

**SEQUENCE
OF
TAKE-DOWN and
ASSEMBLY OPERATIONS**

WINCHESTER.

**MODEL 37 SINGLE BARREL SHOTGUN
12, 16, 20, 28 GAUGE 410 BORE**



PRODUCT SERVICE DEPARTMENT

Olin

**WINCHESTER-WESTERN DIVISION
NEW HAVEN 4, CONNECTICUT**

PRINTED FOR THE GUNSMITH TRADE

INSTRUCTIONS
FOR
TAKE DOWN & ASSEMBLY
OF
M/37 SINGLE BARREL SHOTGUN
12, 16, 20, 28 GA.
410 BORE

PRODUCTS SERVICE DEPT.,
WINCHESTER-WESTERN DIVISION,
OLIN-MATHIESON CHEMICAL CORP.,
NEW HAVEN, 4, CONN.

7 OCT 59 A. Q. Grubbs.

INSTRUCTIONS
FOR
TAKE DOWN
OF
M/37 SINGLE BARREL SHOT GUN,
12, 16, 20, 28 GA.
410 BORE.

PRODUCTS SERVICE DEPT.,
WINCHESTER-WESTERN DIVISION,
OLIN-MATHIESON CHEMICAL CORP.,
NEW HAVEN, 4, CONN.

7 OCT 57 A. G. Arnold.

12.16.20.78
TO TAKE DOWN M137 SINGLE BARREL SHOT GUN- 410 BORE
TO REMOVE FOREARM-

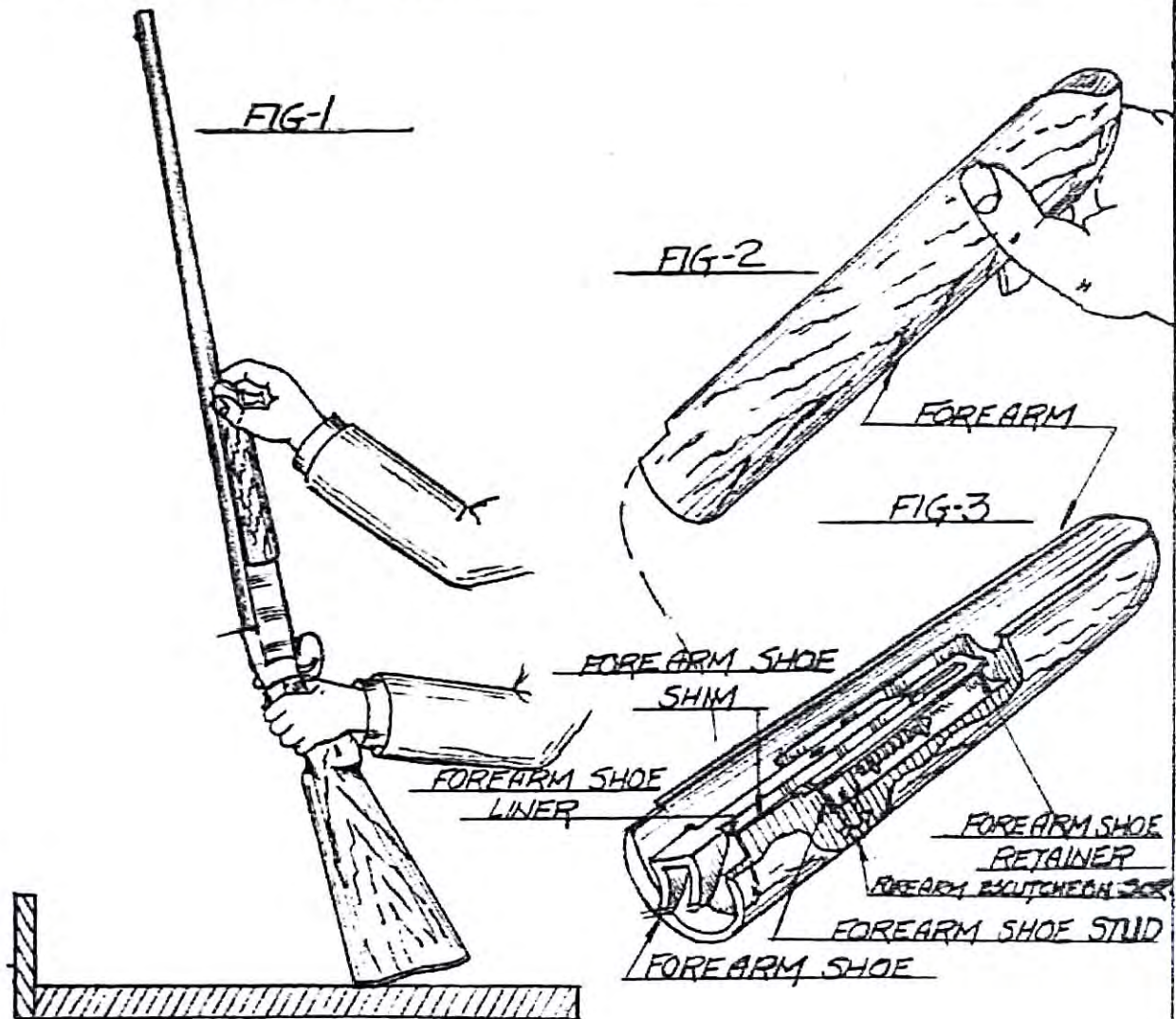


Fig. 1, 2, 3

To Remove Forearm From Gun

Hold gun inverted, with left hand at pistol grip and gun inclined away from operator at approximately 60° angle with bench. Grasp front end of forearm with right hand, pull it backward and break front end downward off barrel. Remove forearm to bench with right hand.

6 OCT 59 A.A. Arnold.

TO TAKE DOWN M/37 SINGLE BARREL SHOTGUN - 12, 16, 20, 28 GA,
410 BORE -
TO REMOVE FOREARM ESCUTCHEON SCREW, FOREARM SHOE -
FOREARM SHOE RETAINER ASSEMBLY, FOREARM LINER & SHIM -

Fig. 4, 5, 6, 7

To Take Down Forearm - To Remove Escutcheon Screw

Place forearm on bench, inletted sides downward, front end to left of the operator. Remove forearm escutcheon screw with a suitable screw driver by turning it counterclockwise. Invert forearm and remove retainer shoe assembly, forearm shoeliner and shim from rear end of forearm.

The M/37 single barrel shotgun is made in 12, 16, 20, 28 Ga, 410 bore. The design is constant but many of the various components vary in size, according to the barrel and frame sizes required by the gages and bore, but are similar in design and functioning.

6 OCT 57 A. T. Arnold

12,16,20,28 GA.
TO TAKE DOWN M.37 SINGLE BARREL SHOT GUN- 410 BORE
TO REMOVE FORE ARM-

FIG 4

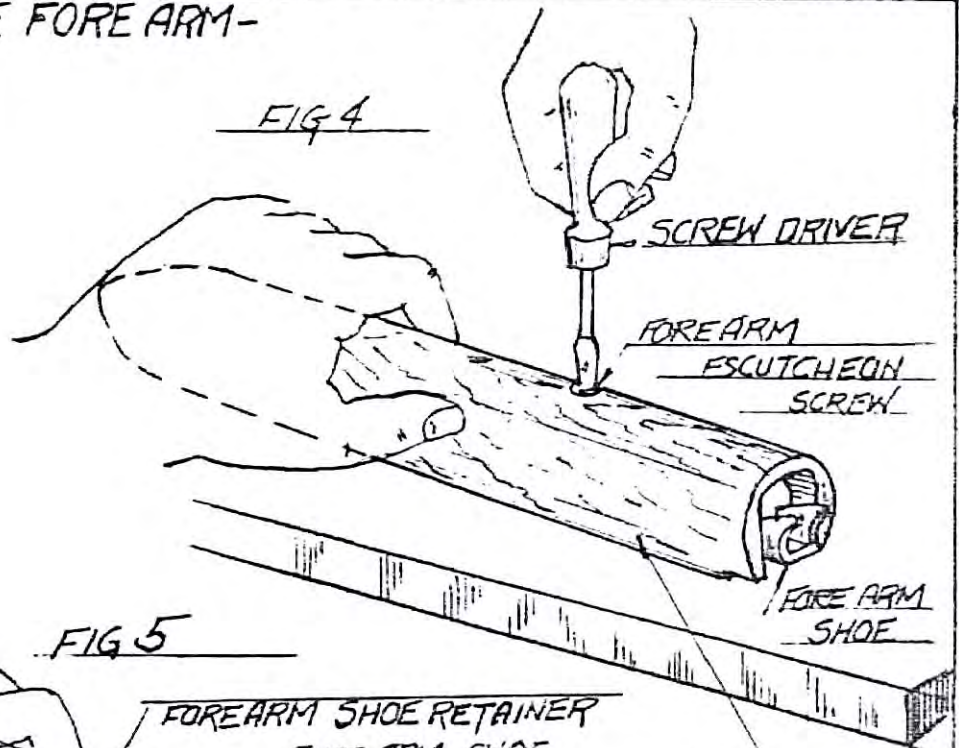
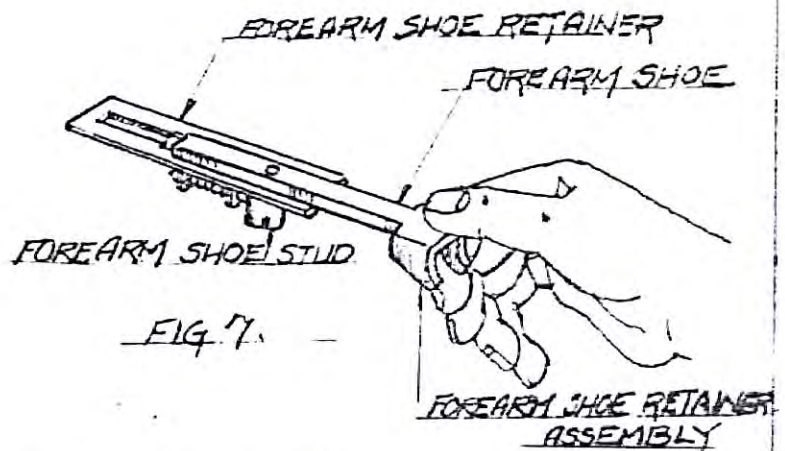
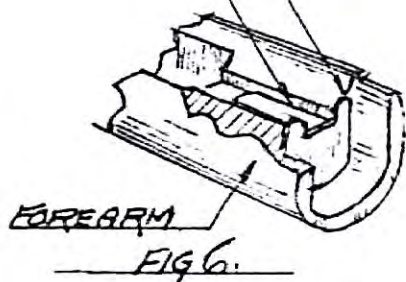
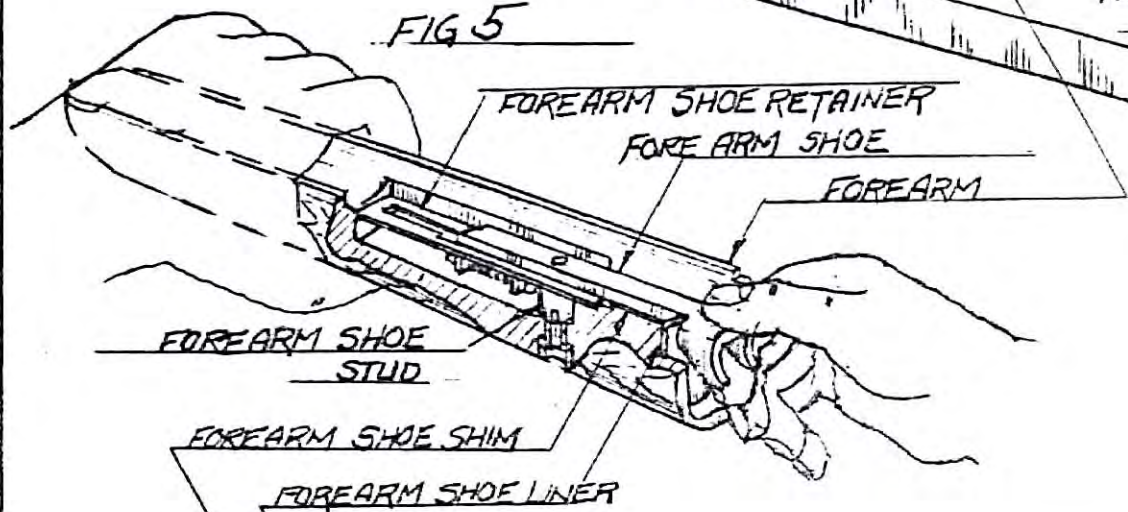


FIG 5



6 OCT 57 A. G. G. G. G.

TO TAKE DOWN M137 SINGLE BARREL SHOT GUN-^{12, 16, 20, 28 GA}
 410 BORE
 TO TAKE DOWN FOREARM SHOE & FOREARM SHOE RETAINER-

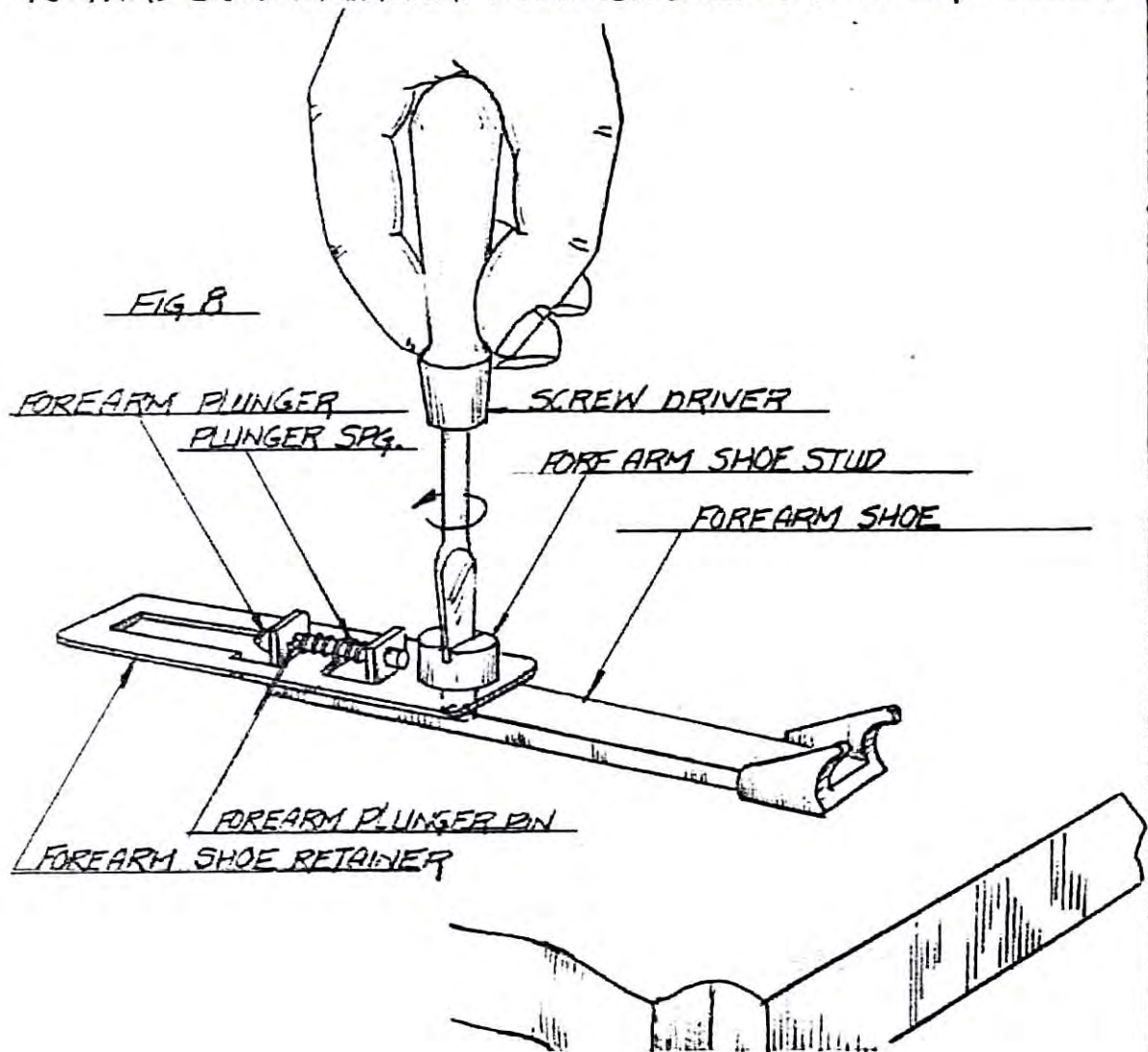


Fig. 8

To Take Down Forearm Retainer Shoe Assembly

Place retainer shoe assembly on bench with forked end of shoe upward and forked end toward operator. With a suitable screw driver turn the forearm shoe stud counterclockwise to remove it. Remove retainer from shoe.

6 OCT 59 A. A. Arnold

12,16,20,28 GA

TO TAKE DOWN M/37 SINGLE BARREL SHOT GUN- 410 BORE
TO REMOVE BUTT STOCK FROM ACTION-

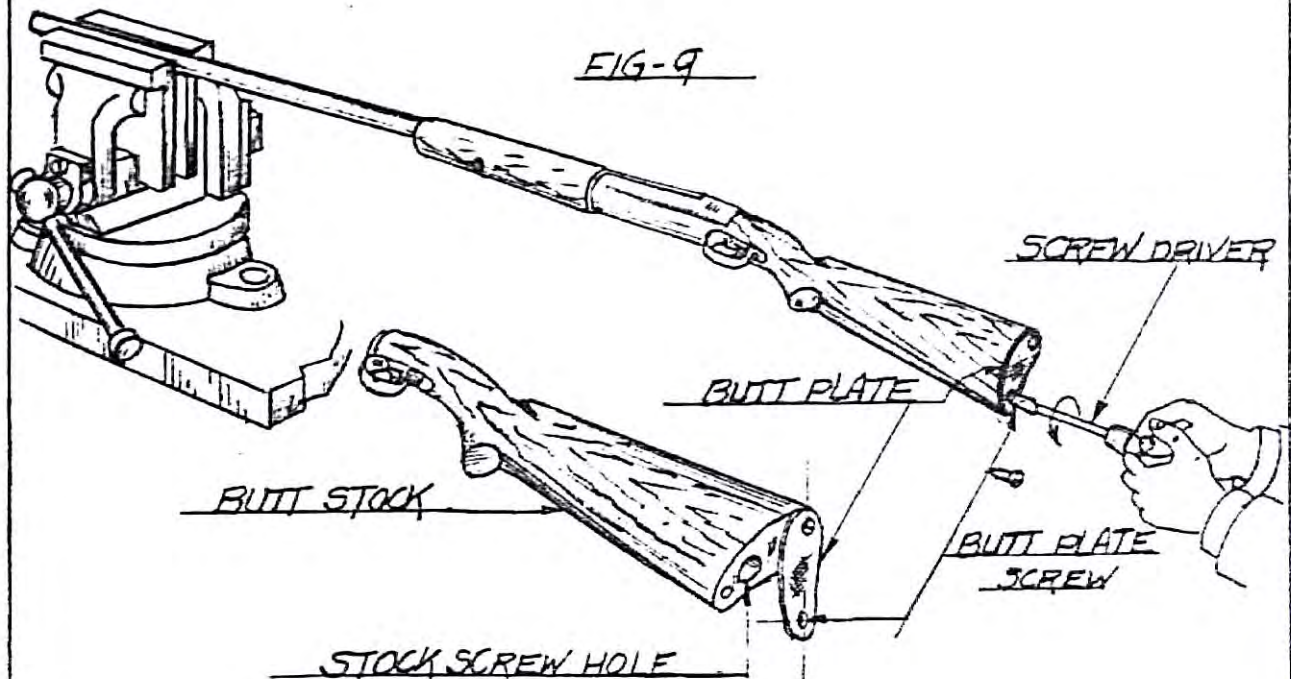


Fig. 9

To Remove Butt Stock From Gun

Hold gun by barrel, left side upward, in a suitable vise with protected jaws and with butt at right of vise.

With a suitable screw driver, remove lower butt plate screw by turning it counterclockwise. Loosen upper butt plate screw about one-half turn or until butt plate drops down and hangs vertically on upper screw.

7 OCT 59 A. G. Gandy

TO TAKE DOWN M137 SINGLE BARREL SHOT GUN- 12,16,20,28 GA.
410 BORE
TO REMOVE BUTT STOCK FROM ACTION- (CONTINUED)

FIG 10

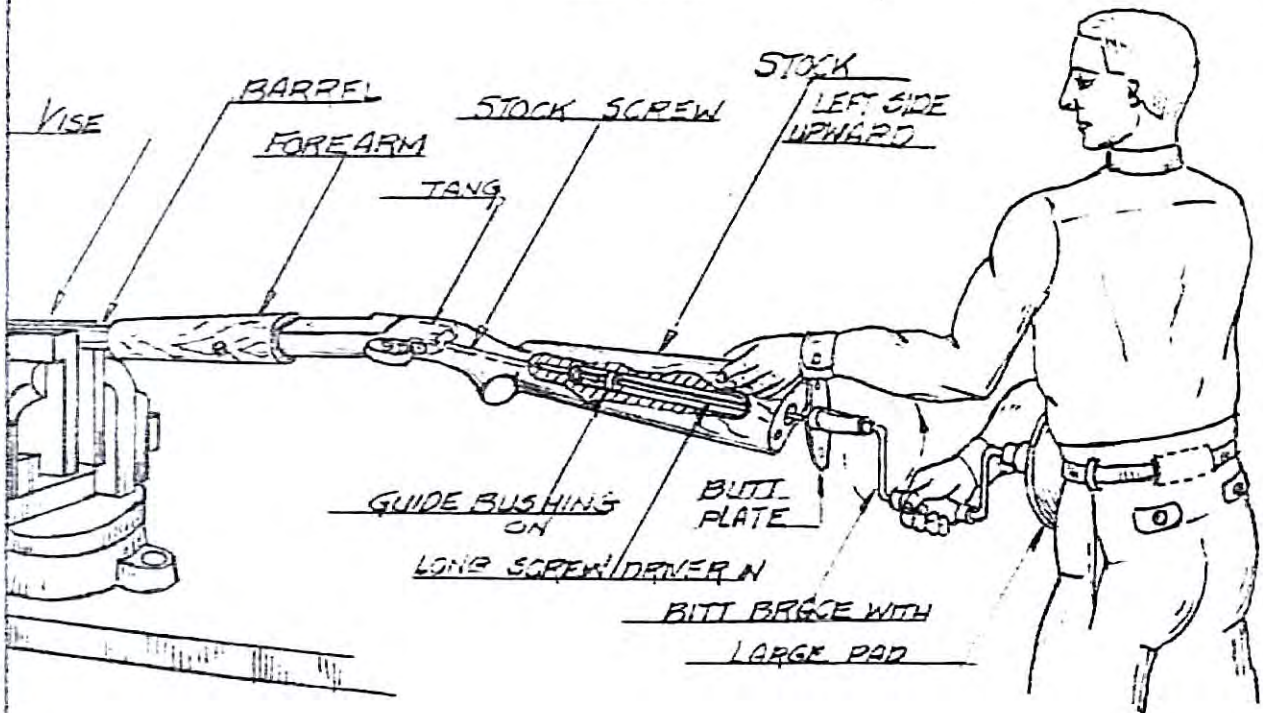


Fig. 10

To Remove Butt Stock From Gun (cont'd)

With a long screw driver blade having a guide bushing and held in a suitable butt brace with a large pad, loosen and free the stock screw by turning it counterclockwise. Remove stock, still held in left hand, from gun. Leave stock screw in its hole in butt stock except in case of replacement.

8 OCT 59 A. A. Arnold

12.16.20.2864
TO TAKE DOWN M137 SINGLE BARREL SHOT GUN 410 BORE
TO REMOVE FRAME FROM BARREL & BARREL LUG-

Fig. 11, 12, 13

To Remove Frame From Barrel

Hold gun by the barrel with left side upward, in a suitable vise with protected jaws, with forearm lug at right of and near vise. Press top lever down to right side and swing tang end of frame off from breech end of barrel.

When frame clears barrel and barrel lug, move it forward to disengage joint pin from its seat in barrel lug, and frame may be removed from barrel.

