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INSERT FOR COLT AUTOMATIC MACHINE RIFLE (R 75) HANDBOOK

Information Relating To
Colt Automatic Machine Rifle (R 75 A)

(with quickly demountable barrel)

COLT'S PATENT FIRE ARMS MFG. CO.
Hartford, Connecticut, U. S. A.

Colt Automatic Machine Rifle (R 75 A)

(with quickly demountable barrel)

The information and data given in the following pages relating to Colt Automatic Machine Rifle (R 75 A), supplement the information and instructions given in the Colt Automatic Machine Rifle (R 75) Instruction Book.

The information given in the R 75 Handbook is generally correct for the Colt Automatic Machine Rifle (R 75 A). The barrel in the latter, however, is of the quickly demountable type and instructions for dismounting and mounting the barrel in the receiver are given in the following pages.

General Data

Weight of Rifle with Bipod and Magazine	21 lbs.	Length of Barrel	24 inches
Weight of Barrel with Changing Handle	5½ lbs.	Length of Rifle, overall	43½ inches
Weight of Magazine, empty, (20 rounds)	10 ozs.	Sight graduated up to 1400 meters	
Weight of Magazine, filled, (20 rounds)	1 lb. 10 ozs.	Gas Port from Muzzle	6 inches
Weight of Sling Strap	8 ozs.	Rate of Fire (nominal)	500 shots per minute
Weight of Bipod (including yoke)	1 lb. 3 ozs.	Aimed Shots per Minute, semi-automatic	60
		Rifle fires Caliber .30 Standard Military Cartridge	

Regular Equipment with each rifle
supplied on F. O. 9387 also F. O. 907 is as follows:—

SPARE PARTS

2 Extractors	6 Extra Magazines
2 Extractor Springs	1 Magazine Catch
1 Ejector	1 Magazine Catch Pin
1 Recoil Spring	2 Magazine Catch Springs
2 Firing Pins	1 Gas Cylinder Tube Retaining Pin
1 Sear Spring	1 Trigger Pin
1 Bolt Guide Spring	1 Trigger Guard Retaining Pin
1 Connector	1 Recoil Spring Rod

ACCESSORIES

1 Leather Accessory Case	1 Oil Can (filled)
1 Magazine Filler	1 Ruptured Cartridge Extractor
1 Combination Tool	1 Gas Cylinder Cleaning Tool
1 Thong Cleaner with brush complete	1 Cleaning Brush for Chamber

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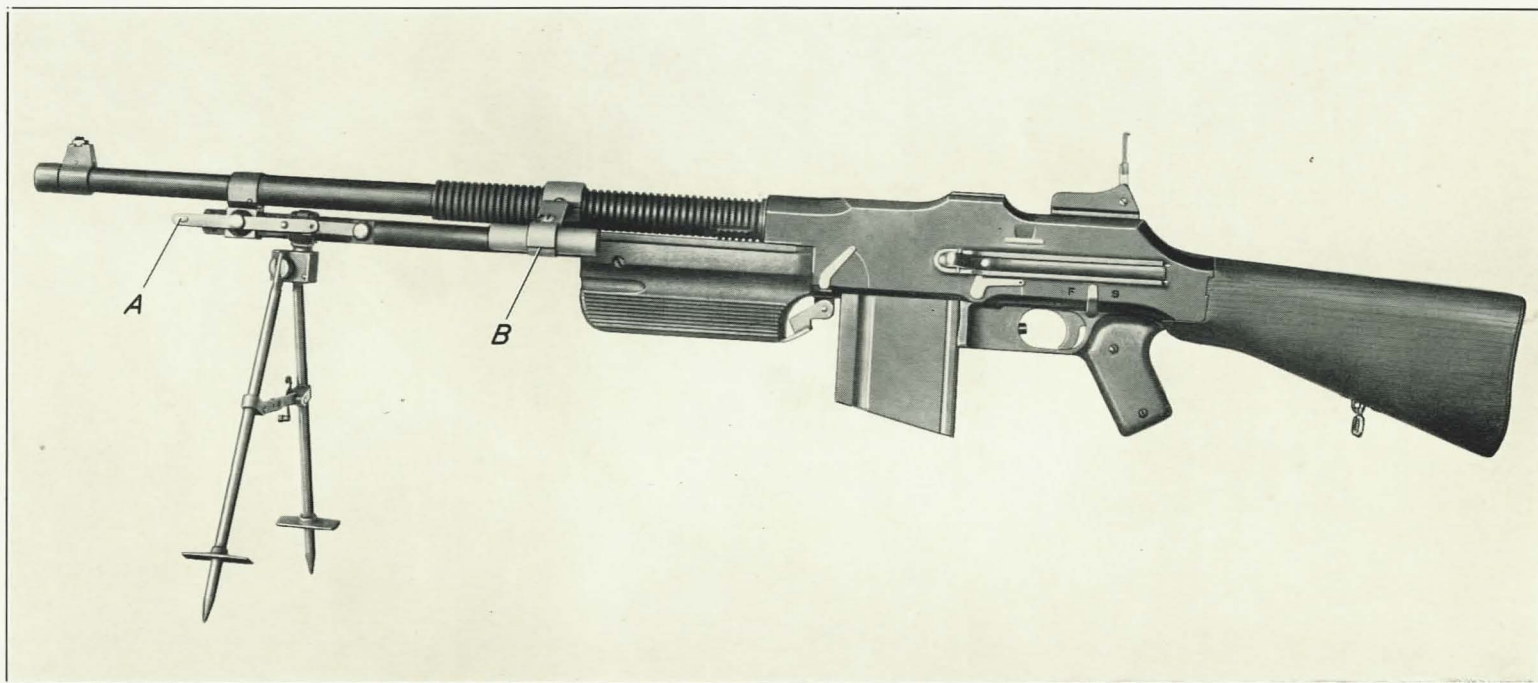


