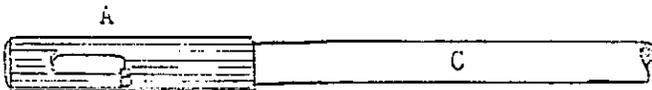
Head made flat.

Model 1892/96/98



RAMROD

Pattern 1 - Model 1892, Variation 1



Parts List

- A BRASS jag/Head
- B Slot
- C Shaft

Special Note: The 1st Pattern of the Model 1892 ramrod had a distinctive BRASS jag or head. It is doubtful if this pattern was in fact an issue item.

Pattern 2 - Model 1892, Variation 2



Parts List

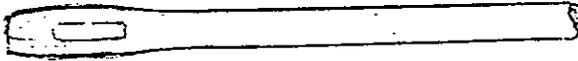
- A Head
- B Slot
- C Shaft
- D Threads

Special Note: One piece steel ramrod - The head is straight "sided" with slot for a cleaning patch.

Stock/Mounting Group

RAMROD

Pattern 3 - Model 1892, Variation 3



Deleted in Model 1896

Special Note: The head of this variation has a distinctive curved - "barrel shaped" configuration that is like the head of the later (Model 1896/98) cleaning rod.

RAMROD STOP

Model 1892

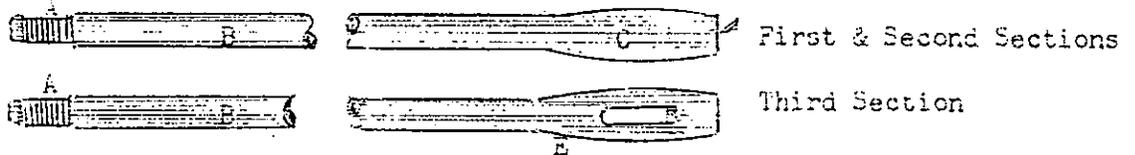
Deleted in Model 1896



CLEANING RODS

Model 1896/98 - Model 1892 Retro-Fit

Model 1896 Changes -- Cleaning rod made jointed and inserted in butt of stock. D

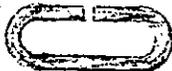


Parts List

- | | | |
|-----------------|-----------------|--------|
| A Joint threads | C Joint swell | E Head |
| B Shaft | D Joint threads | F Slot |

BUTT SWIVEL

Model 1892/96/98



BUTT SWIVEL PIN

One-half size

Model 1892/96/98



BUTT SWIVEL PLATE

Model 1892/96/98



Side View

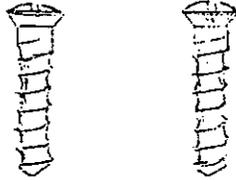


Bottom Face View

Stock/Mounting Group

BUTT SWIVEL SCREWS

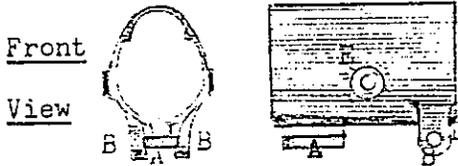
Model 1892/96/98



Front and Rear - Identical with small butt place screw.

UPPER BAND

Pattern 1 - Model 1892, Variation 1

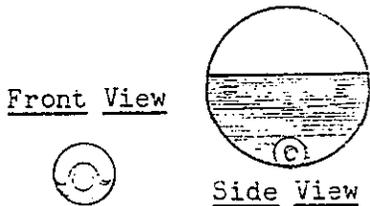


Parts List

- A Bayonet stud
- B Stacking swivel ears
- D Swivel screw hole
- E Band screw hole

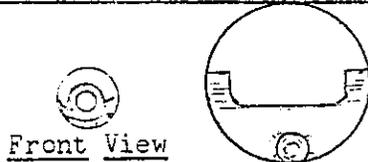
Special Note: The early M 92 upper bands did not have a ramrod bushing/tab/hole. Ref: SN 5 at Springfield Museum & SN 332.

