How to: Disassemble and Reassemble

## the Madsen M47/Colombian M1958 bolt

Click on any of the images below to see a larger version of the image.



Disassembly Instructions

figure 1

1) Open the bolt.

**NOTE:** Make sure rifle is unloaded and pointed in a safe direction before proceeding.



2) Depress trigger.



**3)** While **trigger** is depressed, remove **bolt** from **rifle**.



4) Pull cocking piece and sleeve to full extent (as shown in figure 4).



5) Turn cocking piece and sleeve and let sear contact lug rest on lip of safety as shown in figure 5.

Turn cocking piece either

direction and pull out of **bolt**.

Note: Safety has a lug (as shown in legend above) that fits into a channel on the inside of the bolt.



6) There is a spring loaded piston/cam (as shown in legend above) at the top of the sear contact lug that keeps cocking piece in place.

Place tip of striker on block of wood.

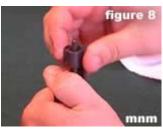
Make sure you have a good downward grip on the safety (as shown in **figure 6**) as spring is under pressure.

Depress piston (as shown in figure 6) and unscrew cocking piece by turning counter clockwise.

7) Continue unscrewing the



**cocking piece** and remove while applying constant downward pressure on **safety**.



8) Remove sleeve/sear contact lug.



9) Note that sleeve/sear contact lug is keyed to striker (as shown in figure 9).

Slowly release pressure on **safety** and allow **spring** to expand.



Remove **safety** and set aside.

10) Remove spring from striker.



**11) Figure 11** shows the disassembled **bolt**.





igure 12 12) Return spring to striker.



13) Return safety.



**14)** Align flat sides of **striker** with flat sides of **sleeve**.



15) Return sleeve.



**16)** Place tip of **striker** on block of wood.

Make sure you have a good downward grip on the safety (as shown in figure 16) as spring is

under pressure.

Depress piston/cam and turn cocking piece clockwise.



17) Turn cocking piece and sleeve and let sear contact lug rest on lip of safety (as shown in figure 17).



**18)** Return **striker assembly** to **bolt** and turn **cocking piece** either direction to lock **lug** into **bolt**.



**19) Figure 19** shows the **lug** of the **safety** locked into place inside the **bolt**.

20) Figure 20 shows the channel on the safety and bolt body aligned. The sleeve and sear contact lug slides into and is guided by this channel.





21) Pull and turn sleeve and cocking piece. Slide sear contact lug into channel on bolt (as shown in figure 21).



**22)** Depress **trigger** of **rifle** and return **bolt** to **receiver**.



**23)** Depress magazine follower and close **bolt**.

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