



Model 1903 Drill Rifle

Disassembly and Assembly Instructions

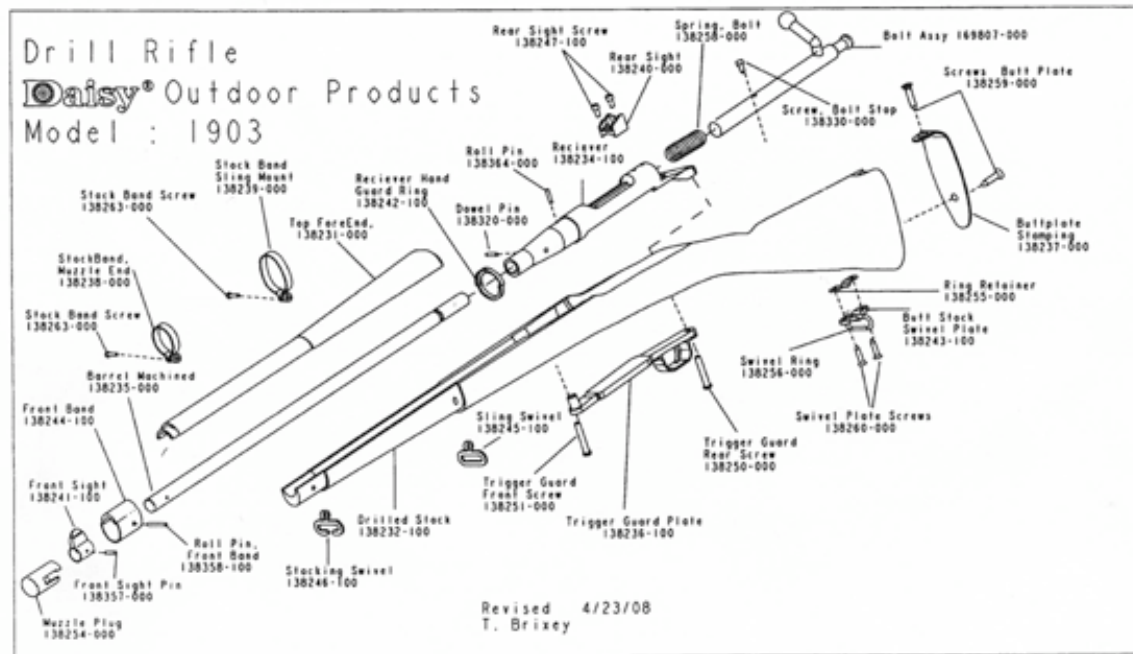


Contents of this CD

- Parts assembly drawing and parts list (slides 3 and 4)
- Tool requirements (slide 5)
- Complete Parts Photo (slide 6)
- Disassembly step-by-step instructions with photos (slides 7 through 26)
- Assembly step-by-step instructions with photos (slides 27 – 46)
- Contact information (slide 47)



Parts Assembly Drawing



*This file is available on this CD as a viewable pdf and jpeg file
("1903 Parts List and Drawing") so that you can enlarge to view or print.*



Parts List



Order Form
FACSIMILE DRILL RIFLE
MODEL 1903

How to Order: Parts should be identified by part numbers listed on this sheet. There is a minimum order of \$2.00. Please enclose remittance by check or money order. Sorry, but no C.O.D. orders on repair parts. Prices are subject to change without notice.