Pattern 2 - Model 1892, Variation 2



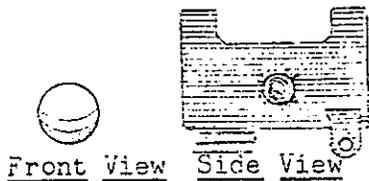
Solid band with ramrod bushing/tab/hole added

Pattern 3 - Model 1892, Variation 3



Special Note: Band cut-out over barrel - has ramrod bushing/tab/hole.

Pattern 4 - Model 1896 - Model 1892 Retro-Fit



Split Band without ramrod bushing/tab/hole.

Model 1896 Changes -- Ramrod bushing omitted

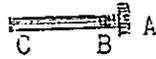
Pattern 5 - Model 1898

Model 1898 Changes -- Cut made between stacking swivel ears that permits the "binding" of the stacking swivel.

Stock/Mounting Group

UPPER BAND SCREW

Model 1892/96/98

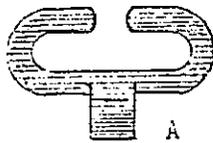


Parts List

- A Head
- B Threads
- C Pin

STACKING SWIVEL

Model 1892/96/98



Parts List

- A Lug

Special Note: The Model 1892 stacking swivel is held in place by the screw, about which it has, however, free motion. The Model 1896/98 stacking swivel is held in the same manner, but the screw will "bind" the swivel.

STACKING SWIVEL SCREW

Pattern 1, Model 1892



Eight threads

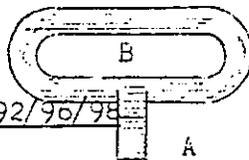


Five threads

Pattern 2, Model 1896/98

LOWER BAND SWIVEL

Model 1892/96/98



Parts List

- A Lug
- B Sling loop

Special Note: When the screw is tightened the ears are drawn together but the swivel retains its free motion.

LOWER BAND SWIVEL SCREW

Model 1892/96/98



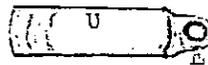
Special Note: When installed the screw is upset in place.

LOWER BAND

Model 1892/96/98

Parts List

- A Body
- B Creases
- C Shoulders
- D Swivel ears



E Swivel screw holes

LOWER BAND PIN

Item of Interest: The upper end of the letter "U" indicates the front of the band.

Special Note:

Model 1892/96/98



UNITED STATES MAGAZINE RIFLE AND CARBINE - CALIBER .30

MODEL 1892 - 1896 - 1898

CHRONOLOGY OF CHANGES AND MODIFICATIONS

Production Changes to Model 1892

1894

- Apr 2 - TRIGGER--Case-hardened in water instead of in oil.
- Jun 1 - SIDE PLATE SCREW--Shortened in length one thread.
- Jun 20 - FRONT SIGHT--Height of top above axis of bore increased from 0".82 to 0".85.
- Aug 16 - UPPER BAND--Middle portion over barrel removed.
- Sep 8 - GUIDE LIP--Tenon to enter groove in receiver omitted.
RECEIVER--Groove for guide lip tenon omitted.
- Oct 22 - SAFETY LOCK SPINDLE--Depth of safety lock pin groove reduced. Note: The spindle with deep groove is known as Model 1892, 1st Pattern; and with the shallow groove, as Model 1892, 2nd Pattern.

1895

- Jan 28 - EJECTOR PIN--Head rounded and length increased.
RECEIVER--Slot for ejector pin head omitted.
- SIDE PLATE--Hole for ejector pin head added.
- Mar 4 - CARRIER--Magazine spring lug shortened.
- Apr 1 - GATE--Length of lug reduced 0".0065.
BAYONET BLADE--Blowing stopped.

SLEEVE--Safety lock pin hole raised 0".03. Note: The sleeve with low safety lock pin hole is known as Model 1892, 1st pattern; and with high hole as Model 1892, 2nd pattern.

Apr 30 - CUT-OFF---Thickness of thumb-piece increased 0".015 and slot for flat spring replaced with spring spindle hole.

CUT-OFF SPRING---Flat replaced by spiral pattern.

CUT-OFF SPRING SPINDLE---Added.

May 11 - HINGE BAR HEAD---Rear right edge rounded.

May 27 - RECEIVER---Walls of trigger heel slot omitted.

