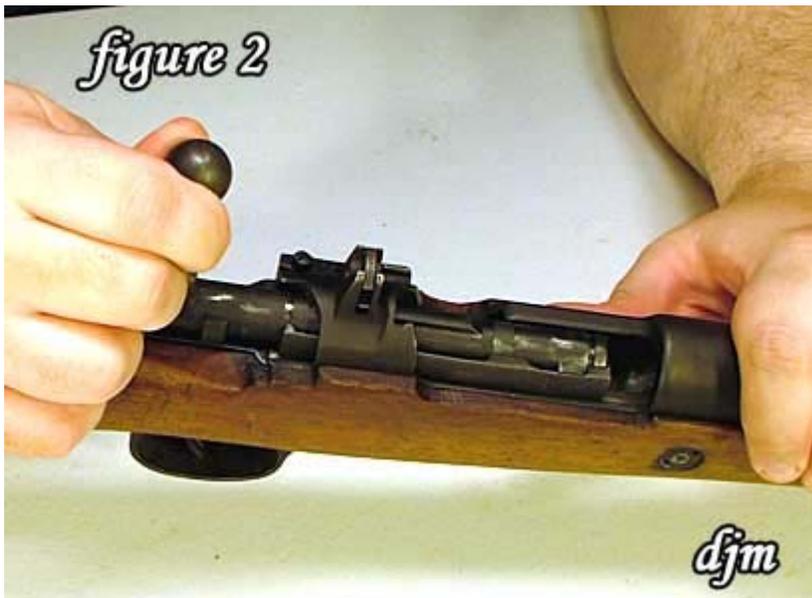


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**Safety First! With the rifle pointed in a safe direction, open the bolt and make sure the rifle is not loaded.**



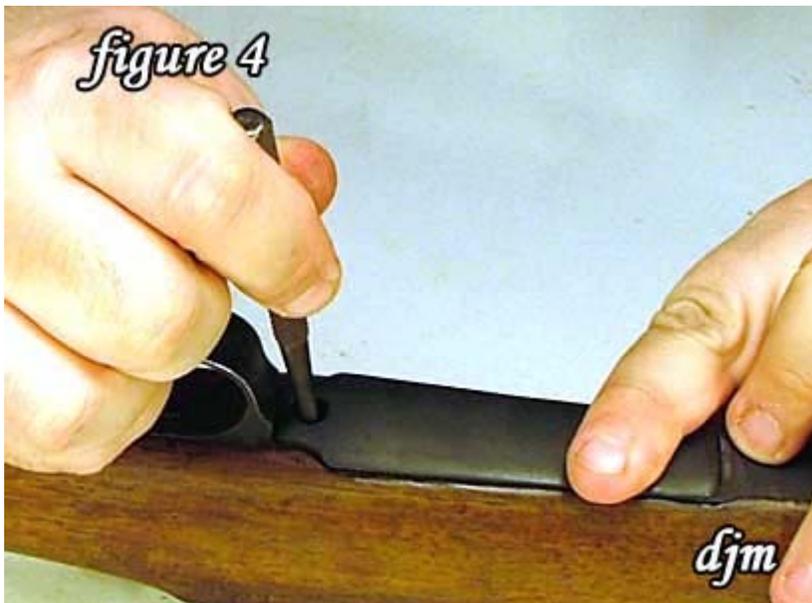
1) Figure 1 shows the Spanish FR-8.



2) Pull the bolt to the rear.



**3) Depress the bolt stop. Remove the bolt from the receiver.**



**4) Depress the magazine catch.**

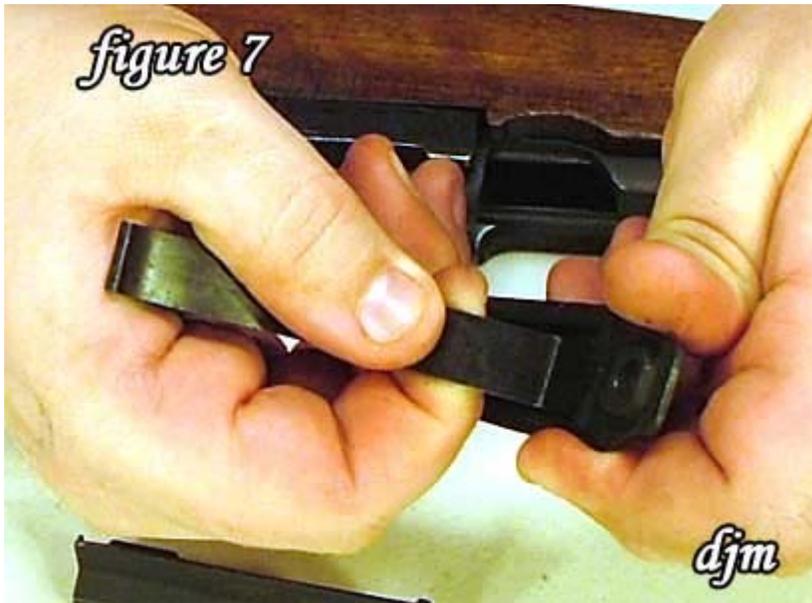
**5) Slightly slide the magazine floor plate to the rear and remove.**



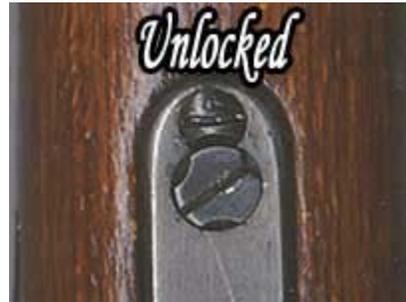
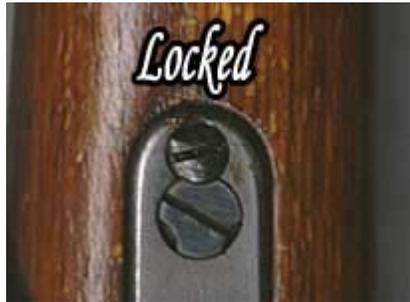
6) Slide the magazine spring from the follower.



7) Slide the magazine spring from the magazine floor plate.



Locking Screws

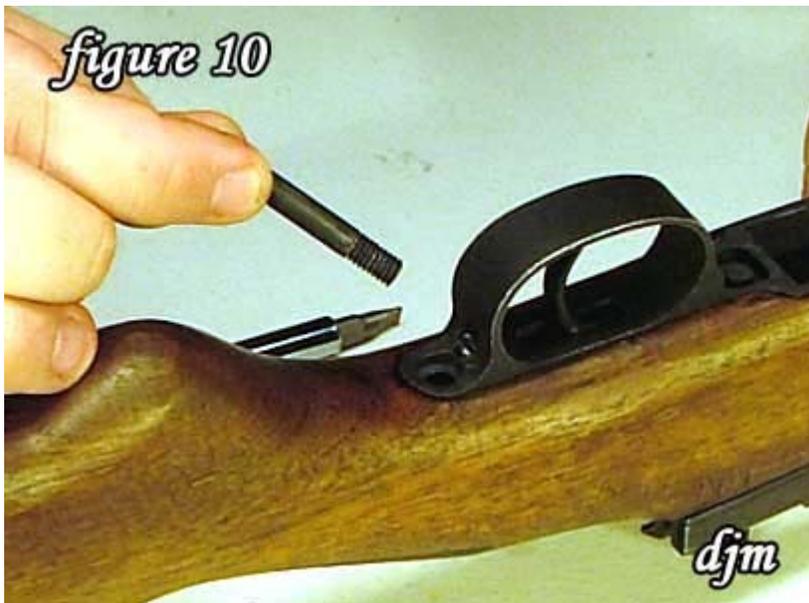


Most 98 type Military Mausers have locking screws that lock the trigger guard screws in place. The two figures to the left show the positions of the locking screws.