Plate 1
Left-hand side view of rifle

Colt Automatic Machine Rifle (R 75 A)

(with quickly demountable barrel)

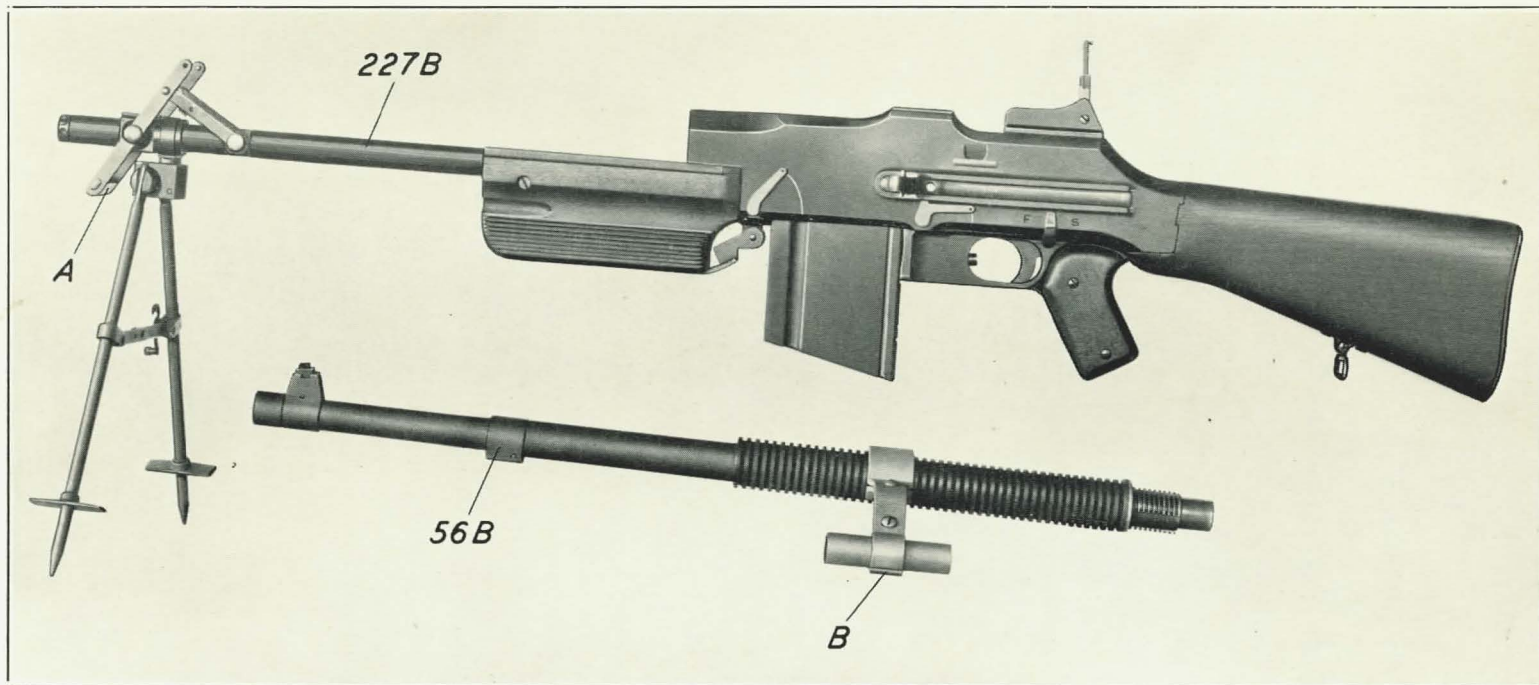


Plate 2
View of rifle showing barrel dismounted

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To Dismount Barrel from Receiver, Proceed as Follows:

1. Pull back on operating handle until bolt is held in the fully drawn back position.
2. Pull bar A to the down position shown in illustration Plate 2, which will disconnect the gas cylinder tube (227B) from the gas cylinder tube bracket (56B) of the barrel.
3. With rifle inverted and using the combination tool or the point of a cartridge, pry barrel locking spring C (see Plate 3) out of engagement with notch in barrel, then push down on the barrel changing handle B making one-third of a turn, which will disengage barrel from segmental threads in receiver. Now pull the barrel straight out towards the front.