8 OCT 59 A. A. Arnold

TO TAKE DOWN M/37 SINGLE BARREL SHOT GUN - 12, 16, 20, 28 GA.
410 BORE

TO REMOVE FRAME FROM BARREL & BARREL LUG -

FIG-11

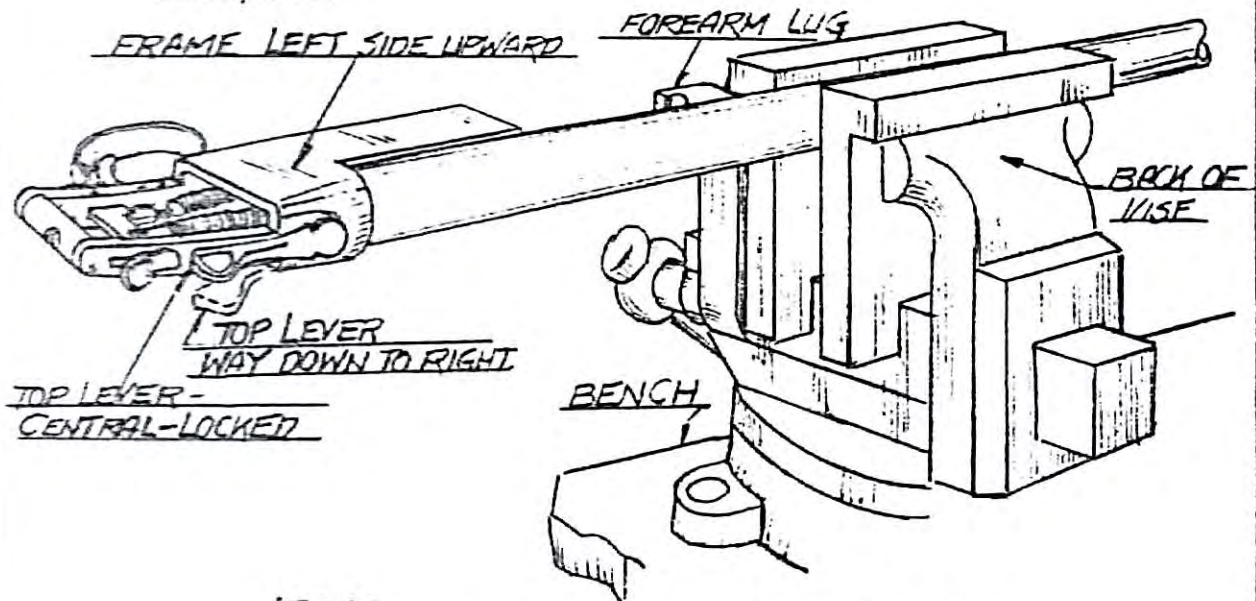


FIG-12

SWING FRAME AWAY FROM BARREL AROUND JOINT PIN - THEN PULL FRAME FORWARD OFF

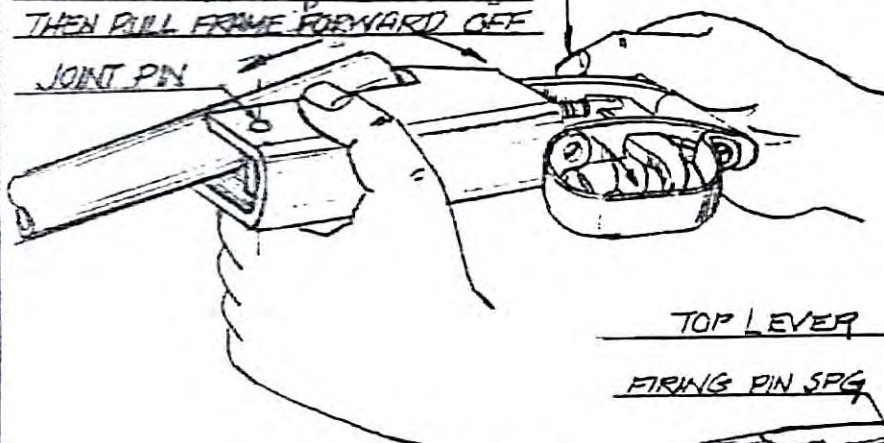
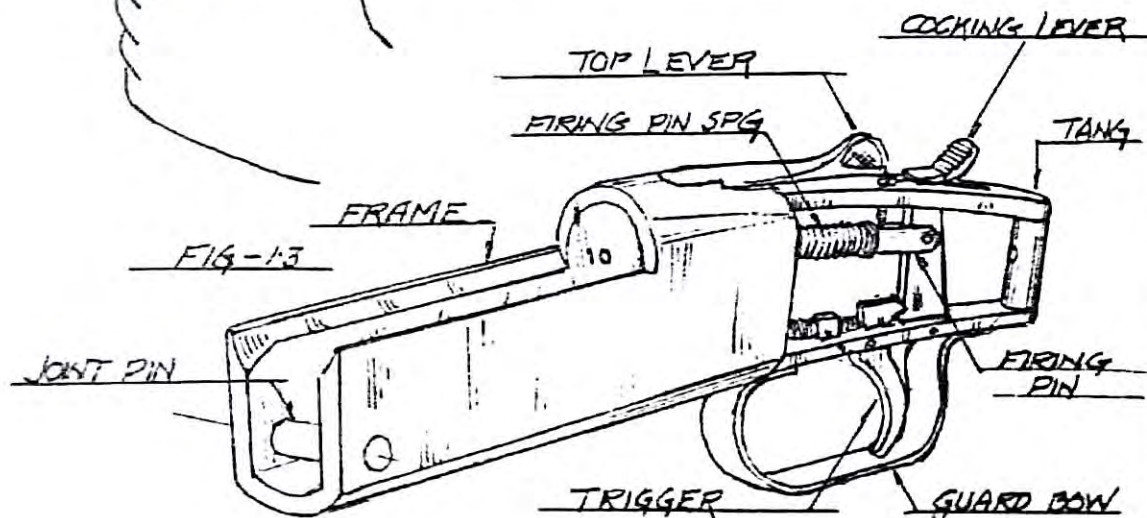


FIG-13



8 OCT 29 A. A. Grubbs

TO TAKE DOWN M137 SINGLE BARREL SHOTGUN- 12, 16, 20, 28 GA.
 410 BORE
 -- TO TAKE DOWN BARREL LUG - TO DISENGAGE EXT. SEAR FROM EXTRACTOR

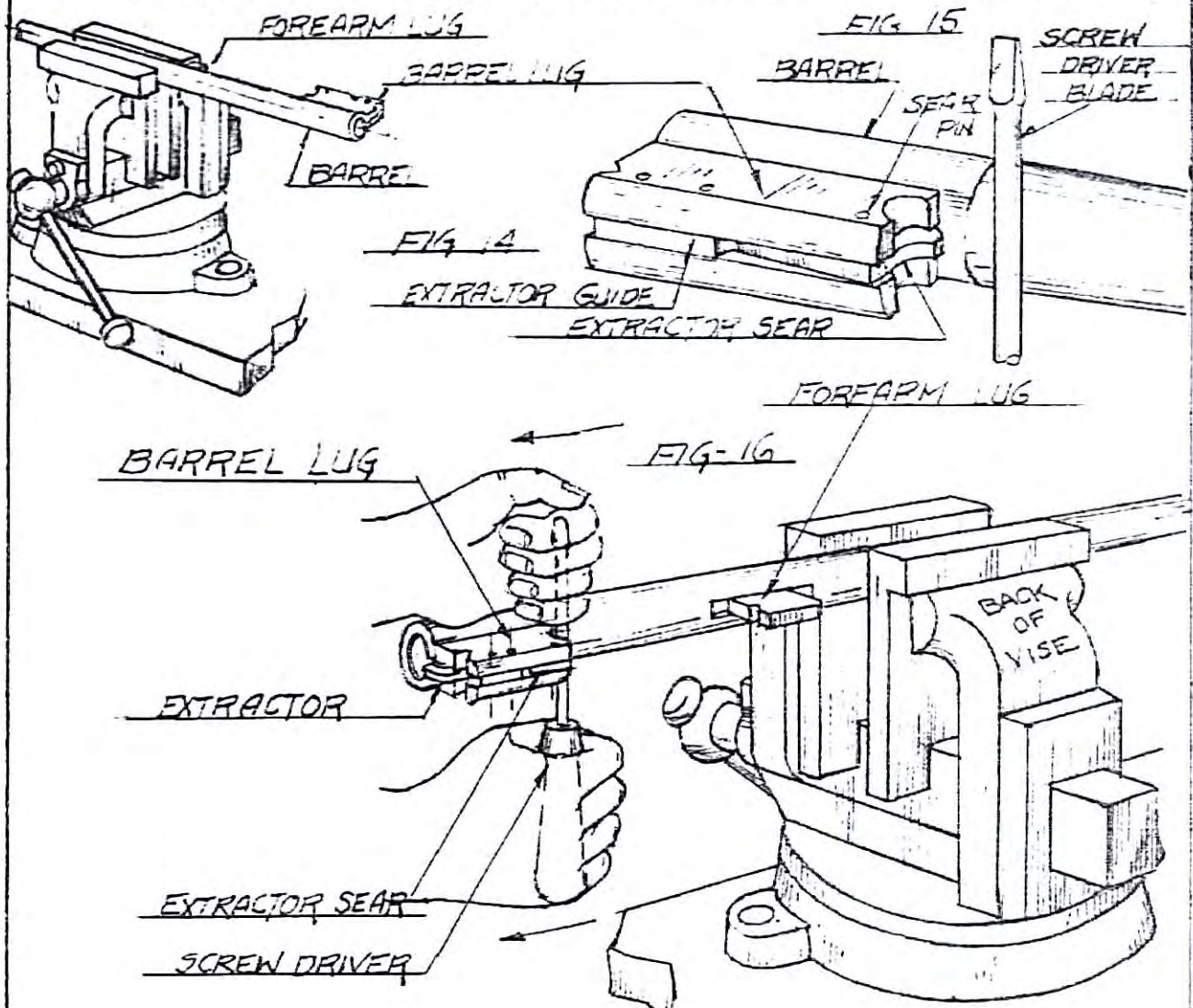


Fig. 14, 15, 16

To Take Down Barrel Lug

To disengage extractor sear from extractor. Place barrel in a suitable vise with protected jaws, with right side upward and chamber at right with forearm lug near vise. Grasp a suitable screw driver, held vertically by both hands, and place shank of blade against front side of extractor sear. Pull sear rearward to disengage hook on it from extractor, where a click will be heard.

5 NOV 59 A. A. Greding

TO TAKE DOWN M137 SINGLE BARREL SHOT GUN- 12, 16, 20, 28 GA,
410 BORE
TO TAKE DOWN BARREL LUG- TO REMOVE EXTRACTOR, EXTRACTOR
SEAR, SEAR SPRING

Fig. 17, 18, 19

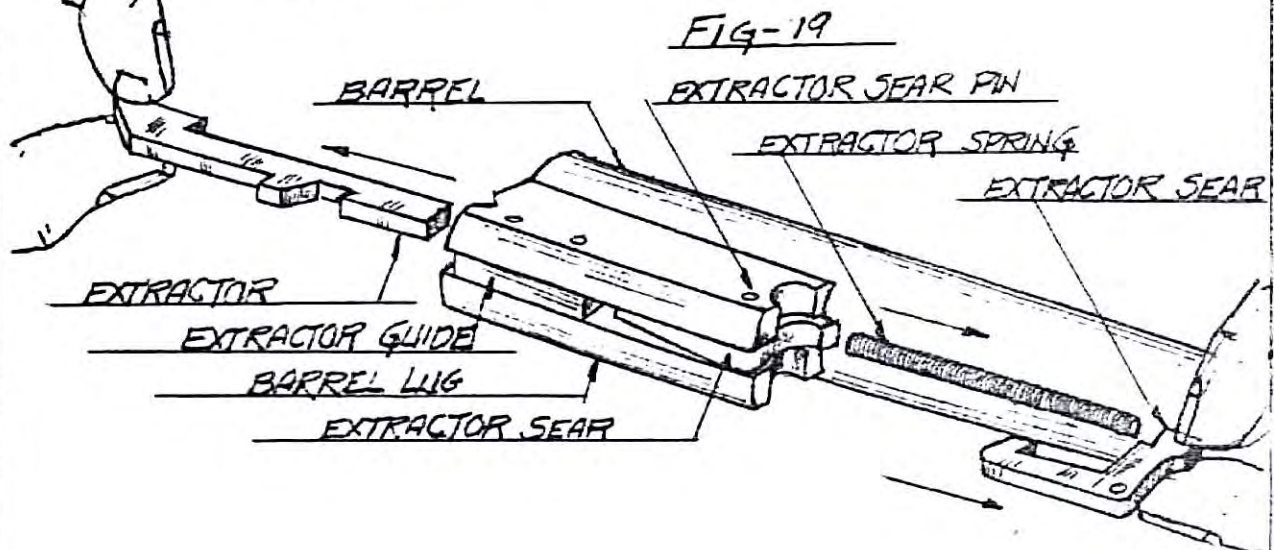
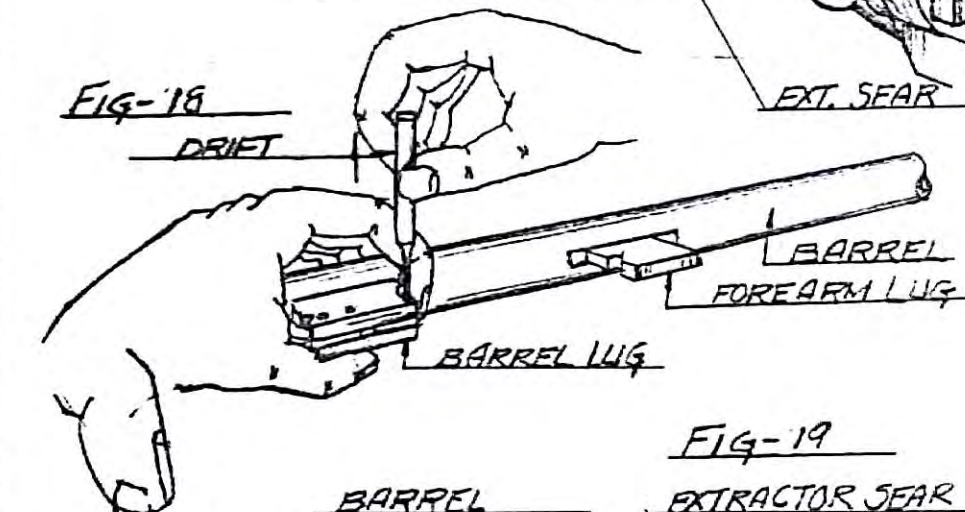
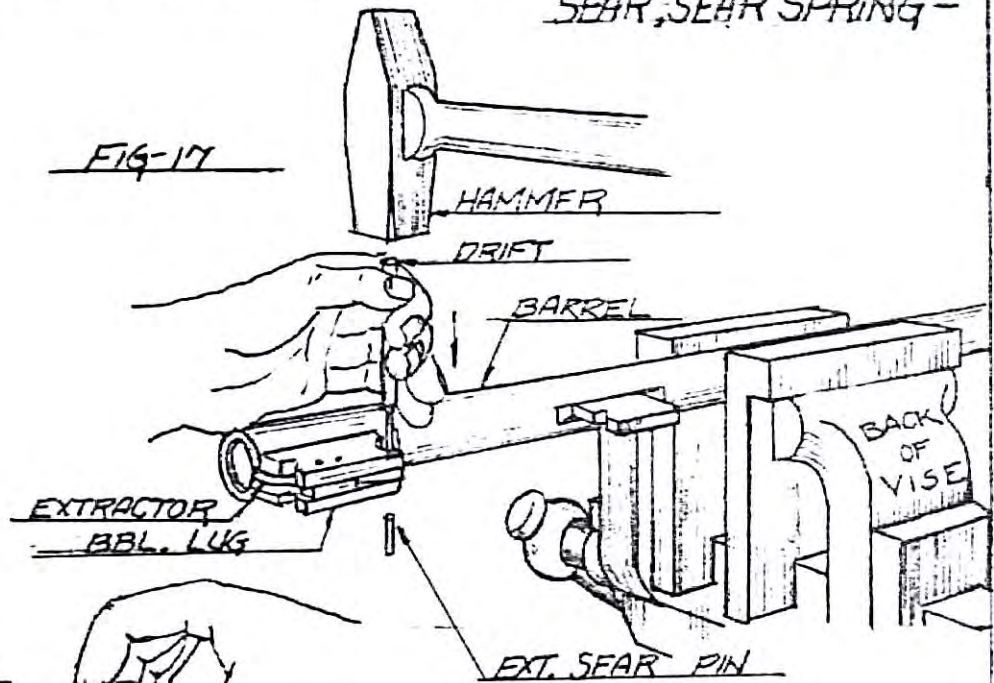
To Remove Extractor, Extractor Sear and Sear Spring

Hold barrel in a suitable vise with protected jaws, right side upward and chamber at right. Use a suitable drift and hammer to drive out sear pin (front pin in barrel lug) from right to left leaving drift in hole to hold sear in place.

Place forefinger of left hand over front of sear, which is under pressure from spring. Remove drift with right hand releasing spring pressure. Remove sear, sear spring and extractor from barrel lug.

5 NOV 57 *[Signature]*

TO TAKE DOWN M137 SINGLE BARREL SHOT GUN - 12, 16, 20, 28 GA. 410 BORE -
 TO TAKE DOWN BARREL LUG - TO REMOVE EXTRACTOR, EXTRACTOR SEAR, SEAR SPRING -



5 NOV 59 a. a. Arnold

TO TAKE DOWN M137 SINGLE BARREL SHOT GUN - 12, 16, 20, 28 GA
410 BORE
TO TAKE DOWN BARREL LUG - TO REMOVE EXTRACTOR GUIDE -

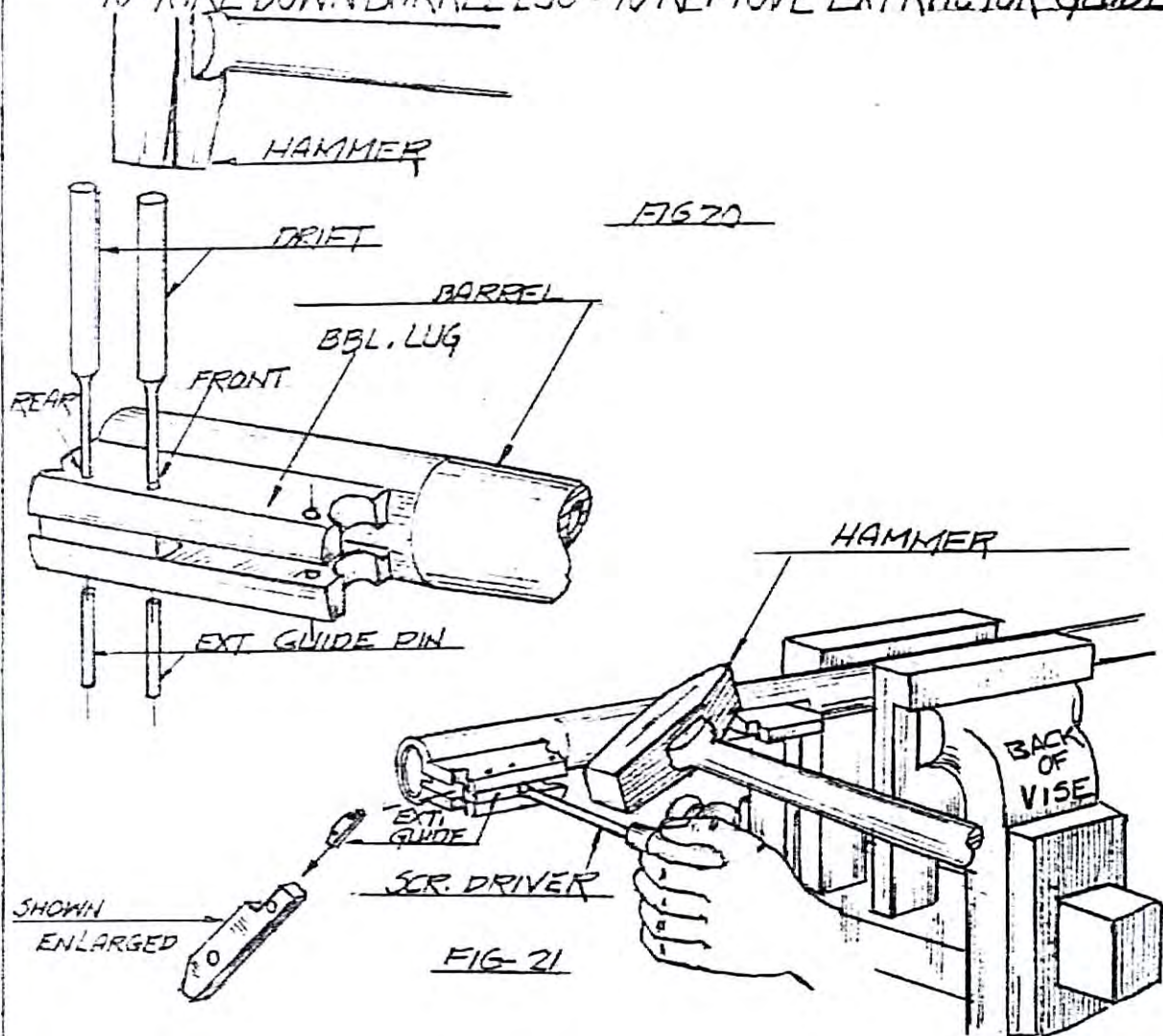


Fig. 20, 21

To Remove Extractor Guide Pins, Front and Rear, and
Extractor Guide

Hold barrel in a suitable vise with protected jaws, right side upward and chamber at right. With a suitable drift and hammer drive out the front extractor guide pin (middle pin in barrel lug), and the rear extractor guide pin.

The extractor guide fits tightly in slot in barrel lug. Insert blade of a suitable screw driver, held in left hand in slot and against end of guide. With a suitable hammer tap shank of screw driver to remove extractor guide through rear of barrel lug.

5 NOV 59 J. J. Quady

TO TAKE DOWN M1/37 SINGLE BARREL 5 SHOT GUN- 12, 16, 20, 28 GA.
410 BORE

TO TAKE DOWN FRAME - TO REMOVE FIRING PIN CONNECTING PIN -

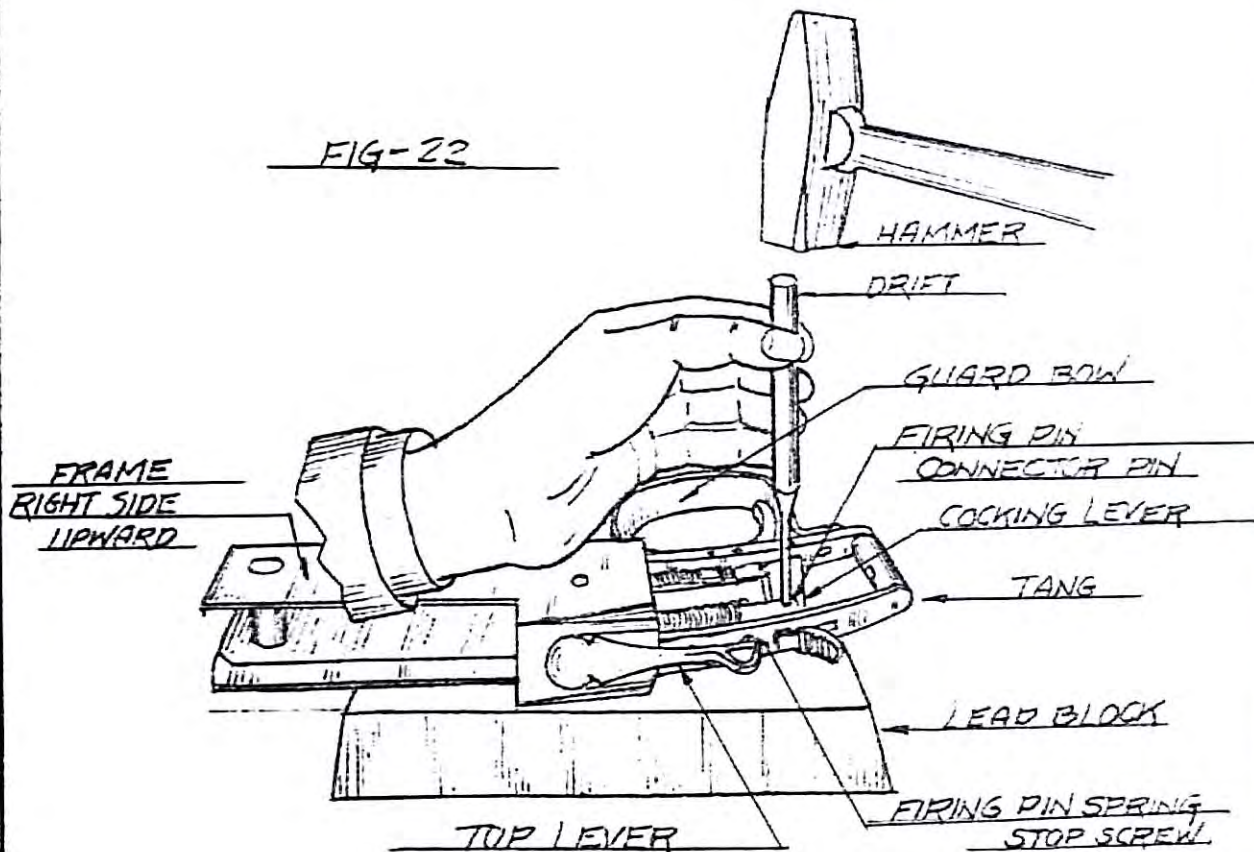


Fig. 22

To Take Down Frame
To Remove Firing Pin Connecting Pin

Place frame on lead block on bench, guard bow away from operator at right and with right side upward. With a suitable drift and hammer drive out the firing pin connecting pin from right to left.

