



## Maintenance & Parts list for:



## Industrial gun

GB 2  
10/2020



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This Maintenance & Parts list for industrial gun is prepared by :

### **Winchester Europe Service V. Parbst & Søn**

as a comprehensive maintenance guide and quick reference booklet at the same time.

If you need to disassemble your Winchester gun for cleaning and maintenance with only little prior training, just follow this guide page by page until you reach the pages marked with the ⊗. Hereafter work your way backward through the booklet until gun is completely assembled.

During maintenance always use the tools from the International tool kit, which came with the gun. Remember all measurements are in inches. Use of metric tool may therefore damage your gun.

Use of the Cleaning Kit, which came with the gun, is also highly recommended. It is particularly important that oil is **NOT** used anywhere on the gun. Use only dry silicone based lubricant on all parts, and wipe clean with a rag prior to assembly. Use grease inside the gearbox of the mount.

If you are well experienced in making service on the gun, you can look at the index on page 3 for reference on specific parts. The index page will guide you directly to the page with the spare parts you need with exact part number and name for your order.

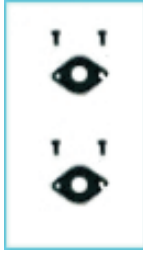
The parts on pages marked ⊗ should never be disassembled during normal cleaning and service. These pages are only included for the rare occasion where these parts get worn or damaged and therefore need replacement.

To ensure that the Winchester Industrial Gun is in operative condition at all times, it should be stripped down, cleaned, and inspected in accordance with this manual once a year.

We hope this Maintenance and Parts list will assist you in your work. Should you have questions or require assistance please feel free to call (45) 49 76 54 00,



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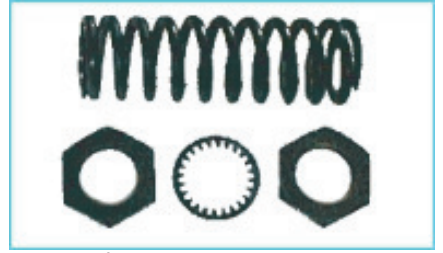
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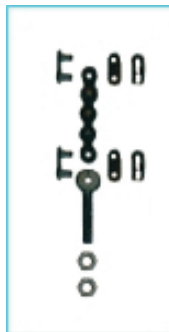
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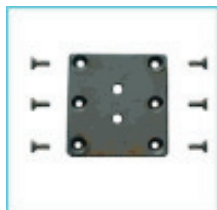
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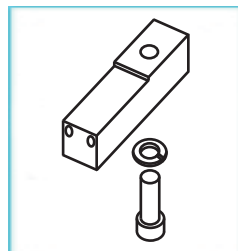
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## WINCHESTER INDUSTRIAL SERVICE

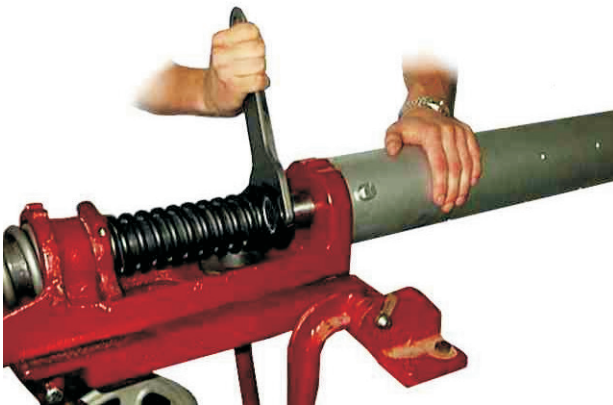
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### To disassemble Recoil Spring:

Loosen the Wing Nuts W12028 from the Spring Guard W12026. (See Mount parts list for drawing) Swing Spring Guard W12026 away from barrel assembly.

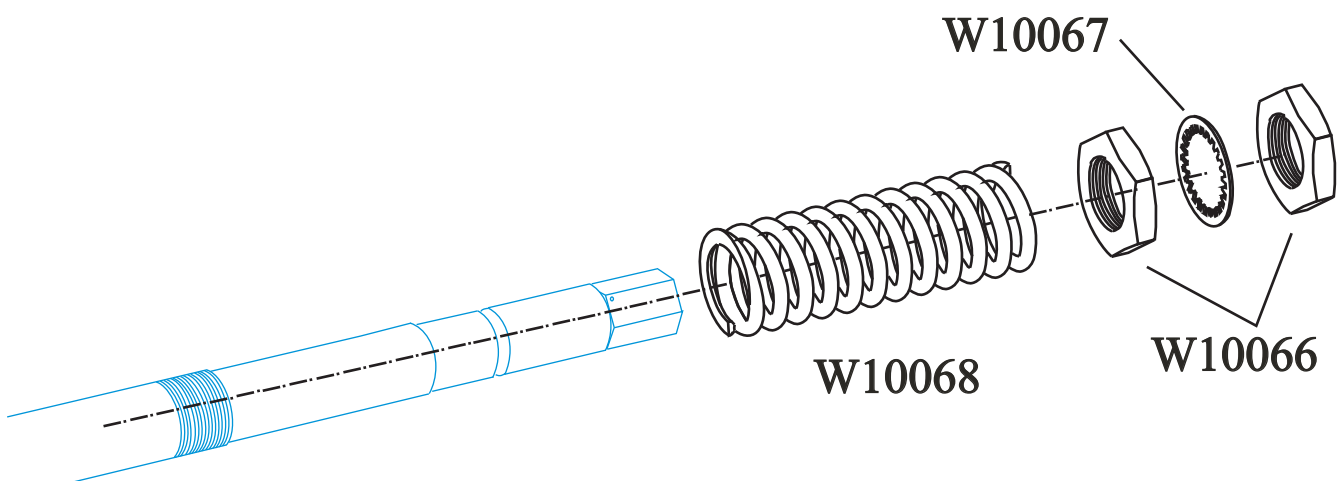
Close the Breech Block and pull the Gun to the rear from the Mount, after having unscrewed the two Check Barrel Recoil Nuts W10066 which are placed in front of the Recoil Spring W10068.



### To assemble Recoil Spring:

Make sure that gun is aligned with the mount so that the W10038 Guide Block underneath the gun slides into its slot in the mount. Check position of W10059 Camming Link on the gun and W12099-1 Cocking Link on the mount, so that they slide together when the gun is pushed forward into the mount.

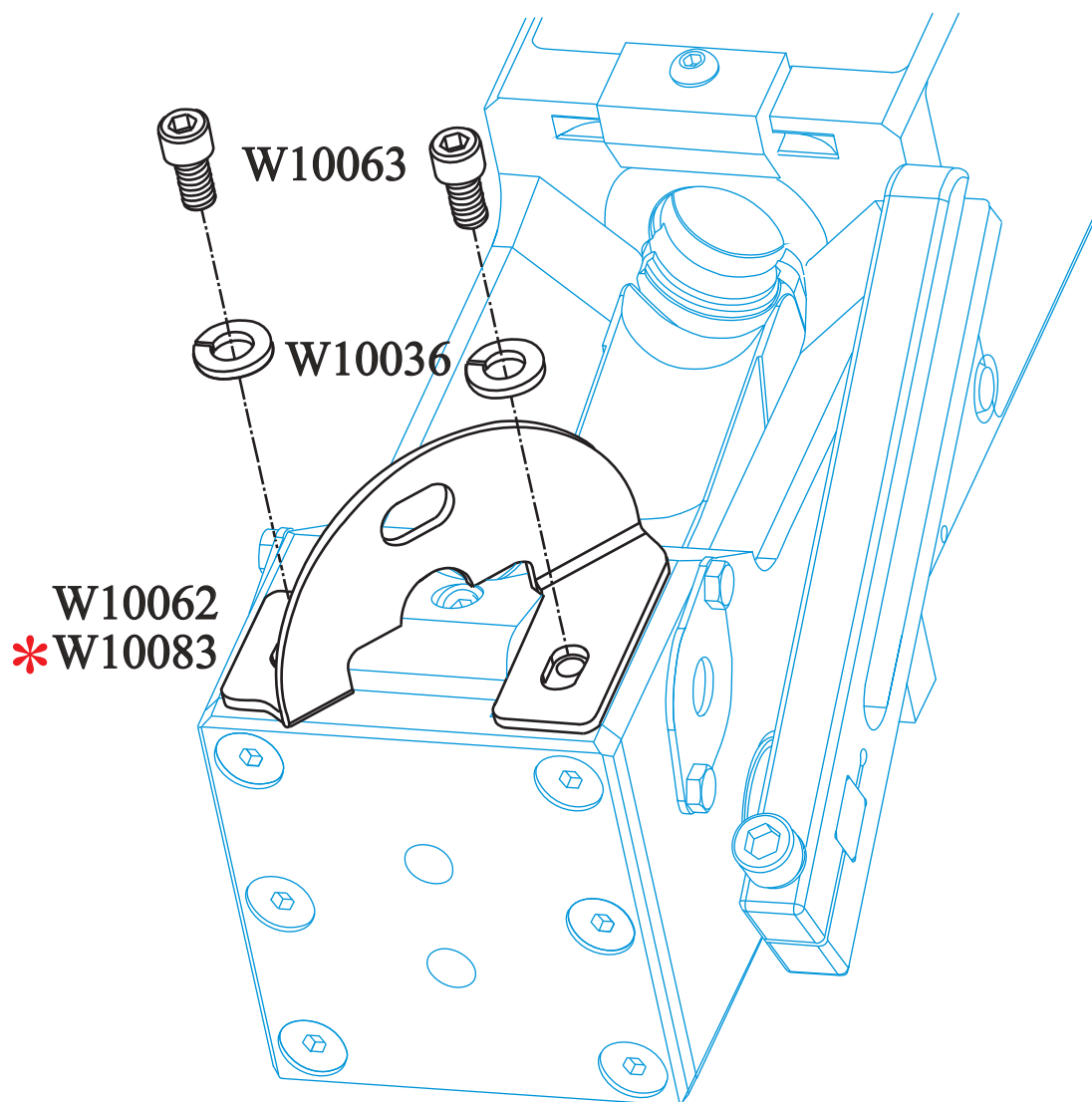
Tighten the two Check Barrel Recoil Nuts W10066 firmly with the wrench to the end of the threads. If you hit the wrench with a hammer to tighten nuts the threads may be damaged.



No.	Name of Part	Required
W10066	Check Barrel Recoil Nut	2
W10067	Tooth Lock Washer	1
W10068	Recoil Spring	1

**To assemble Deflector:**

When installing the W10062 Deflector the W10003 Breech Block should be in open position to make sure that Deflector does not hinder the free movement of the W10003 Breech Block.



\* To accommodate left hand shooters a W10083 Deflector Right Hand is available, which deflects empty cartridges towards the right.