To Mount Barrel in Receiver, Proceed as Follows:

1. With the rifle held upright, enter the barrel into the hole in the receiver until barrel flange comes up against face of receiver (in doing this pry the barrel locking spring C outwards to allow flange of barrel to pass).
2. When barrel flange comes up against face of receiver, grasp the barrel changing handle B which is attached to the barrel and give one-third of a turn to the barrel in a clock-wise direction. This will allow the barrel locking spring C to snap into the notch in the barrel, thus preventing any circumferential movement of the barrel during firing.
3. Return bar A to position shown in Plate 1 making sure that gas cylinder tube (227B) and gas cylinder tube bracket (56B) engage, and rifle is ready for firing.

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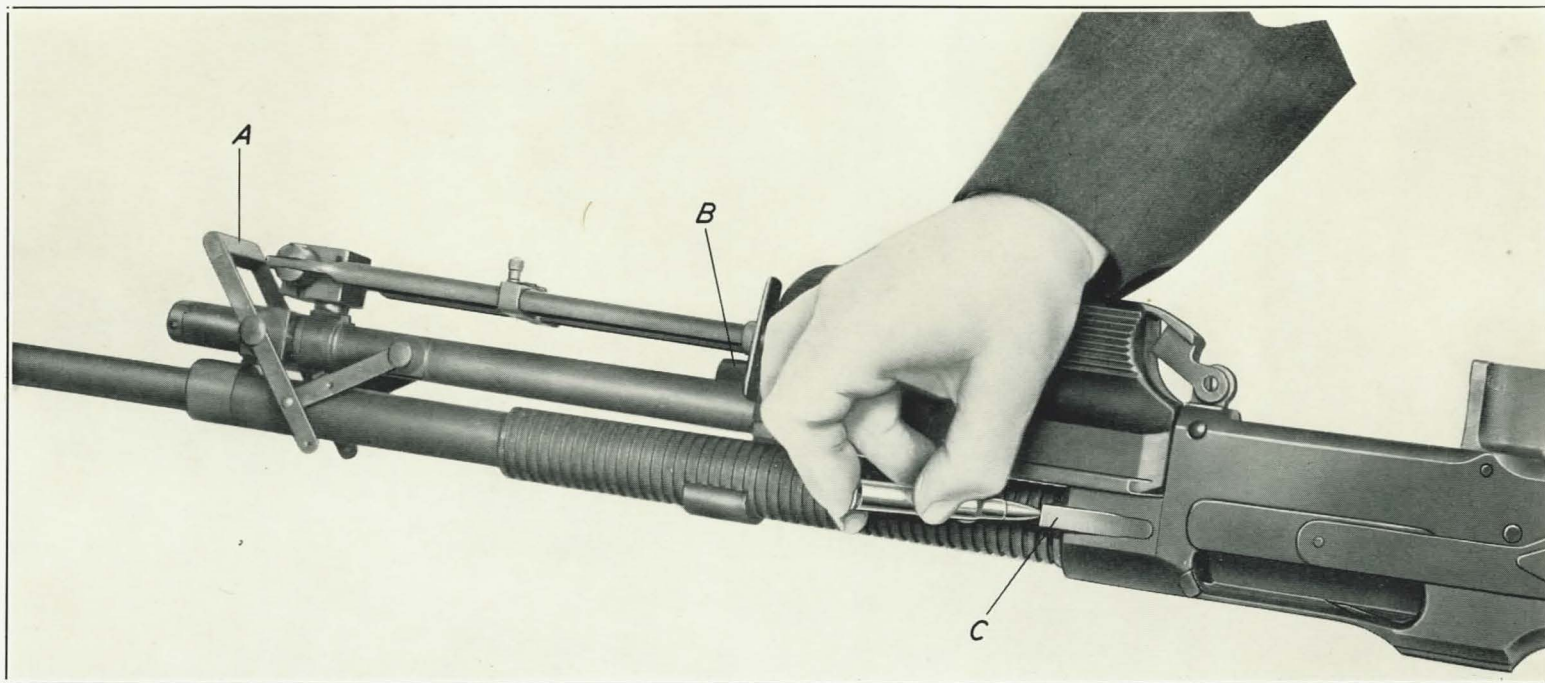