Part No.	Description	Quantity	Price ea	Total
138283-000	STOCK BAND SCREW		\$ 0.25	
138238-000	STOCK BAN MUZZLE END		\$ 4.50	
138239-000	STOCK BAND SLING MOUNT		\$ 4.50	
138231-000	TOP FOREEND		\$ 5.00	
138242-100	RECEIVER HAND GUARD RING		\$ 6.50	
138320-000	DOWEL PIN BARREL		\$ 1.00	
138364-000	KNURL PIN TOP FORE END		\$ 0.50	
138234-100	RECEIVER		\$ 56.00	
138247-000	REAR SIGHT SCREWS		\$ 0.50	
138246-100	REAR SIGHT		\$ 5.50	
138330-000	SCREW, BOLT STOP		\$ 1.00	
999807-000	BOLT		\$ 30.00	
138258-000	BUTT PLATE SCREWS		\$ 0.25	
138258-000	SPRING BOLT		\$ 1.00	
138237-000	BUTT PLATE STAMPING		\$ 7.75	
138255-000	RING RETAINER		\$ 1.50	
138243-100	BUTT STOCK SWIVEL PLATE		\$ 2.50	
138256-000	SWIVEL RING		\$ 2.00	
138250-000	TRIGGER GUARD REAR SCREW		\$ 0.50	
138236-100	TRIGGER GUARD PLATE		\$ 23.00	
138251-000	TRIGGER GUARD FRONT SCREW		\$ 1.25	
138245-100	SLING SWIVEL		\$ 5.00	
138233-100	DRILLED STOCK, PLASTIC		\$ 31.00	
138246-100	STACKING SWIVEL		\$ 8.00	
138358-000	ROLL PIN, FRONT BAND		\$ 0.25	
138357-000	FRONT SIGHT PIN		\$ 0.25	
138254-000	MUZZLE PLUG		\$ 0.50	
138384-000	RUBBER BUTT PLATE		\$ 10.25	
138491-000	BLACK NYLON SLING		\$ 11.25	
138235-000	BARREL		\$ 21.00	
138244-100	FRONT BAND		\$ 5.25	
138241-100	FRONT SIGHT		\$ 5.25	
138260-000	SWIVEL PLATE SCREW		\$ 0.25	
	Ship to address:			
	Name:			
	Address:			
	City:	State:	Zip:	
	Phone:			
	Email:			
			AR res. Only, add 9% Tax	
			Shipping and Handling	
			Grand Total	

CALL 800-643-3458 FOR SHIPPING CHARGES

REFURBISH / NICKEL FINISH REFURBISH 1903 FACSIMILE DRILL RIFLE
 To have your rifle refurbished the cost will be \$23.00 per rifle plus parts that need to be replaced.
 To have your rifle refurbished with the polished nickel finish the cost will be \$173.00 per rifle plus parts that need to be replaced. NEW Nickel finished drill rifle \$380.00.
 Return shipping and handling will be \$6.50 per rifle.

This file is available on this CD as a viewable pdf and jpeg file ("1903 Parts List and Drawing") so that you can enlarge to view or print.



Necessary Tools

To disassemble and reassemble Daisy's 1902 Drill Rifle, the following tools are required:

- #2 Phillips-head screwdriver
- 1/8", 3/16", 9/64" Hex wrench
- 3/16", 11/64" Punch
- Nippers
- Hammer
- Leather or hard rubber hammer
- Note: To ensure trigger guard front and rear screws remain in place, we recommend using a drop of Loctite brand "277".



Photo of All Parts

This photo shows a completely-disassembled Daisy Model 1903 Drill Rifle. Please refer to parts drawing for part numbers.



Disassembly

Using a 1/8" hex wrench, remove the stock band screws (138263-000) from the stock band muzzle end (138238-000).



Disassembly

Then remove the stock band screw (138263-000) from the stock band sling mount (138239-000).



Disassembly

Shown are the two sets of bands, screws and swivels.



Disassembly

Spread the bands to remove over the muzzle.



Disassembly



Using a 3/16” punch and hammer, drive the front band roll pin (138358-100) out of the front band (138244-100).



Disassembly

Note: Once the roll pin is removed, the top fore end (138231-000) is removed.



Disassembly

Using a 3/16" hex wrench, remove the trigger guard rear screw (138250-000) from the trigger guard plate (138236-100).



Disassembly

Using a 3/16" hex wrench, remove the trigger guard front screw (138251-000) from the trigger guard plate (138236-100).



Disassembly

Remove the trigger guard plate (138236-100) from the stock (138232-100).