Jun 4 - HINGE BAR HEAD---Fillet added at junction of spring and head.

Jun 15 - SLEEVE---Knurling omitted.

Jun 17 - BOLT---About one-fourth of left side of guide rib removed.

Jun 29 - BOLT---Slot for securing stud omitted.

SLEEVE---Securing stud and rivet omitted.

Jul 15 - CUT-OFF---Blued instead of spring tempered.

HINGE BAR PIN---Blued instead of spring tempered.

BAYONET SCABBARD MOUTHPIECE---Aperture for blade made rectangular.

Aug 1 - COCKING PIECE---Made of high instead of low steel.

Aug 6 - CUT-OFF SPRING SPINDLE---Length increased 0".013.

Sep 3 - EXTRACTOR---Depth of extractor spring pivot hole increased 0".028.

Oct 8 - GATE---Fillet added at junction of lug and hinge.

---Shape of exterior and interior of front end changed.

Oct 15 - RECEIVER---Depth of cut-off spring spindle recesses increased.

Oct 25 - SEAR---Made of low instead of high steel

Page 3

Nov 15 - TRIGGER PIN--Length reduced 0".045.

Nov 26 - REAR SIGHT--Model 1892 (sight) became obsolete and Model 1896 adopted.

REAR SIGHT BASE SCREW, FRONT--Body reduced in length 0".01, end made flat and thread cut nearer head in Model 1896 (sight).

REAR SIGHT BASE SCREW, REAR--Body reduced in length 0".01, end made flat and thread cut nearer head in Model 1896 (sight).

SEAR--Nose shortened 0".005.

Dec 2 - STRIKER--Point rounded

1896

Jan 25 - EXTRACTOR--Fillet added at junction of underside of body and heel.

Jan 30 - HINGE BAR HEAD--Width of lug on spring reduced 0".03.

Changes Embodied in the Model 1896

BARREL--Muzzle rounded.

BUTT PLATE--Thickness increased 0".04 toe curved, cap hole and spring lug added.

BUTT PLATE CAP, CAP PIN, CAP SPRING AND CAP SPRING SCREW--Added.

BUTT PLATE SCREW, LARGE--Head made flat.

COCKING PIECE--Rear part of lug beveled and locking notch added.

EXTRACTOR--Extractor pin lug added.

EXTRACTOR SCREW--Replaced by Extractor Rivet.

EXTRACTOR PIN--Added.

FRONT SIGHT STUD--Width of slot reduced to 0".05.

FRONT SIGHT--Thickness made 0".05 throughout, and shape of top changed.

FRONT SIGHT PIN--Length increased and taper changed.

GUIDE LIP--Thickness increased.

HAND GUARD BODY--Extended rearward over tenon of receiver and heads of rivets countersunk deeper.

HAND GUARD RIVETS, FRONT AND REAR--Shortened.

HAND GUARD SPRINGS--Crimp omitted.

MAIN SPRING--Length increased from $30\frac{1}{2}$ to $33\frac{1}{2}$ coils.

RAMROD--Omitted.

RAMROD STOP--Omitted.

CLEANING ROD--Made jointed and inserted in butt of stock.

RECEIVER--Extractor pin notch added.

SAFETY LOCK--Thickness of thumb-piece increased; thumb-piece and spindle made separate, and spring and spring spindle added.

SAFETY LOCK PIN--Omitted.

SIDE PLATE--Thickness of upper half increased and cartridge rib lengthened.

SLEEVE--Safety lock pin omitted.

Front end of barrel shortened 0".0345.

Thickness of extractor arm reduced 0".035.

Countersink for screw head omitted, and lower part of rivet hole countersunk for rivet head.

Groove with a recess at each end added for safety lock spring spindle.

STOCK--Small enlarged.

Toe rounded.

Two holes, 1" in diameter, to decrease weight, and three small holes for cleaning rod drilled in butt.

Ciler seat cut between large holes.

Channels cut under barrel to decrease weight.

Ramrod groove and stop slot omitted.

UPPER BAND--Bushing for ramrod omitted.

Production Changes to Model 1896

1897

Apr 17 - BAYONET SCABBARD HOOK--Oscillation limited to 100°.