Plate 3

View showing barrel locking spring C held out with the point of a cartridge in order that the barrel may be turned in the receiver. Note rifle is inverted for convenience in handling, also that bolt is drawn back.

Colt Automatic Machine Rifle (R 75 A)

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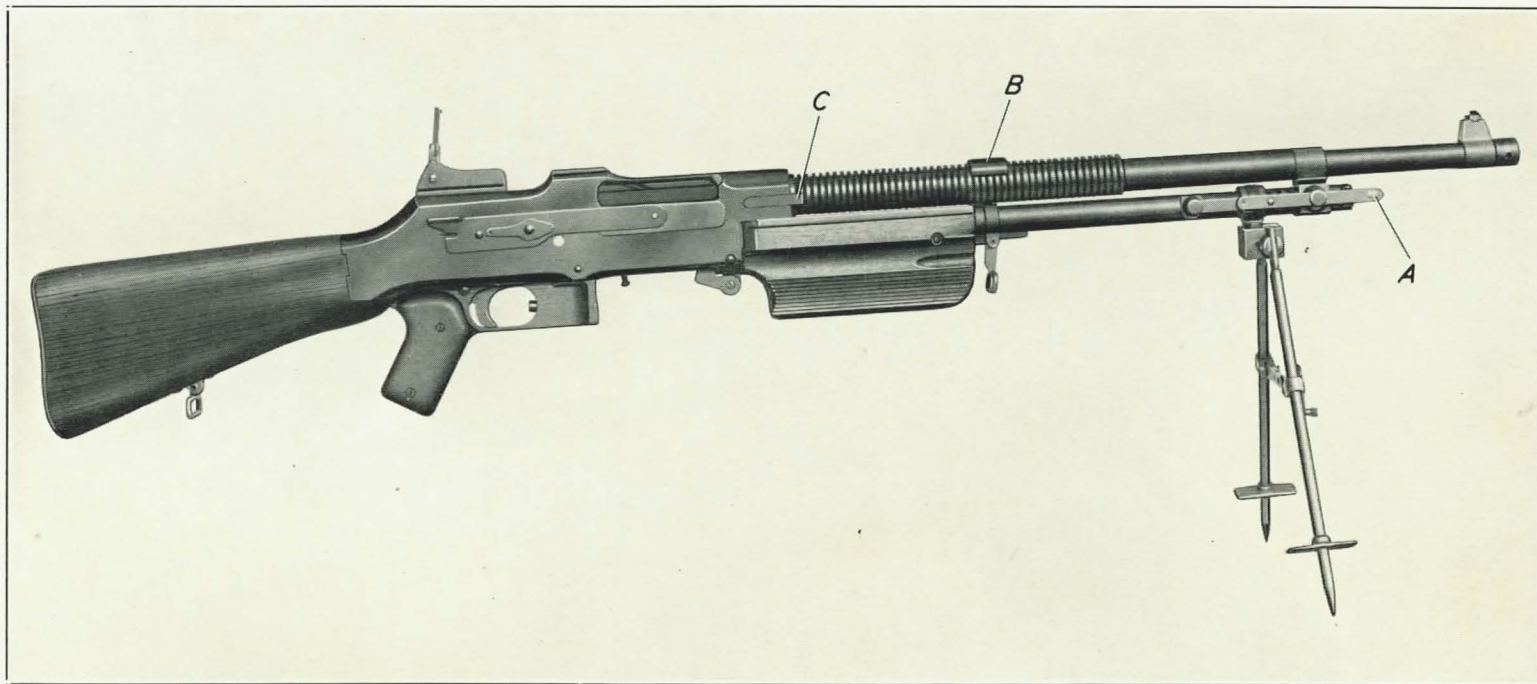