This is the suggested holding position for many of the subsequent take down operations.

9 OCT 59 A. G. Gandy

TO TAKE DOWN M137 SINGLE BARREL SHOT GUN - 12, 16, 20, 28 GA.
410 BORE

TO TAKE DOWN FRAME - TO REMOVE FIRING PIN SPRING STOP SCREW

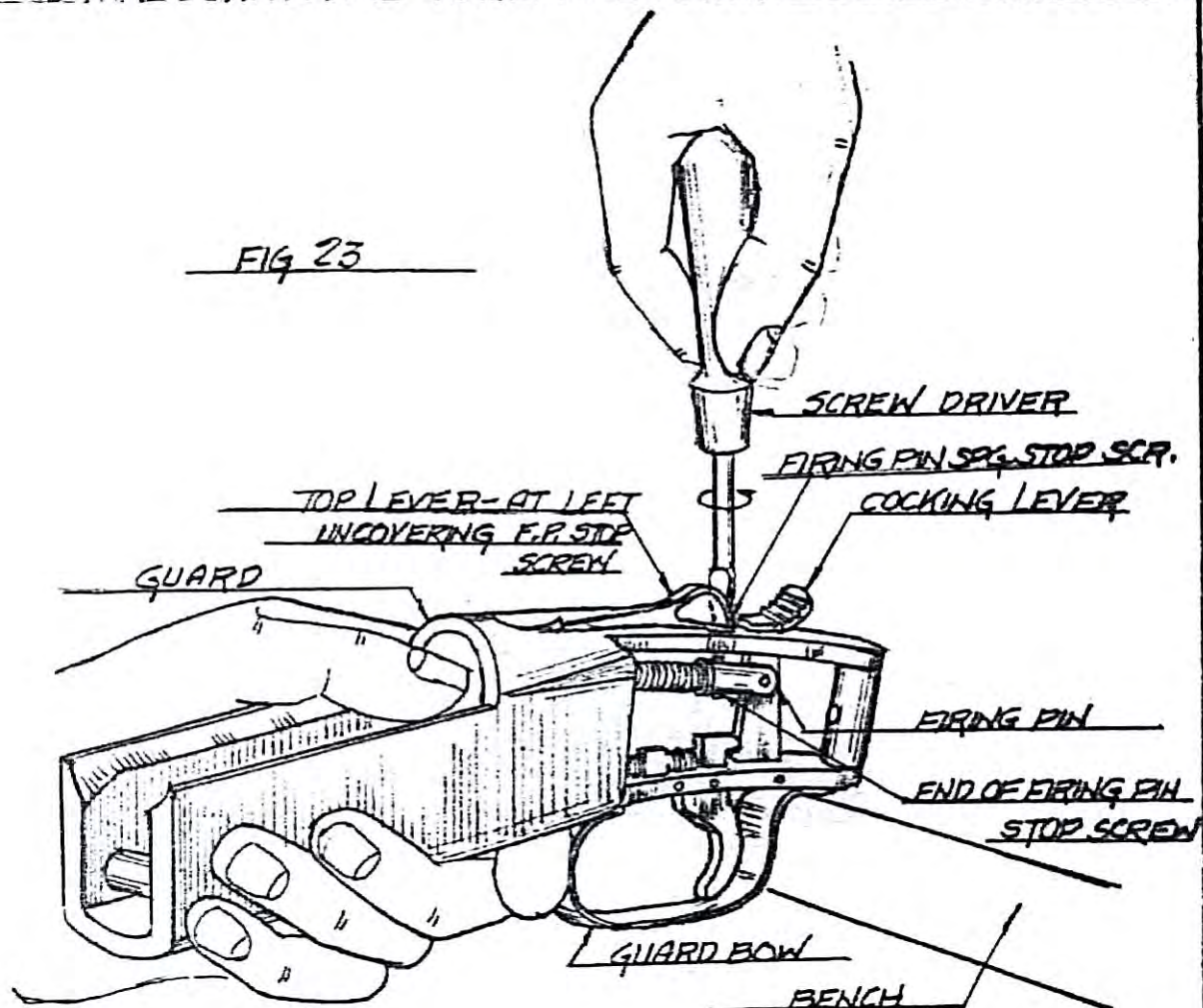


Fig. 23

To Remove the Firing Pin Spring Stop Screw

Remove the firing pin spring stop screw from top tang of frame, held top upward in left hand with tang resting on bench, by turning it counterclockwise with a suitable screw driver. Push top lever to right by screw driver, when reaching screw.

9 OCT 59 A. A. Grady

TO TAKE DOWN M/37 SINGLE BARREL SHOT GUN - 12, 16, 20, 28 GA.
410 BORE
TO TAKE DOWN GUARD - TO REMOVE COCKING LEVER PIN &
COCKING LEVER -

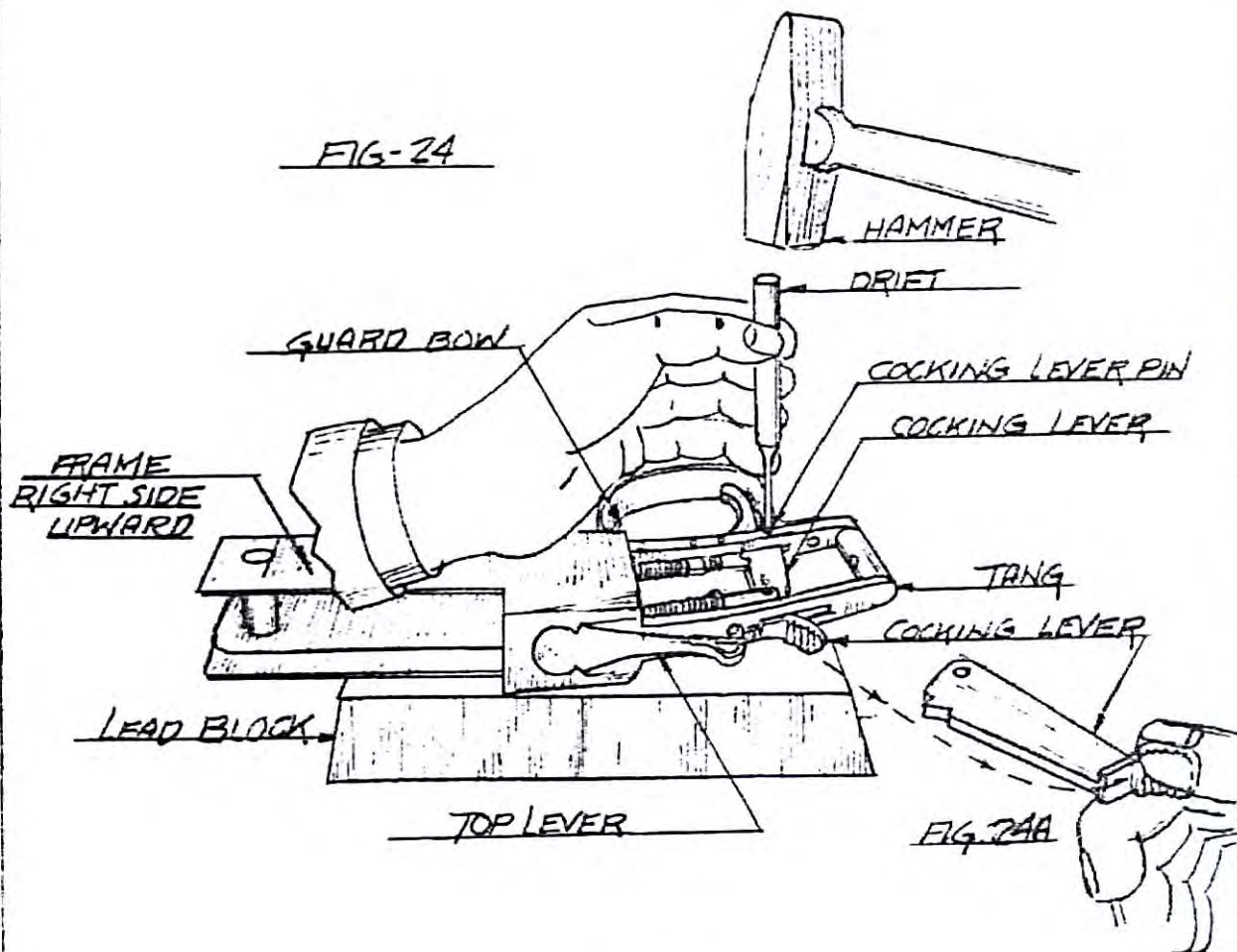


Fig. 24

To Remove Cocking Lever Pin and Cocking Lever

Place frame on lead block on bench, guard away from operator, right side upward. With a suitable drift and hammer drive out the cocking lever pin from frame, right to left. Remove cocking lever with right hand, sliding it out through top tang toward operator.

9 OCT 59 A. G. Arnold

TO TAKE DOWN M/37 SINGLE BARREL SHOT GUN- 12, 16, 20, 28 GA.
410 BORE
TO TAKE DOWN GUARD- TO REMOVE FIRING PIN & F.P. SPRING-

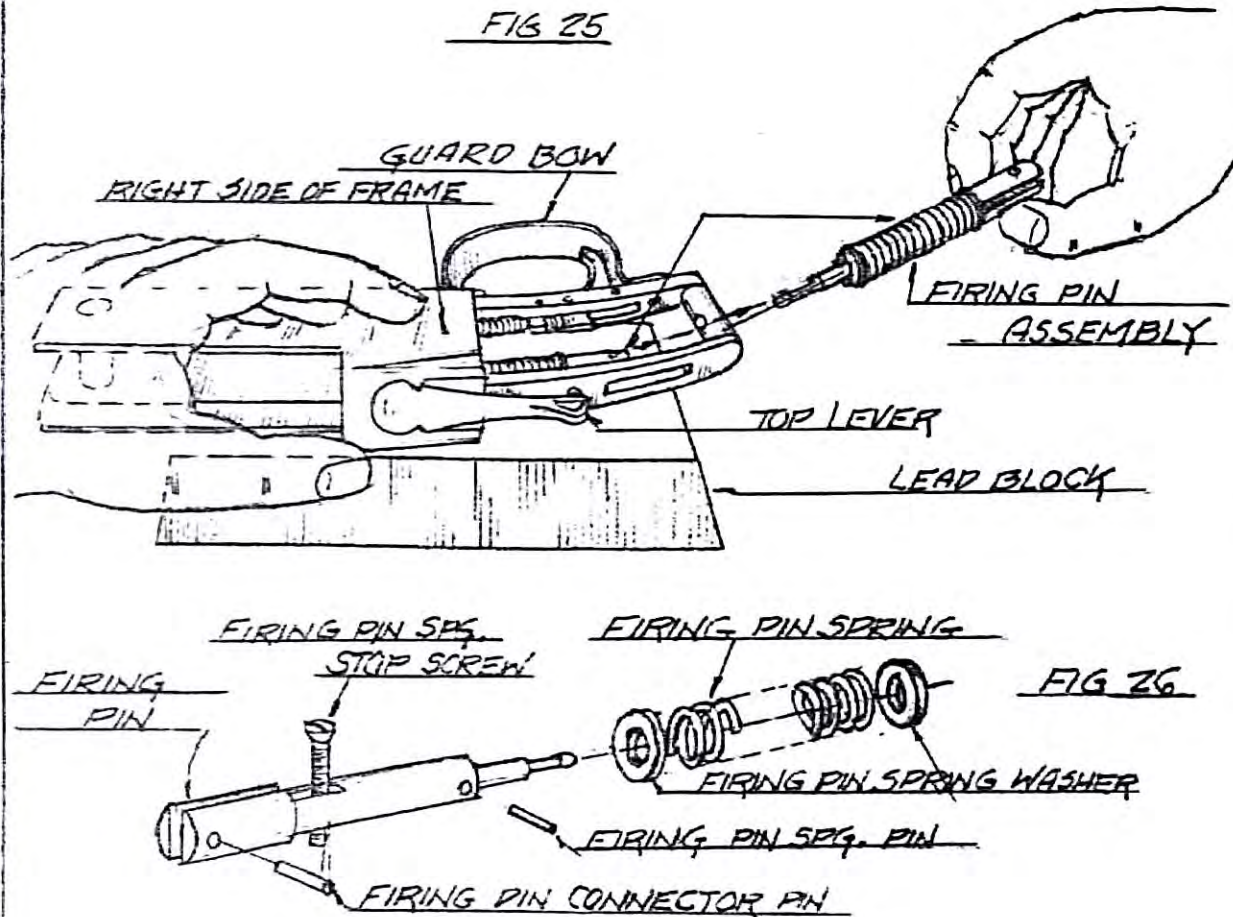


Fig. 25, 26

To Remove Firing Pin

After removing the cocking lever, with frame still on lead block on bench, guard away from operator and right side upward, grasp firing pin with right hand and remove it from the rear of frame to the right. If necessary to take out firing pin, be careful not to lose the firing pin spring, washers or spring pin.

12 OCT 59 A. A. Arnold

TO TAKE DOWN M/37 SINGLE BARREL SHOT GUN - 12, 16, 20, 28 GA.
TO TAKE DOWN FRAME - TO REMOVE TRIGGER PIN & TRIGGER - 410 BORE

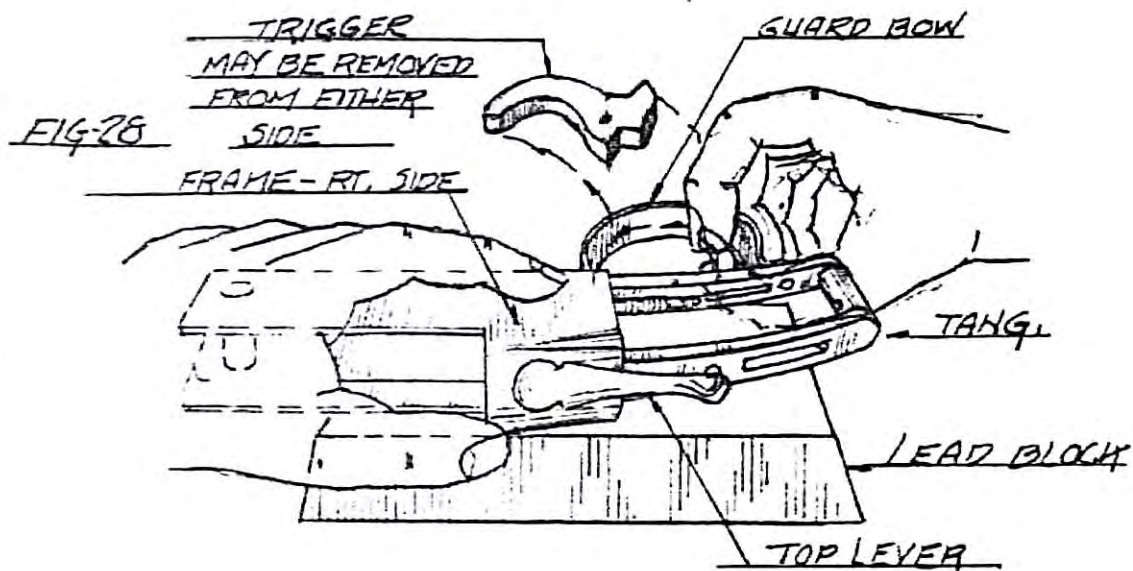
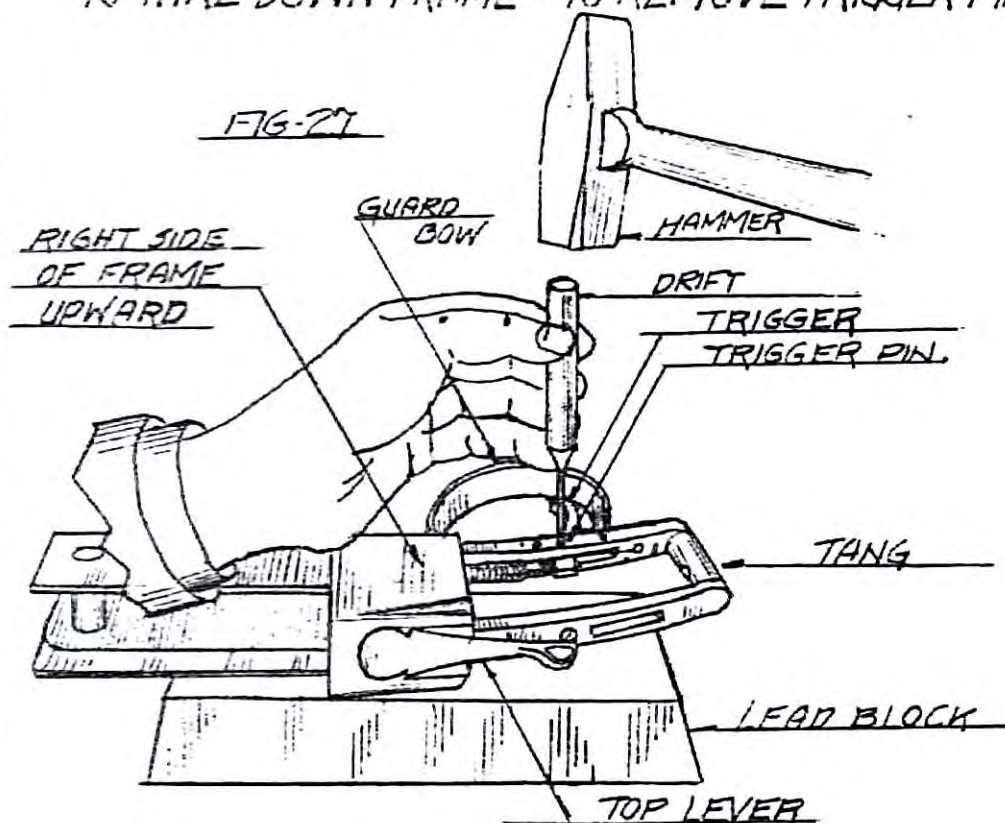
Fig. 27, 28

To Remove Trigger Pin and Trigger

Hold frame on lead block on bench, guard away from operator right side upward. Drive out trigger pin from right to left and remove trigger down through frame into guard bow by swinging bottom end forward and removing it from either side of bow.

12 OCT 59 A. A. Gentry

12.16.20.286A
 TO TAKE DOWN M137 SINGLE BARREL SHOT GUN 410 BORE
 TO TAKE DOWN FRAME - TO REMOVE TRIGGER PIN & TRIGGER.



12 OCT 57 A.A. Arnold

12.16.20.20 GA
910 BORE
TO TAKE DOWN M137 SINGLE BARREL SHOT GUN -
TO TAKE DOWN GUARD - TO REMOVE TRIGGER SPRING -

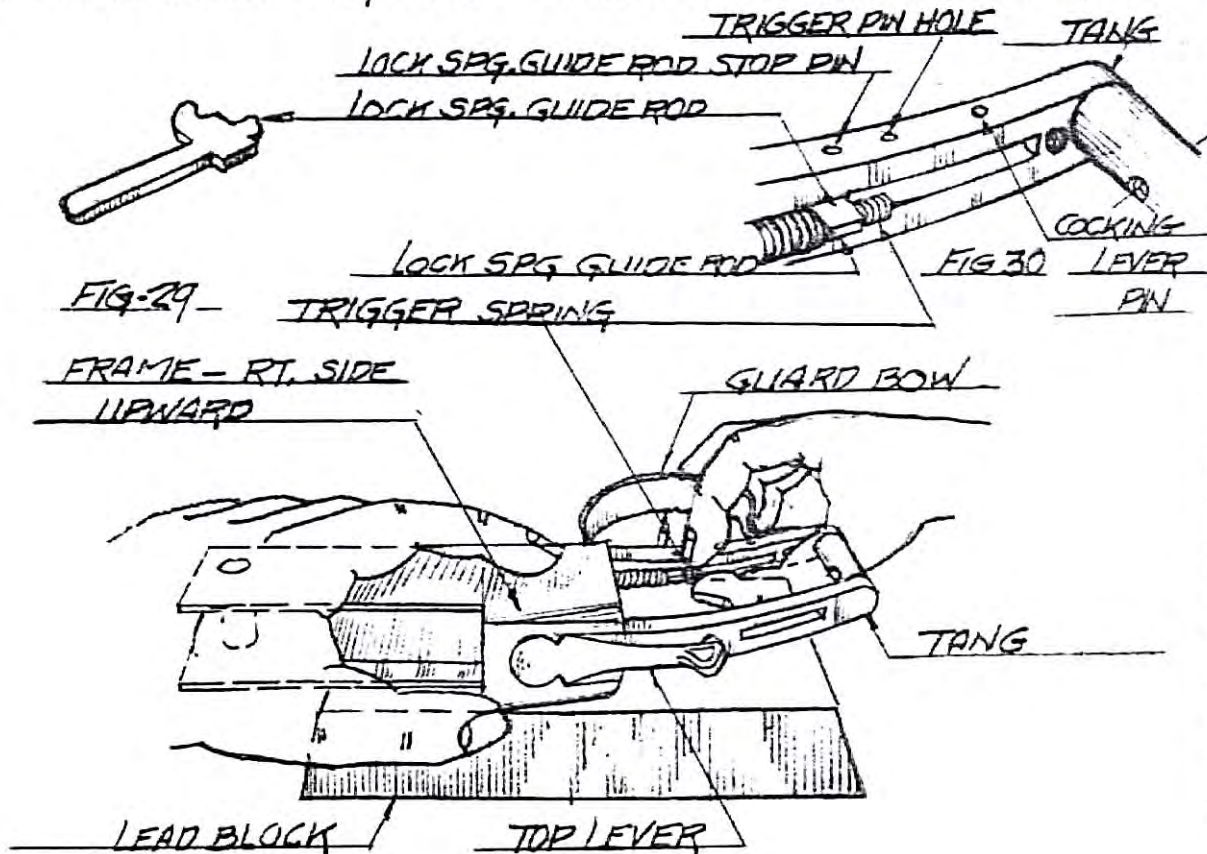


Fig. 29, 30

To Remove Trigger Spring

Remove trigger spring with right hand from end of lock spring guide rod, with frame held on lead block on bench, right side upward and bow away from operator.