No.	Name of Part	Required
W10036	Lock Washer	2
W10062	Deflector Left Hand (Normal)	1
W10063	Socket Head Cap Screw	2
* (W10083	Deflector Right Hand)	(1)

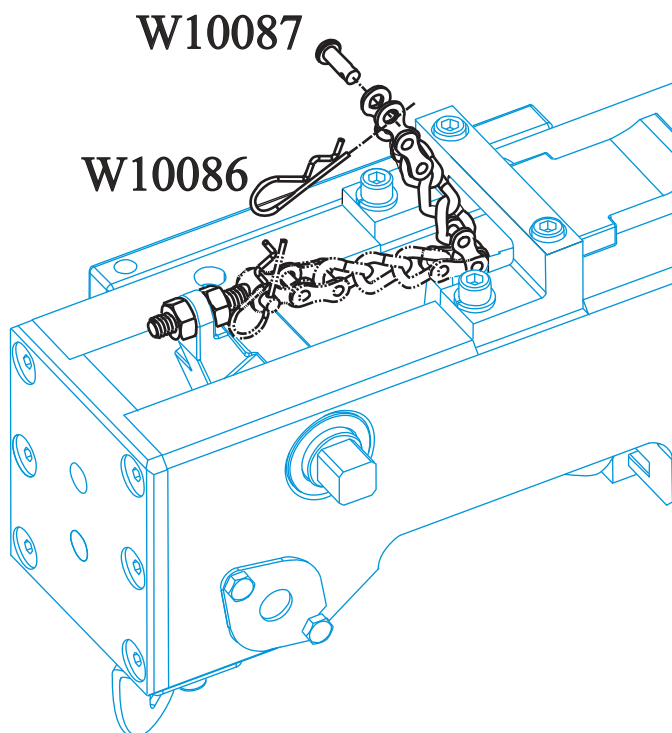




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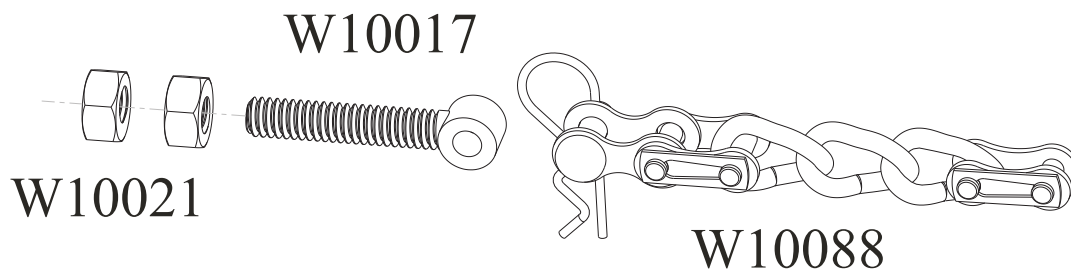
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## To disassemble Adjusting Bolt and Connecting Chain:

Remove W10088 Connecting Chain Assembly from W10017 Adjusting Bolt.

The gun may instead be installed with a W10071 Lanyard Assembly for manual fire. Disassemble W10088 Connecting Chain from W10071 Lanyard and remove Lanyard.



No.	Name of Part	Required
W10017	Adjusting Bolt	1
W10021	Hex Nut	2
W10071	Lanyard Assembly	1
W10086	Hairpin Cotter Pin	1
W10087	Clevis Pin	1
W10088	Connecting Chain Assy.	1



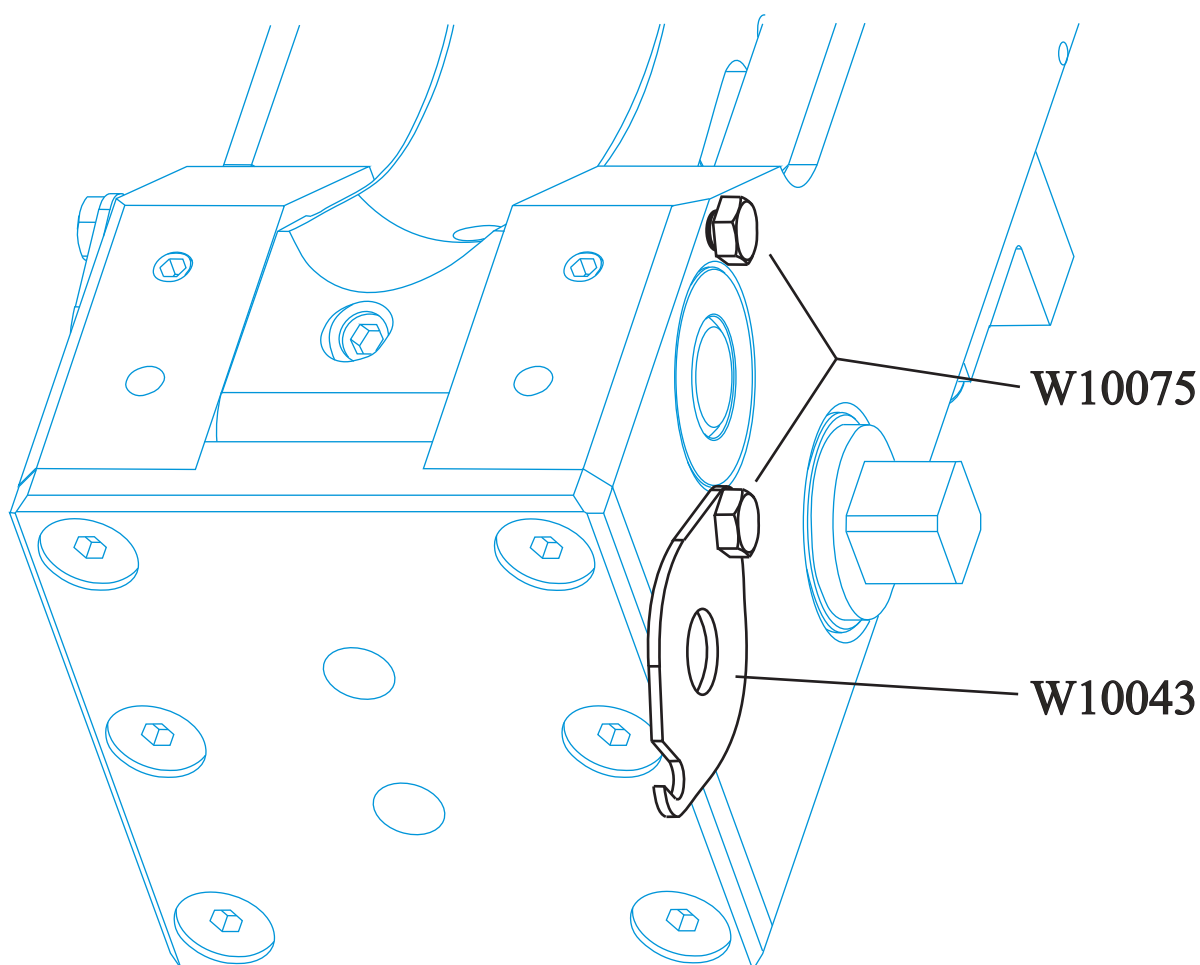
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### To disassemble Breech Pin Retainer:

W10075 Hex Head Screws should only be loosened to allow W10043 Breech Pin Retainer to be moved to the rear.



No.	Name of Part	Required
W10043	Breech Pin Retainer	2
W10075	Hex Head Screw	4



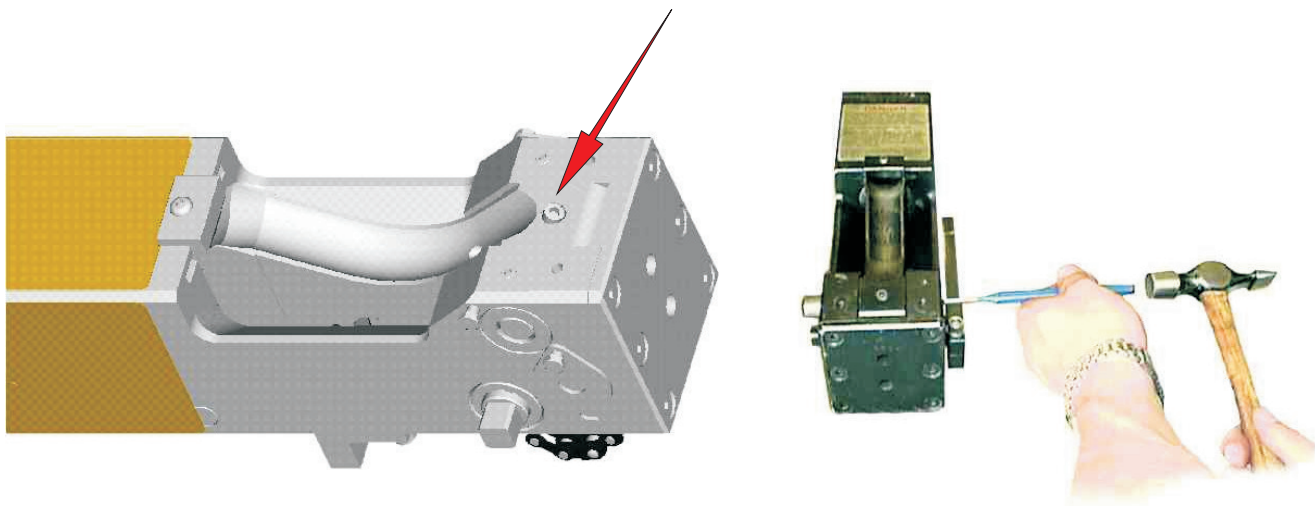
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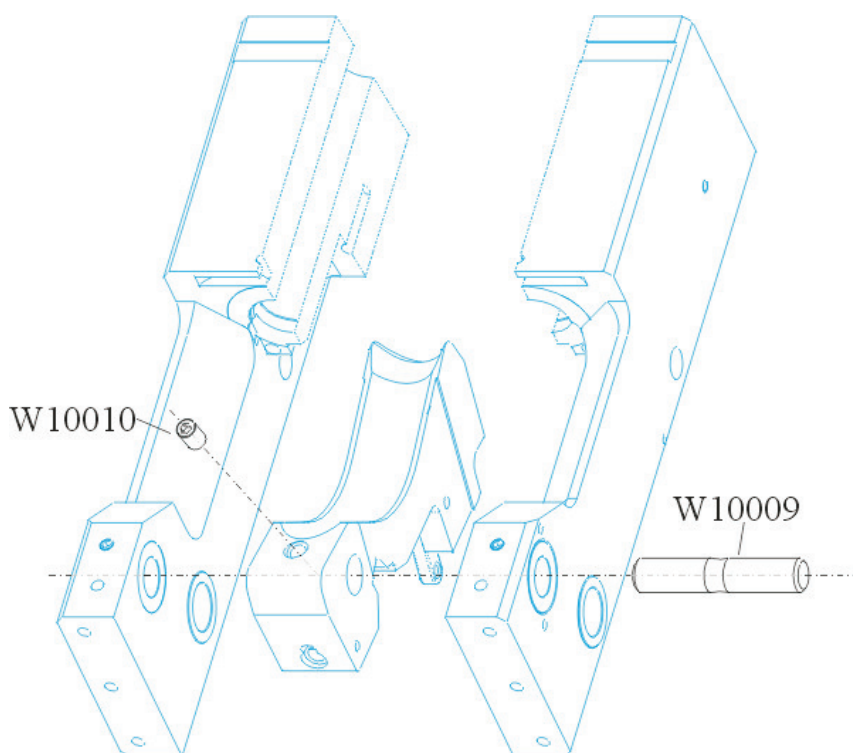
## To disassemble Breech Block Pivot Pin:

Unscrew W10010 Socket Head Set Screw halfway before pushing W10009 Breech Block Pivot Pin out.