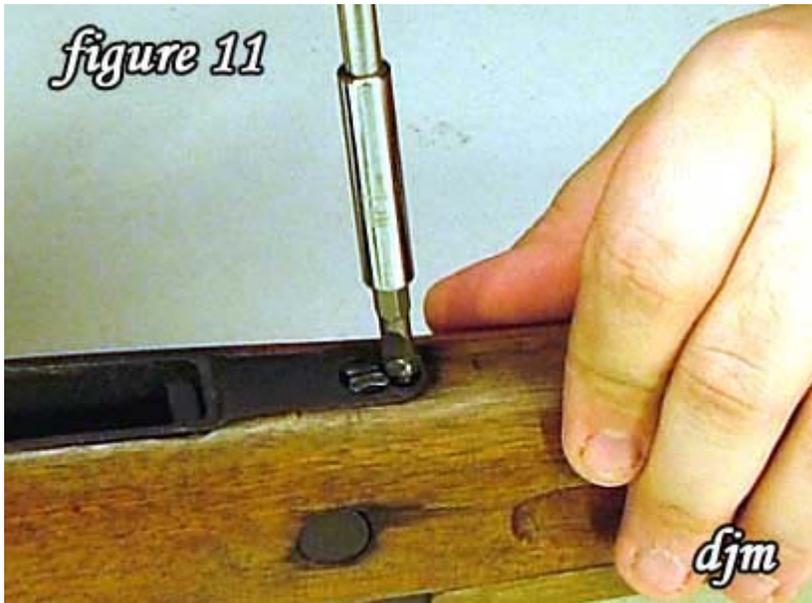
8) Loosen the locking screw to the unlocked position.

9) Unscrew the rear guard screw.



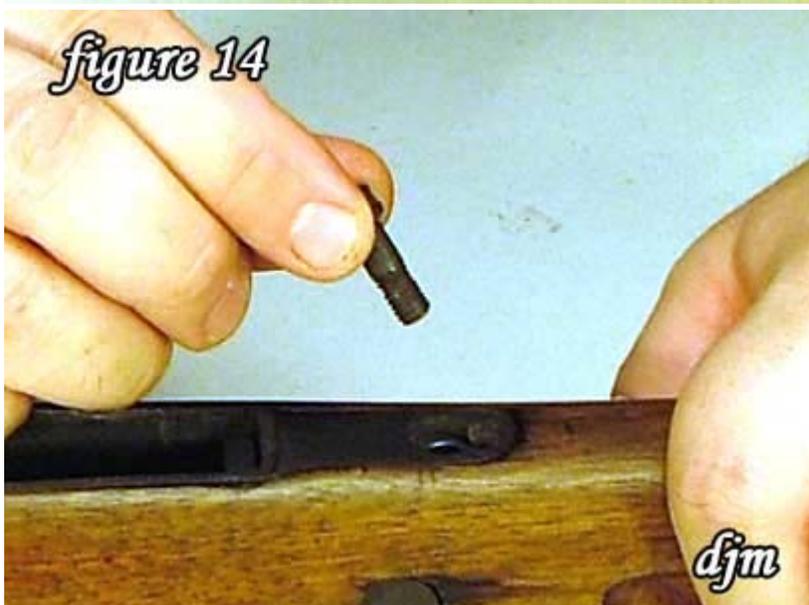
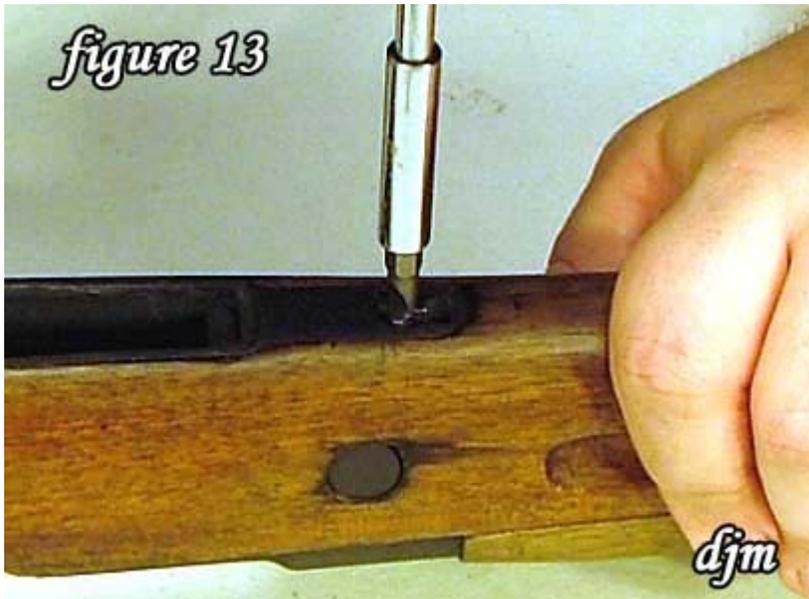
10) Remove the rear guard screw.

11) Sometimes setting the lock screw to the lock position does not allow the guard screw to be removed. In this case completely unscrew the lock screw.



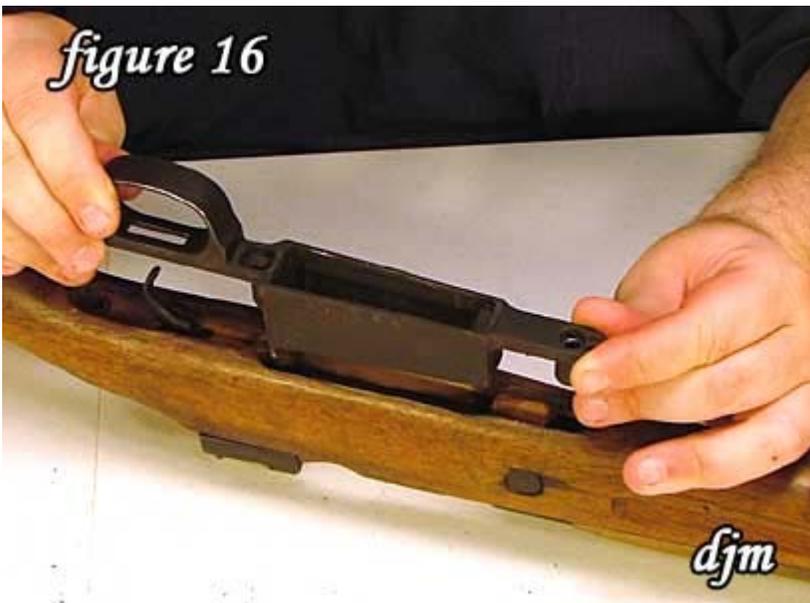
12) Remove the lock screw.

13) Unscrew the forward guard screw.



14) Remove the forward guard screw.

15) If the guard is difficult to remove you can turn the rifle over and tap the guard out from the top using a wooden dowel. Be very careful in this procedure not to damage the stock. Remember you are only trying to loosen the guard, not remove it.



16) Remove the guard once loosened.

17) Depress the cleaning kit tube catch.

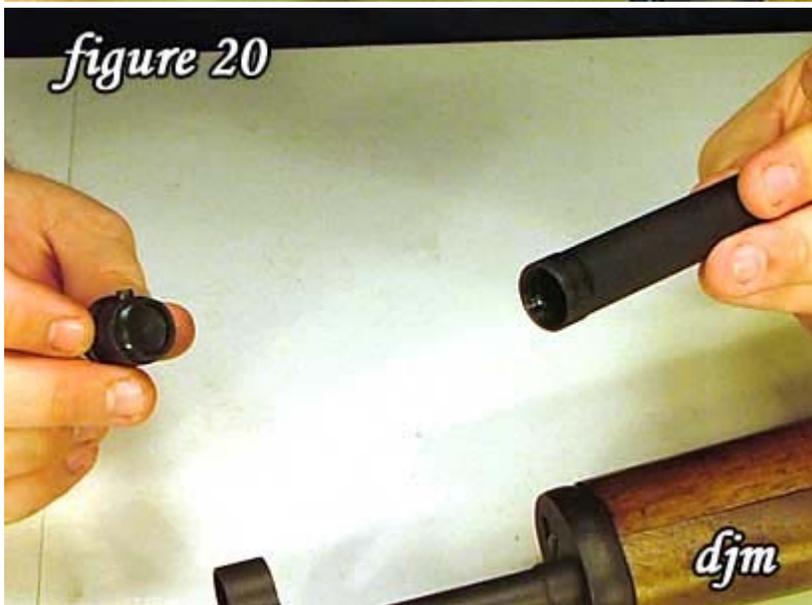


18) Slide the cleaning kit tube forward.

19) Unscrew the cleaning kit tube.



*figure 19*



*figure 20*

20) Figure 20 shows the cleaning kit tube to be a hollow container once the cap is removed.

21) Unscrew the stock band screw.



22) Remove the stock band screw.



23) Slide the stock band forward.