Note: Barrel/receiver/bolt assembly is now free from the stock.



Disassembly

Using a #2 Phillips head screwdriver, remove the swivel plate screws (138260-000) from the stock.



Disassembly



This removes the butt stock swivel plate (138243-100), swivel ring (138256-000) and ring retainer (138255-000).

Disassembly

To remove the butt plate (138237-000), use a #2 Phillips head screwdriver to remove the butt plate screws (138259-000) from the top and end of the butt plate.



Disassembly

To remove the bolt assembly (169807-000), use a 3/16" hex wrench to remove the bolt stop screw (138330-000).



Disassembly

Remove the bolt (169807-000) then retrieve the bolt spring (138258-000) out of the receiver (138234-100).



Disassembly

Using a 9/64" hex wrench, remove the two rear sight screws (138247-000) from the rear sight (138240-000) to detach from receiver (138234-100).



Disassembly

Using nippers, grasp pin (138364-000) firmly.



Disassembly

Using a leather or hard rubber mallet, strike the top of the front end of the receiver while holding the receiver in a suspended position.



Disassembly

Slide the receiver hand guard ring (138242-100) forward onto the barrel.



Disassembly



Using an 11/64" punch and hammer, remove the dowel pin (138320-000), which retains the barrel, from the side of the receiver (138234-100).

Disassembly

Separate the barrel (138235-000) from the receiver (138234-100).



Assembly



Insert the barrel (138235-000) into the receiver (138234-100) and drive the dowel pin (138320-000) into the hole in the side of the receiver.

Assembly

Note: It is critically important that the flat side of the receiver hand guard ring (138242-000) faces the rear and the cavity side faces forward, toward the muzzle in order to receive the top fore end (138231-000).