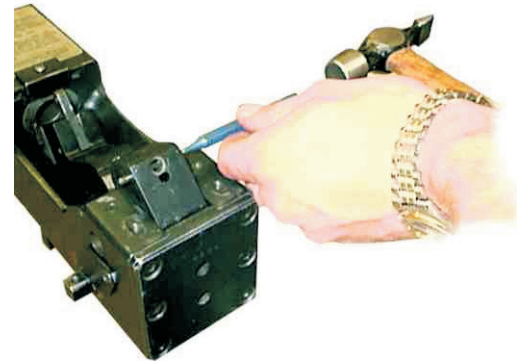
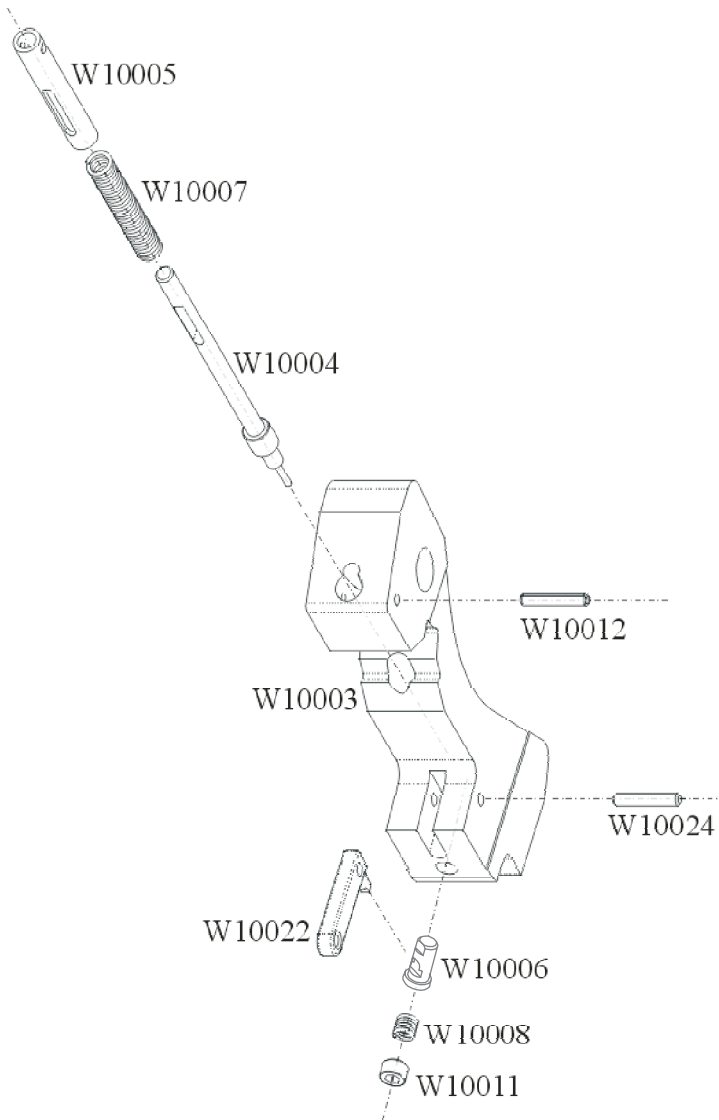
## To assemble Breech Block Pivot Pin:

Make sure that W10009 Breech Block Pivot Pin is absolutely in center before tightening W10010 Socket Head Set Screw.



No.	Name of Part	Required
W10009	Breech Block Pivot Pin	1
W10010	Socket Head Set Screw	1



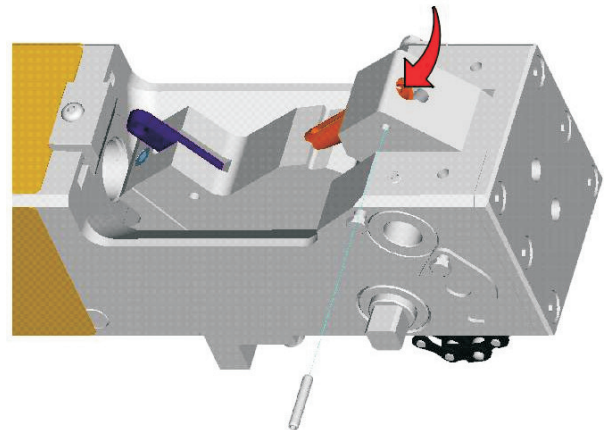


### To disassemble Breech Block:

Remove W10003 Breech Block and place it upside down in receiver as illustrated.

Remove W10012 Dowel Pin using a 5/32" pin punch.

Cover rear of Breech Block with a gloved hand as the W10005 Sleeve is under spring pressure. This will prevent the W10005 Sleeve and the W10007 Spring from ejecting when the punch is removed.



Now remove W10005 Sleeve, W10007 Spring, and W10004 Firing Pin from W10003 Breech Block, and clean firing pin hole in Breech Block with compressed air. If dirt is jammed turn with your fingers a 13/32" drill bit with a ground off tip in the firing pin hole.

Check Firing Pin and Spring for wear. Firing Pin must be straight, and without wear from the Sear, and with a round smooth surface on the front tip. Check if Firing Pin Spring is straight by rolling it on a table, and inspect visually for wear. Replace if necessary.



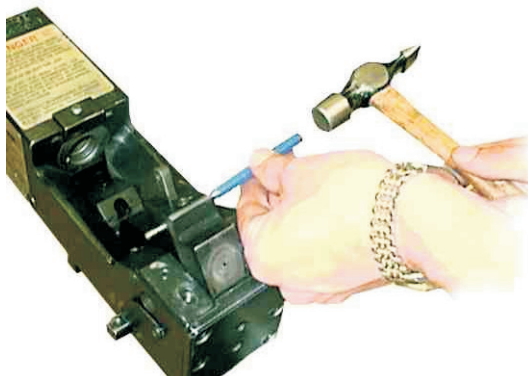
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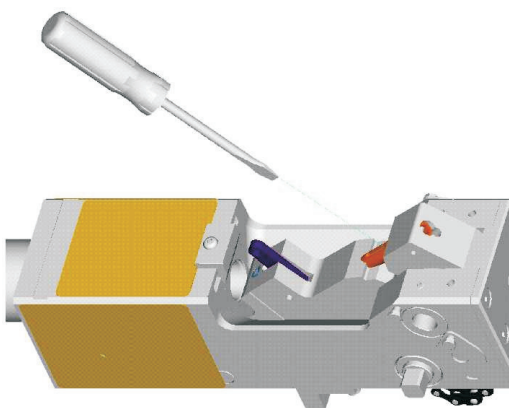
### To disassemble Trigger:

Turn W10003 Breech Block and place it with W10011 Screw upward as illustrated.

Remove W10022 Trigger by driving out W10024 Trigger Pin. Remove W10008 Sear Spring and W10006 Sear by unscrewing W10011 Socket Head Set Screw. If screw was locked with Loctite it will aid removal to heat the screw head with a torch for 20 - 30 seconds and then remove the screw immediately. Check parts for wear, and blow Sear and Trigger slot in the Breech Block clean with compressed air.

### To assemble Trigger:

Insert W10006 Sear into the Breech Block. Turn W10006 Sear until slot for Trigger becomes visible. Insert W10022 Trigger in slot, and make sure holes are aligned before W10024 Trigger Pin is driven back in place. Now check that the W10022 Trigger can move freely. Insert W10008 Sear Spring and W10011 Socket Head Set Screw into the Breech Block. Tighten W10011 Socket Head Set Screw until it is flush with the Breech Block and lock it with Loctite 242 (mid strength) or a burr over using a Center punch.



### To assemble Breech Block:

Insert W10004 Firing Pin, W10007 Spring, and W10005 Sleeve in Breech Block with the oval slot in Firing Pin and Sleeve upward. Adjust the slots in Sleeve and Firing Pin by pushing down a screwdriver in the slot. Retain Spring, Sleeve, and Firing Pin within the Breech Block with a pin punch so that holes are aligned before driving in the W10012 Spring Pin.