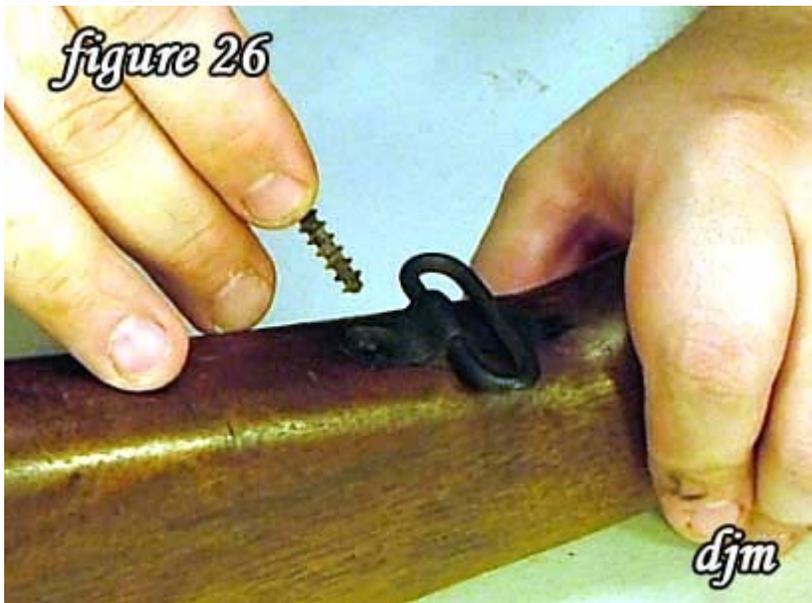
*figure 23*



*figure 24*

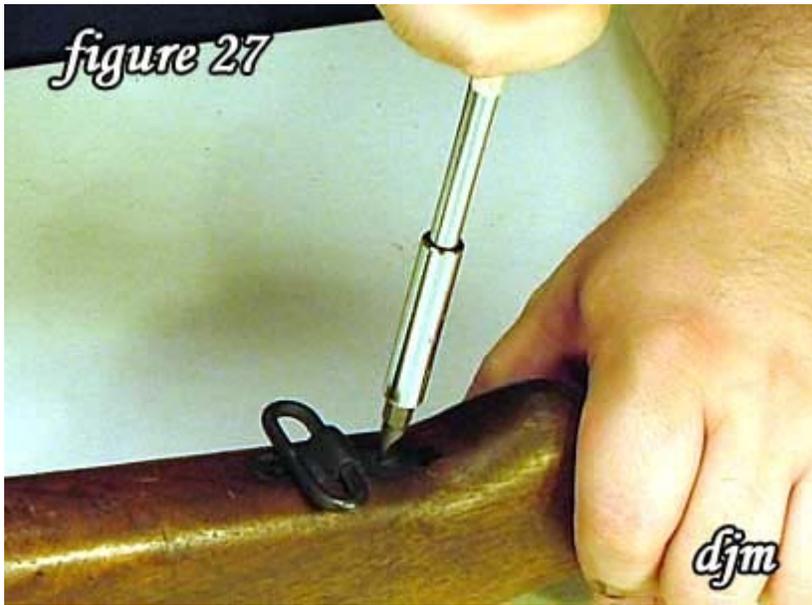
**24) Separate the barreled receiver from the rifle stock.**

**25) Unscrew the rear, rear swivel screw.**



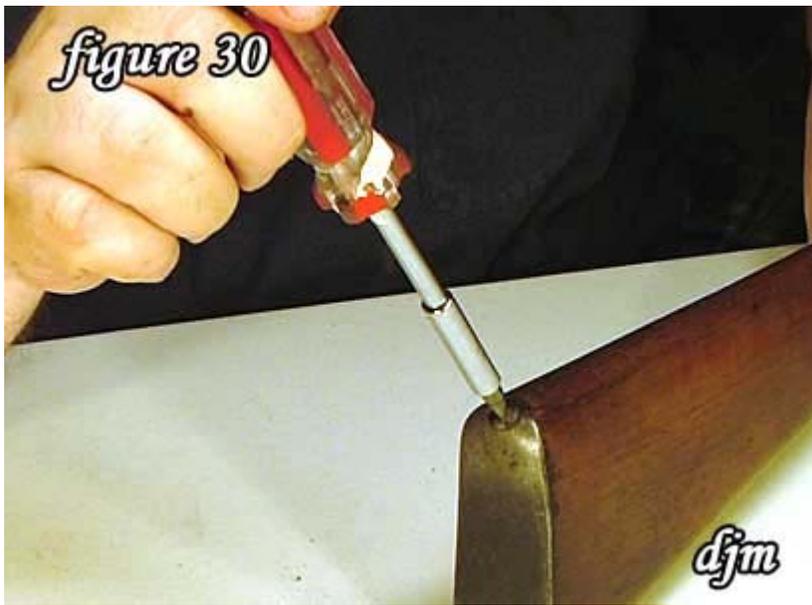
26) Remove the rear, rear swivel screw.

27) Unscrew the front, rear swivel screw.



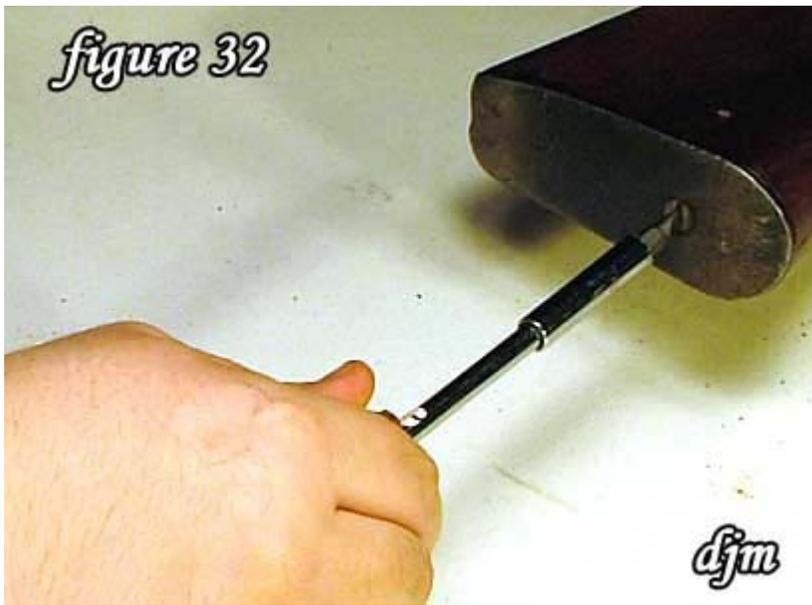
28) Remove the front, rear swivel screw.

29) Remove the rear swivel.



30) Unscrew the upper butt plate screw.

31) Remove the upper butt plate screw.



32) Unscrew the lower butt plate screw.

33) Remove the lower butt plate screw.



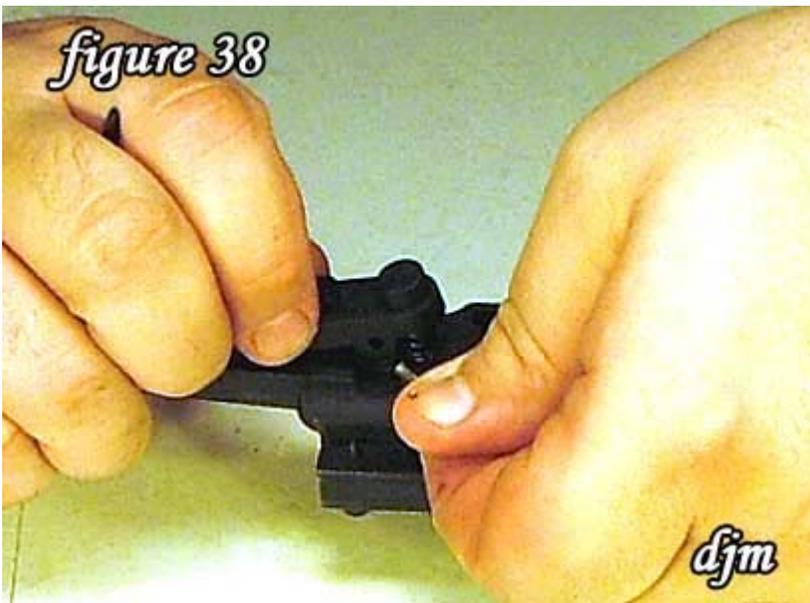
34) Remove the butt plate screw.

35) The FR-8 hand guard is held onto the barrel by a band spring at the rear of the hand guard. Slowly lift the hand guard from the front and separate the spring from the barrel.