12 OCT 59 A. G. Gandy

12, 16, 20, 28 GA.
410 BORE

TO TAKE DOWN M137 SINGLE BARREL SHOT GUN-
TO TAKE DOWN FRAME-TO REMOVE LOCK SPG. GUIDE ROD-

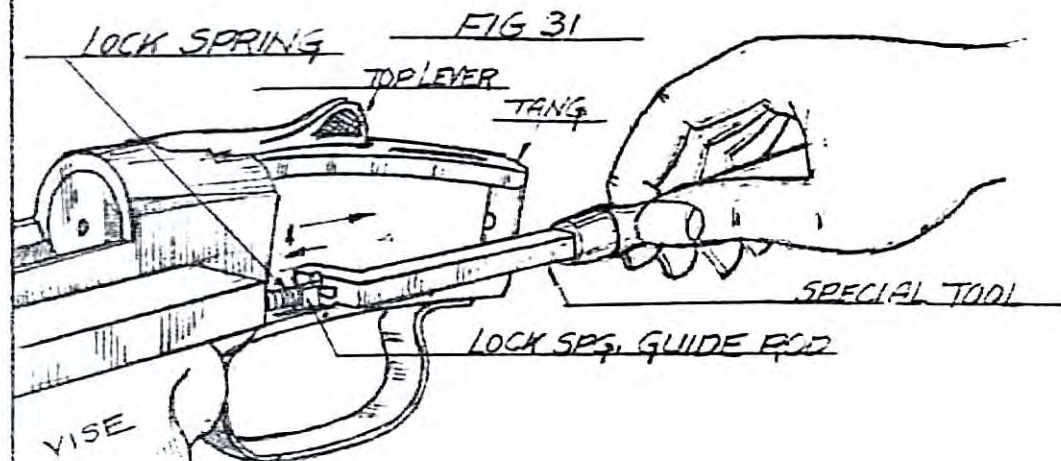
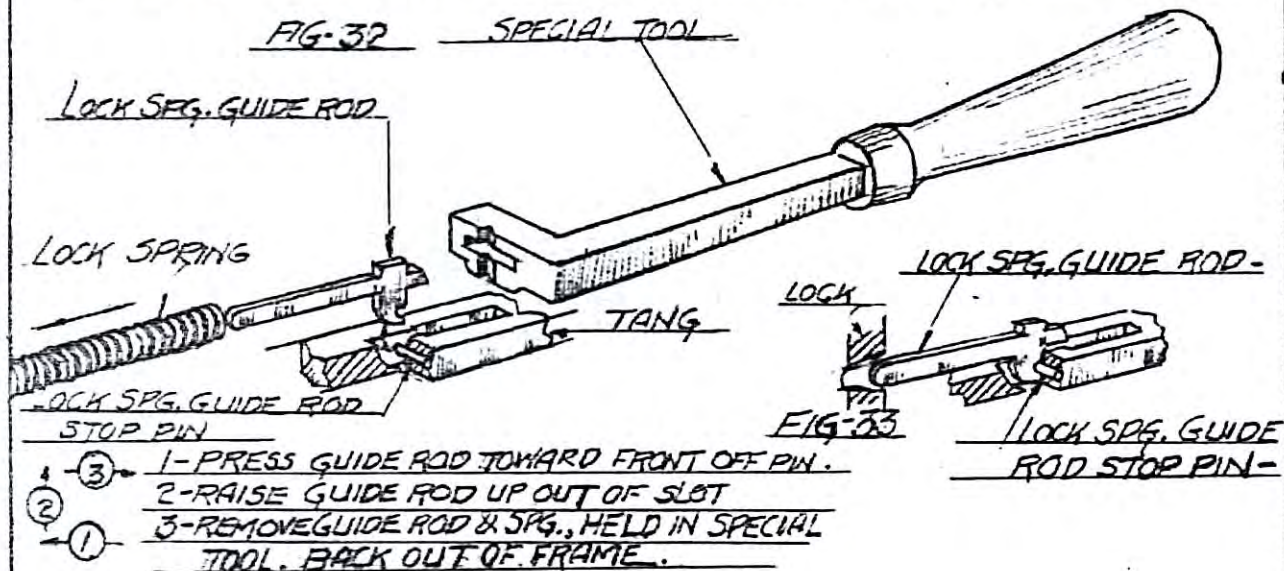


Fig. 31, 32, 33

To Remove Lock Spring Guide Rod and Lock Spring

Place frame, top upward and tang to right in a suitable vise with protected jaws. Preferably using a special tool, inserted from left side rear of frame, engage lock spring guide rod. Compress lock spring enough, by pressing guide rod forward, to free it from its pin in front end of slot in tang. Lift it up and out of slot and out of frame while held in special tool. The spring should come out of frame on the guide rod. Remove lock spring from lock spring guide rod.

13 OCT 54 G. G. G. G.

12, 16, 20, 28 GA
410 BORE

TO TAKE DOWN M/37 SINGLE BARREL SHOT GUN

TO TAKE DOWN FRAME-TO REMOVE TOP LEVER RETAINER SCR.
& RETAINER-

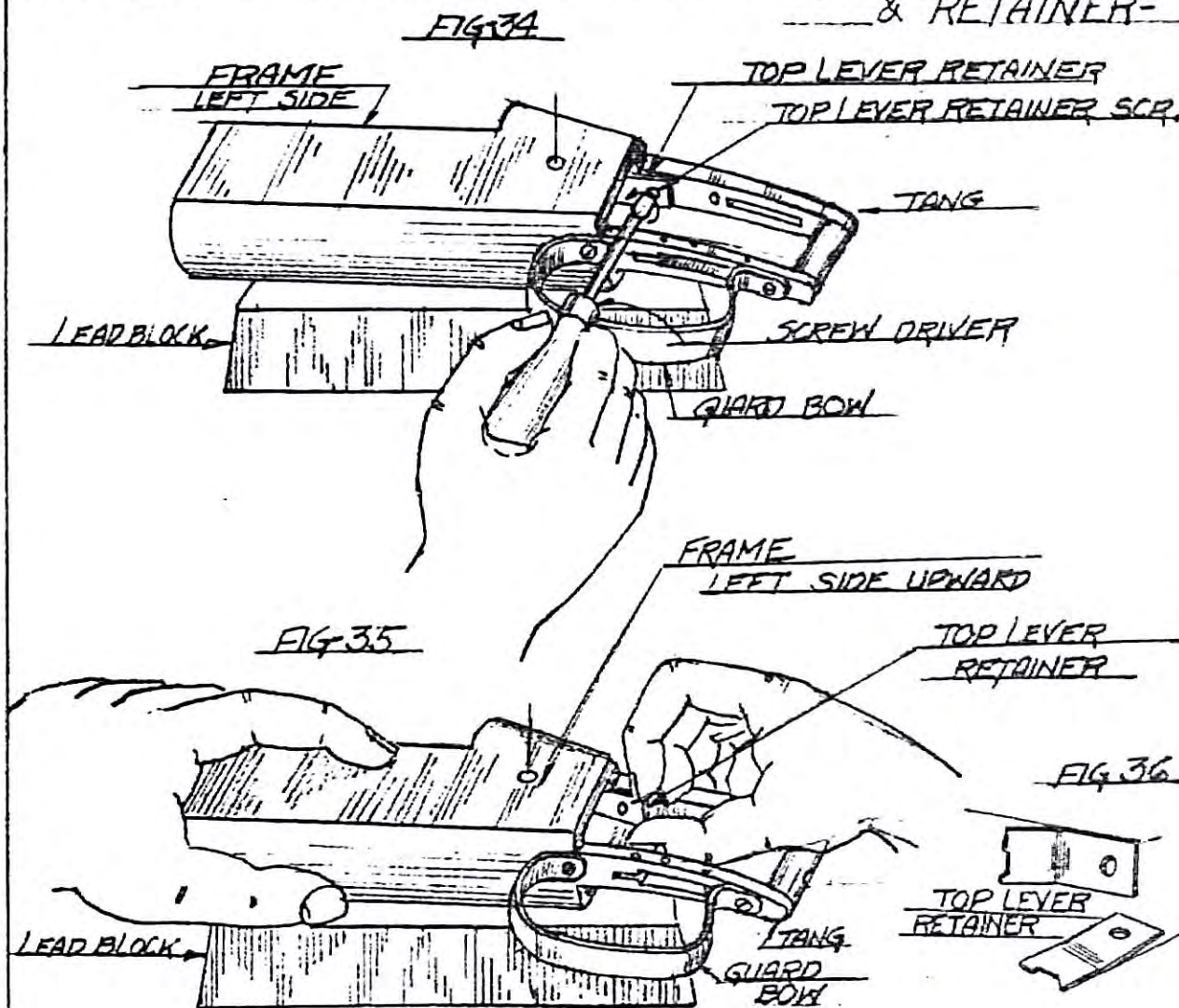


Fig. 34, 35, 36

To Remove Top Lever Retainer Screw and Retainer From Frame

Hold frame on lead block on bench, left side upward with bow toward the operator. Remove the top lever retainer screw from frame with a suitable screw driver by turning it counterclockwise.

Remove retainer from frame, and out of slot in top lever with fingers of right hand.

13 OCT 59 J. A. Gandy

TO TAKE DOWN M137 SINGLE BARREL SHOT GUN- 12, 16, 20, 28 GA.
410 BORE

TO TAKE DOWN FRAME - TO REMOVE TOP LEVER-

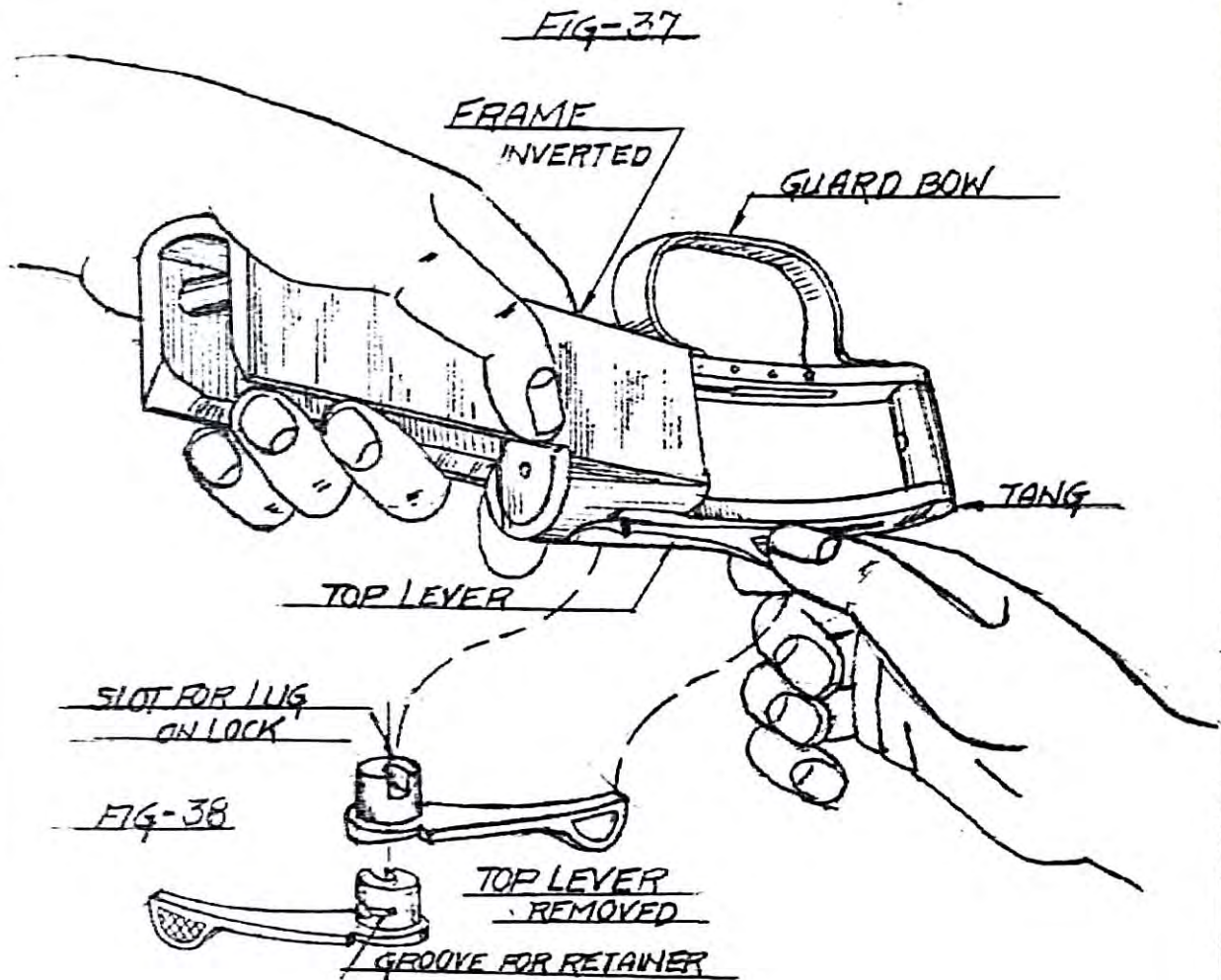


Fig. 37, 38

To Remove Top Lever From Frame

Invert frame in left hand and remove top lever down through frame with fingers of right hand.

14 OCT 54 Q. Q. Arnold.

TO TAKE DOWN M/37 SINGLE BARREL SHOT GUN - 12, 16, 20, 28 GA
410 BORE
TO TAKE DOWN FRAME - TO REMOVE LOCK PIN & LOCK -

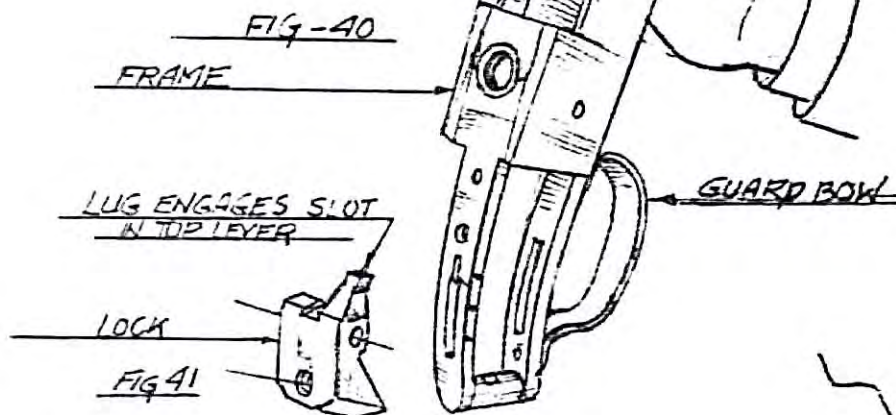
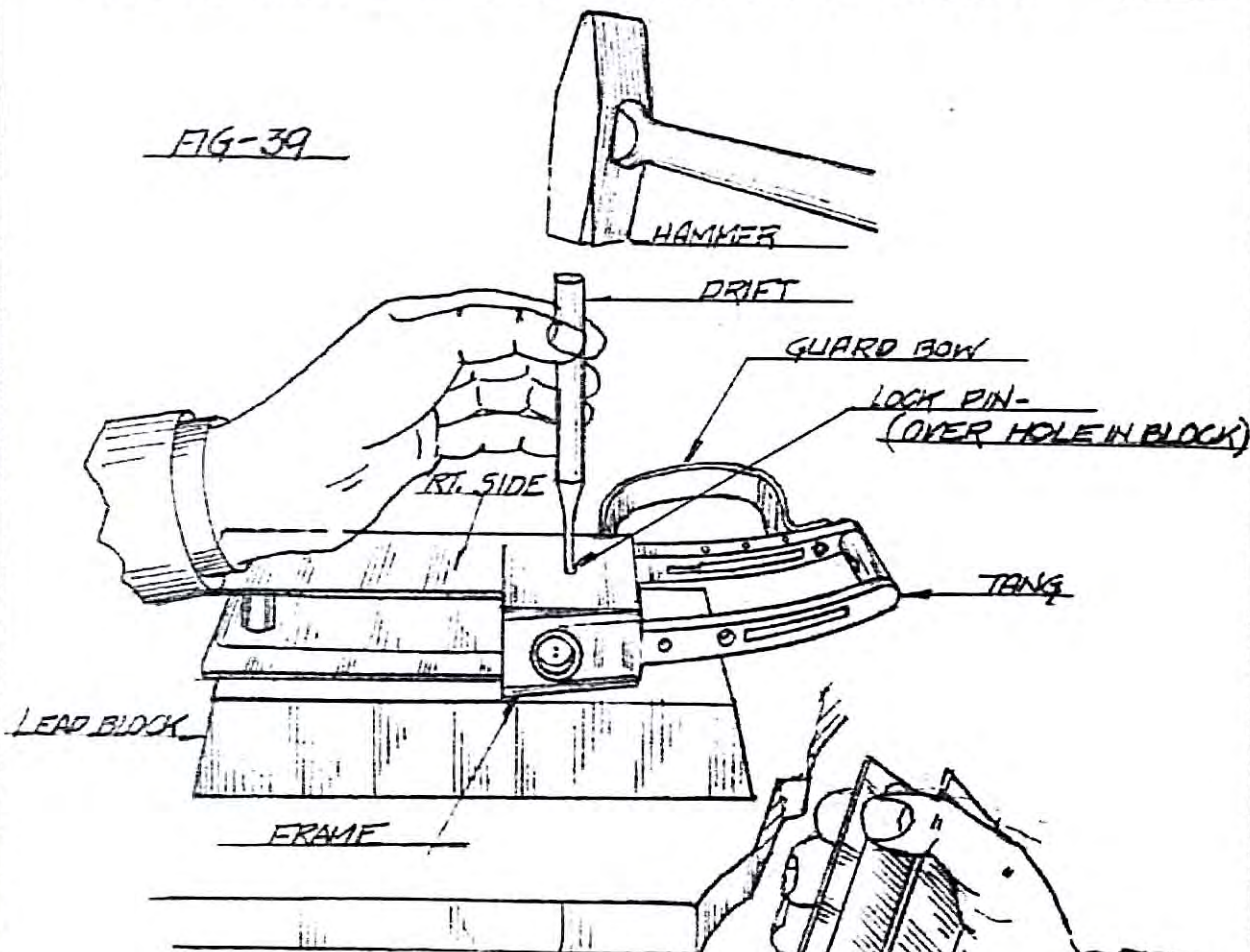
Fig. 39, 40, 41

To Remove Lock Pin and Lock From Frame

Hold frame with right side upward on lead block on bench, with bow away from operator.

With a suitable drift and hammer, remove the lock pin by driving it out from right to left over hole in lead block. Lift frame with right hand and tilt tang end upward. Lock should drop out of the front of frame.

TO TAKE DOWN M/37 SINGLE BARREL SHOT GUN 12.16.20.28 GA.
 410 BORE
 TO TAKE DOWN FRAME-TO REMOVE LOCK PIN & LOCK-



14 OCT 59 J. J. Gandy

12, 16, 20, 28 GA.
410 BORE



FIG-43

Hold frame inverted in left hand, rear end against bench. With a suitable screw driver loosen the rear guard bow screw and then the front guard bow screw completely by turning them counterclockwise. Remove screws and guard bow from frame.

14 OCT. 59 Q.O. Grubbs

INSTRUCTIONS
FOR
ASSEMBLY
OF
M/37 SINGLE BARREL SHOT GUN,
12, 16, 20, 28 GA.,
410 BORE.

PRODUCTS SERVICE DEPT.,
WINCHESTER-WESTERN DIVISION,
OLIN-MATHIESON CHEMICAL CORP.,
NEW HAVEN, 4, CONN.

7 OCT 59 A. A. Arnold.

TO ASSEMBLE M/37 SINGLE BARREL SHOT GUN 12,16,20,28 GA. 410 BORE

TO ASSEMBLE FRAME - TO ADD GUARD BOW & GUARD BOW SCRS

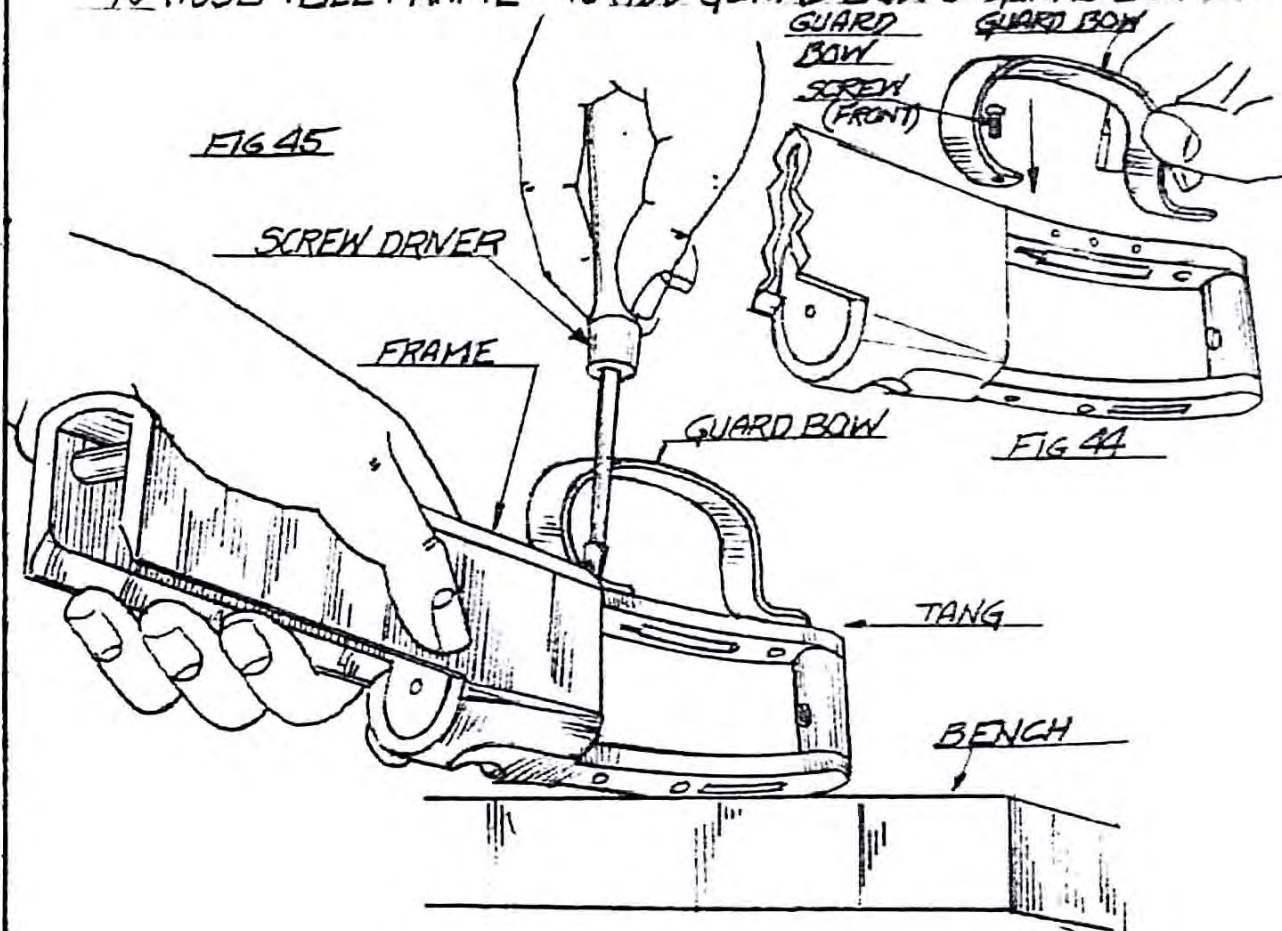


Fig. 44, 45

To Assemble Guard Bow to Frame

Hold frame inverted in left hand, rear end against bench. Place guard bow in proper position on frame. Insert front guard screw and turn it home clockwise with a suitable screw driver.

28 OCT 59 A. A. G. G. G.

12, 16, 20, 28 GA.
410 BORE
TO ASSEMBLE M/37 SINGLE BARREL SHOTGUN
TO ASSEMBLE FRAME - TO ADD GUARD BOW & GUARD BOW SCRS

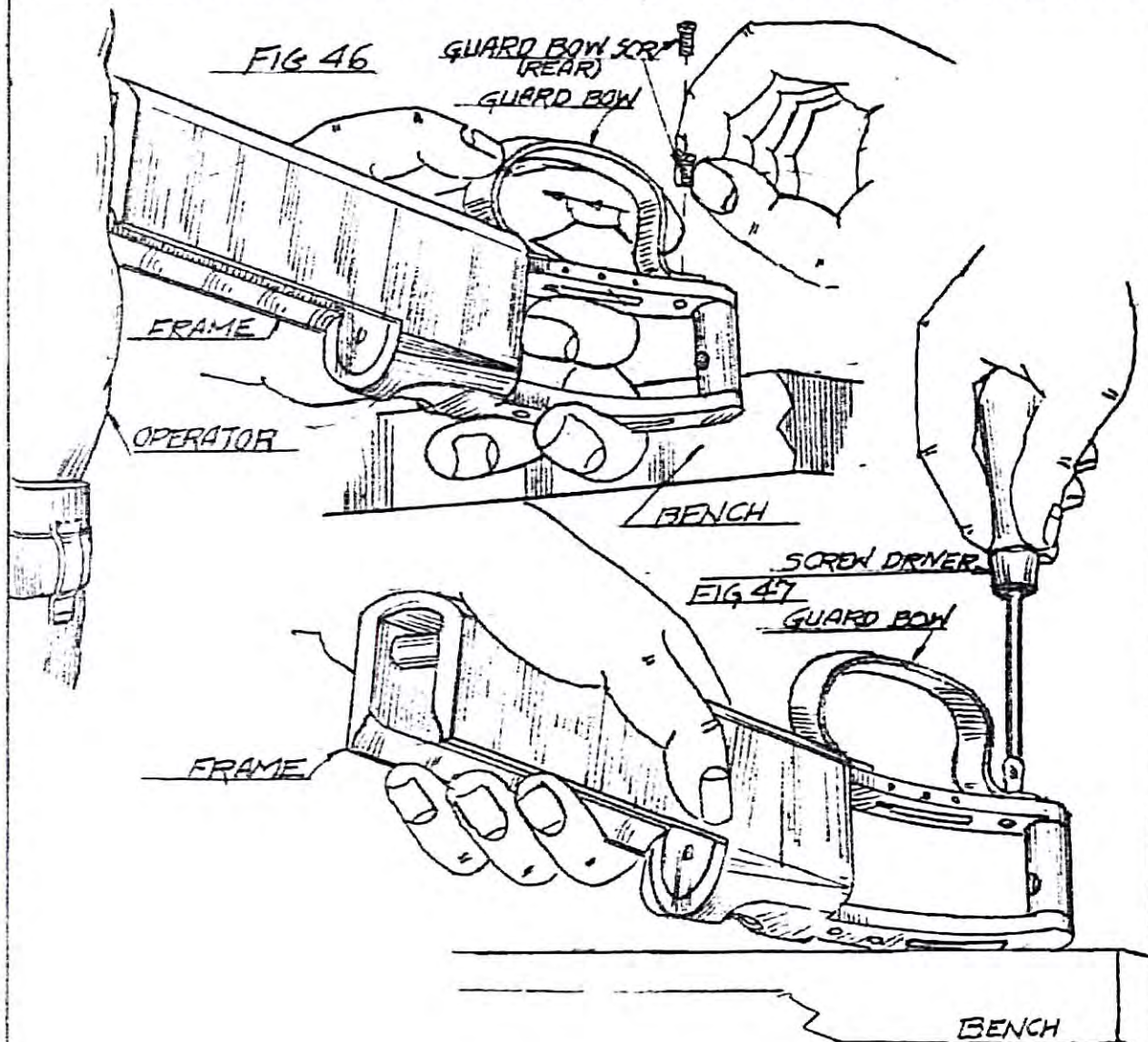


Fig. 46, 47

To Assemble Guard Bow to Frame (Continued)

Hold frame in left hand inverted, with rear end on bench and front end against operator.