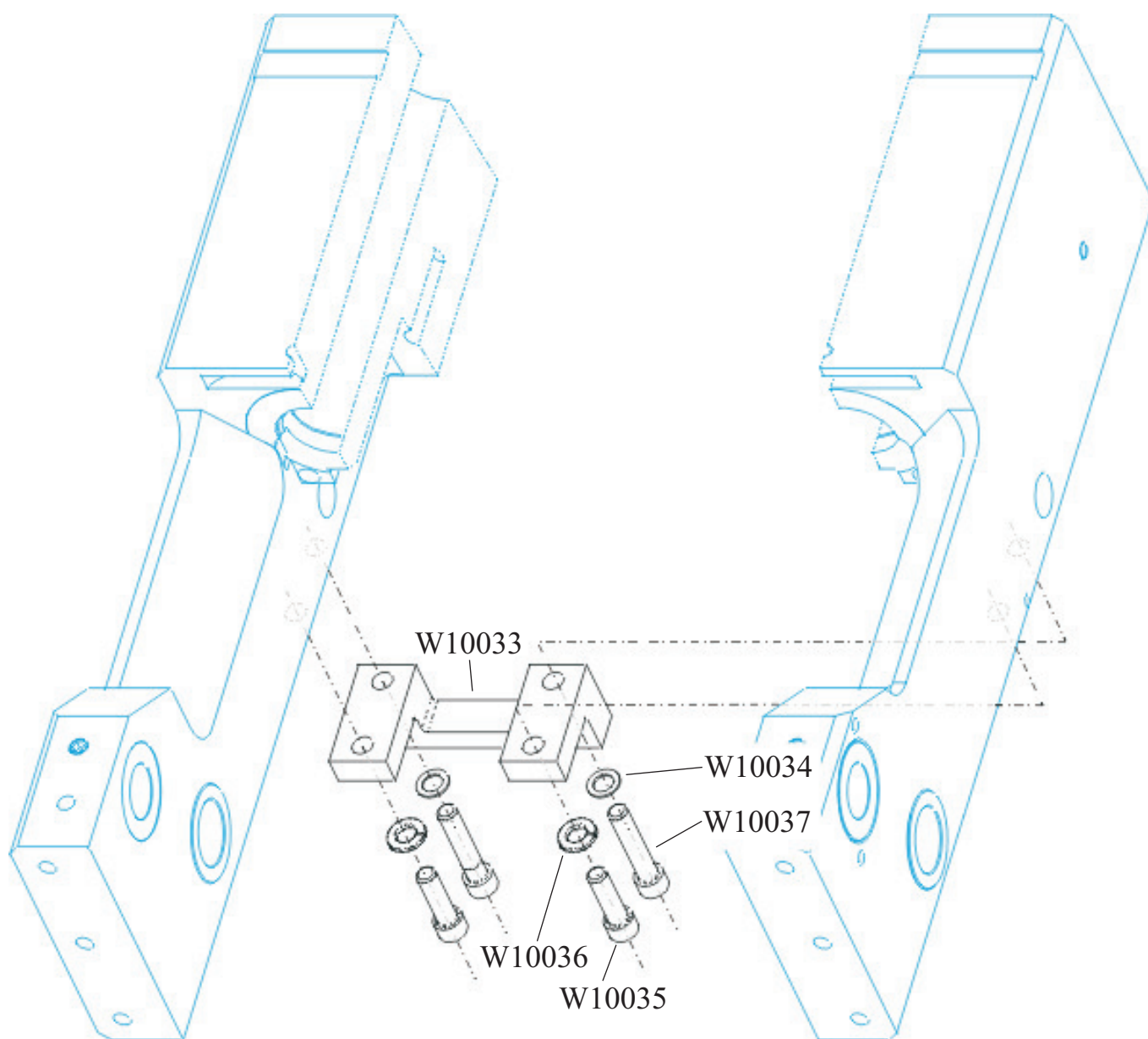
Check that Trigger works by pulling it to the rear which should release Firing Pin with a click. Re-cock Firing Pin before installing Breech Block in the gun by pulling with a screwdriver in the Firing Pin slot towards the rear of the Breech Block.



No.	Name of Part	Required
W10003	Breech Block	1
W10004	Firing Pin	1
W10005	Firing Pin Sleeve	1
W10006	Sear	1
W10007	Firing Pin Spring	1
W10008	Sear Spring	1
W10011	Socket Head Set Screw	1
W10012	Dowel Pin	1
W10022	Breech Block Trigger	1
W10024	Trigger Pin	1

**To disassemble Bracket:**

Turn the Gun upside down. Unscrew W10035 Screw and W10037 Screw and remove W10033 Bracket .



No.	Name of Part	Required
W10033	Breech Block Stop Bracket	1
W10034	Lock Washer	2
W10035	Socket Head Cap Screw	2
W10036	Lock Washer	2
W10037	Socket Head Cap Screw	2



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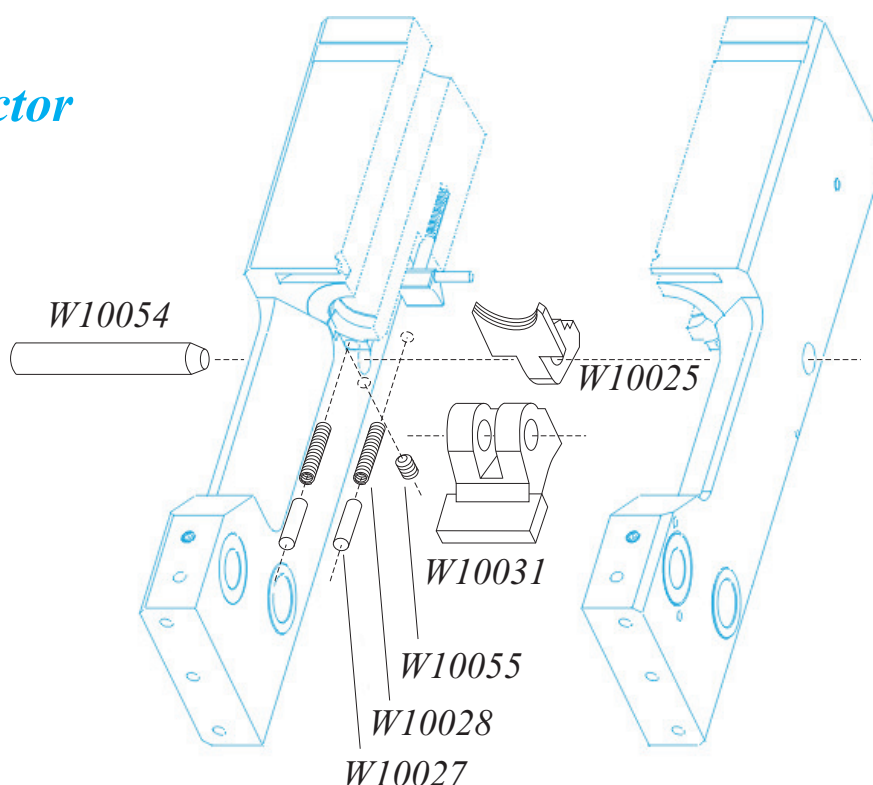
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### **To disassemble Extractor:**

Loosen Screw W10055 half way, Extractor Pivot Pin W10054 can then be driven out with a pin punch, while pressing thumb against Extractor W10025. When Extractor Pivot Pin W10054 is removed, remove Extractor W10025 and Extractor Release Cam W10031 by drawing it to the rear. Remove the two Extractor Pins W10027 and the two Extractor Springs W10028.

Clean holes for Extractor Springs and Extractor recess in chamber with compressed air and while Breech Block is out of Receiver clean barrel and chamber with Cleaning Rod and brushes provided in the Cleaning Kit.

### **Old Extractor System**



### **To assemble Extractor:**

Push W10031 Extractor Release Cam towards the chamber. During assembly Extractor Release Cam must slide under W10051 Extractor Release Cam Plunger (see page 17) underneath the Receiver. It is therefore necessary to pull down Extractor Release Cam Plunger while sliding Extractor Release Cam in place. Make sure that W10025 Extractor and W10031 Extractor Release Cam are aligned before driving W10054 Extractor Pivot Pin back in place with its flat area aligned with the W10055 Socket Head Set Screw.

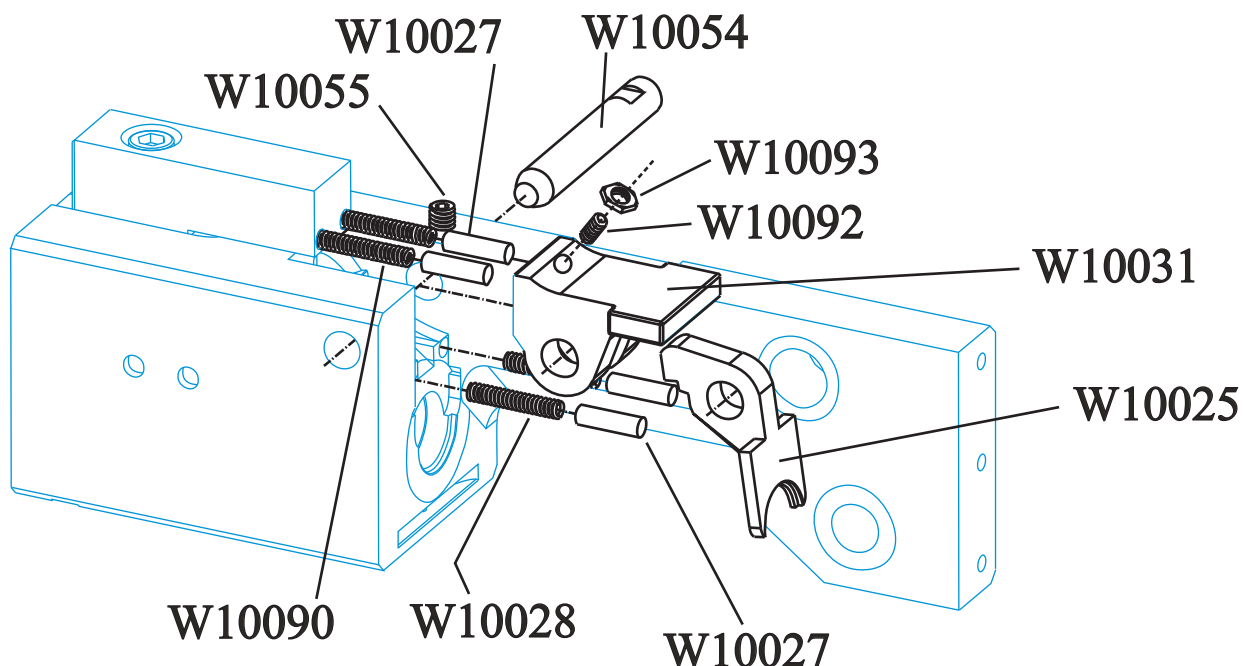
No.	Name of Part	Required
W10025	Extractor	1
W10027	Extractor & Release Pin	2
W10028	Extractor & Release Spring	2
W10031	Extractor Release Cam	1
W10054	Extractor Pivot Pin	1
W10055	Socket Head Set Screw	1



### To disassemble Extractor:

Loosen Screw W10055 half way, Extractor Pivot Pin W10054 can then be driven out with a pin punch, while pressing thumb against Extractor W10025. When Extractor Pivot Pin W10054 is removed, remove Extractor W10025 and Extractor Release Cam W10031 by drawing it to the rear. Remove the 4 Extractor Pins W10027 and the 2 Extractor Springs W10028 and the 2 Extractor Cam Springs W10090.

Clean holes for Springs and Extractor recess in chamber with compressed air and while Breech Block is out of Receiver clean barrel and chamber with Cleaning Rod and brushes provided in the Cleaning Kit.



### To assemble Extractor:

Push W10031 Extractor Release Cam towards the chamber. Make sure that W10025 Extractor and W10031 Extractor Release Cam are aligned before driving W10054 Extractor Pivot Pin back in place with its flat area aligned with the W10055 Socket Head Set Screw. Push W10031 Extractor Release Cam down to test release of the Extractor. If release is not possible, unscrew W10092 Set Screw slowly until release is possible. Fix position of W10092 Set Screw with Loctite.