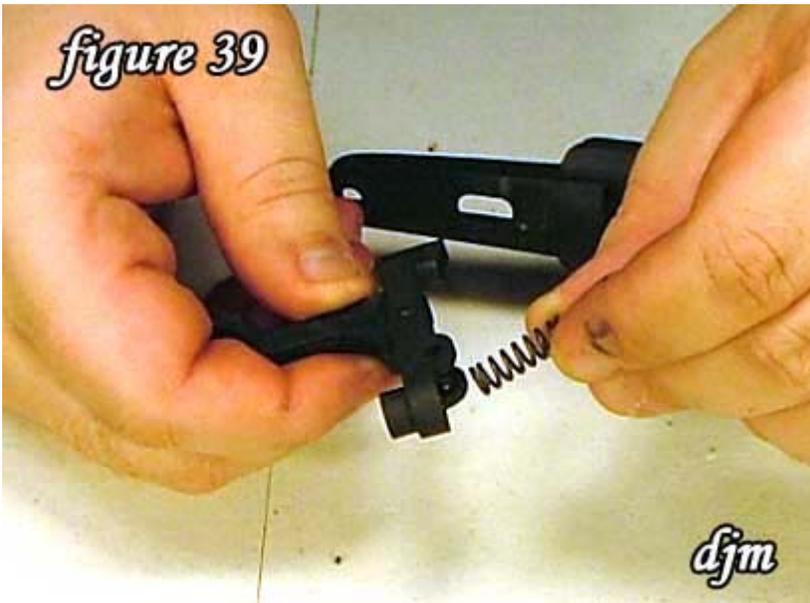
**36) Remove the hand guard. Figure 36 shows the contoured fit of the hand guard and the band spring.**

**37) Using a tap and mallet punch out the sear pin.**



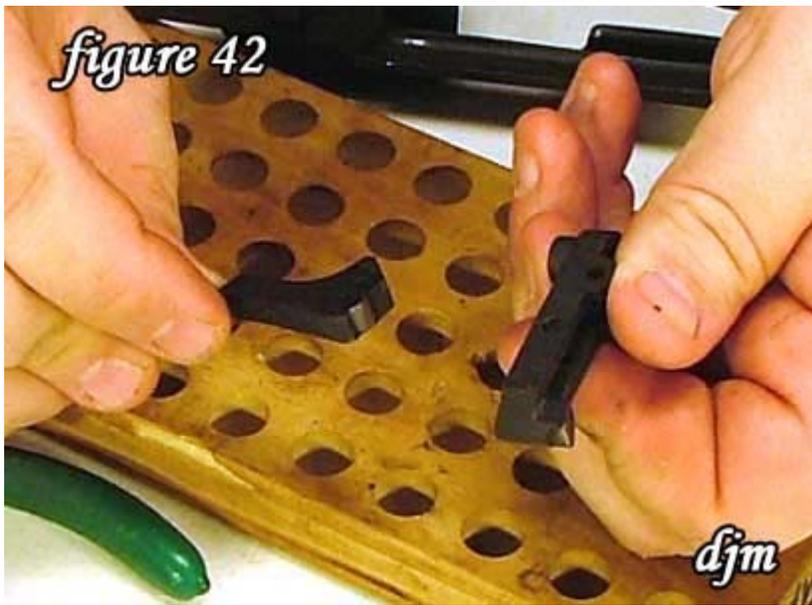
38) Remove the sear pin.

39) Remove the sear spring from the sear.



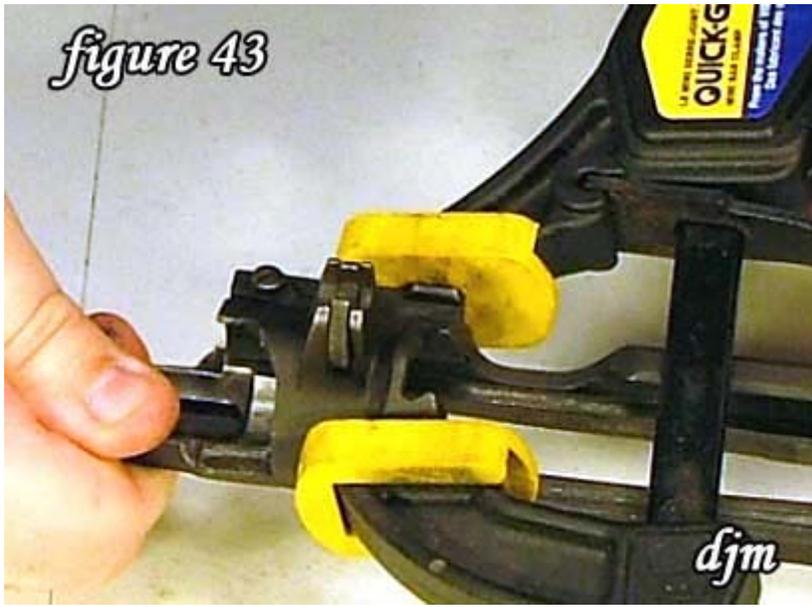
40) Using a tap and mallet punch out the trigger pin.

41) Remove the trigger pin.



42) Separate the trigger (left) from the sear (right).

43) It is easier to remove the bolt stop screw if the bolt stop is held in place.



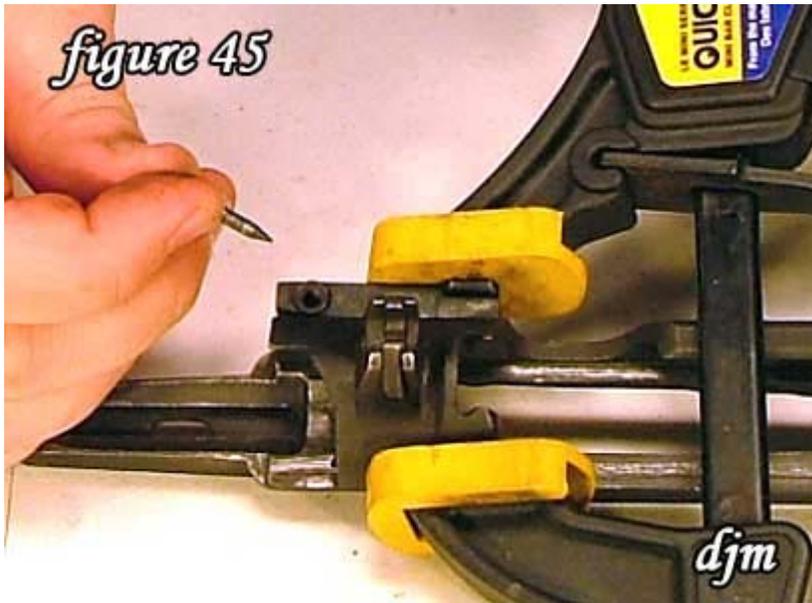
*figure 43*



*figure 44*

44) Unscrew the bolt stop screw.

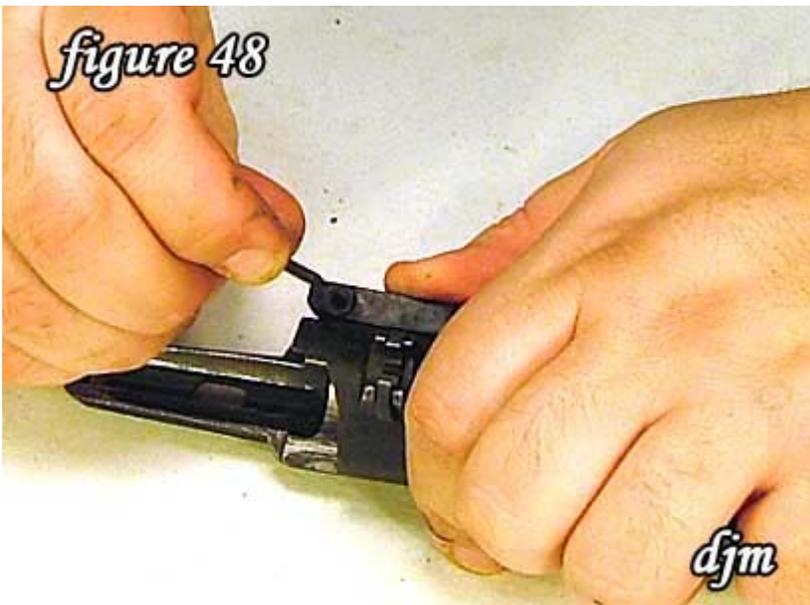
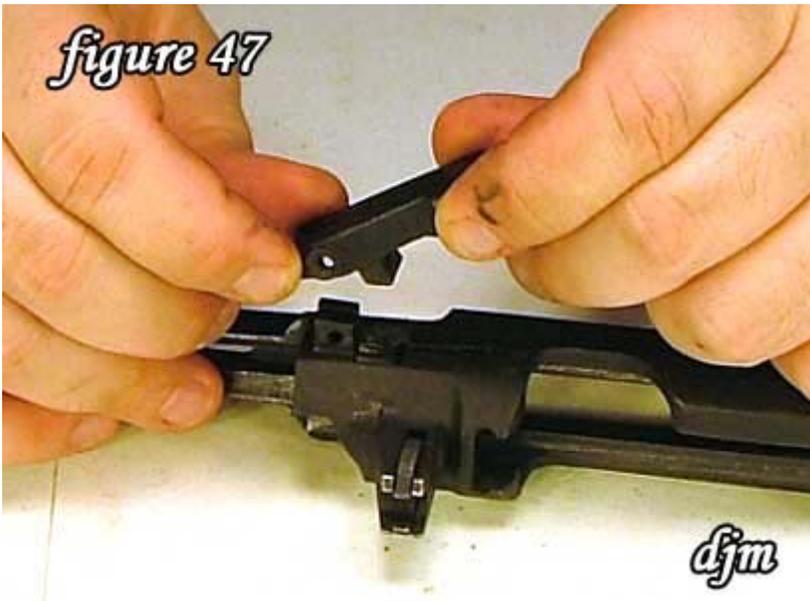
45) Remove the bolt stop screw.