Before inserting the second or rear guard bow screw, it may be necessary to compress the guard bow lengthwise slightly with fingers of left hand to visually align the screw holes in frame and guard bow. Insert screw, while compressing guard bow and turn it home clockwise with a suitable screw driver.

In some of the following assembly operations a suggested position for ease of handling is with frame on a lead block of bench, left side upward and guard bow toward operator.

27 Oct 59 a. d. Gould

TO ASSEMBLE M137 SINGLE BARREL SHOT GUN- 12, 16, 20, 28 GA
410 BORE
TO ASSEMBLE FRAME- TO ADD LOCK & LOCK PIN-

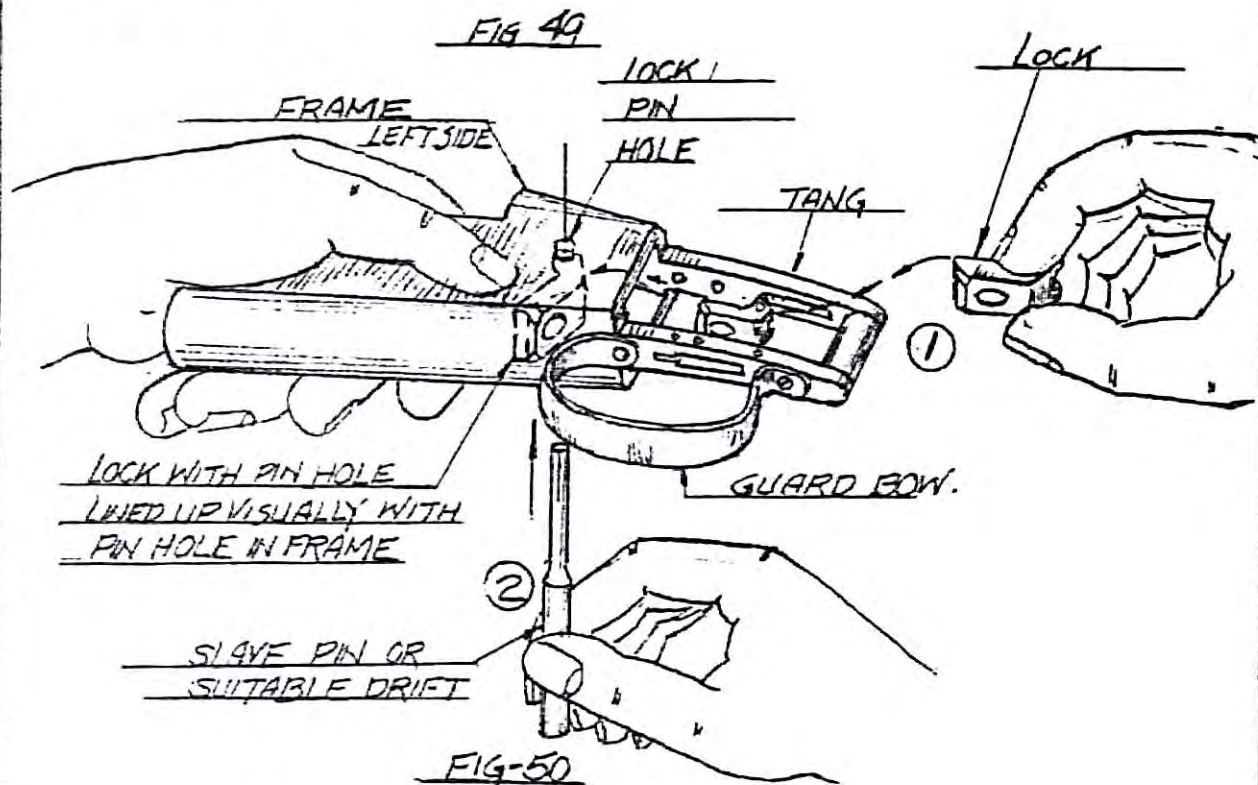
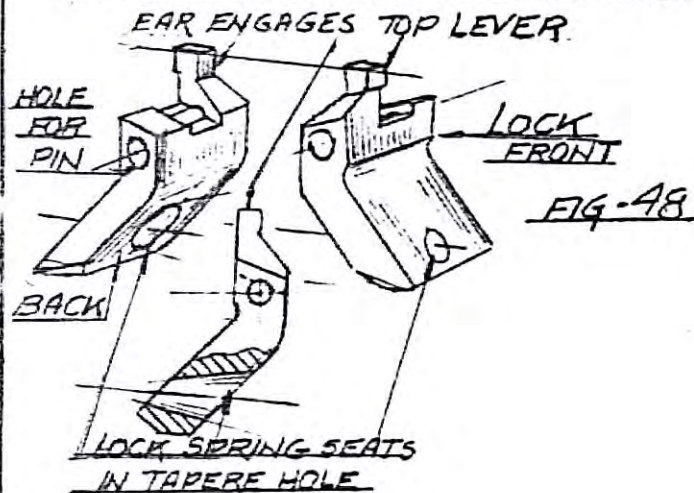
Fig. 48, 49, 50

To Add Lock and Lock Pin

Hold frame on lead block on bench, left side upward and guard bow toward operator. Grasp lock by forked end with fingers of right hand. Insert lock in frame from rear with top edge of lock roughly parallel with top tang. Align holes in frame and lock visually, holding frame in left hand and insert slave pin or suitable drift from below, -right side-with right hand to hold parts together.

29 OCT 59 A. A. Gensler

12.16.70.28.6A
 TO ASSEMBLE M137 SINGLE BARREL SHOT GUN - 410 BORE
 TO ASSEMBLE FRAME - TO ADD LOCK & LOCK PIN



29 OCT 59 A. G. Arnold

TO ASSEMBLE M437 SINGLE BARREL SHOT GUN- ^{12, 16, 20, 28 GA} 410 BORE
 TO ASSEMBLE FRAME- TO ADD LOCK & LOCK PIN- (CONTINUED)

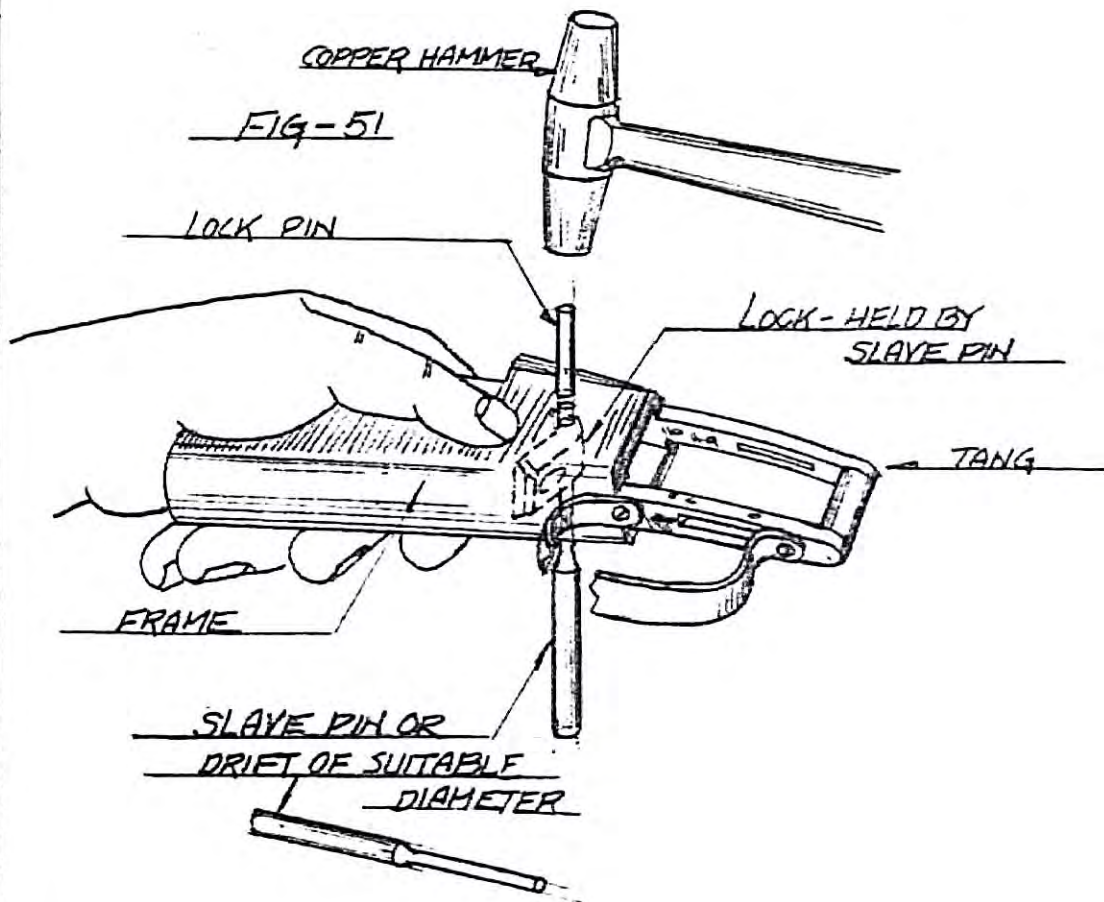


Fig. 51

To Add Lock and Lock Pin (Continued)

Insert lock pin from left side of frame and with a suitable copper hammer tap pin home driving out the slave pin or drift.

A slave pin is a pin replacing another pin of the same diameter temporarily, to facilitate an assembly operation.

29 OCT 59 A. J. Gault

TO ASSEMBLE M137 SINGLE BARREL SHOT GUN- 12,16,20,28 GA
410 BORE-
TO ASSEMBLE FRAME- TO ADD TOP LEVER TO FRAME-

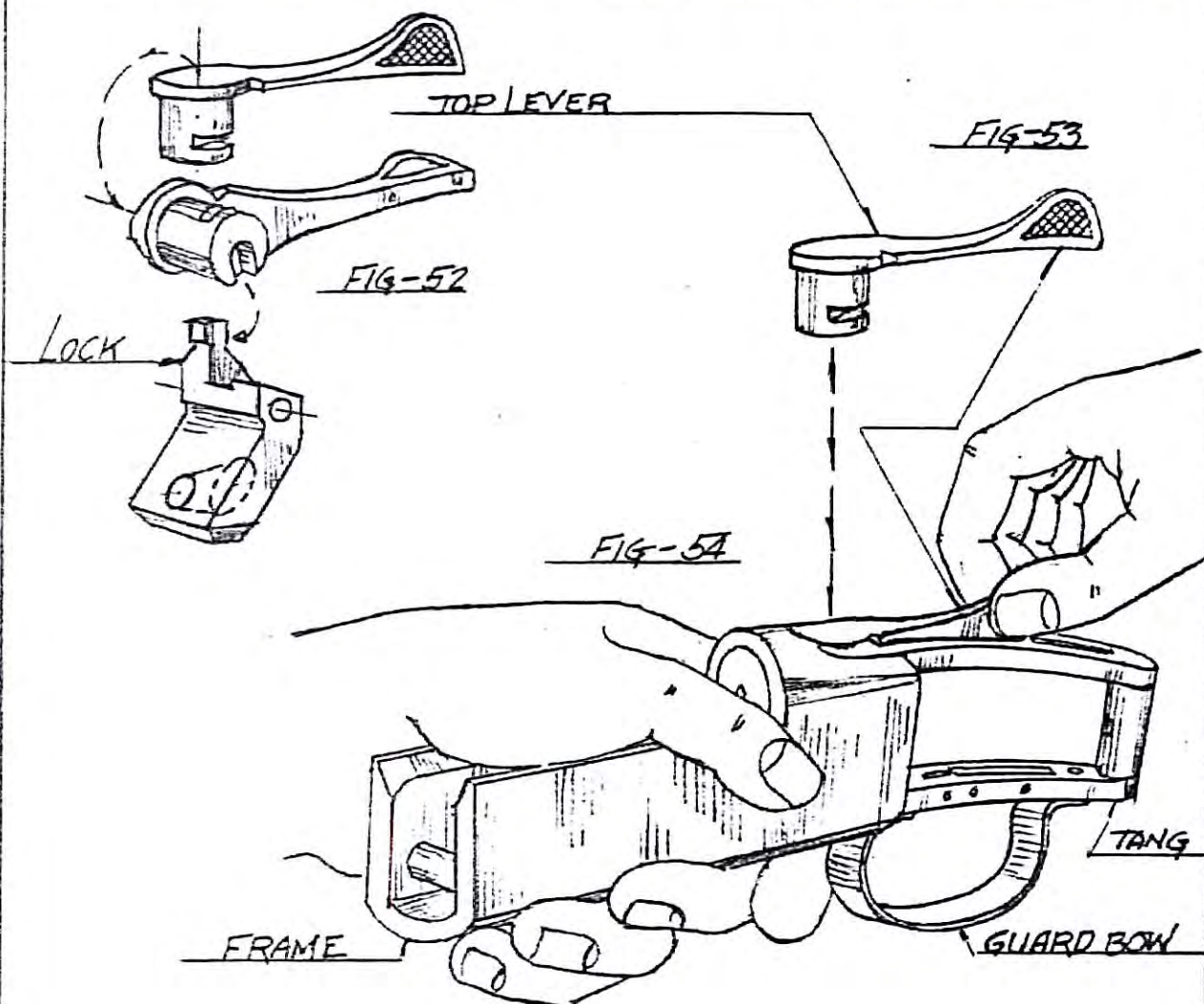


Fig. 52, 53, 54

To Add Top Lever to Frame

Hold frame in left hand, top upward, and with tang away from operator and against bench. Insert top lever, shank end first, in hole in top of top tang with lever pointing to rear of tang and located centrally.

29 OCT 59 G. A. Gandy.

~~TO ASSEMBLE M/37 SINGLE BARREL SHOT GUN~~ ^{12, 16, 20, 28 GA.}
~~TO ASSEMBLE FRAME - TO ADD TOP LEVER RETAINER & SCREW~~ ^{410 BORE}

Fig. 55, 56, 57, 58

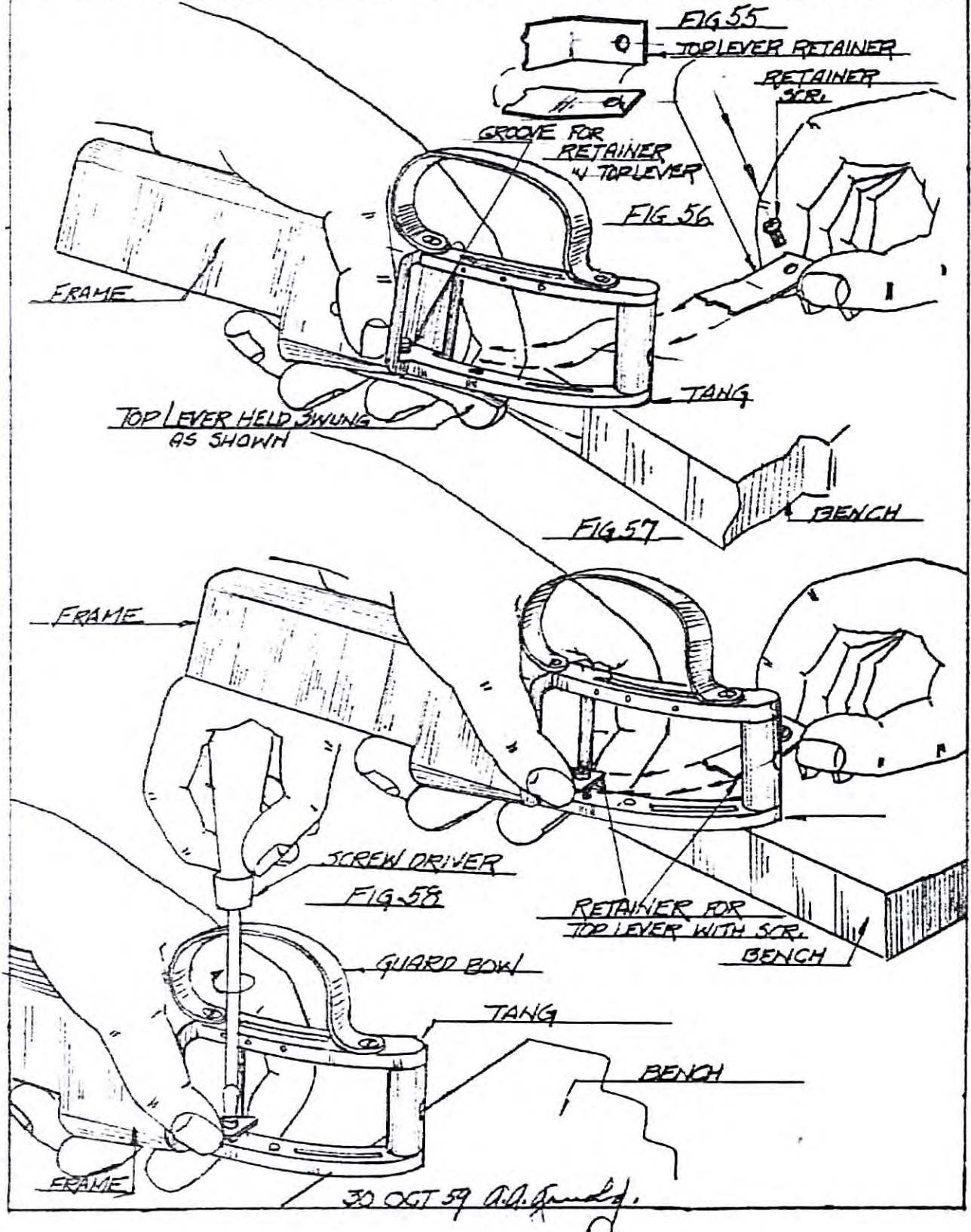
To Add Top Lever Retainer and Retainer Screw to Top Lever and Frame

Holding frame inverted in left hand with tang ends against bench, hold top lever in place with fingers of left hand with forefinger between lever and top tang at right side of frame so that slot for retainer in top lever will engage retainer when it is installed.

Place retainer screw in retainer. With right hand place retainer between thumb and forefinger of left hand, so screw is visually lined up with its hole in frame and retainer while retainer is slightly raised from tang. With a suitable screw driver start retainer screw in tang. See that retainer is engaging slot in shank of top lever and turn screw home clockwise with the screw driver.

30 OCT 59 A. P. Grandy

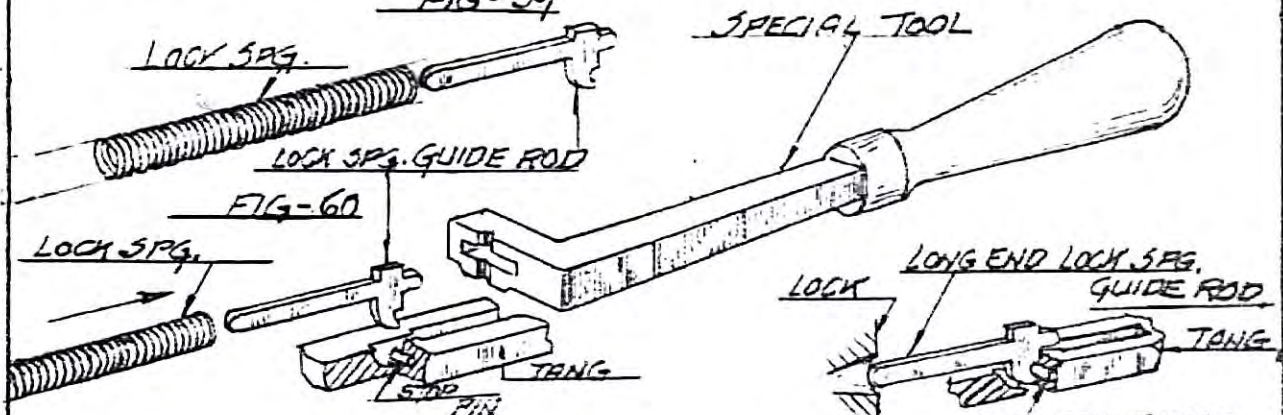
TO ASSEMBLE M/37 SINGLE BARREL SHOT GUN- 12,16,20,28 GA.
 410 BORE
 TO ASSEMBLE FRAME- TO ADD TOP LEVER RETAINER & SCREW



TO ASSEMBLE M/37 SINGLE BARREL SHOT GUN— 12, 16, 20, 28 GA.
410 BORE—

TO ASSEMBLE FRAME—TO ADD LOCK SPR. & LOCK SPR. GUIDE ROD

FIG-59



- 1 COMPRESS SPR. INTO FRAME BY SPEC. TOOL UNTIL NOTCH
 - 2 IN HOOK OF GUIDE ROD IS IN FRONT OF STOP PIN.
 - 3 LOWER LOCK SPR. GUIDE ROD SO NOTCH WILL ENGAGE STOP PIN
- MOVE SPEC. TOOL BACK UNTIL NOTCH SEATS ON STOP PIN. — REMOVE SPEC. TOOL.

FIG-61

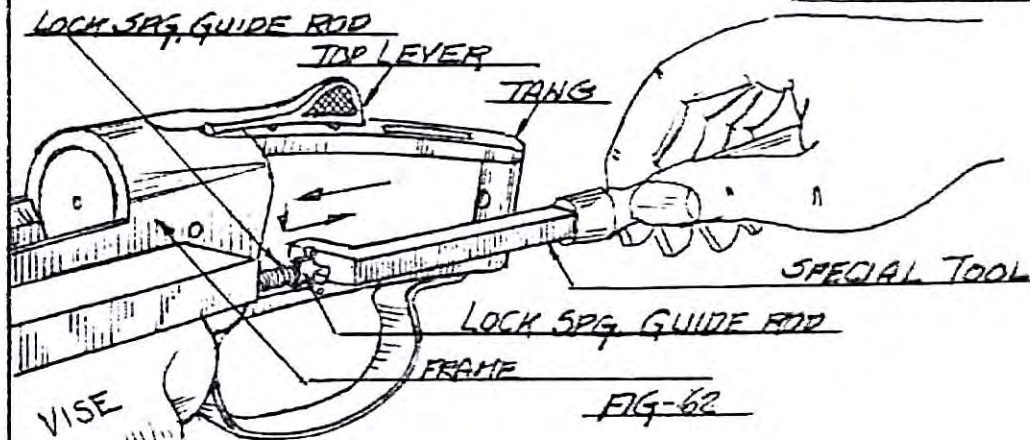


FIG-62

Fig. 59, 60, 61, 62

To Add Lock Spring to Lock in Frame

Place frame, with top upward and tang at right, in a suitable vise with protected jaws. Move top lever to right position which positions lock to easily receive spring. Place lock spring on long end of lock spring guide rod. Place guide rod with spring in special tool. Reaching in from left of tang, insert spring in seat in lock, compress spring by means of special tool holding guide rod and position guide rod in its slot in lower tang, by pressing it first forward and then down to seat on pin in rear end of slot as compressed spring is freed.