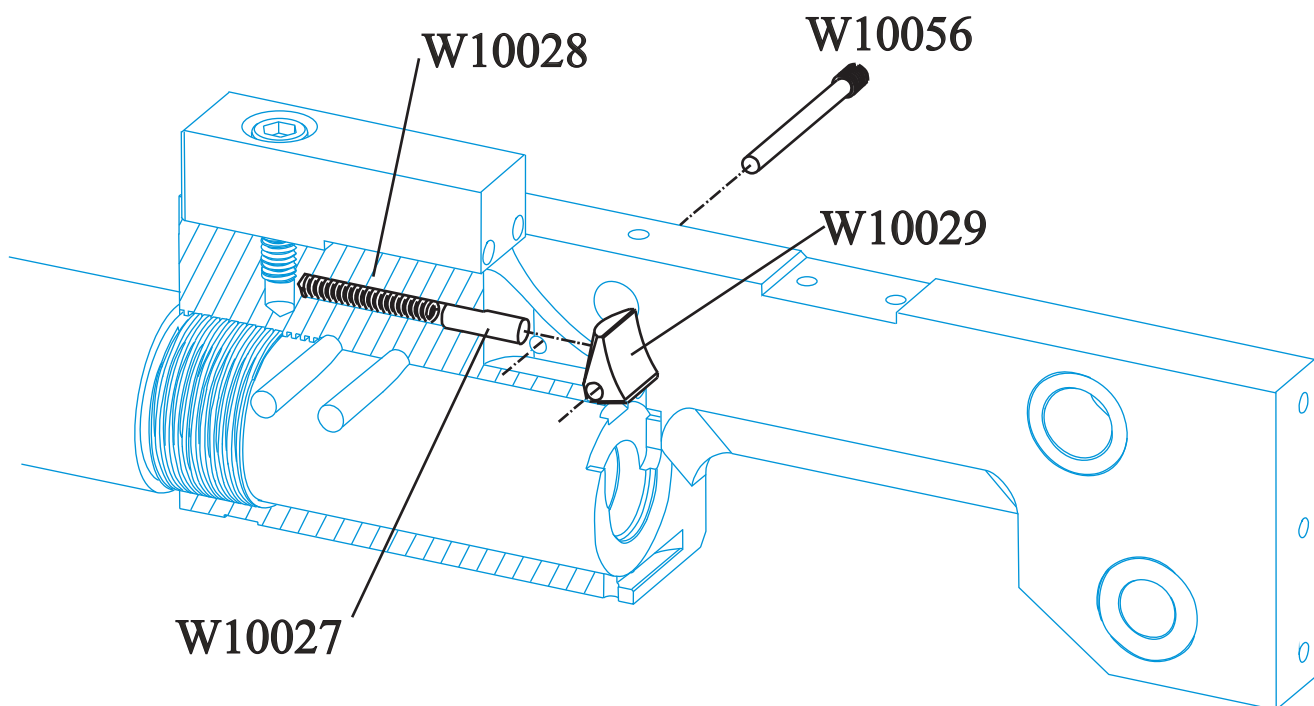
No.	Name of Part	Required
W10025	Extractor	1
W10027	Extractor & Release Pin	4
W10028	Extractor & Release Spring	2
W10031	Extractor Release Cam	1
W10054	Extractor Pivot Pin	1
W10055	Socket Head Set Screw	1
W10090	Extractor Cam Spring	2
W10092	Slotted Set Screw	1
W10093	Jam Nut	1



### To disassemble Extractor Release:

Hold back Extractor Release W10029 with a thumb while unscrewing Extractor Release Screw W10056. Then remove Extractor Release W10029, Extractor Pin W10027 and Extractor Spring W10028.

Clean hole for Extractor Release Spring with compressed air.



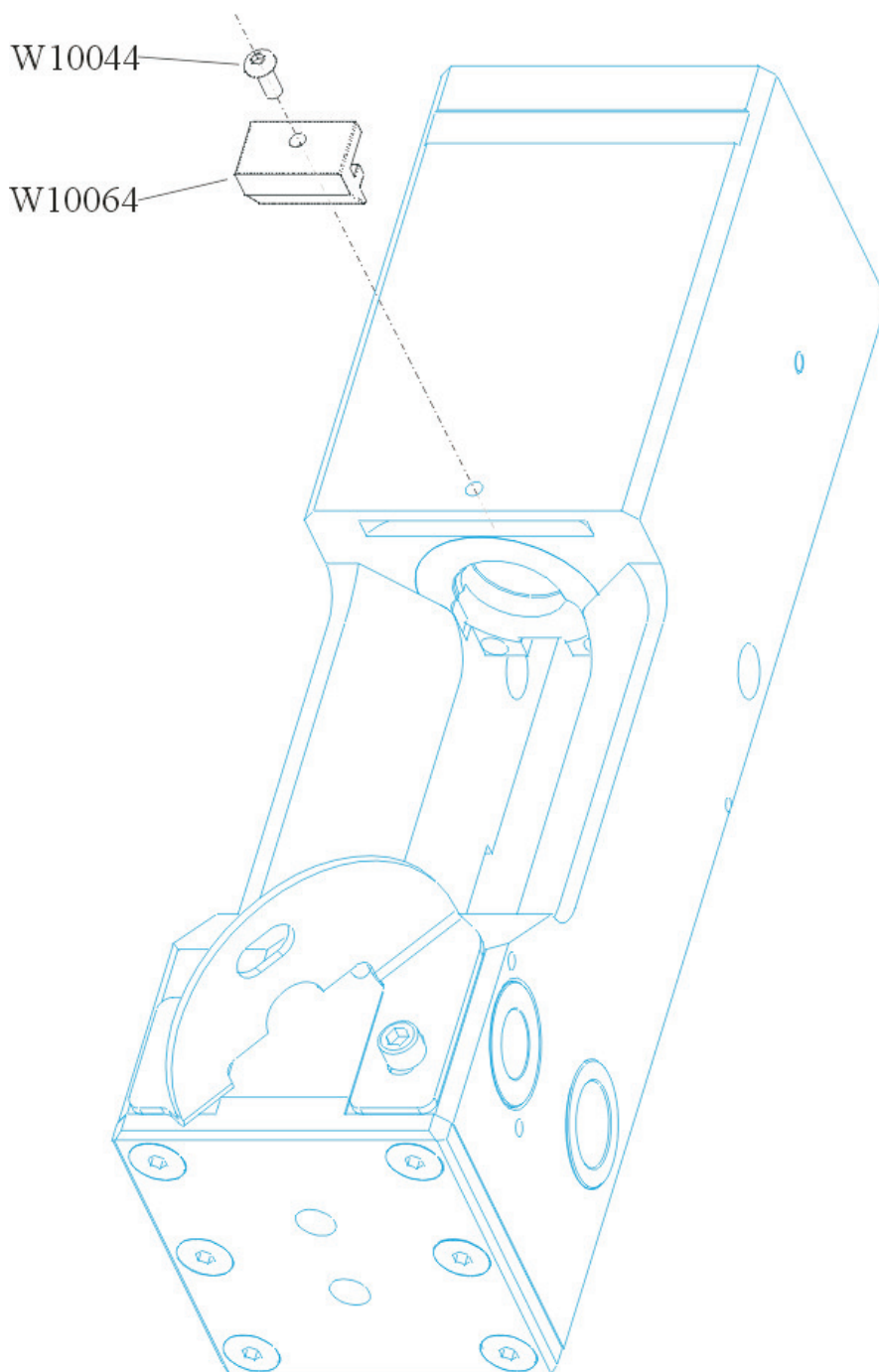
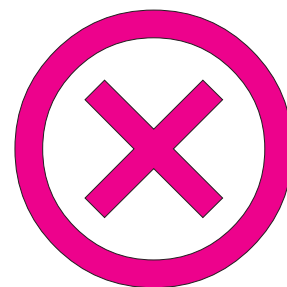
### To assemble Extractor Release:

Make sure that hole in Extractor Release W10029 is aligned with hole in receiver before W10056 Extractor Release Screw is put back in place.

No.	Name of Part	Required
W10027	Extractor & Release Pin	1
W10028	Extractor & Release Spring	1
W10029	Extractor Release	1
W10056	Extractor Release Screw	1

### Breech Block Stop:

Should not be removed during normal maintenance and cleaning of the gun. If Breech Block Stop comes loose by itself, tighten W10044 Button Head Screw firmly and seal with Loctite.



No.	Name of Part	Required
W10044	Button Head Screw	1
W10064	Breech Block Stop	1



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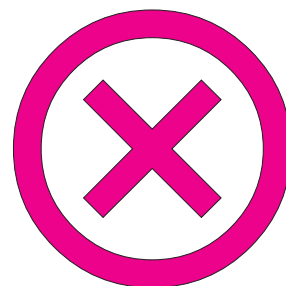
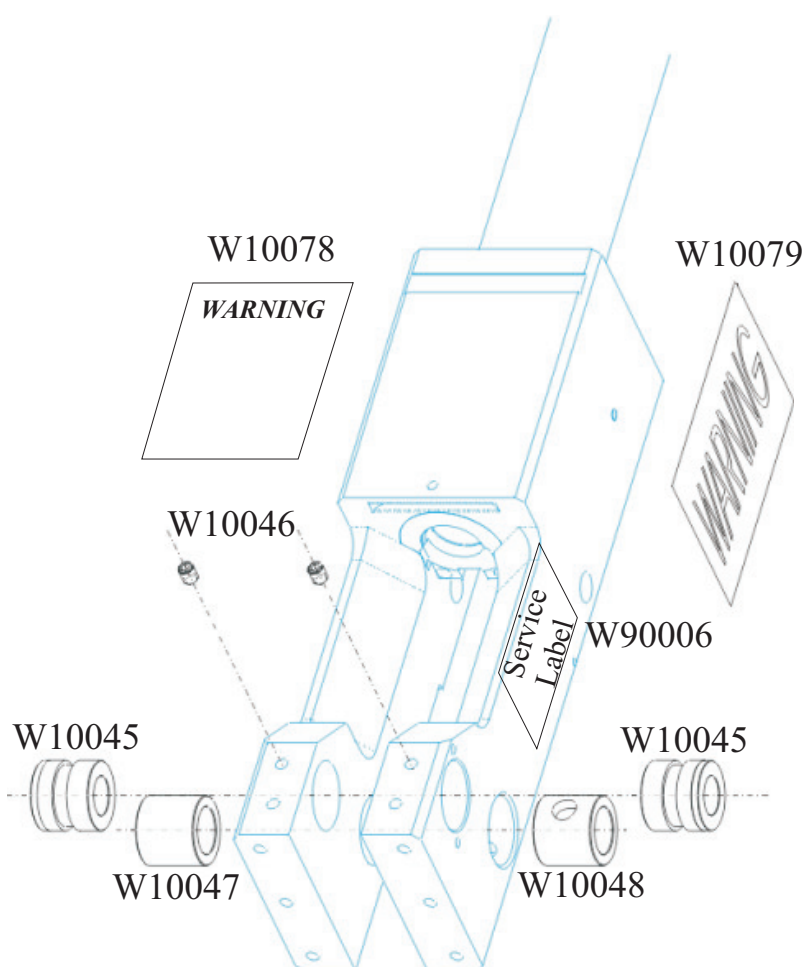
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### Receiver:

If Warning Label W10078 or W10079 needs replacement, be sure to remove any oil, and clean surface carefully before adding the new Label.