**46) Separate the bolt stop from the receiver.**

**Reassembly Instructions**

**47) Install the bolt stop.**



48) Install the bolt stop screw.

49) Tighten the bolt stop screw.



50) Insert the sear spring.

51) Compress the sear against the receiver. I have found that using a quick clamp to hold the sear in place leaves your hands free while you install the sear pin.



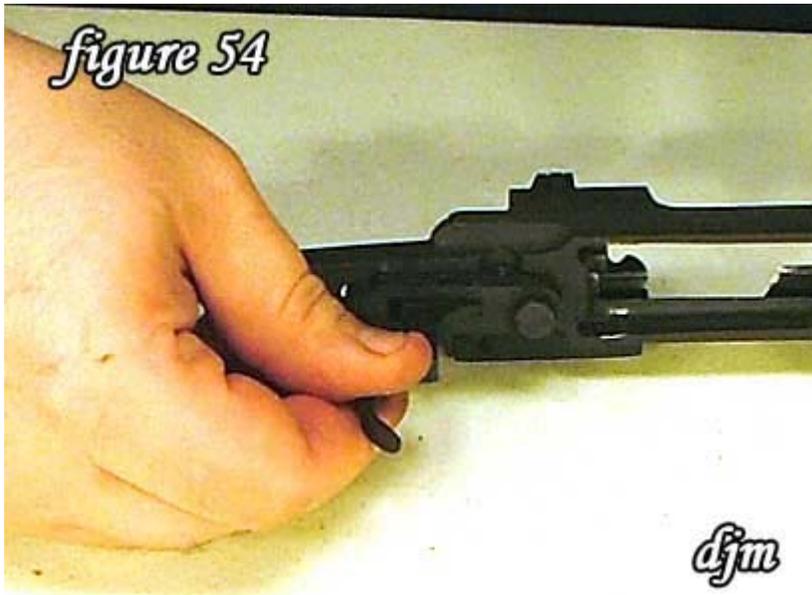
*figure 51*



*figure 52*

52) Install the sear pin into the sear.

53) Tap the sear pin into place with a punch.



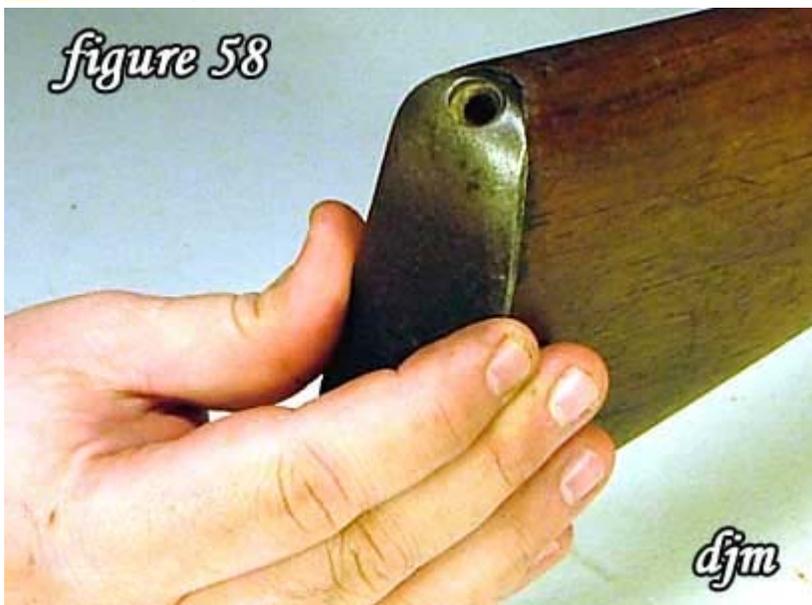
54) Insert the trigger into the sear as shown in figure 54.

55) Insert the trigger pin.



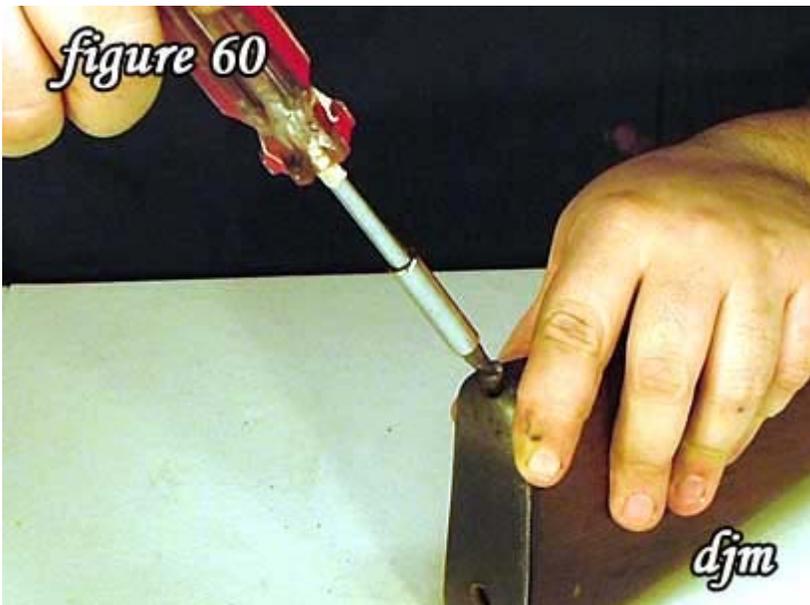
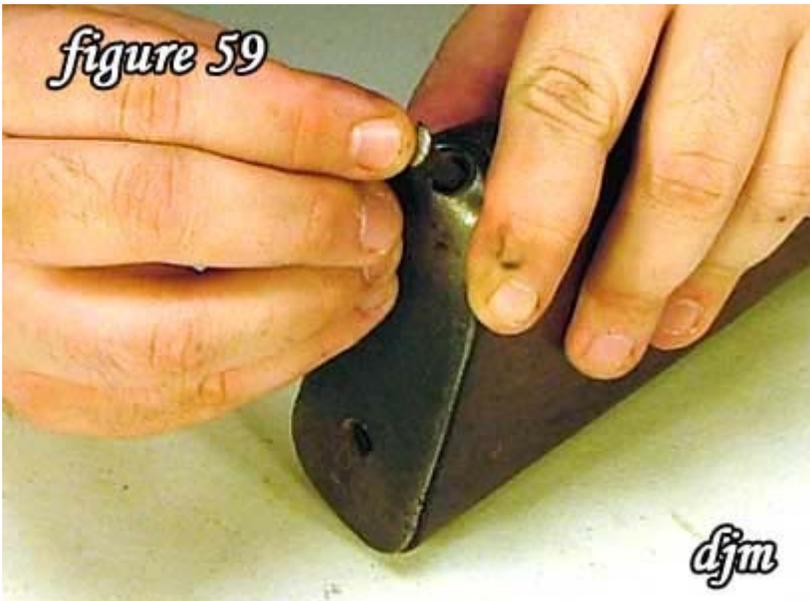
56) Tap in the trigger pin.

57) Test the trigger and make certain it does not bind and functions properly.