2 NOV 59 J. G. Grubbs

12/16, 20, 28 GA
410 BORE
TO ASSEMBLE M137 SINGLE BARREL SHOT GUN

TO ASSEMBLE FRAME - TO ADD TRIGGER SPRING

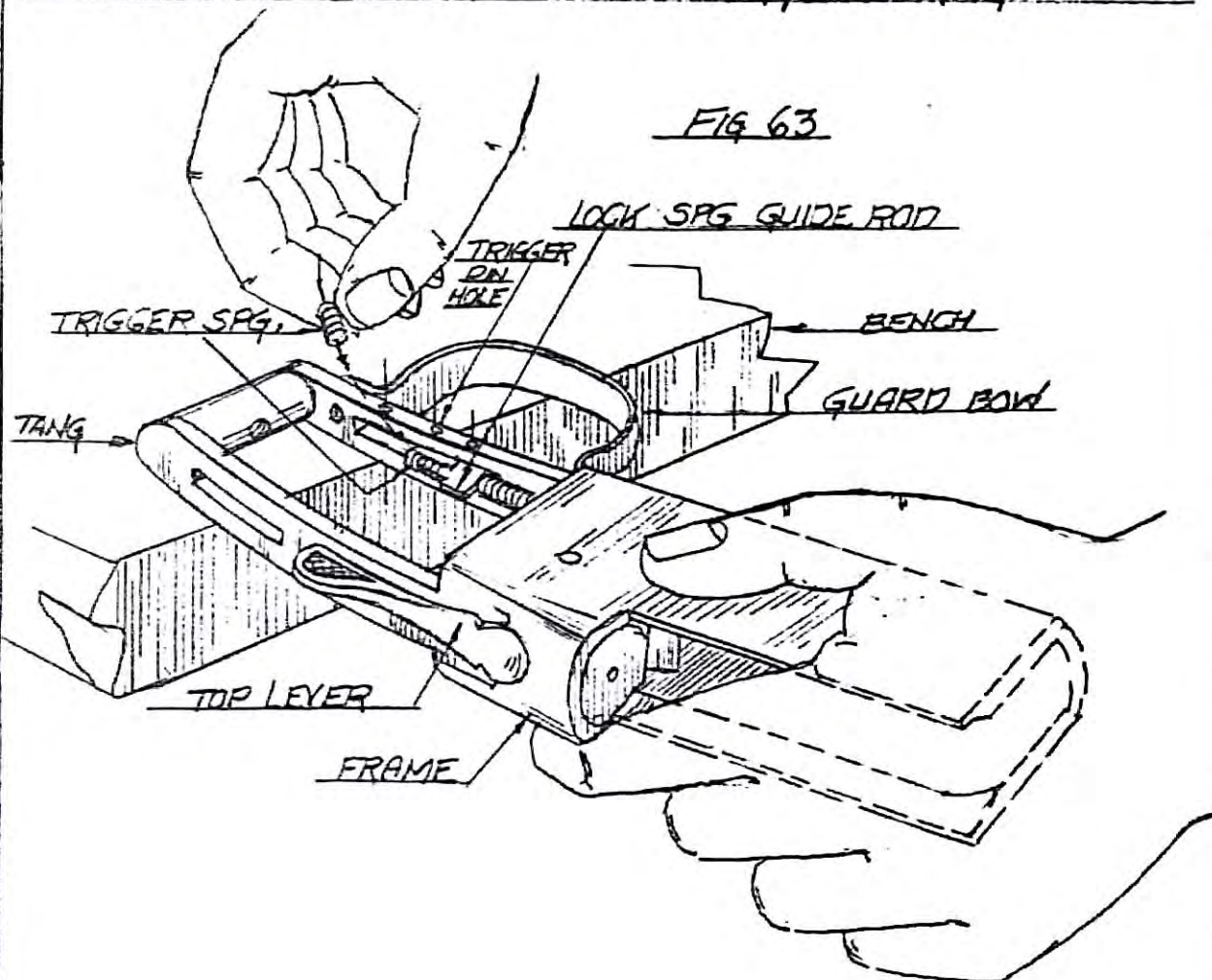


Fig. 63

To Add Trigger Spring

Hold frame in left hand, left side upward, tang on bench with guard bow at right. Place trigger spring on short end of lock spring guide rod.

2 NOV. 59 A. A. Quady.

TO ASSEMBLE M137 SINGLE BARREL SHOT GUN - 12, 16, 20, 28 GA. 410 BORE
TO ASSEMBLE FRAME - TO ADD TRIGGER & TRIGGER PIN

Fig. 64, 65, 66

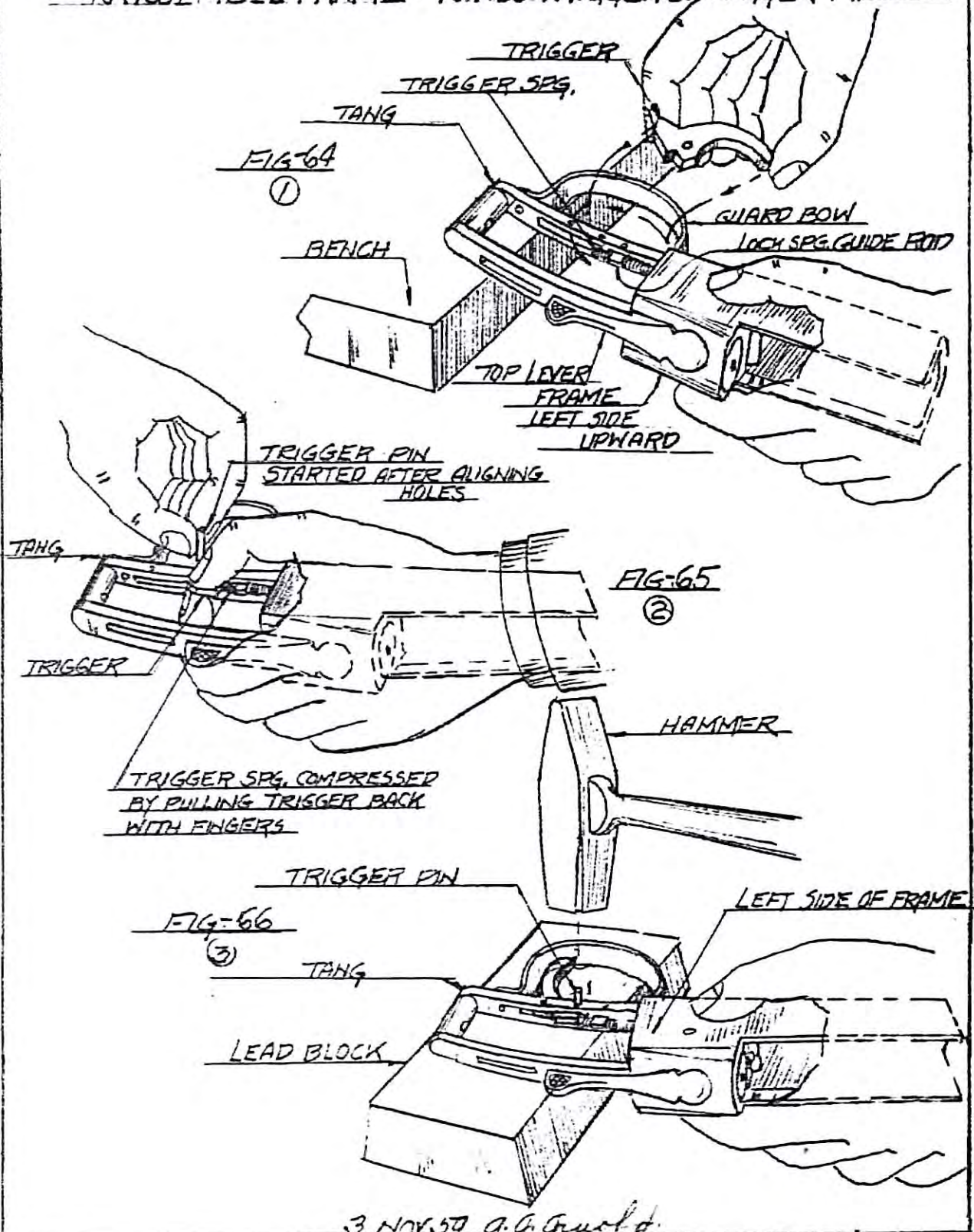
To Add Trigger and Trigger Pin

Hold frame in left hand, left side upward, tang on bench away from operator with guard bow at right. Trigger spring on lock spring guide rod. Insert trigger up through guard bow by swinging top end forward and up in slot to engage trigger spring. Align hole for pin in frame and trigger visually, insert trigger pin and tap in home with a suitable hammer on a lead block until end of pin is flush with side of tang.

3 NOV. 57 A. G. Spaulding

12/620,28 GA.
410 BORE

TO ASSEMBLE M137 SINGLE BARREL SHOT GUN -
TO ASSEMBLE FRAME - TO ADD TRIGGER & TRIGGER PIN



3 NOV 59 A.G. Gualf

TO ASSEMBLE M/37 SINGLE BARREL SHOTGUN - 12, 16, 20, 28 GA. 410 BORE

TO ASSEMBLE FRAME

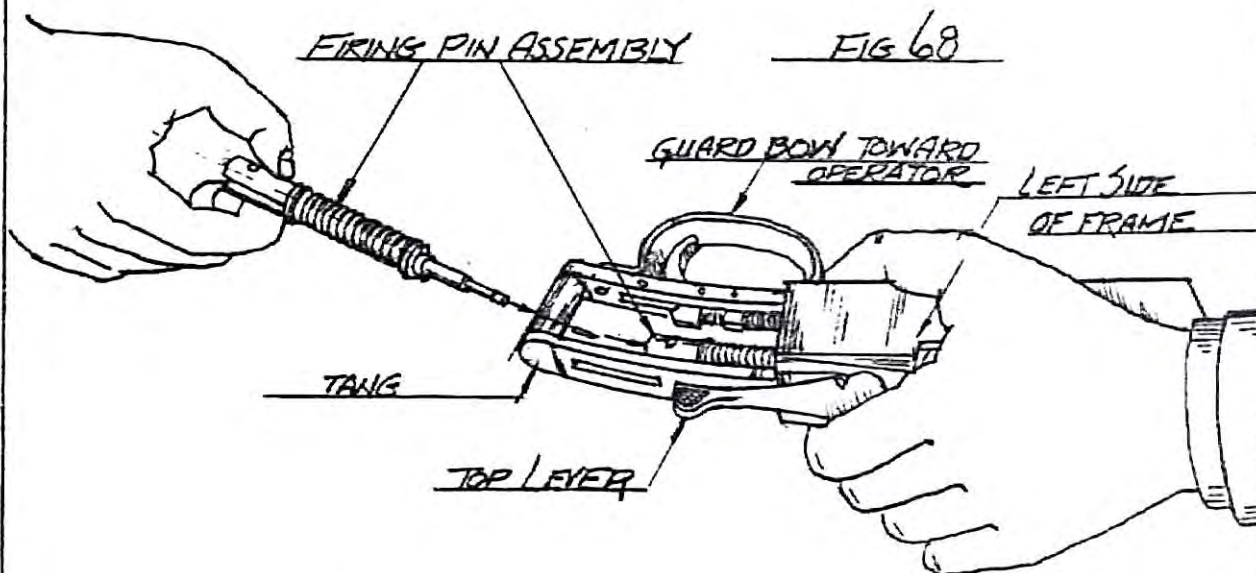
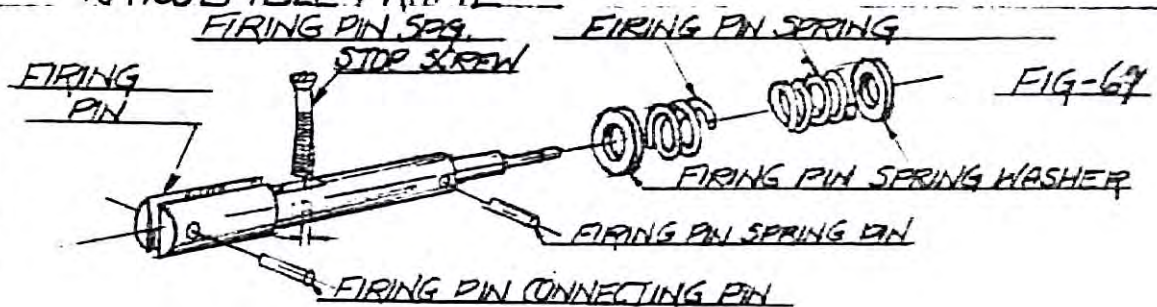


Fig. 67, 68

To Add Firing Pin

Hold frame in left hand, left side upward and guard bow toward operator. Insert assembled firing pin, pointed end first in hole in frame, from the right with right hand, as far as it will go.

3 NOV 57 G.D. Smith

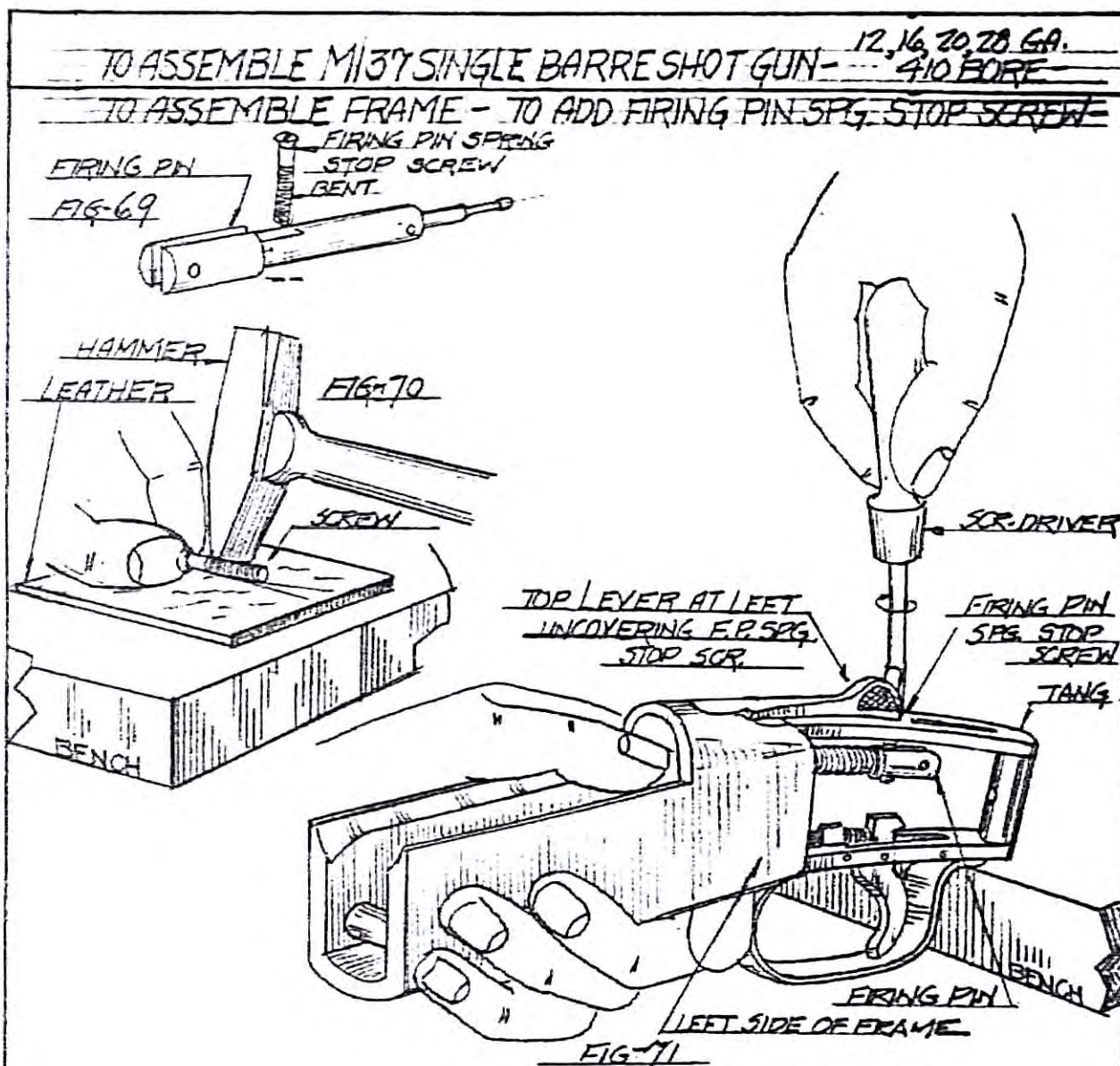


Fig. 69, 70, 71

To Add Firing Pin Spring Stop Screw

Examine firing pin spring stop screw. It should be bent slightly. The bend should be toward rear of tang when screw is in place. This is necessary to permit sufficient rearward travel of firing pin. If a new straight screw is to be installed, place it on a piece of leather on the bench and bend it slightly, tapping it lightly with a suitable hammer at about the middle of its length. Insert the bent screw in top tang and with a suitable screw driver turn it home clockwise, being sure it engages slot in rear end of firing pin and does not bind firing pin in any way. When this condition is attained, the screw end should be inclined slightly to rear due to bend.

3 NOV. 59 G.A. Gmoly

12, 16, 20, 28 GA.
410 BORE-

~~TO ASSEMBLE M/37 SINGLE BARREL SHOTGUN~~
~~TO ASSEMBLE FRAME - TO ADD COCKING LEVER & COCKING LEVER~~
PIN -

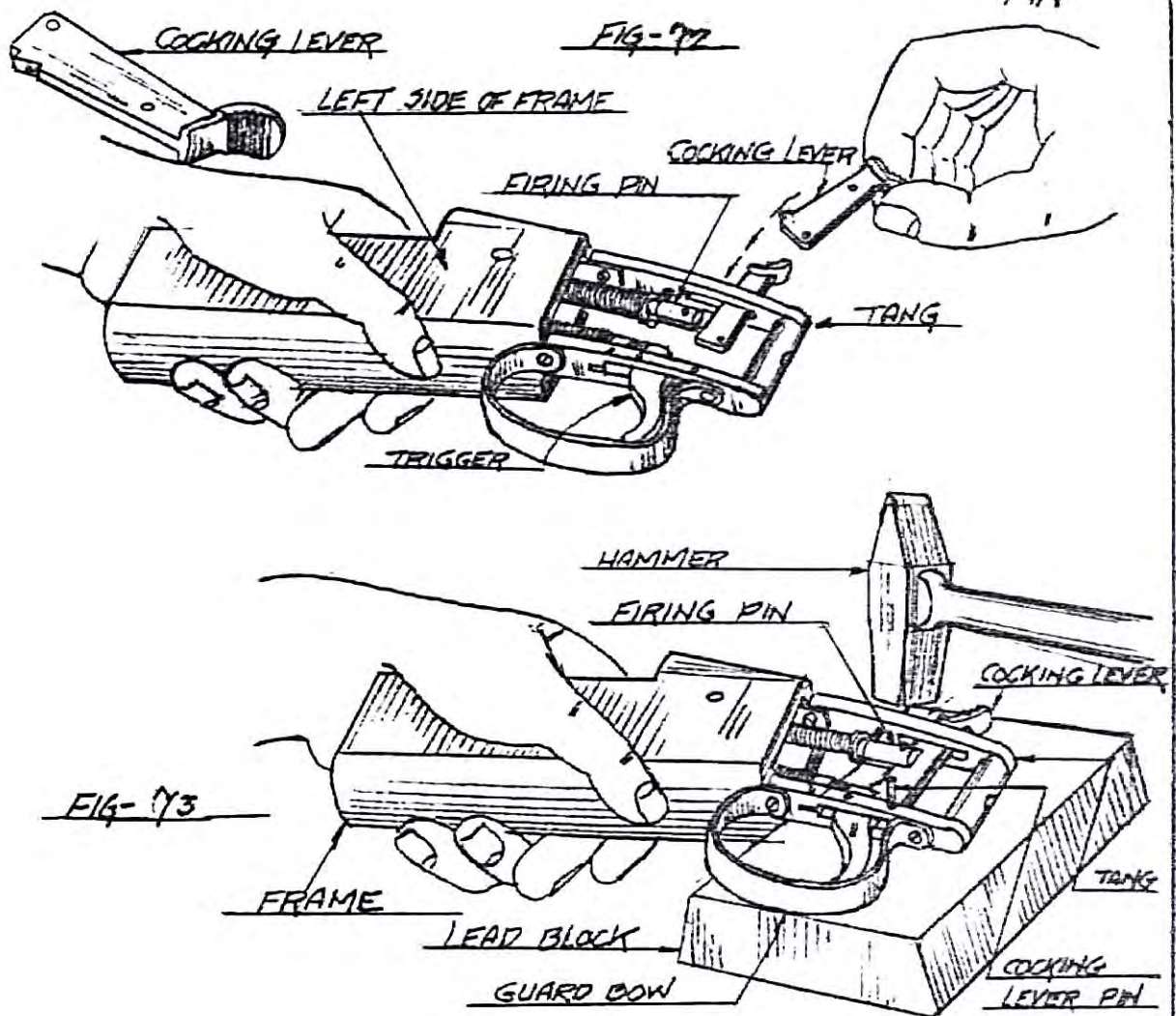


Fig. 72, 73

To Add Cocking Lever and Cocking Lever Pin

Hold frame in left hand on lead block, left side upward and bow toward operator. Insert cocking lever through top of tang with edge having pin hole toward rear, using right hand. Align pin hole in cocking lever and tang, insert cocking lever pin and tap same home flush with side of tang with a suitable hammer.

4 NOV 59 A. A. Gandy

12, 16, 20, 28 GA
410 BORE

TO ASSEMBLE M/37 SINGLE BARREL SHOT GUN

TO ASSEMBLE FRAME - TO ADD COCKING LEVER & F.P. CONNECTING
PIN -

FIG-74

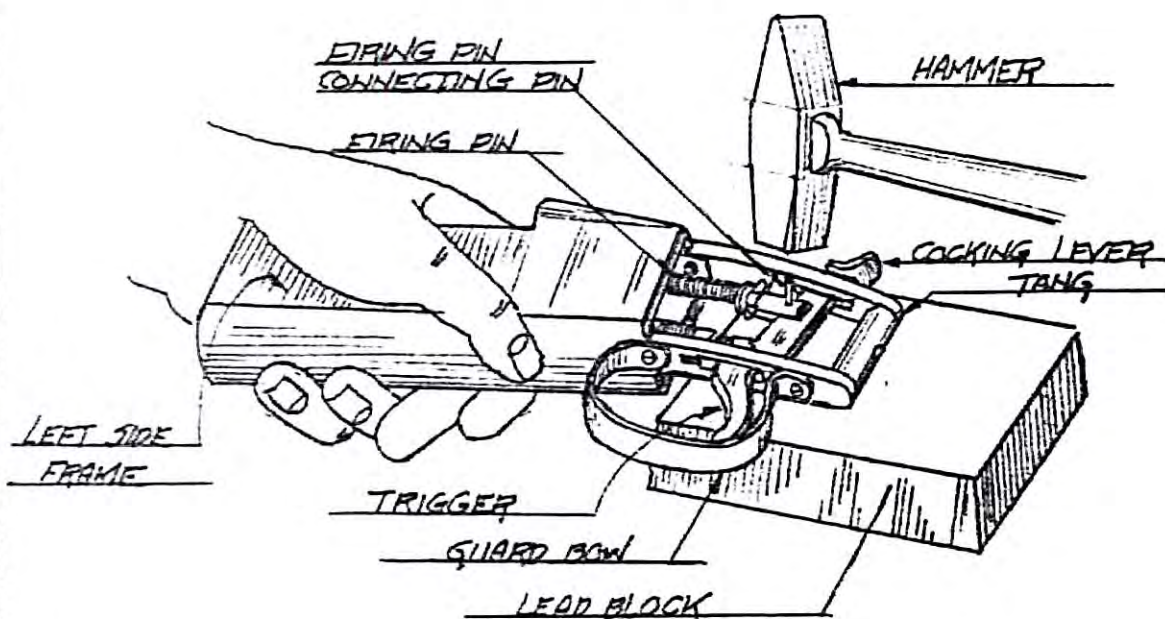


Fig. 74

To Add Firing Pin Connecting Pin to Firing Pin and Cocking Lever

With frame held by left hand on lead block with left side upward and guard bow toward operator, move cocking lever to left into slot in rear end of firing pin. Line up pin holes in firing pin and cocking lever visually for connecting pin.

Insert firing pin connecting pin in pin hole. Using a suitable hammer in right hand drive firing pin connecting pin home flush with outside of firing pin.