1898

Jul 1 - REAR SIGHT BASE SCREW, FRONT--Made identical with the Carbine rear sight base screw, front.

Changes Embodied in the Model 1898

BOLT--Length of flat surface on underside of handle increased.

CARRIER--Arbor made perpendicular to top and shortened 0".02, and distance between lug and bottom side of body decreased 0".02.

CUT-OFF--Flattening of spindle reversed, length of spindle decreased 0".5, rear upper edge of thumb-piece beveled and fillet added at junction of spindle and thumb-piece.

GATE--Curvature of exterior and shape of interior at rear end changed, and bevel on the front part of the interior of the top omitted.

MAIN SPRING--Weight reduced from 18 to 22 pounds to 16 to 18 pounds.

RECEIVER--Cut-off hole reduced 0".5 in depth and position slightly changed.

Width of mortise for side plate tenon increased 0".02.

That part of the bolt handle seat projecting beyond tang omitted.

Outside of right wall over gate beveled.

Bearing for top side of carrier, in carrier arbor cavity, lowered 0".02.

That part of the left wall of the magazine spring channel projecting beyond the bottom wall omitted.

Mark on side of tenon for position of barrel omitted.

Top of carrier arbor ear lowered to project only slightly above top of gate.

Bottom of magazine spring channel made parallel to bottom of magazine.

SIDE PLATE--Thickness of tenon increased 0".02.

STOCK--Bolt handle seat changed.

Source Document: "Description and Rules for the Management of the U.S. MAGAZINE RIFLE AND CARBINE.
Calibre .30." Ordnance Department U.S.A. Washington: Government Printing Office.
1898.

United States Magazine Rifles and Carbines - Calibre .30

Models 1892 - 1896 - 1898 - 1899 R&C

Annual Production and Approximate End-of-Year Serial Numbers

CALENDAR YEAR - FISCAL YEAR

UNITED STATES MAGAZINE RIFLE AND CARBINE - CALIBER .30

MODELS 1892 - 1896 - 1898 - 1899 - 1899

<u>CALENDAR YEAR</u>	<u>ANNUAL PRODUCTION</u>	<u>MONTHLY RATE</u>	<u>SERIAL NUMBER</u>
1894	10196	850	10196
1895	13663	1139	23859
1896	27143	2262	51002
1897	36709	3059	87711
1898	73439	6120	161150
1899	82570	6880	243720
1900	59626	4969	303346
1901	61323	5110	364669
1902	62542	5212	427211
1903	78846	6570	506057

UNITED STATES MAGAZINE RIFLE AND CARBINE - CALIBER .30

MODELS 1892 - 1896 - 1898 - 1899

ANNUAL PRODUCTION AND APPROXIMATE END-OF-YEAR SERIAL NUMBERS

<u>FISCAL YEAR</u>	<u>RIFLES</u>	<u>CARBINES</u>	<u>ANNUAL TOTAL</u>	<u>MONTHLY RATE</u>	<u>SERIAL NUMBER</u>
1894	2951	-	2951	492	2951
1895	14491	-	14491	1208	17442
1896	10535	7111	17646	1471	35088
1897	28899	2930	31829	2652	66918
1898	29566	12022	41588	3464	108505
1899	100228	5002	105230	8769	213735
1900	54701	5150	59851	4988	273586
1901	48499	10901	59400	4950	332986
1902	43246	20000	63246	5270	396232
1903	61838	-	61838	5153	458070
1904	<u>47929</u>	<u>-</u>	<u>47929</u>	<u>3994</u>	<u>505999</u>
Totals	442883	63116	505999	-	-

Source of Data: Hicks, James E. Notes on United States Ordnance, Volume I, Small Arms, 1776 to 1940

Special Note: While the basic production figures are valid they have been CORRECTED to reflect FISCAL YEAR rather than CALENDAR YEAR with arms production ending in November of 1903.