The W10003 Breech Block can be adjusted sideways by moving the W10045 Breech Block Bushing Pivots. Prior to adjustments loosen W10046 Socket Head Set Screws, and remember to tighten them again when adjustment is completed.

If Cocking Cam Bushings (W10047 & W10048) needs to be replaced, remember that left and right hand bushings are NOT interchangeable. The vertical hole in the Cocking Cam Bushings must be aligned with holes in Receiver.

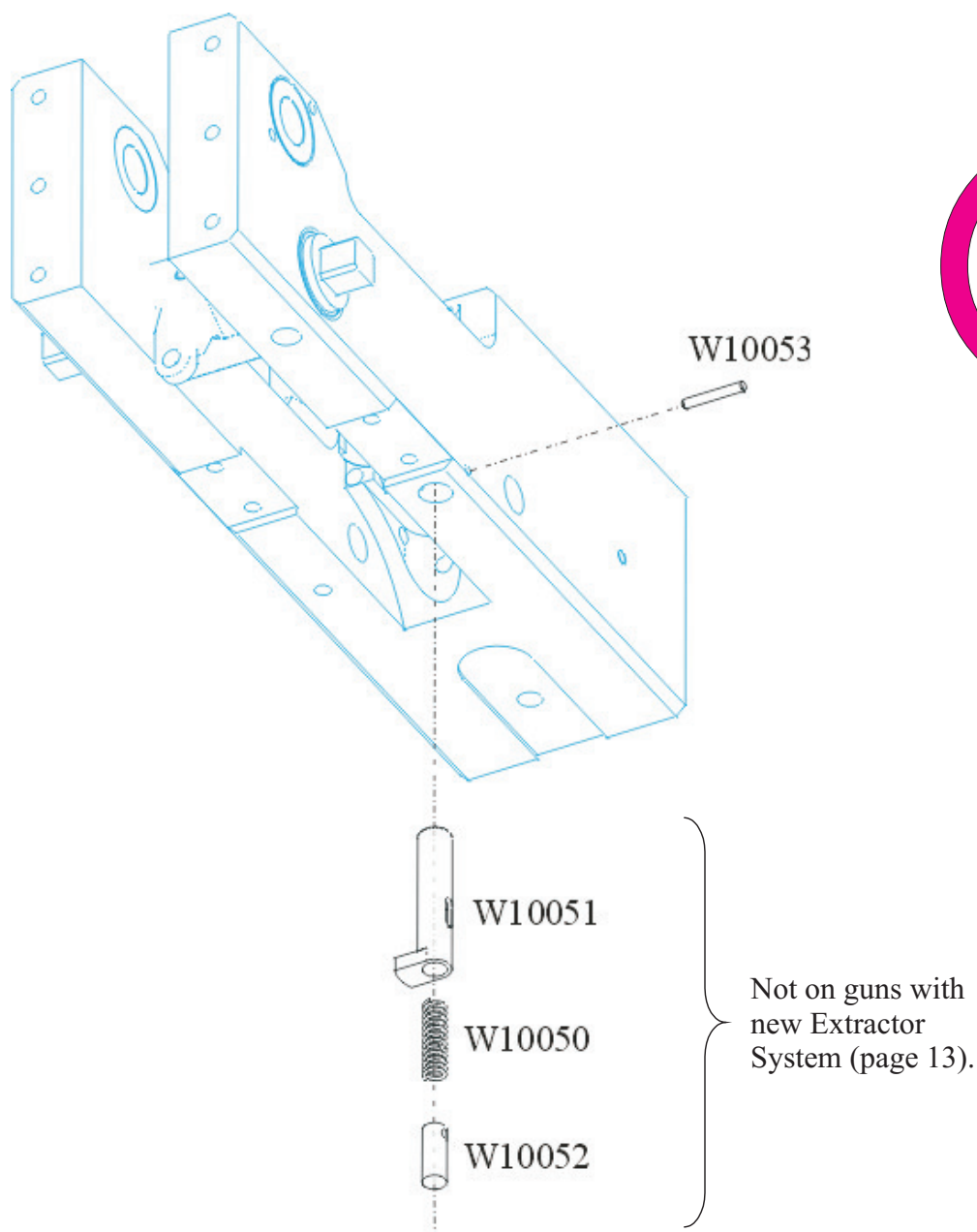


No.	Name of Part	Required
W10045	Breech Block Bushing Pivot	2
W10046	Socket Head Set Screw	2
W10047	Cocking Cam Bushing (L.H.)	1
W10048	Cocking Cam Bushing (R.H.)	1
W10078	Label Warning	1
W10079	Label Warning	2
W90006	Service Label	1

### Extractor Release Cam Plunger:

Drive out W10053 Dowel Pin with a pin punch. Before removing punch hold thumb in front of W10052 Extractor Release Cam Plunger Plug since it is under spring pressure. Plunger, Plunger Plug and Plunger Spring may now be removed.

When reinstalling make sure that hole in W10051 Extractor Release Cam Plunger and W10052 Extractor Release Cam Plunger Plug are aligned with hole in Receiver before driving W10053 Dowel Pin back in place.



No.	Name of Part	Required
W10050	Cocking Cam Plunger Spring	1
W10051	Extractor Release Cam Plunger	1
W10052	Extractor Release Cam Plunger Plug	1
W10053	Dowel Pin	1



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**Barrel:** Following accessories are available:

## Long Barrel Extension W15046

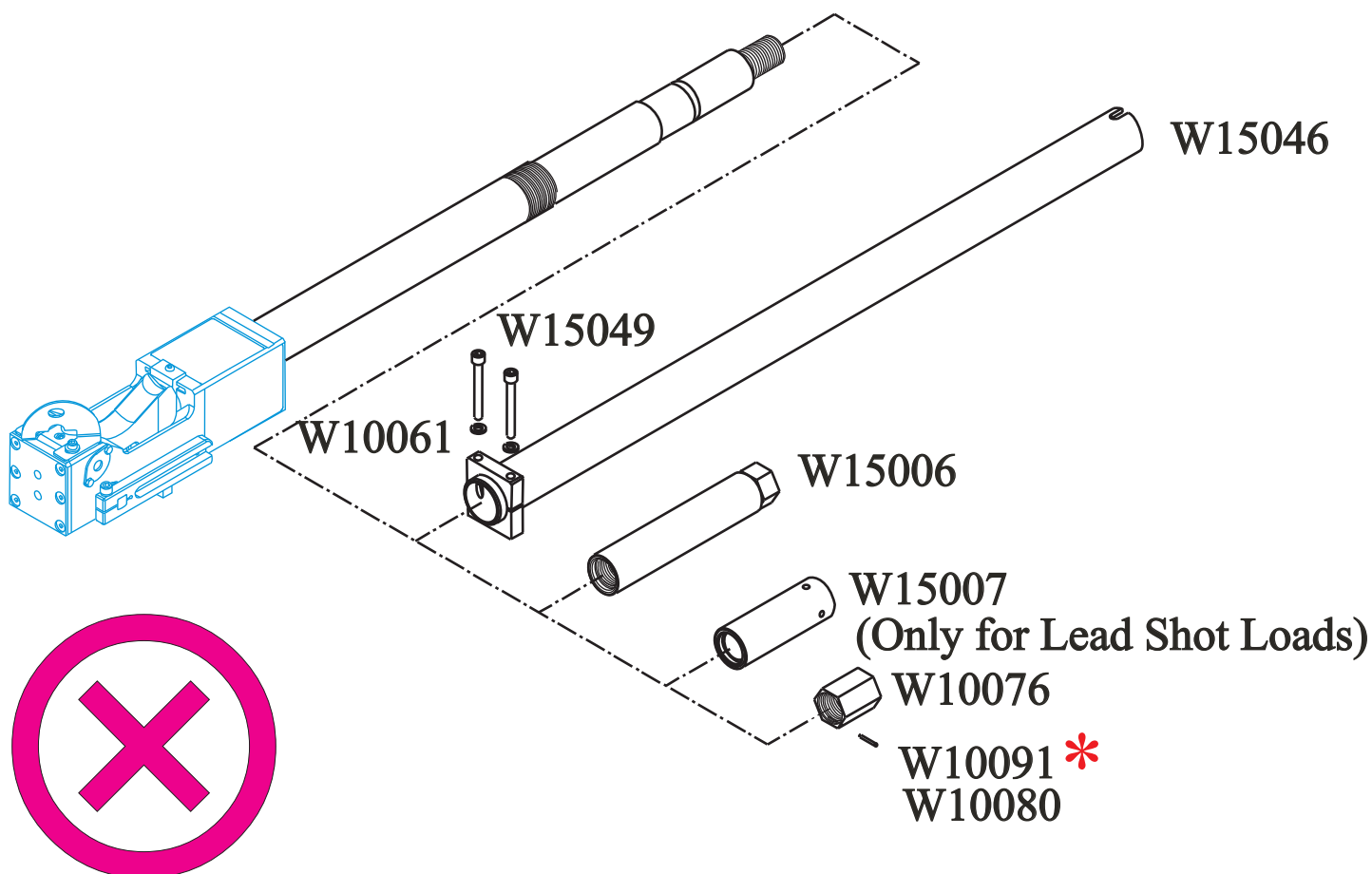
Remove the 2 W15049 Socket Head Screws and push the Long Barrel Extension over the barrel until the 2 Socket Head Screws fit into the groove in the barrel.

## Rifled Barrel Extension W15006

Drive out Spring Pin W10080. Then unscrew W10076 Cap. Screw the W15006 Rifled Barrel Extension on and tighten it with 150 foot pounds of force, then make a burr over into the 2 grooves of the Rifled Barrel Extension with a Center Punch.

Before installing W15006 Rifled Barrel Extension or re installment of the W10076 Cap, Barrel threads must be lubricated with a high temperature (1400°C) anti seize compound.

When removing the Rifled Barrel Extension the W10076 Cap must be re-installed to protect the threads. It is of utmost importance that W10080 Spring Pin is driven back in place to prevent the W10076 Cap from unscrewing itself.