4 NOV 59 A. A. Gandy.

12,16,20,28 GA.
410 BORE

TO ASSEMBLE M137 SINGLE BARREL SHOT GUN -
TO ASSEMBLE BARREL LUG - TO ADD EXTRACTOR SEAR & PIN -

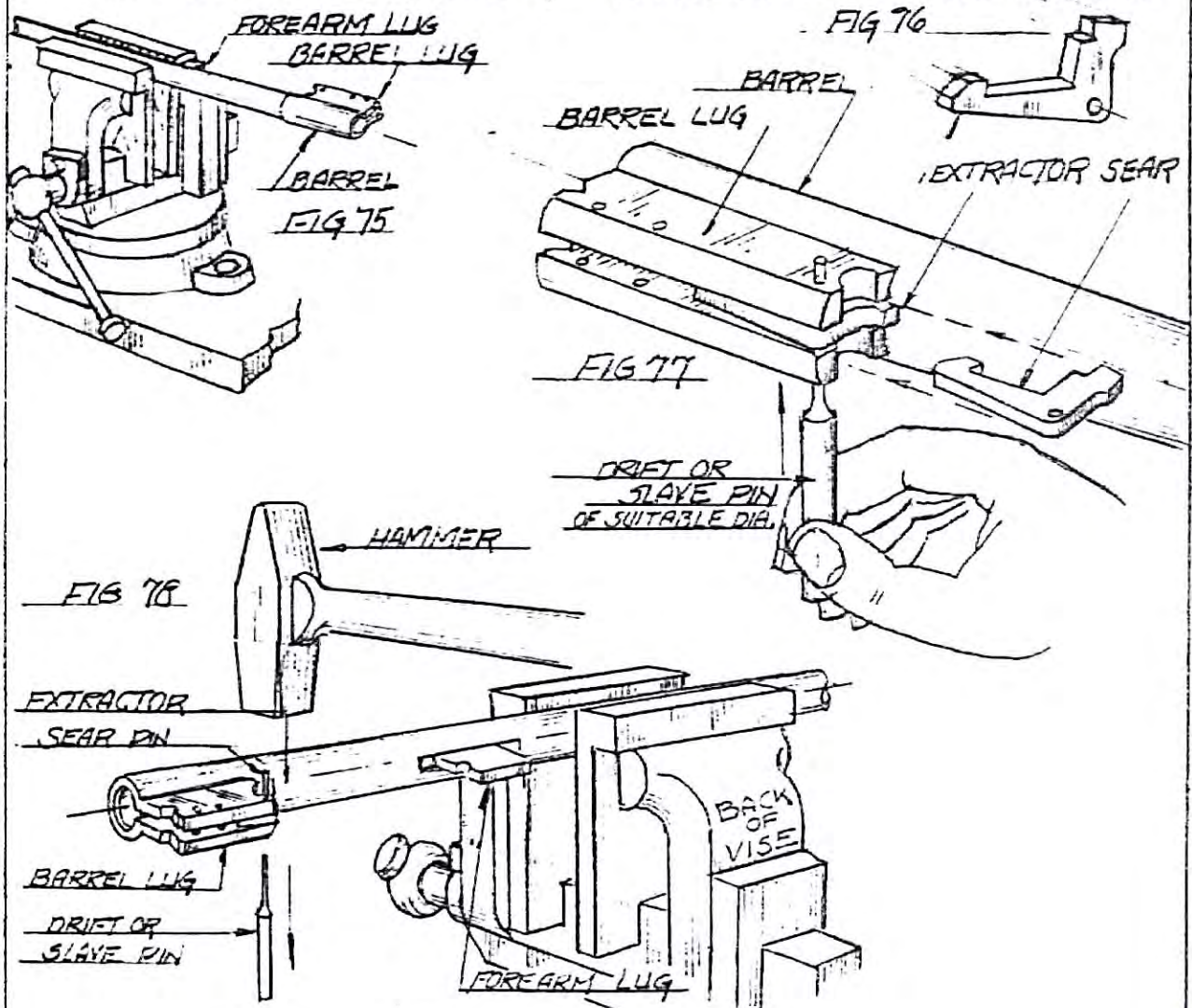


Fig. 75, 76, 77, 78

To Assemble Barrel Lug Group
To Add Extractor Sear and Sear Pin

Place barrel in a suitable vise with protected jaws, right side upward and chamber at right with forearm lug next vise. Insert extractor sear in front end of barrel lug and align pin holes visually in sear and barrel lug. Insert suitable drift or slave pin from below to hold sear in barrel lug. Insert sear pin from top and tap it home with a suitable hammer, driving out the slave pin or drift. The sear should move freely when held on pin in barrel lug.

6 NOV 57 G. A. G. G. G.

12/6/20/286
410307
TO ASSEMBLE M137 SINGLE BARREL SHOT GUN
TO ASSEMBLE BARREL LUG TO ADD EXTRACTOR, EXT. SPRING,
EXT. GUIDE, FRONT & REAR GUIDE PINS.

Fig. 79, 80, 81, 82

To Assemble Extractor, Extractor Spring, Extractor Guide
and Front and Rear Guide Pins to Barrel Lug Group

Place the extractor, extractor guide and extractor spring on
bench in same relative positions as in the barrel lug. Hold
barrel right side upward in a suitable vise, with protected
jaws, with chamber at right and forearm lug next to vise.

Grasp three parts as a unit in fingers of right hand and
insert in slot in barrel lug from rear, with sear spring bearing
on sear, and hold group in barrel with right hand.

Place large end of hammer handle, or other suitable tool against
rear end of extractor and press group assembly into barrel lug
until front hole in extractor guide lines up visually with pin
hole in barrel lug and a click is heard when sear and extractor
engage.

6 NOV 54 A. B. Gandy.

TO ASSEMBLE M137 SINGLE BARREL SHOT GUN- 12.16.20.28 GA. 410 BORE
 TO ASSEMBLE BARREL LUG- TO ADD EXTRACTOR, EXT. SPRING, EXT. GUIDE, FRONT & REAR GUIDE PINS- EXTRACTOR SPRG.

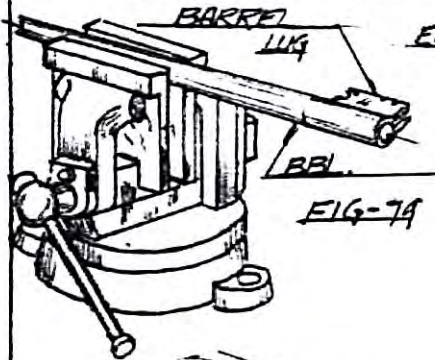


FIG-79

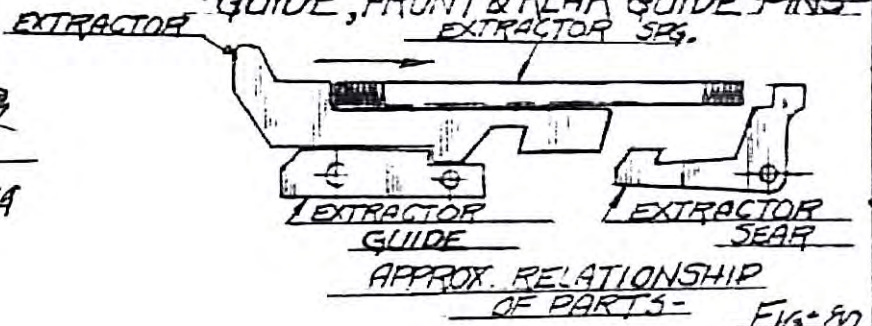


FIG-80

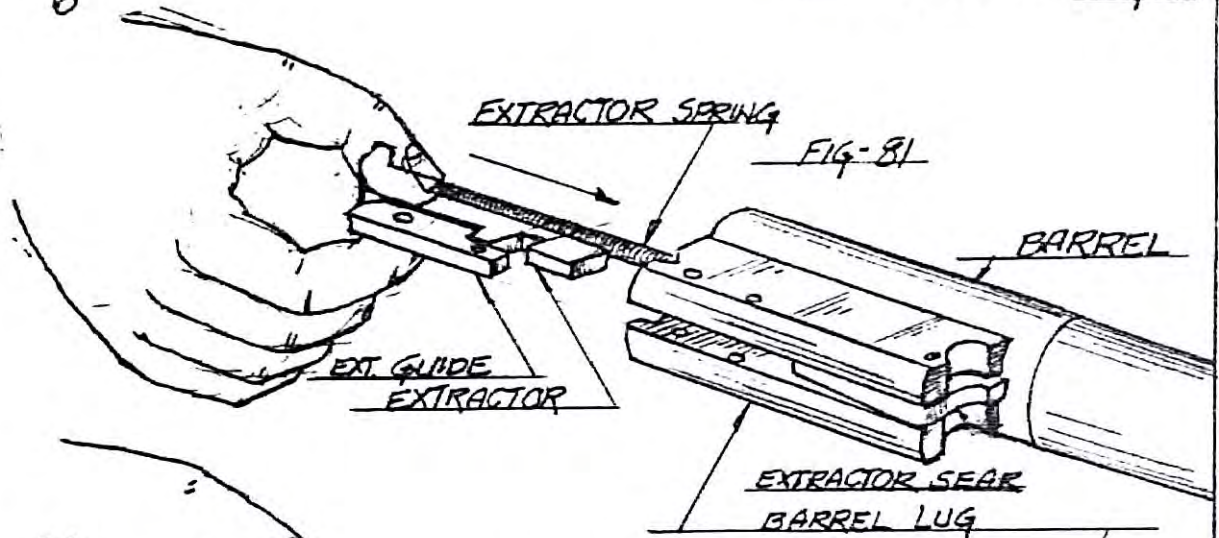


FIG-81

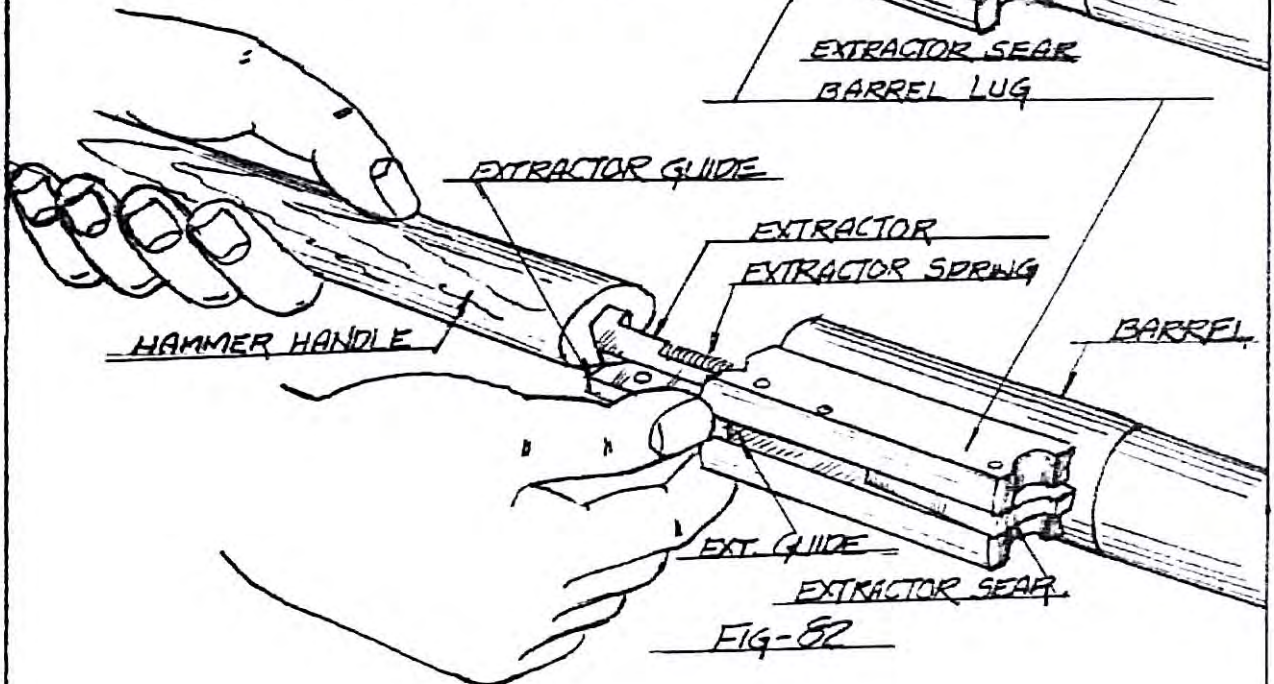


FIG-82

6 NOV 59 A. A. Grunold

12, 16, 20, 28 GA.
410 BORE

TO ASSEMBLE M137 SINGLE BARREL SHOT GUN—
TO ASSEMBLE BARREL LUG—TO ADD EXTRACTOR, EXT. SPRING,
EXT. GUIDE, FRONT & REAR GUIDE PINS—

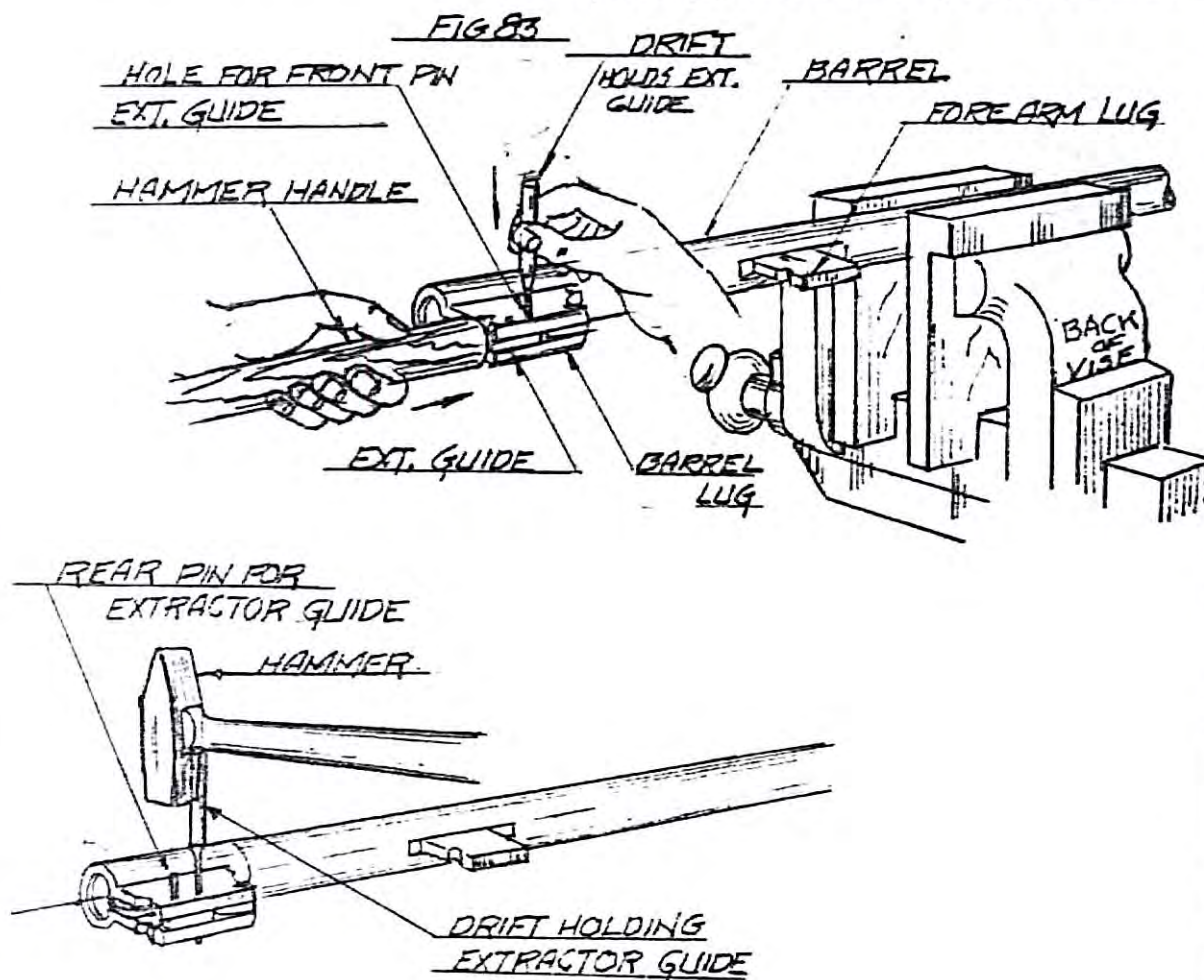


Fig. 83, 84

To Assemble Extractor, Extractor Spring, Extractor Guide,
Front and Rear Extractor Guide Pins to Barrel Lug

Insert a suitable drift from top in front pin hole to hold parts in barrel lug. Insert rear pin for extractor guide in lug with right hand and drive it home flush with side of lug with a suitable hammer.

6 NOV 59 J. J. J. J. J.

TO ASSEMBLE M137 SINGLE BARREL SHOT GUN - 12, 16, 20, 28 GA - 410 BORE

TO ASSEMBLE BARREL LUG - TO ADD EXTRACTOR, EXT. SPRING
EXT. GUIDE, FRONT & REAR GUIDE PINS

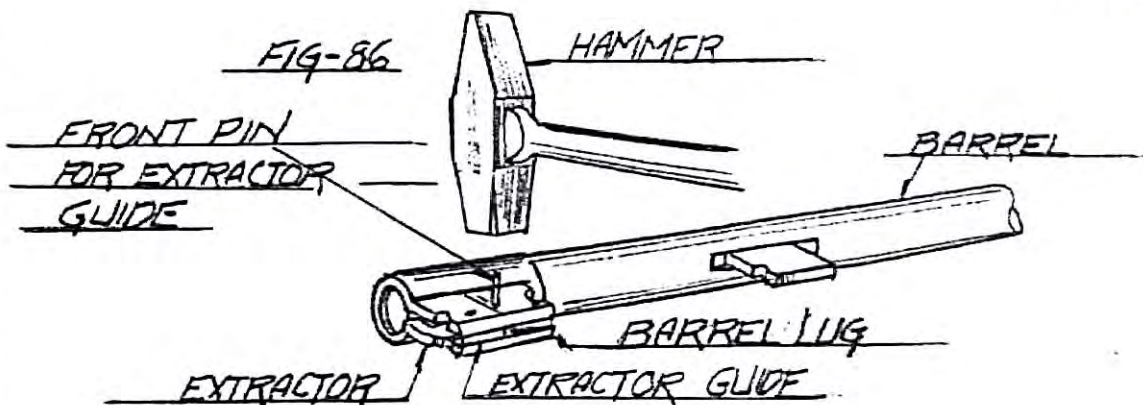
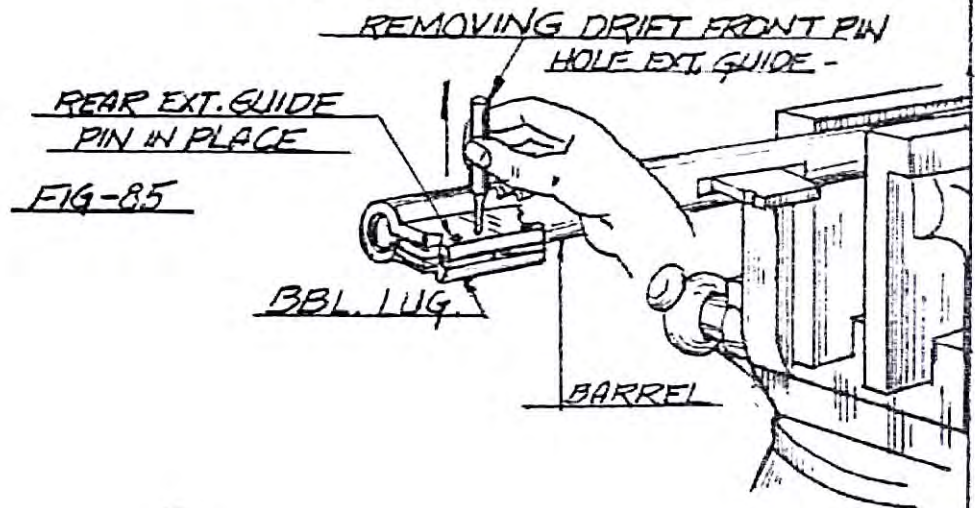


Fig. 85, 86

To Add Front Extractor Guide Pin To
Extractor Group Assembly in Barrel Lug

Remove drift from front guide pin hole. Insert front guide pin
and drive it home flush with side of barrel lug with a suitable
hammer.

9 NOV 59 G. A. Gruenberg

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TO ASSEMBLE M/37 SINGLE BARREL SHOTGUN
TO ADD FRAME ASSEMBLY TO BARREL ASSEMBLY-

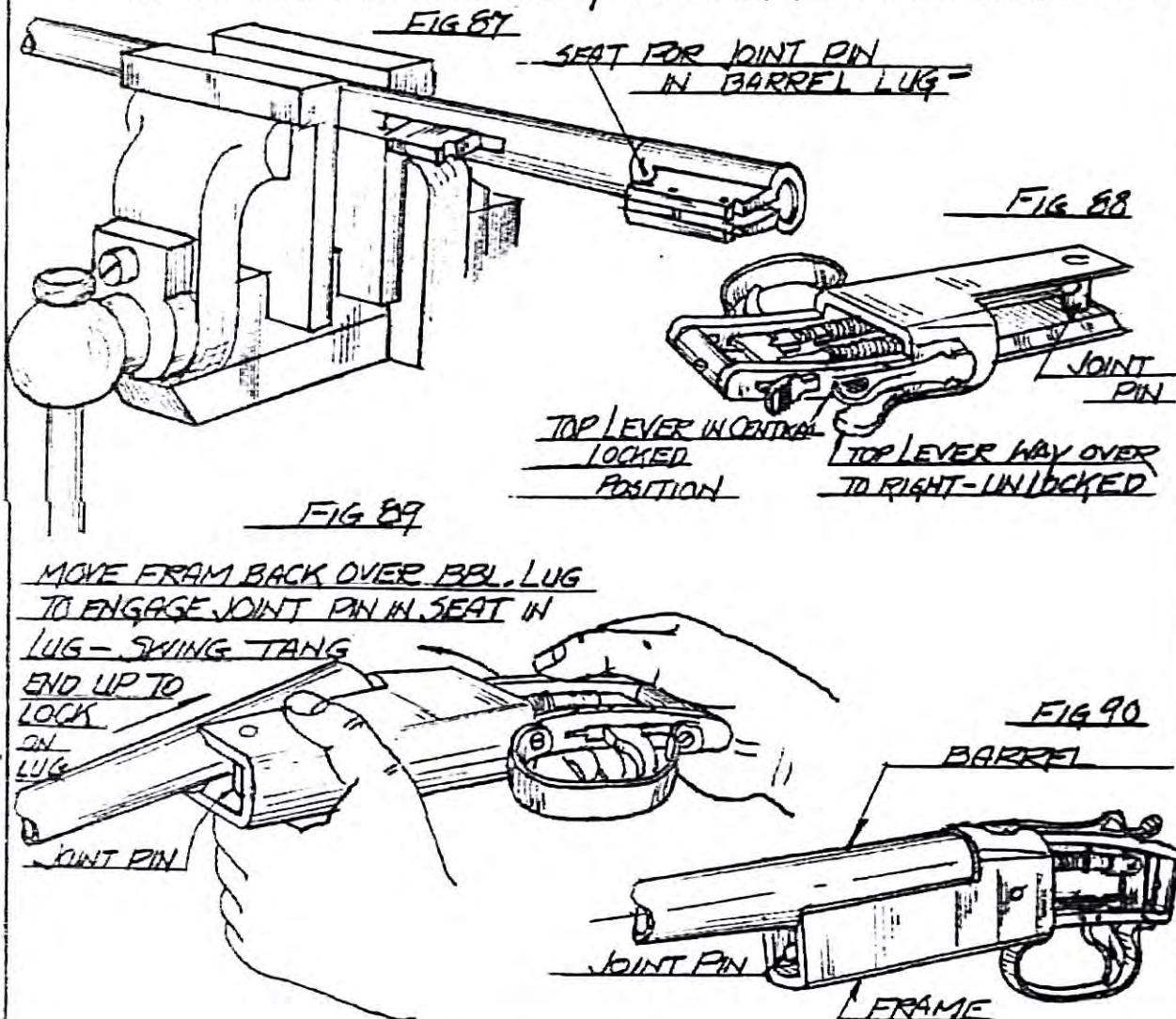


Fig. 87, 88, 89, 90

To Add Frame to Barrel

Hold barrel in a suitable vise having protected jaws, with left side upward and forearm lug near vise, or right. Slide open end of frame, left side upward, on to barrel lug and hook joint pin into seat in front of barrel lug. Swing frame on to barrel lug and barrel until frame fits on to barrel at breech. Lock will engage and hold frame on barrel. Pushing the top lever toward right side of frame will make operation easier when swinging frame in place.