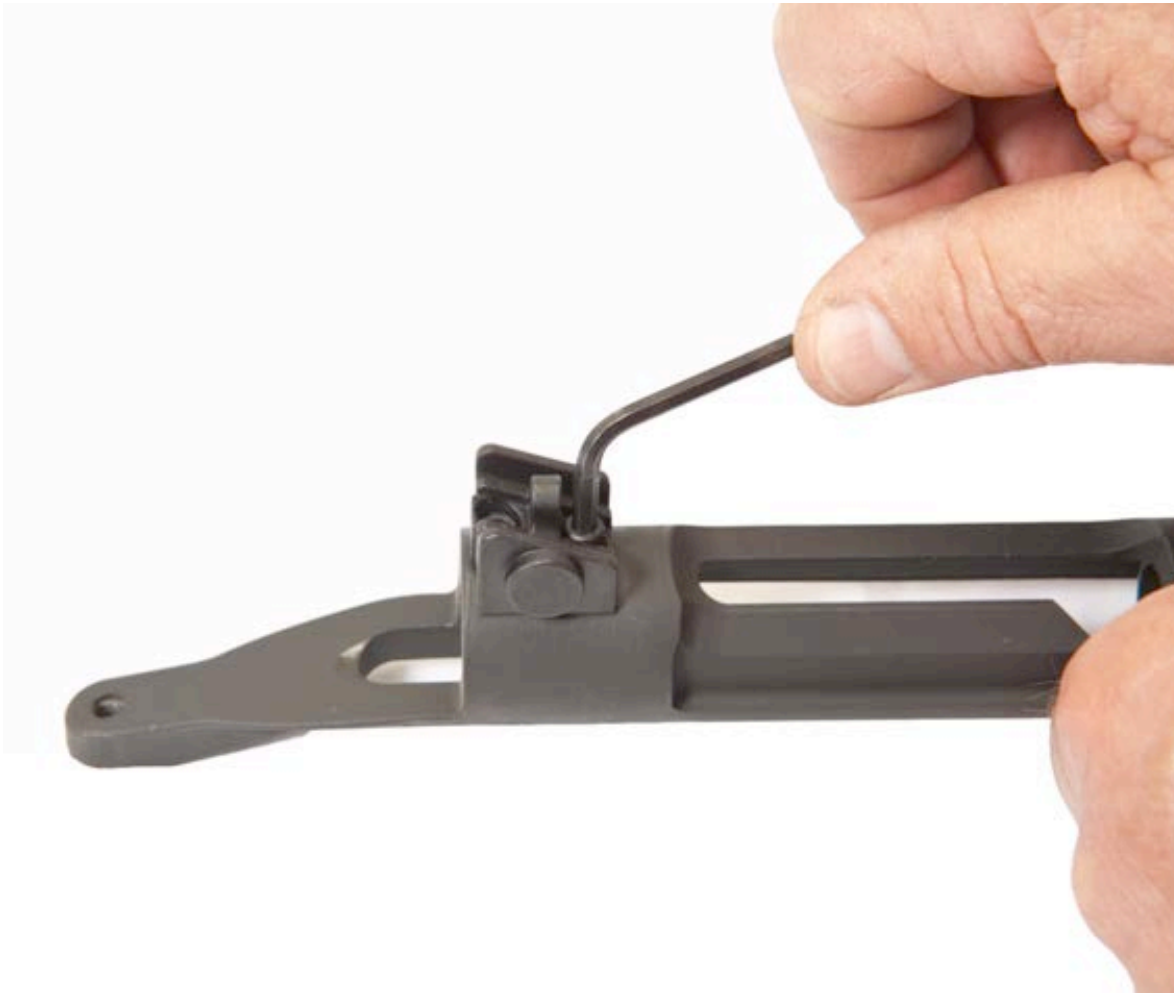
Assembly

Slide the receiver hand guard ring (138242-100) back onto the receiver and install the pin (138364-000). Insert the knurled end into the receiver and tap flush with a hammer.



Assembly

Using a 9/64" hex wrench, reattach the rear sight (138240-000) using two rear sight screws (138247-100).



Assembly

Insert spring (138258-000) into the receiver.



Assembly

Insert bolt (169807-000) into receiver (138234-100).



Assembly

Using a 3/16" hex wrench, screw the bolt stop screw (138330-000) into the bolt (169807-000).



Assembly

Reattach the butt plate (138237-000) to the stock (138232-100)



Assembly

Be sure the weld on the swivel ring (138256-000) is positioned between the swivel plate (138243-100) and the ring retainer (138255-000).



Assembly

Using a #2 Phillips head screwdriver, reassemble and install the swivel plate assembly.



Assembly

Align the receiver hand guard ring (138242-100) with the notch on the stock as you install the receiver/barrel assembly into the stock (138232-100).