The United States Magazine Rifles & Carbines - Calibre .30

an

Analysis

of

Production

by

CALENDAR MONTH/YEAR - FISCAL YEAR - MODEL/TYPE - PRODUCTION RATE - SERIAL NUMBER

THE UNITED STATES MAGAZINE RIFLE & CARBINE - CALIBER .30

AN ANALYSIS OF PRODUCTION BY

CALENDAR MONTH/YEAR - FISCAL YEAR - MODEL/TYPE - PRODUCTION RATE - SERIAL NUMBER

Jan				492
Feb				983
Mar				1475
Apr				1965
May				2457
Jun	CY1894	2951 ttl	FY1894	2951
Jul		491 per mo		4159
Aug				5367
Sep				6575
Oct				7783
Nov				8991
Dec				10199
Jan				11407
Feb				12615
Mar				13823
Apr				15031
May				16239
Jun	CY1895	1208 per mo		17442
Jul		17646 ttl		18912
Aug				20382
Sep				21852
Oct				23322
Nov				24792
Dec				26262

Jan				27732
Feb				29202
Mar				30672
Apr				32142
May				33612
Jun	CY1896	1471 per mo	FY1896	35088
Jul		31829 ttl	M92/96 Rifle Transition	37740
Aug				40392
Sep				43044
Oct				45896
Nov				48348
Dec				51002
Jan				53654
Feb				56306
Mar				58958
Apr				61610
May				64262
Jun	CY1897	2652 per mo	M96 Rifle	66917
Jul		41588 ttl		70383
Aug				73848
Sep				77313
Oct				80778
Nov				84243
Dec				87708

Jan	CY1903	3994 per mo FY1904	47929 ttl FY1903	5153 per mo FY1903	M98 Rifle	432303
Feb						437456
Mar						442609
Apr						447762
May						452915
Jun						458069
Jul						467653
Aug						477238
Sep						486823
Oct						496408
Nov						505999
Dec						-

BOLT ASSEMBLY

COMPONENT PART APPLICABILITY
BY
PATTERN AND FORM

<u>Component Part</u>	<u>Serial Number/Assembly Form</u>												
	Form 1 - 0	Form 2 - 7460	Form 3 - 16843	Form 4 - 16923	Form 5 - 17406	Form 6 - 18912	Form 7 - 20529	Form 8 - 24890	Form 9 - 35088	Form 10 - 35088	Form 11 - 35088	Form 12 - 108505	Form 13 - 213735
1. Bolt	1	1	1	2	3	3	3	3	3	3	4	5	5
2. Sleeve	1	2	3	3	4	4	4	4	5	5	6	6	6
3. Securing Stud	1	1	1	1 ^d	-	-	-	-	-	-	-	-	-
4. Securing Stud Rivet	1	1	1	1 ^d	-	-	-	-	-	-	-	-	-
5. Extractor	1	1	1	1	1	1	2	2	3	4	4	4	4
6. Extractor Spring	1	1	1	1	1	1	1	1	1	1	1	1	1
7. Extractor Screw	1	1	1	1	1	1	1	1	1	1	1 ^d	-	-
8. Extractor Pin	-	-	-	-	-	-	-	-	-	^a 1	1	1	1
9. Extractor Rivet	-	-	-	-	-	-	-	-	-	-	-	^a 1	1
10. Cocking Piece	1	1	1	1	1	2	2	2	2	2	3	3	4 ^C
11. Firing Pin	1	1	1	1	1	1	1	1	1	1	1	1	1
12. Striker	1	1	1	1	1	1	1	2	2	2	3	3	3
13. Main Spring	1	1	1	1	1	1	1	1	2	2	3	3	3
14. Safety Lock	1	2	2	2	2	2	2	2	2	2 ^d	-	-	-
15. Safety Lock Pin	1	1	1	1	1	1	1	1	1	1 ^d	-	-	-
16. Safety Lock Thumb Piece	-	-	-	-	-	-	-	-	-	-	^a 1	1	1
17. Safety Lock Spindle	-	-	-	-	-	-	-	-	-	-	^a 1	1	1
18. Safety Lock Spring	-	-	-	-	-	-	-	-	-	-	^a 1	1	1
19. Safety Lock Spring Spindle	-	-	-	-	-	-	-	-	-	-	^a 1	1	1

Legend: - Not applicable

d Deleted

a Added

C Carbine