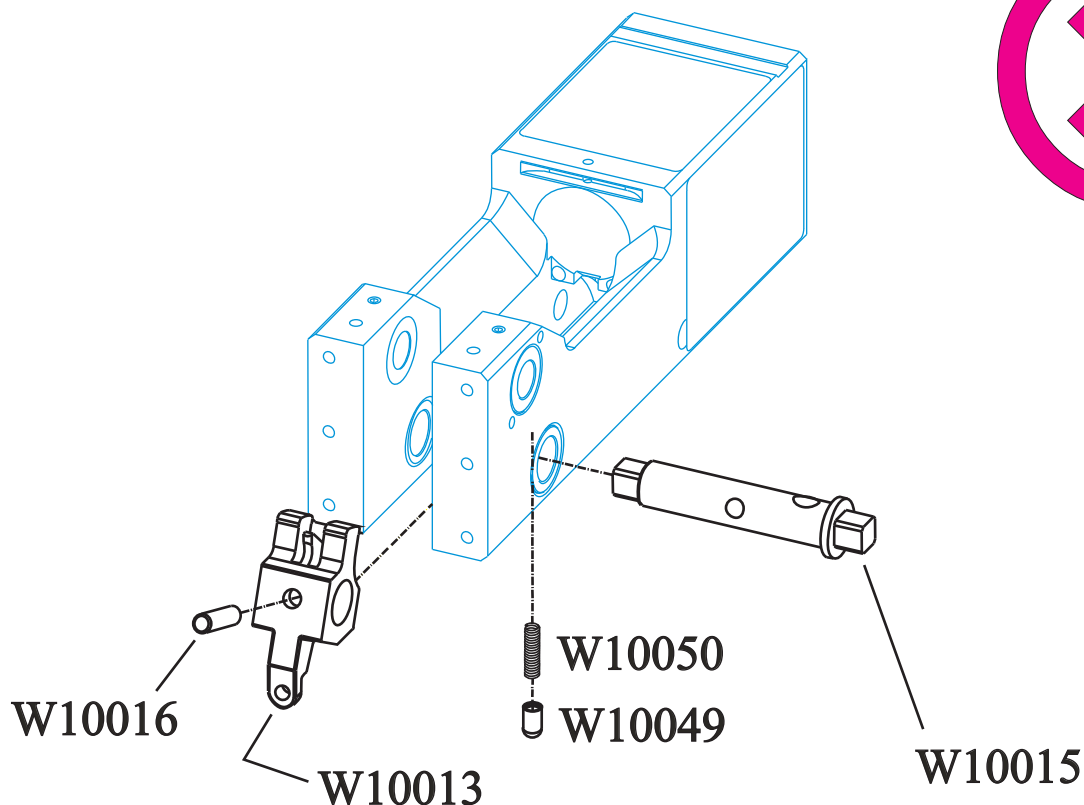


No.	Name of Part	Required
W10061	Lock Washer	2
W10076	Cap	1
W10080	Spring Pin (2,38*22,35 mm) <u>Old</u>	1
* W10091	Spring Pin (3,30*22,35 mm) <u>New</u>	1
W15006	Rifled Barrel Extension	1
W15007	Choke-Full	1
W15046	Long Barrel Extension	1
W15049	Socket Head Screw	2



**To disassemble Cocking Cam:**

Drive W10016 Cocking Cam Pin out with a Pin Punch and remove W10013 Cocking Cam. Then drive W10015 Cocking Cam Shaft out from the left towards the right. When Cocking Cam Shaft is removed W10049 Cocking Cam Plunger will jump out since it is under pressure from W10050 Spring.


**To assemble Cocking Cam:**

Make sure that holes in W10013 Cocking Cam and W10015 Cocking Cam Shaft are aligned before driving W10016 Cocking Cam Pin in place.

No.	Name of Part	Required
W10013	Cocking Cam	1
W10015	Cocking Cam Shaft	1
W10016	Cocking Cam Pin	1
W10049	Cocking Cam Plunger	1
W10050	Cocking Cam Plunger Spring	1



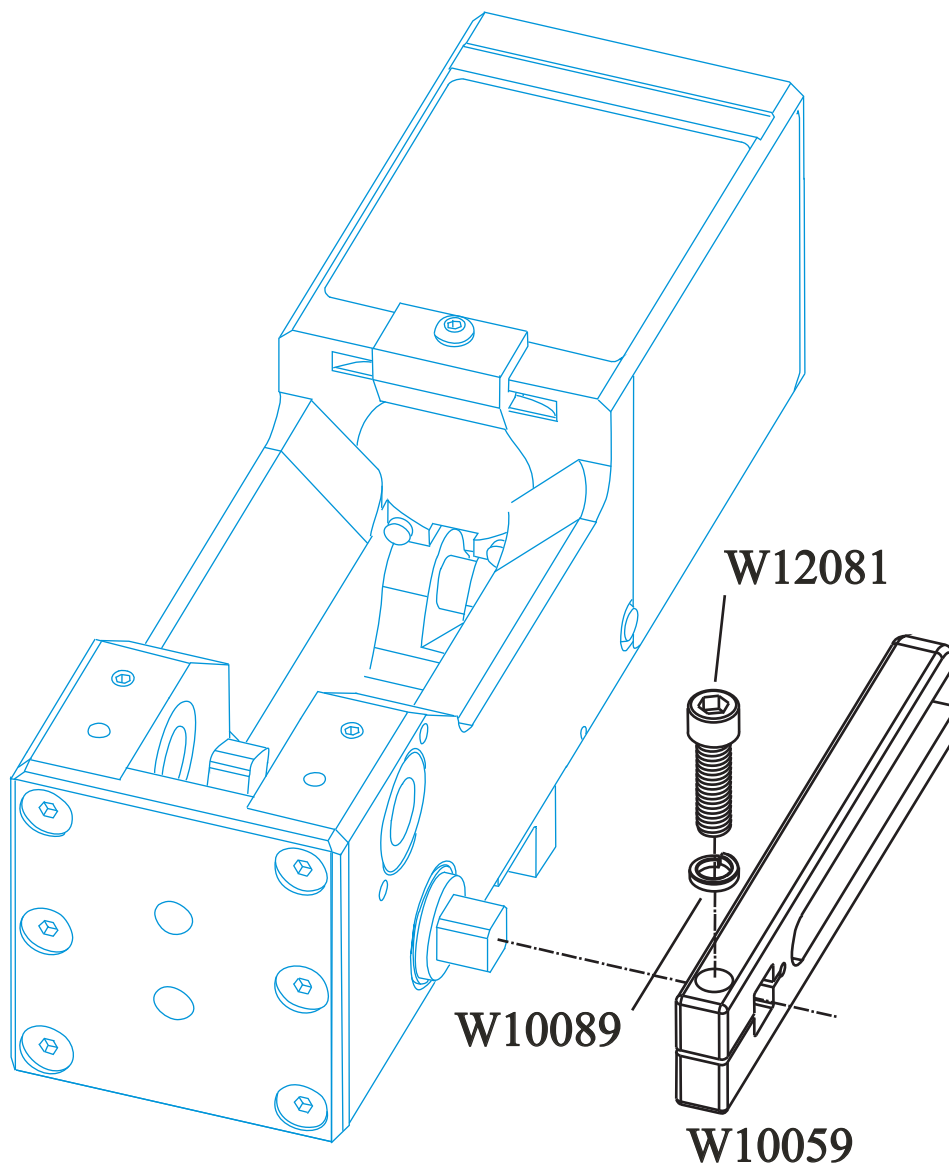
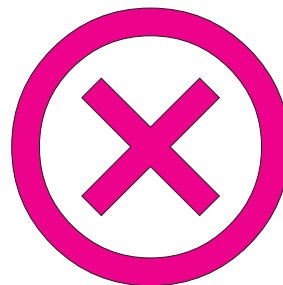
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## Camming Link:

To remove loosen W12081 Socket Head Cap Screw.

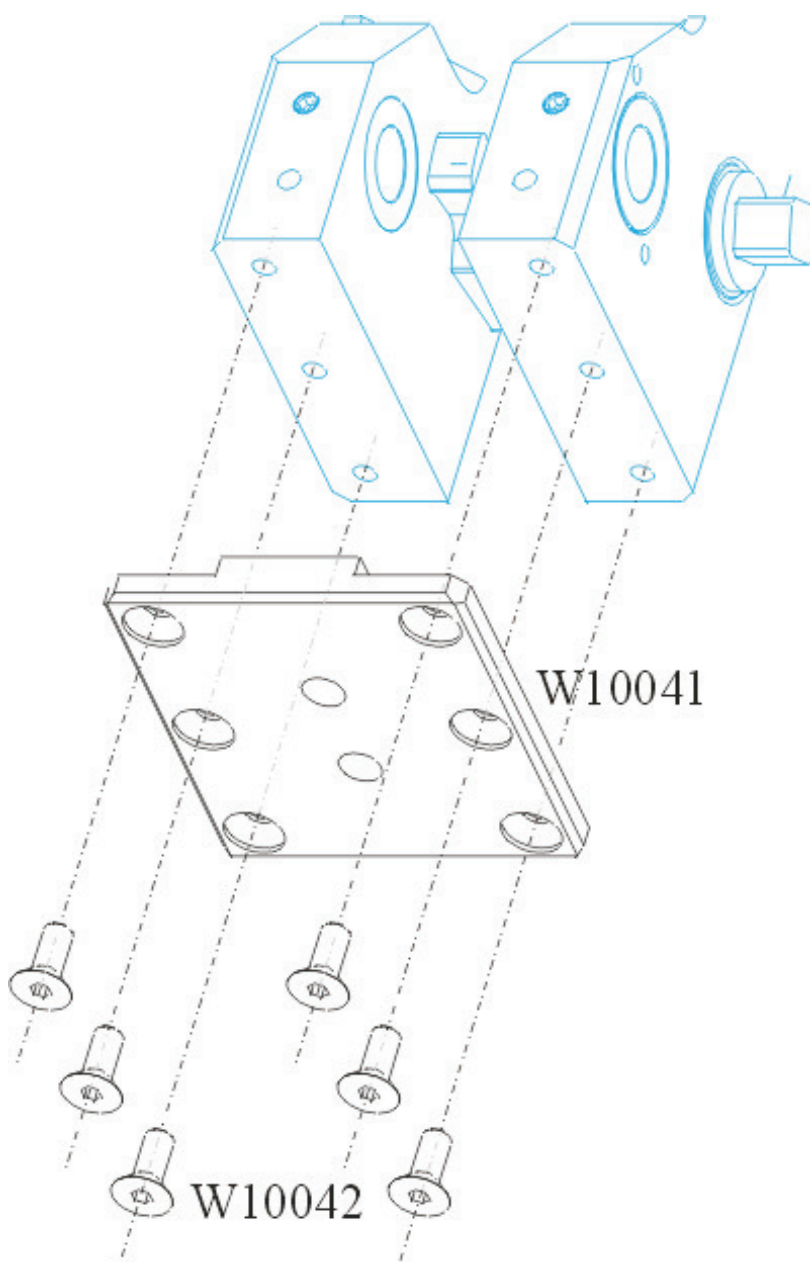
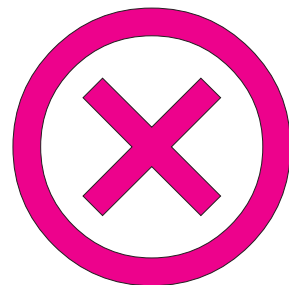


No.	Name of Part	Required
W10059	Camming Link	1
W10089	Lock Washer	1
W12081	Socket Head Cap Screw	1

### Back Plate:

Should never be removed. If one of the W10042 Flat Head Screws comes loose, tighten firmly and seal with Loctite.