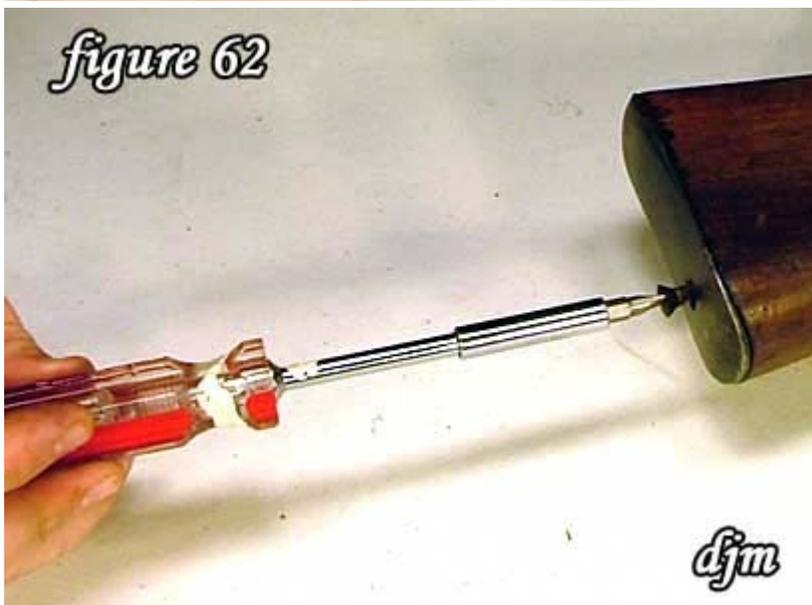
58) Replace the butt plate.

59) Install the upper butt plate screw.



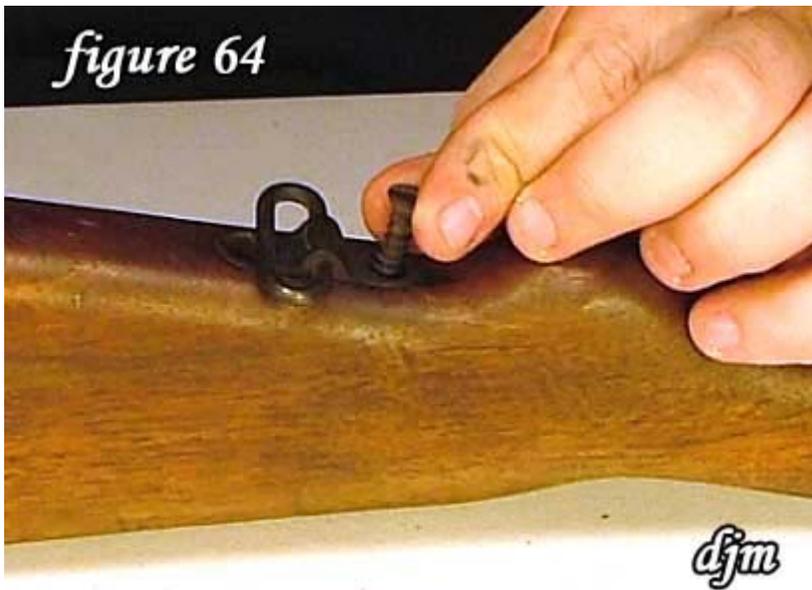
60) Tighten the upper butt plate screw.

61) Install the lower butt plate screw.



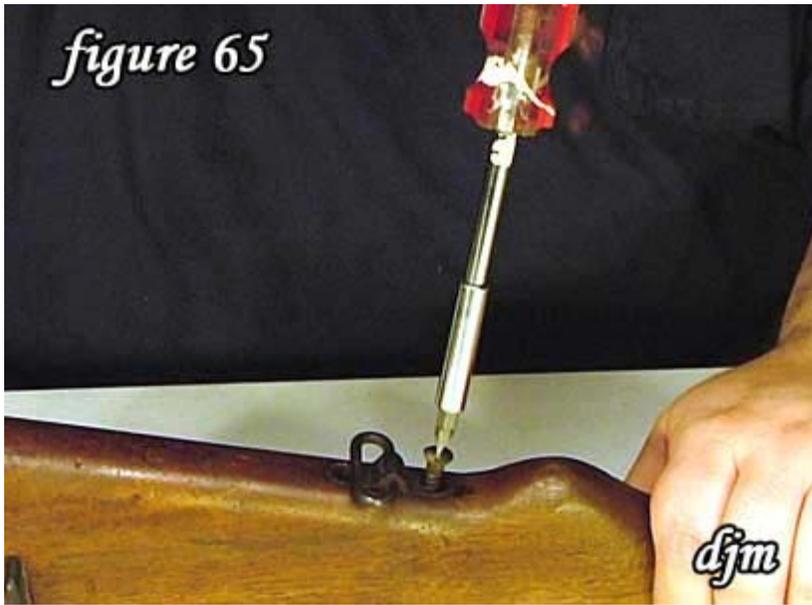
62) Tighten the lower butt plate screw.

63) Replace the rear swivel.



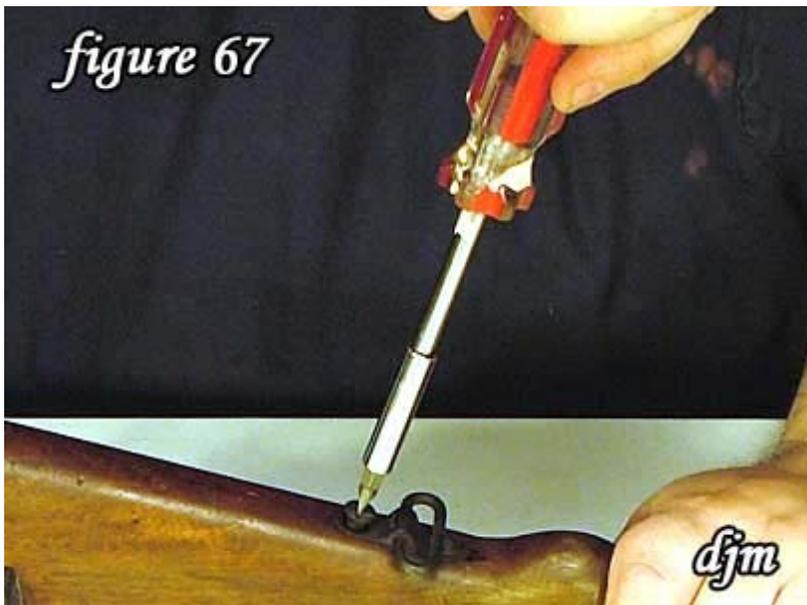
64) Replace the front, rear swivel screw.

65) Tighten the front, rear swivel screw.



66) Replace the rear, rear swivel screw.

67) Tighten the rear, rear swivel screw.



68) Figure 68 shows the contoured fit of the hand guard and the band spring.

69) Snap the hand guard's band spring over the rear of the barrel and slide the hand guard as far to the rear as it will go. When assembled it should look like figure 69.



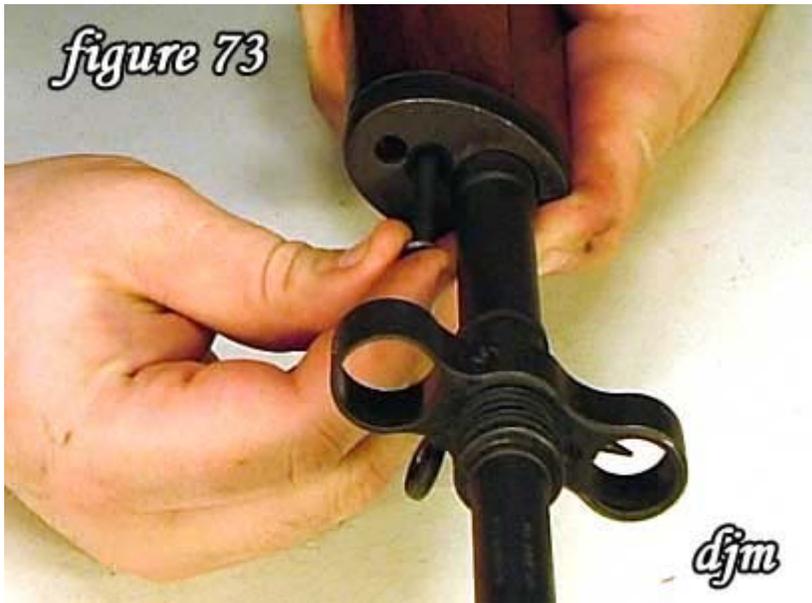
70) Install the barreled receiver into the rifle stock.

71) Figure 71 shows how the hand guard and stock should be aligned before installing the stock band onto the rifle.



72) Slide the stock band into place.

73) Insert the stock band screw.



74) Tighten the stock band screw.

75) Insert the guard.