9 NOV 59 A.A. Jendry

TO ASSEMBLE M137 SINGLE BARREL SHOT GUN- 12, 16, 20, 28 GA. 410 BORE-
TO ADD FORE ARM TO ACTION-

FIG 91

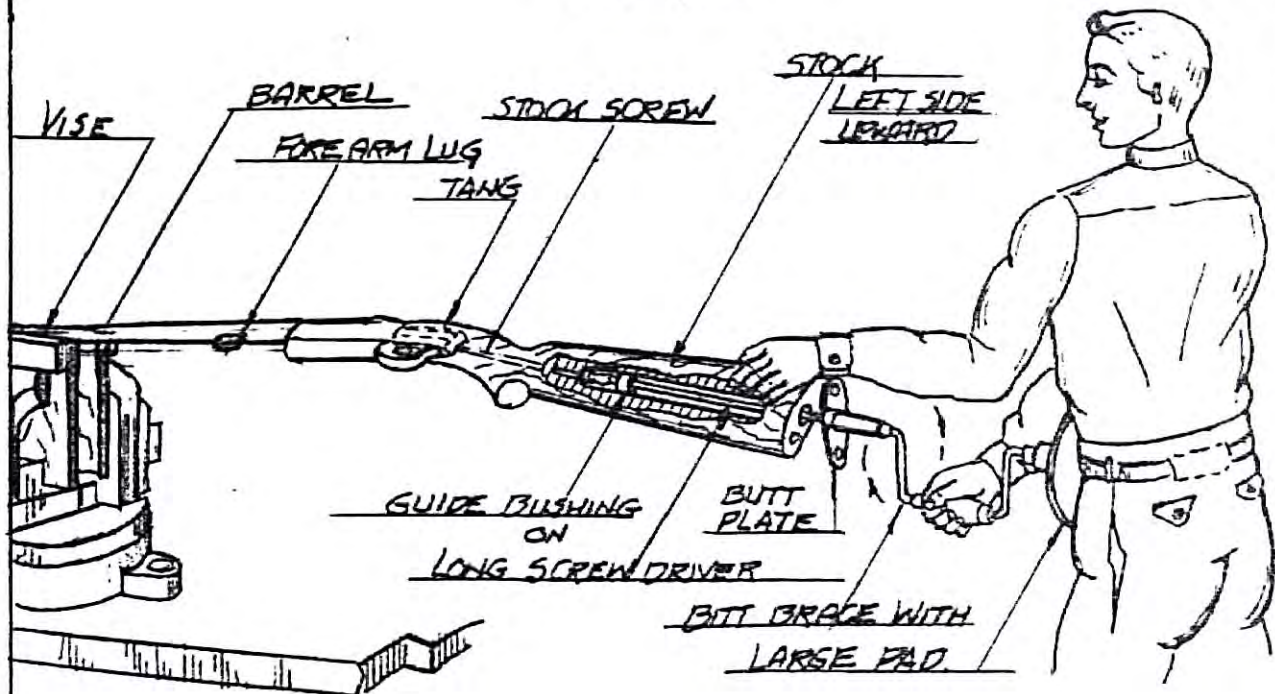


Fig. 91

To Add Butt Stock to Action With Stock Screw

Hold action by barrel in a suitable vise having protected jaws, with left side upward and frame at right of vise. Grasp butt stock, left side upward, and slide it on to frame front end first, so that tenon on front end of butt stock engages frame. With a suitable long screw driver having a guide collar, held in a suitable butt brace with a large pad, seat stock screw firmly by turning it clockwise.

9 NOV 59 G. G. Givoley

TO ASSEMBLE M137 SINGLE BARREL SHOT GUN - 12, 16, 20, 28 GA. 410 BORE
TO ASSEMBLE BUTT PLATE TO STOCK -

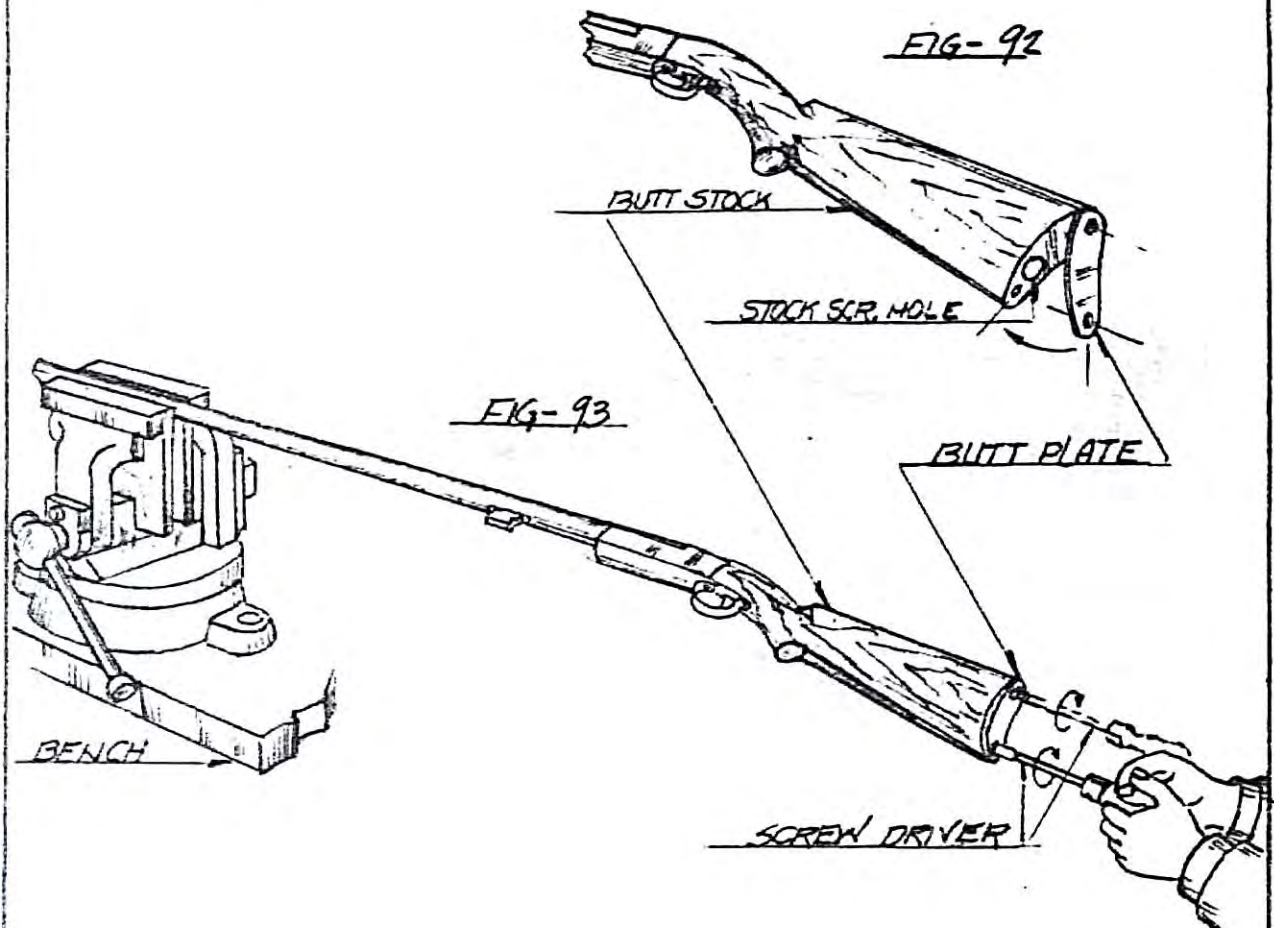


Fig. 92, 93

To Replace Butt Plate and Butt Plate Screws

With gun held by barrel in a suitable vise having protected jaws, with left side upward and butt stock to right, the butt plate hangs vertically from upper butt plate screw. Swing butt plate up in place, insert lower butt plate screw. Tighten both butt plate screws by turning them clockwise with a suitable screw driver.

10 NOV 54 G. A. G. G. G.

12, 16, 20, 28 GA.
410 BORE-

TO ASSEMBLE M/37 SINGLE BARREL SHOT GUN -

TO ASSEMBLE FOREARM SHOE, RETAINER SHOE STUD -

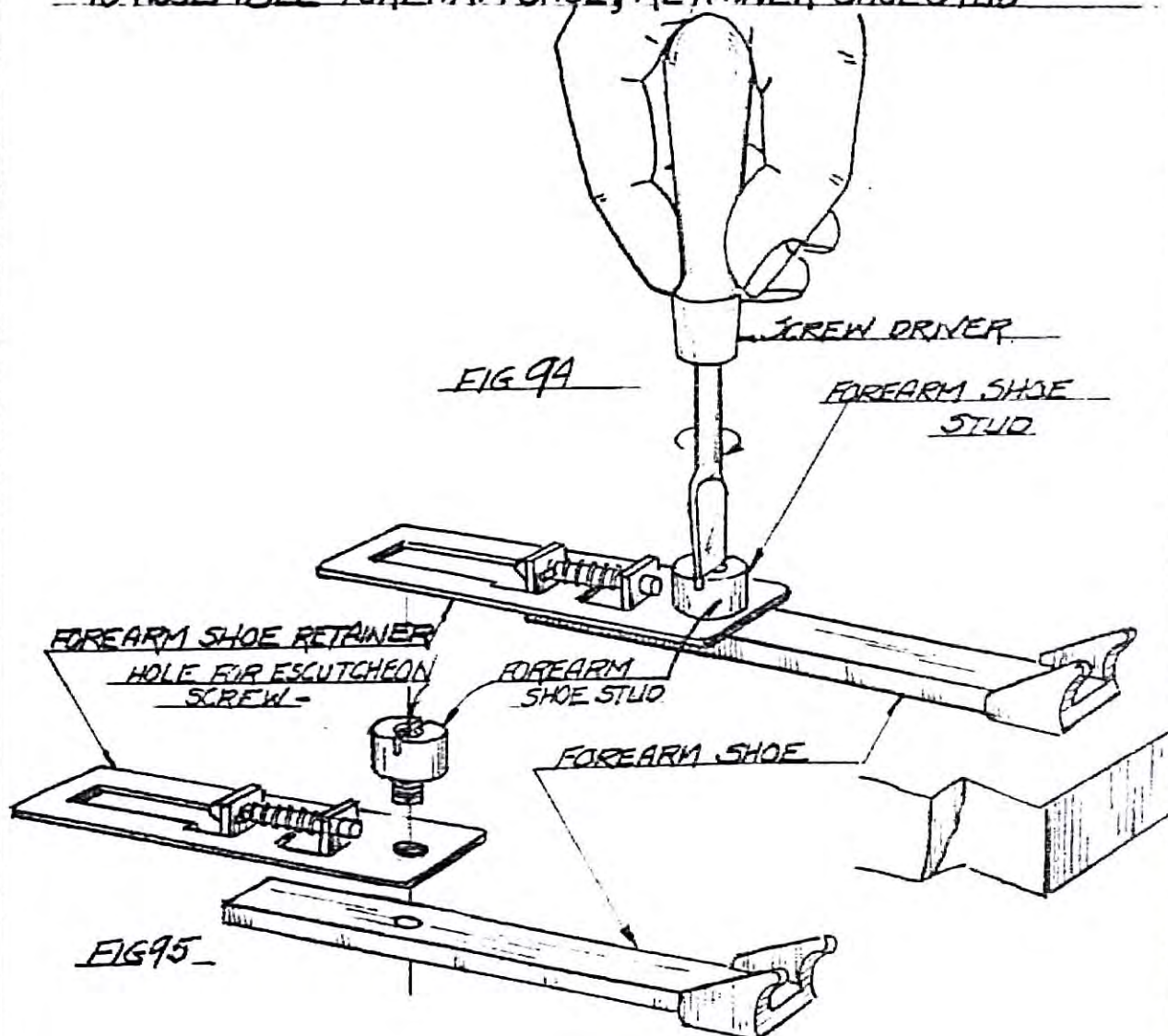


Fig. 94, 95

To Assemble Forearm, Retainer and Retainer Shoe Stud

Place forearm shoe on bench with forked end upward and toward operator.

Place retainer on shoe with screw hole in retainer and shoe lining up visually and spring plunger next forearm shoe stud. Insert the forearm shoe stud and tighten it by turning it clockwise with a suitable screw driver.

6 OCT 59 A. A. Spindel

TO ASSEMBLE M/37 SINGLE BARRE SHOTGUN 12, 16, 20, 28 GA.
410 BORE

TO ASSEMBLE FOREARM SHOE-RETAINER ASSEMBLY TO -
FOREARM-

Fig. 96, 97, 98, 99

To Assemble Forearm Shoe Retainer Assembly to Forearm

Hold forearm in left hand, inletted side upward and rear end away from operator. Place forearm shoe liner and shim in rear end of forearm.

Still holding forearm in left hand as before, place shoe-retainer assembly in forearm, forked end at rear of forearm and plunger on underside of shoe retainer assembly.

Turn forearm bottom upward, still holding group together, and line up screw holes visually. With rear end of forearm on bench, insert the escutcheon screw and turn it home clockwise with a suitable screw driver.

The forearm is now assembled.

TO ASSEMBLE M/37 SINGLE BARREL SHOT GUN- 12, 16, 20, 28 GA. 410 BORE

TO ASSEMBLE FOREARM SHOE-RETAINER ASSEMBLY TO FOREARM-

FIG-96

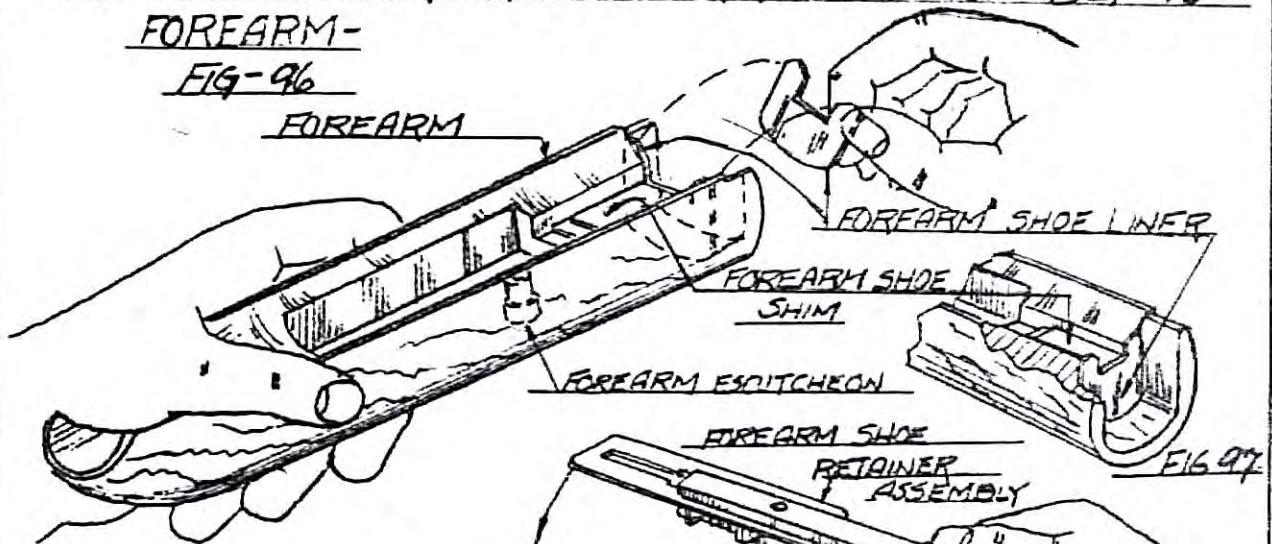


FIG-97

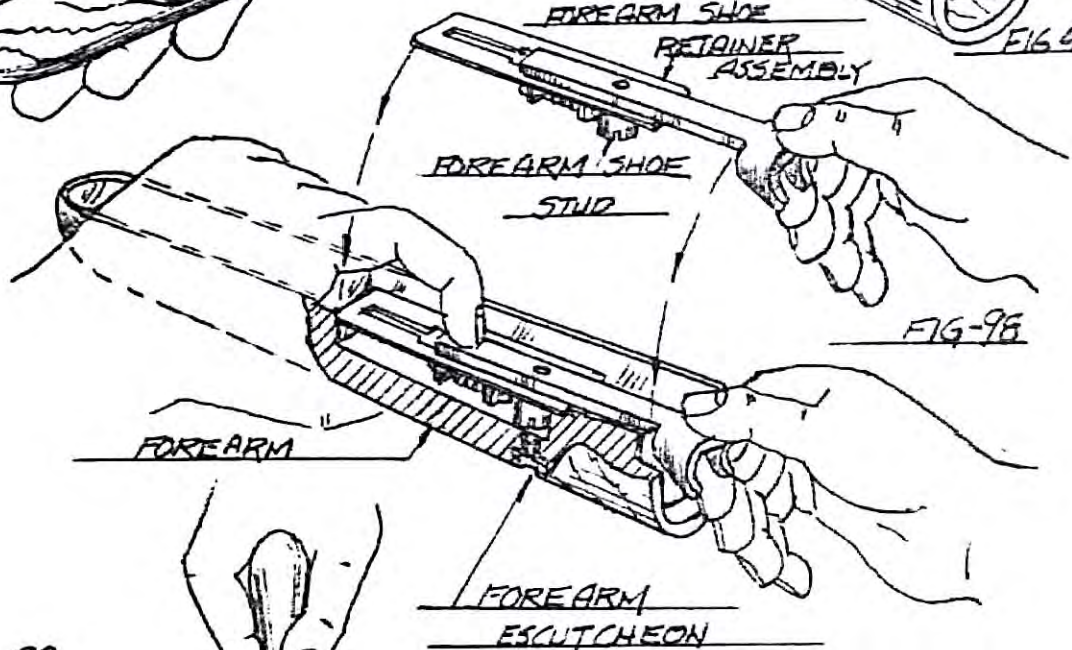
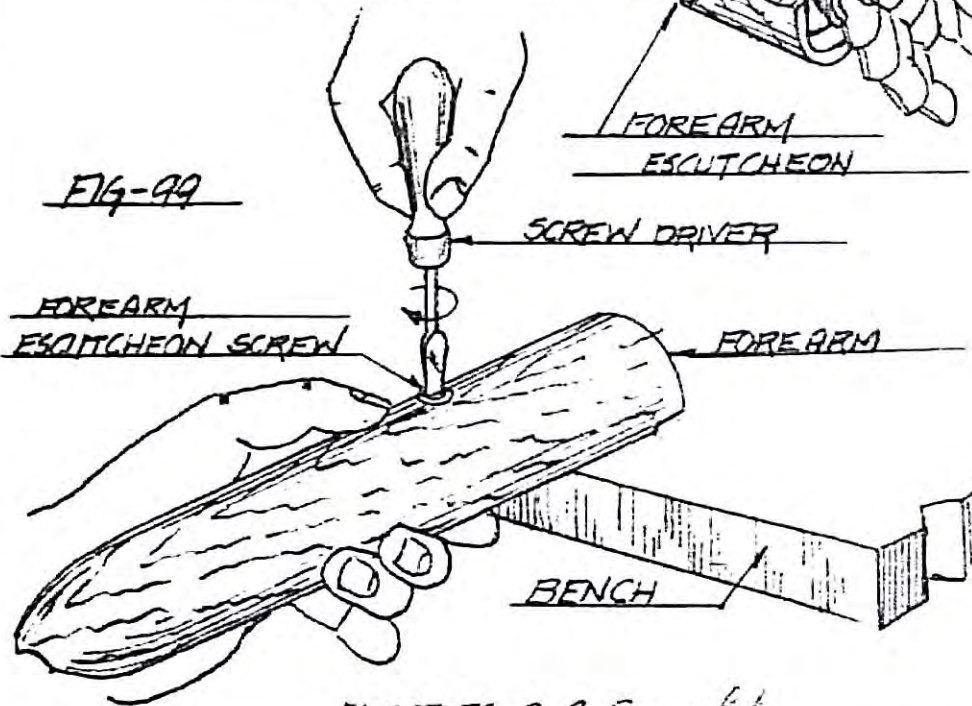


FIG-98

FIG-99



9 OCT 59 A.D. Gmoly

TO ASSEMBLE M1/37 SINGLE BARREL SHOT GUN- 12, 16, 20, 28 GA
410 BORE

TO ADD FORE ARM TO BARREL-

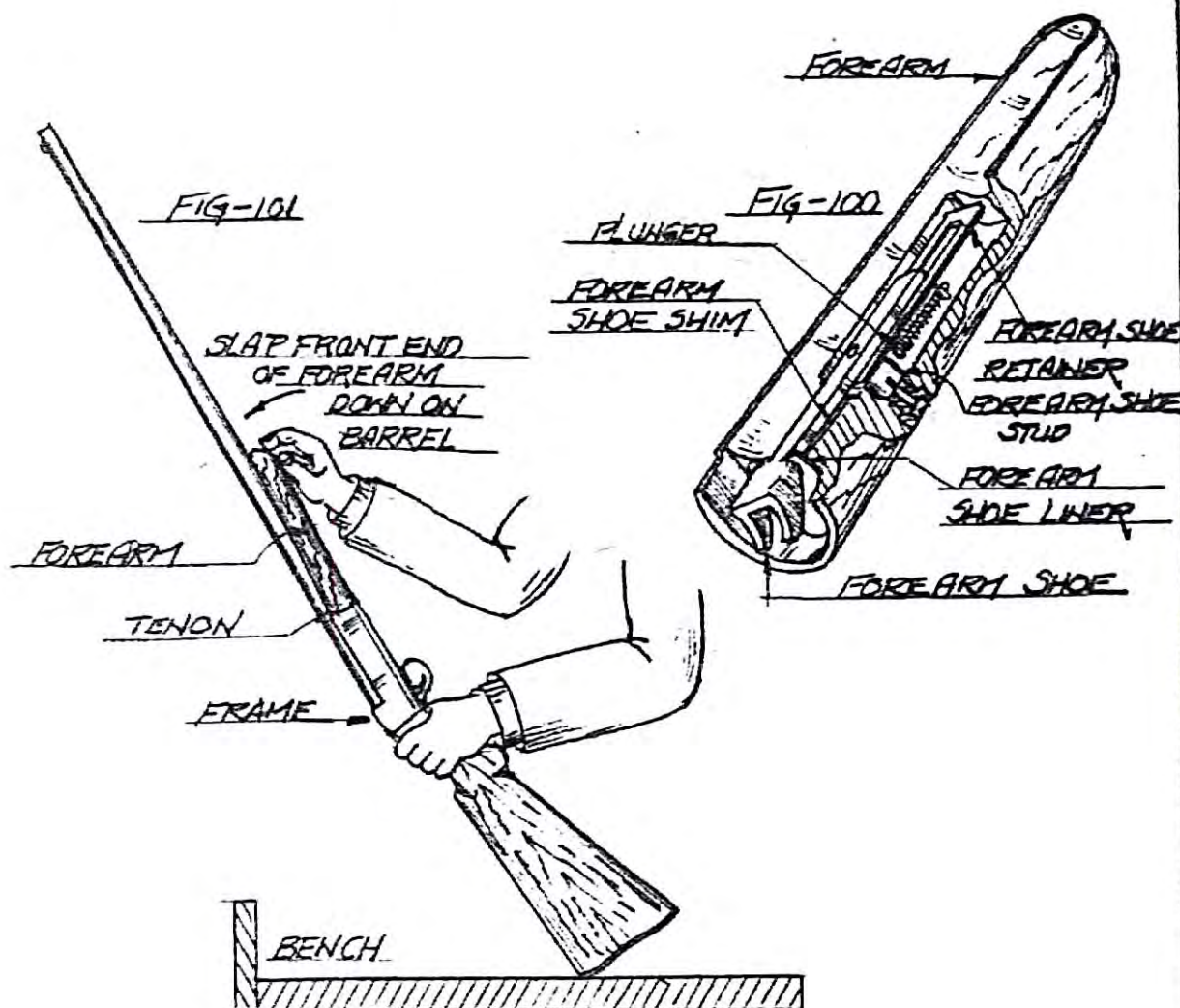


Fig. 100, 101

To Assemble Forearm to Gun

Hold gun inverted by left hand at pistol grip at approximately 60° with bench as butt end of butt stock rests on bench. Place forearm with inletted side on barrel and rear end over front end of frame. At this point, the plunger on forearm shoe retainer is resting on but not engaging its notch in forearm lug or barrel. Slap front end of forearm down on to barrel with open right hand and a click will be heard as plunger on retainer shoe slips into its notch in forearm lug on barrel.

9 NOV 59 A. A. Gruel

12, 16, 20, 25, 64
410 BORE

410 BORE

9 DEC 59 A. A. Quolz