If the screws need to be replaced it is very important to heat the screw head with a torch for 20 - 30 seconds and then remove the screw immediately. Repeat for all six screws. Without the heating the screws can be very difficult to remove.



No.	Name of Part	Required
W10041	Back Plate	1
W10042	Flat Head Socket Screw	6



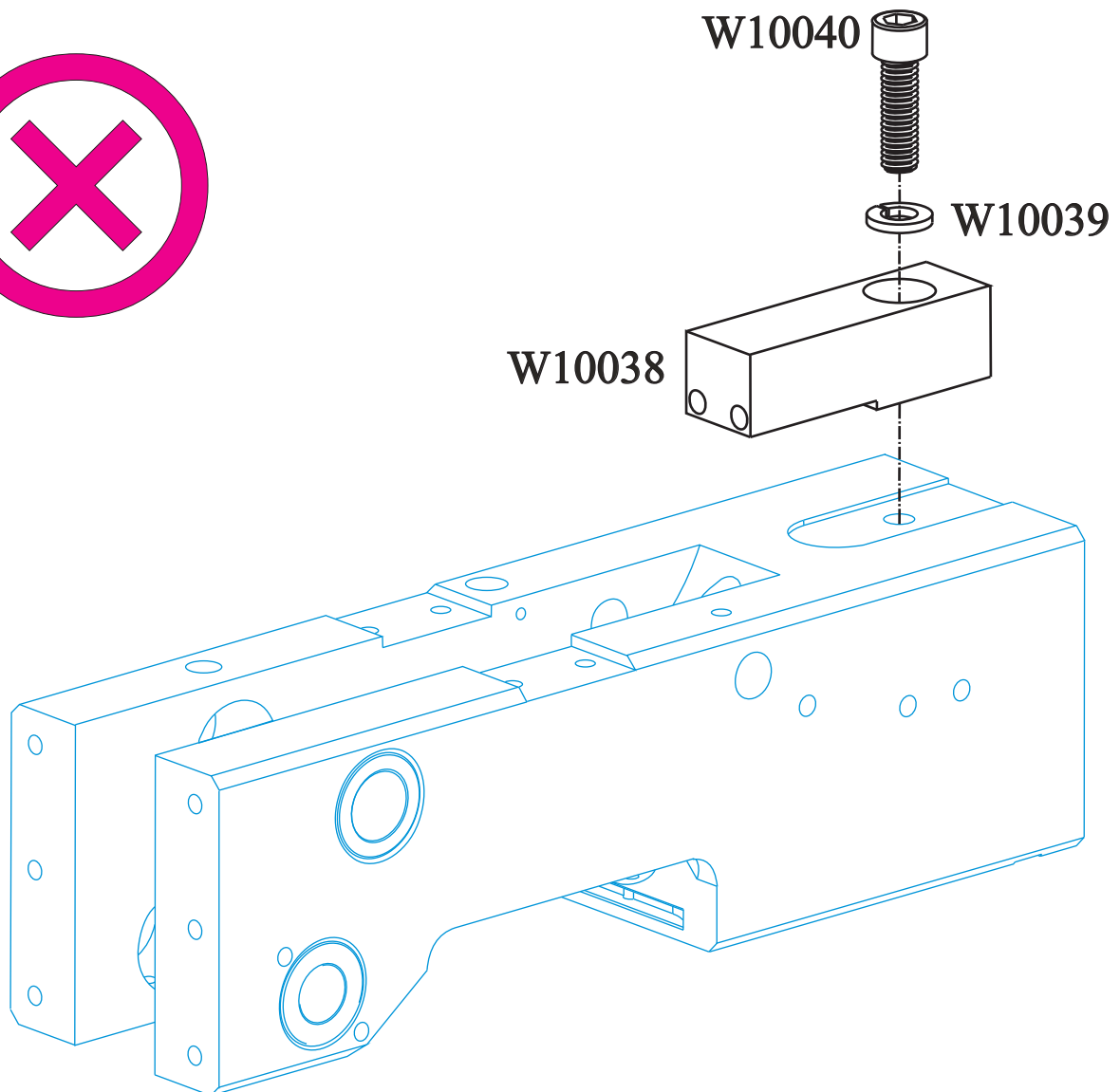
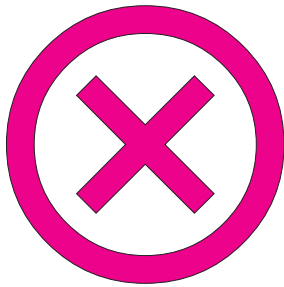
## WINCHESTER INDUSTRIAL SERVICE

V. Parbst & Søn  
41 Borsholmvej, 3000 Helsingør  
Denmark

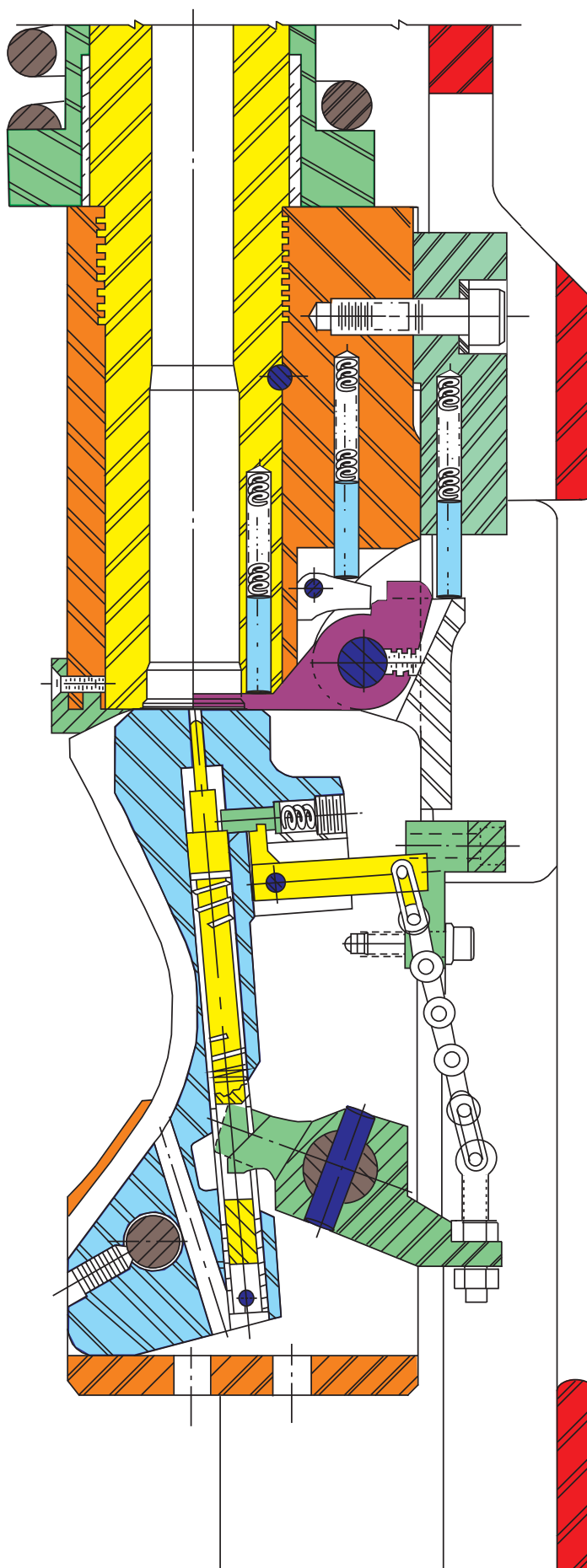
Phone no.: (45) 49 76 54 00  
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### Guide Block:

Remove W10040 Socket Head Cap Screw, and W10038 Guide Block can be replaced. Guns with old Extractor System (page 12) have Guide Block without holes for springs. New Guide Block can be used for all guns.



No.	Name of Part	Required
W10038	Guide Block	1
W10039	Lock Washer	1
W10040	Socket Head Cap Screw	1







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## Correcting Difficulties

Problem	Fault	Remedy	Page
<b>Gun Will Not Fire</b>	1. Pitted or bent Firing Pin.	1. Replace.	9/10
	2. Weak Firing Pin Spring.	2. Replace.	9/10
	3. Contamination between Firing Pin and Breech Block.	3. Disassemble, clean, and re-assemble.	9/10
	4. Broken Trigger.	4. Replace.	9/10
	5. Set screw W10011 has come out and allowed Sear Spring W10008 to fall out.	5. Replace Spring and Set Screw, staking flush with surface of Breech Block	9/10
	6. Incorrect use of Lanyard.	6. Pull the Lanyard to rear. Downward motion only, will not necessarily fire the gun.	6
<b>Shells Do Not Extract</b>	1. Dirty chamber.	1. Clean camber with steel Wire Brush W15041 and spray solvent(*), wipe completely dry.	--
	2. Dirt between Extractor and Receiver	2. Clean the Extractor slot in chamber area of Barrel using compressed air and a spray solvent(*), wipe chamber completely dry	12/13
	3. Broken Extractor.	3. Replace Part.	12/13
	4. Broken Extractor Spring, 2 pcs.	4. Replace Parts.	12/13
<b>Hard Opening and Closing of Breech Block</b>	1. Dirt between Breech Block and Receiver.	1. Remove Breech Block, clean all surfaces with spray solvent(*), wipe completely dry and re-assemble.	8
	2. Friction between Breech Block Pin and Receiver Bushings W10045.	2. Remove Breech Block Pin, Clean bushing and pin, and re-assemble.	8/16
	3. Dirty Cocking Cam.	3. Clean Cocking Cam and mating surface of Breech Block with spray solvent(*), wipe completely dry and re-assemble.	19
	4. Dirty Cocking Cam Shaft & Receiver Bushings.	4. Remove Cocking Cam Shaft, Clean with spray solvent(*), wipe completely dry and re-assemble. (Remove only if absolutely necessary).	19
	5. Cocking Cam Shaft Pin W10016 worked loose.	5. Replace Pin and peen edge of hole in Cocking Cam.	19
* Use a dry lubricant, never use petroleum based spray oils to clean gun.			