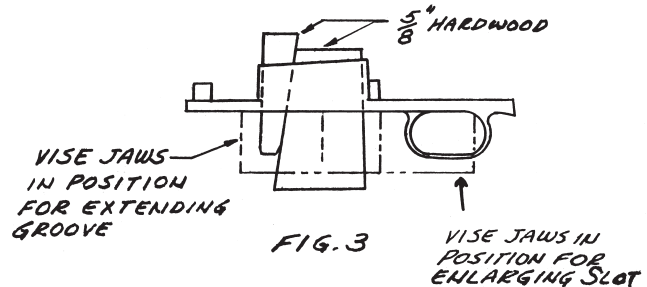
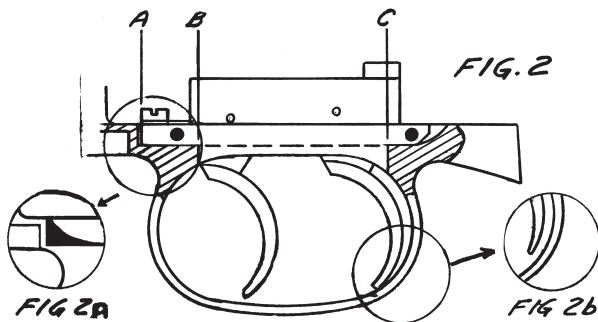
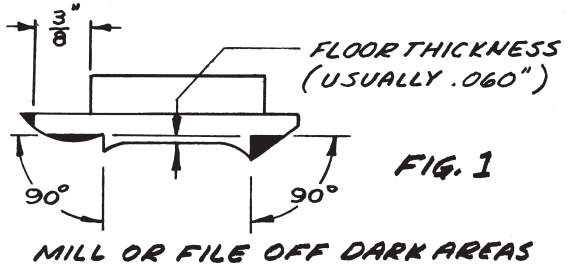


# DOUBLE SET TRIGGER INSTALLATION

The Double Set Trigger (DST) for the Model 98 Mauser comes assembled and includes a loose new kick-off piece. Pulling the rear trigger cocks the front trigger. Then a light pull on the front trigger releases the rear trigger, causing an upward blow on the kick-off cam, which operates the sear bar, overcoming the sear bar spring and releasing the sear and firing pin. The front "trigger pull" is actually sear engagement, and the amount of pull is controlled by the small screw between the triggers. When the front trigger is used alone (un-set) the trigger pull is heavy, determined by the sear bar spring and the reduced leverage of the front trigger. The earlier model Mausers require alterations to the DST body, the triggerguard (TG) and the kick-off piece.

The action should be checked for burrs or machine marks and smoothed on the cocking piece, its sear, the underside of the action where the kick-off piece bears and the top surface of the kick-off piece. Disassemble the DST and coat, with layout dye, the body and the TG behind the magazine to facilitate marking. The dye is helpful, use lots of it. Mark the DST body as indicated in Fig. 1, and mill or file off the surplus metal. Reassemble the DST and clamp beside the TG as shown in Fig. 2. Note that the TG groove will need to be extended forward (Fig 2A) and that the rear trigger may need to be ground to fit the shape of the TG (Fig 2B). If a milling machine is used, a  $\frac{1}{4}$ " end mill will extend the groove forward (Fig 2A) and pierce the floor plate for the enlarged trigger slot. File-fit the corners of the DST body to the radii left by the mill. If a file-and-chisel system is used (and it works well) begin by making wedges of  $\frac{5}{8}$ " hardwood to insert in the magazine well to clamp solidly in the vise. Put several layers of masking tape on the inside bottom of the TG bow and the top of the vise jaws to prevent scratches.



Grind a  $\frac{1}{2}$ " chisel to the groove width for the finish cuts. Remove most of the material with a  $\frac{1}{8}$ " cape chisel, taking off light peels of metal, then finish the removal with the reground  $\frac{1}{2}$ " chisel. BE SURE TO WEAR SAFETY GLASSES. Use the narrow chisel and a NEW 4" mill bastard file, ground safe on one edge, to enlarge the trigger slot to the new size, checking with inletting blue as you go. It doesn't take long unless the chisel is dull and the file is worn out.

When the DST is inletted into the TG to your satisfaction, mount it with two  $\frac{1}{16}$ " diameter cross pins. Brownells' .063" spring wire makes a nice pin and is just enough oversize to allow polishing to fit. Be careful of the drilling, since the tapered sides of the TG may cause the drill to run out if care is not used. The approximate pin locations are shown in Fig. 2 as dark circles.

Assemble the new kick-off piece into the sear bar, cock the firing pin and open the bolt about 30 degrees. The firing pin should remain cocked. The clearance between the bottom of the sear bar and the top of the forward lip of the kick-off piece should be reduced or eliminated by installing an adjusting screw. Remove the kick-off piece and drill a no. 31 hole through the lip, as close as possible to the forward edge, not quite breaking through. Then tap the hole 6x48. The tap will bulge the forward face of the lip. The lip can be pinched slightly in a vise to give tight fit for the 6x48 adjusting screw.

Assemble the action and TG with the DST. Be sure to use the tubular stock bushing on the rear action screw. Cock the firing pin and try the DST. In most Model 93 actions, the triggers will not reach the projection of the kick-off piece, so it will not release the firing pin. Measure the gap and make an extension piece as shown in Fig. 4. Drill rod works well and a piece can be "lathed" to shape using files and a drill. The top of the extension is first fitted to the forward trigger, then to the rear. Be SURE to use the stock bushing on the rear action screw during fitting. When all is in order, silver solder the extension on, or get your local jeweler to do it. The Mauser sear spring is pretty stiff and may need to be carefully shortened to about  $\frac{3}{16}$ " to eliminate some of the pre-load before the trigger will function. Check that jarring the gun will not fire the trigger when set, and adjust the small screw between the triggers to suit. Then "un-set" the trigger, open the bolt and draw back part way. Pull the front trigger. The gun should not be set until on target.