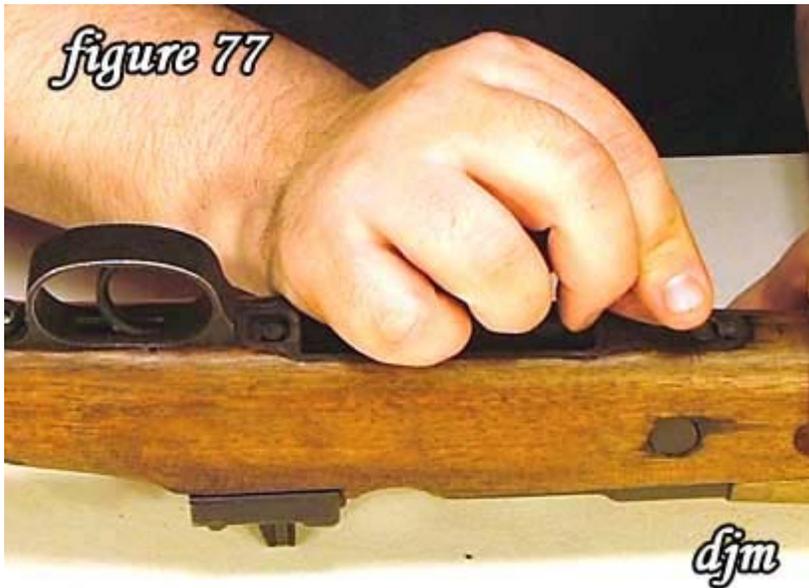
*figure 75*



*figure 76*

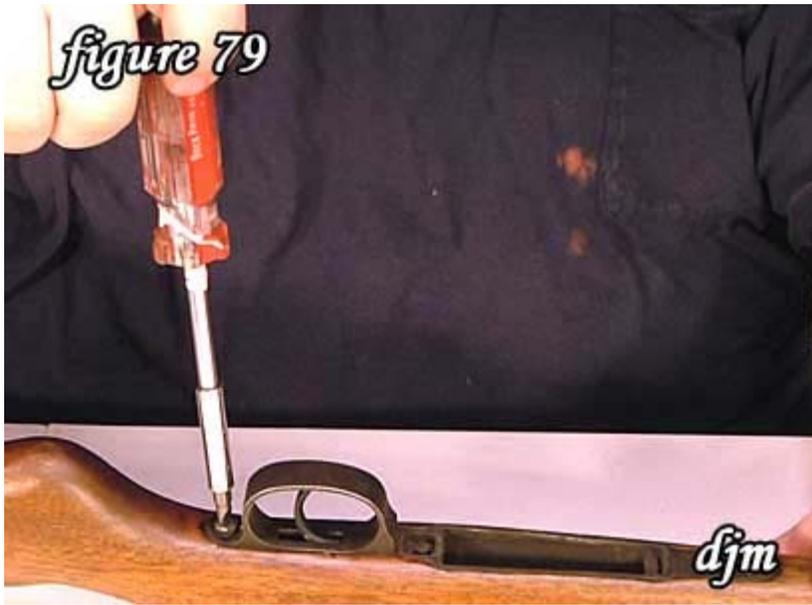
**76) Insert the rear guard screw.**

**77) Insert the forward guard screw.**



78) Tighten partially the forward guard screw.

79) Tighten partially the rear guard screw.



80) Tighten the forward guard screw completely.

81) Tighten completely the rear guard screw.



Locking Screws

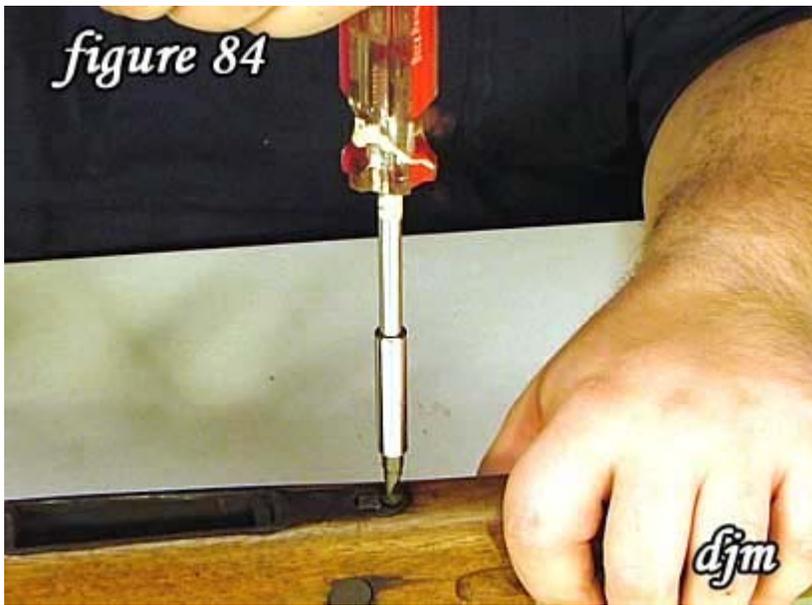
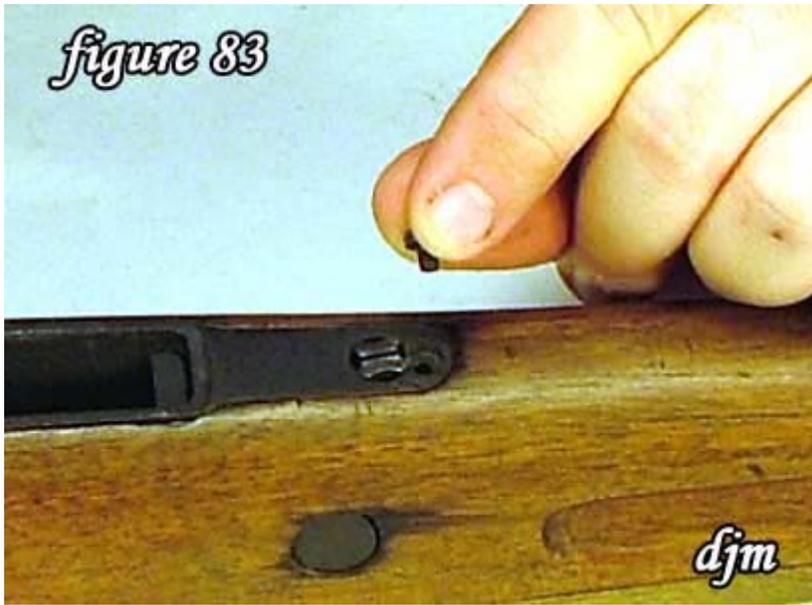


Most 98 type Military Mausers have locking screws that lock the trigger guard screws in place. The two figures to the left show the positions of the locking screws.



82) Tighten the rear locking screw.

83) Insert the forward locking screw.

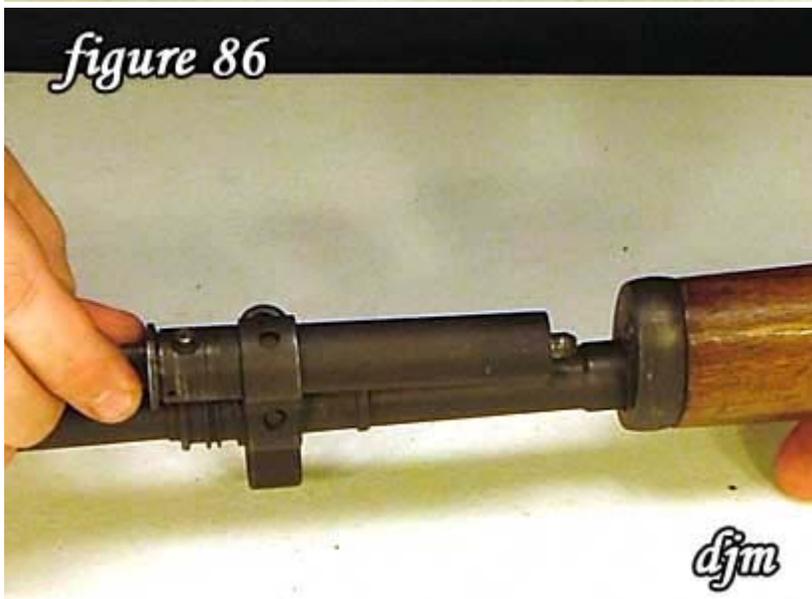


84) Tighten and lock the forward lock screw.

85) Insert the cap onto the cleaning kit tube.