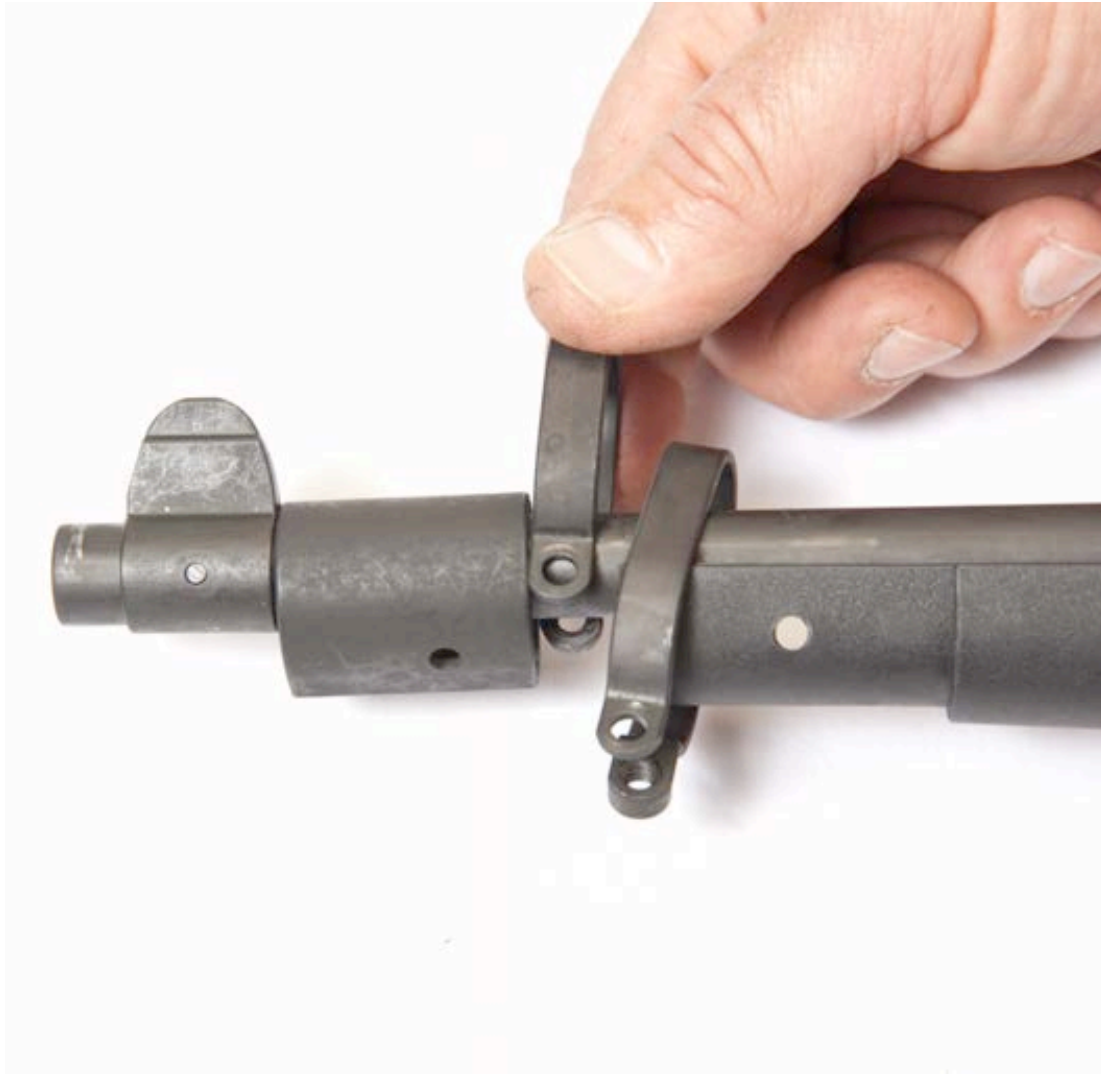


Assembly

Reattach the trigger guard plate (138236-100), using a 3/16" hex wrench to reattach the front (138251-000) and rear (138250-000) trigger guard screws.



Assembly



First reinstall the stock band sling mount (138239-000) over the muzzle. Then install the stock band muzzle end (138238-000) over the muzzle.



Assembly

Tuck the rear end of the top fore end (138231-000) under the lip of the receiver hand guard ring (138242-100).



Assembly

Grasp the front end of the top fore end and slide the stock band sling mount (138239-000) behind the notch on the stock.



Assembly

Slide the stock band muzzle end (138238-000) into place. (photo 42)



Assembly

Slide the front band (138244-100) into place and align holes. (photo 43)



Assembly

Using a hammer, insert the roll pin (138358-100) into the front barrel and tap until the pin is flush.



Assembly

Using a 1/8" hex wrench, secure the stock band sling mount (138239-000) and stock band muzzle end (138238-000) using stock band screws (138263-000).



Assembly



A rubber butt plate (138384-000) is available as an optional accessory.

To install it, remove the standard stamped butt plate and replace it with the rubber butt plate.

Additional Assistance

If you have specific questions or need assistance trouble-shooting a problem, don't hesitate to contact Daisy's Customer Service Department.

1-800-71-DAISY

1-800-713-2479

Daisy Customer Service Department

308 W. Stribling Drive

Rogers, AR 72756



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