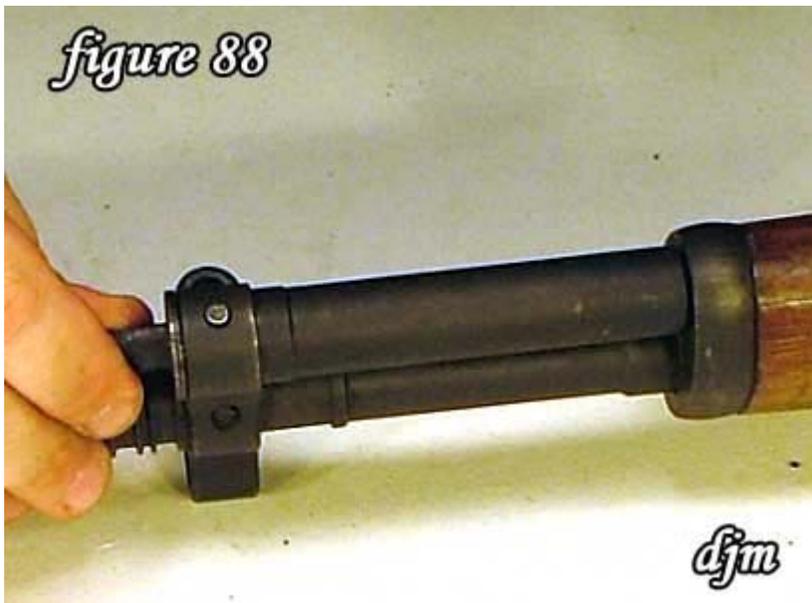
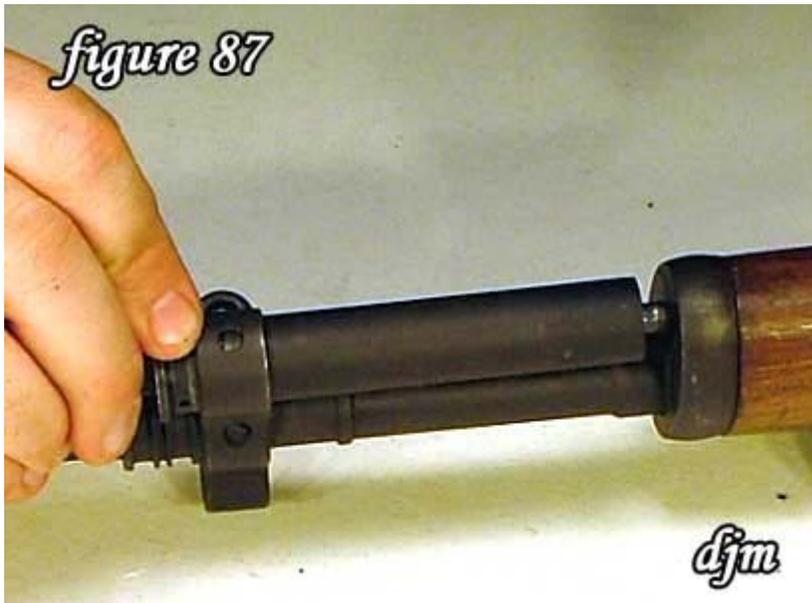
*figure 85*



*figure 86*

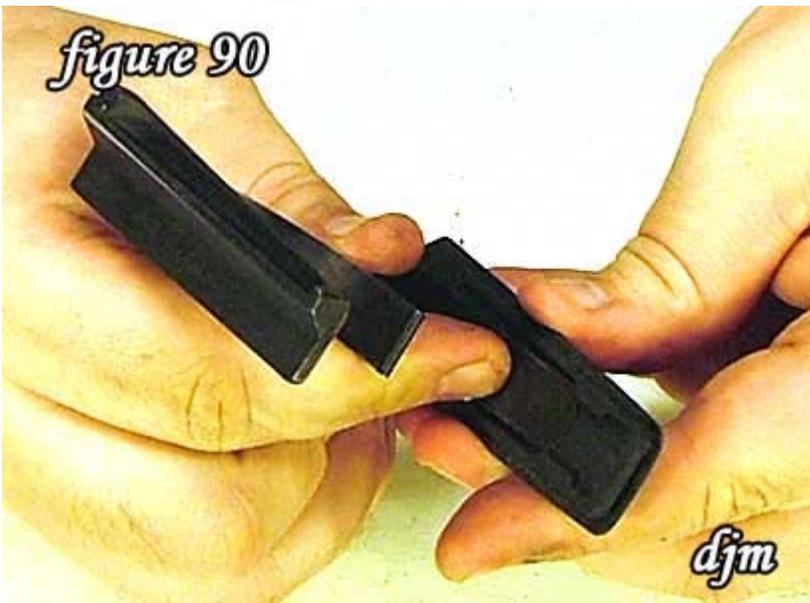
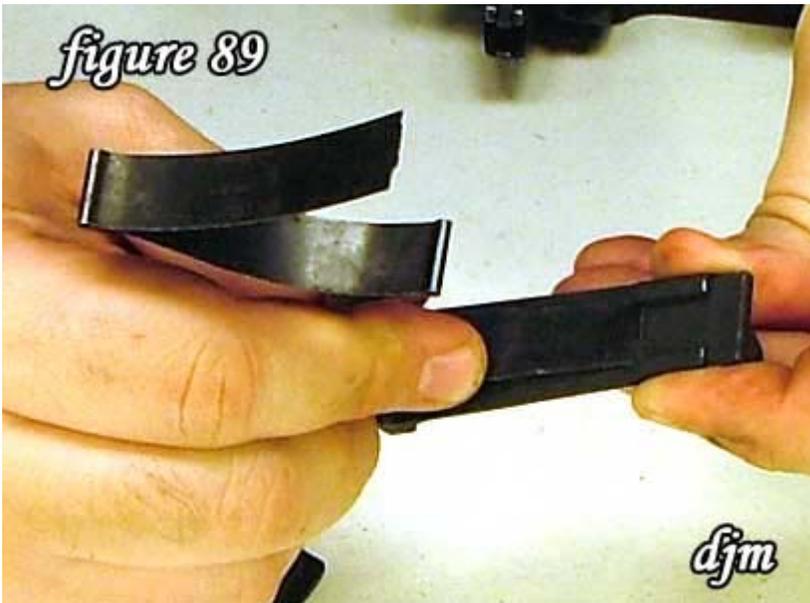
86) Insert the cleaning kit tube as shown in figure 86.

87) Align and insert the guide pin of the cleaning kit tube.



**88) Allow the cleaning kit tube catch to lock into place.**

**89) Slide the tapered part of the magazine spring into the magazine follower.**



90) Slide the other end of the magazine spring into the magazine floor plate.

91) Insert the magazine floor plate/follower assembly into the magazine well of the rifle.



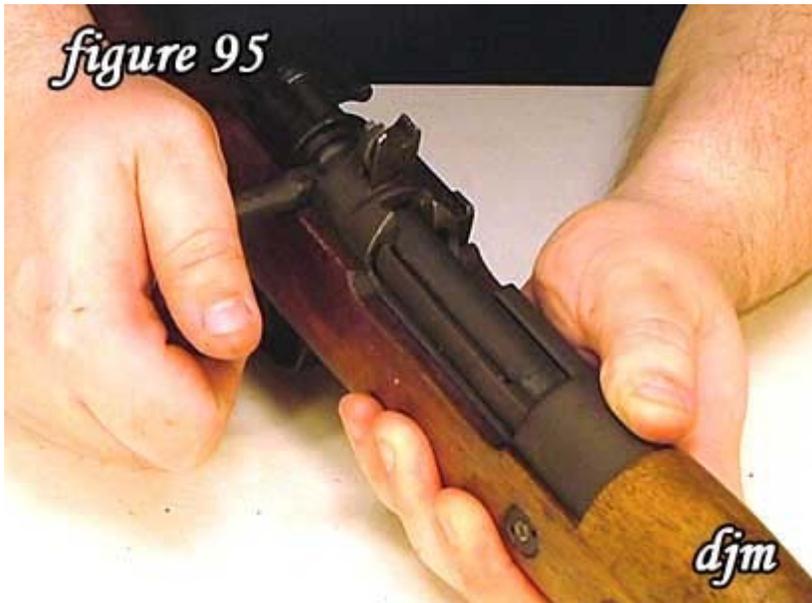
92) Snap the magazine floor plate into place.

93) Depress the magazine follower and insert the bolt into the receiver.



94) Push the bolt fully forward in the receiver.

95) Close the bolt. You have completed the disassembly and reassembly of the Spanish FR-8.



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