Plate 4

Right-hand side view of rifle with magazine removed, showing barrel locking spring C which must be held out of engagement with notch in barrel before barrel can be turned in the receiver. Bolt must be in the fully drawn back position (with the sear of the trigger-guard engaging in notch in slide) and the bar A unlocked by pulling downwards as shown in illustration Plate 2, before attempting to turn the barrel. If any attempt is made to dismount the barrel without taking these precautions, breakage of parts can result.

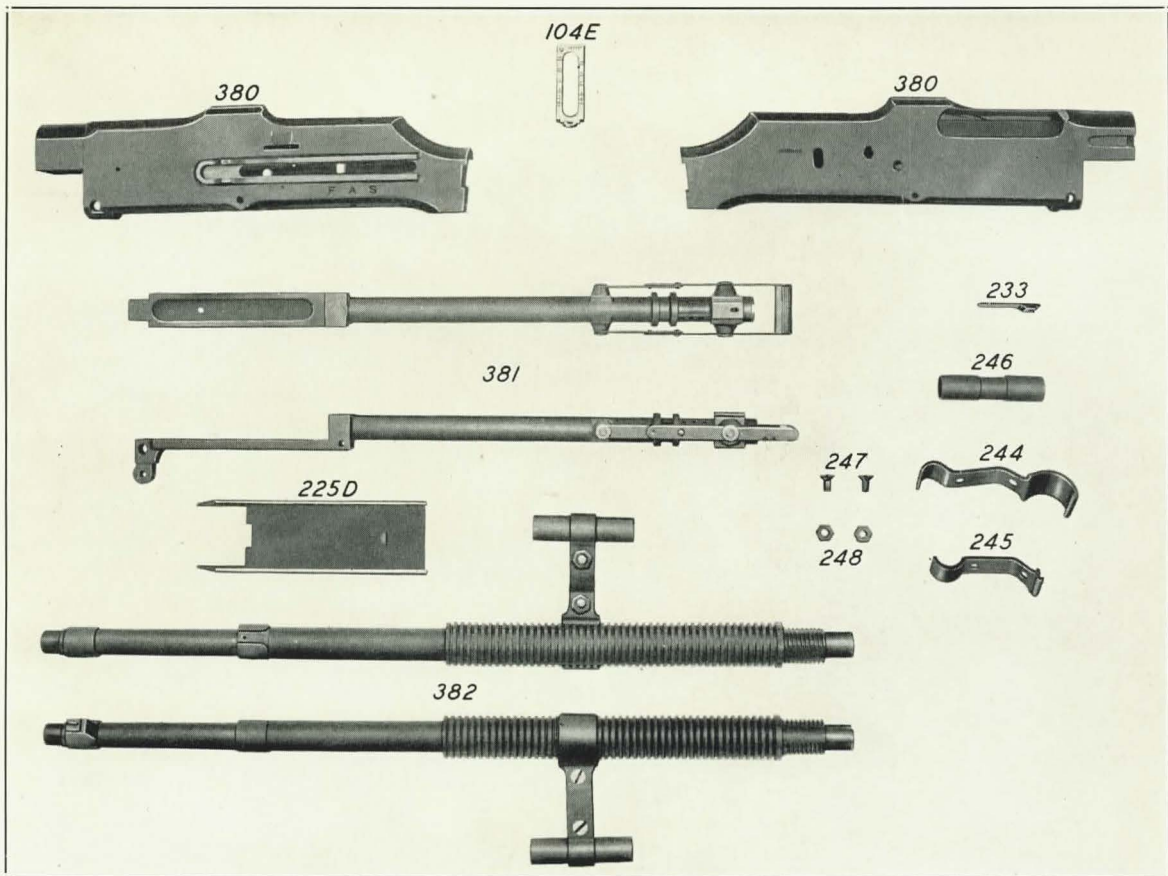


Plate 5

Component parts which are special for the Colt Automatic Rifle (R 75 A)

PART NO.	NAME OF PART
56B	Gas Cylinder Tube Bracket, Front
60K	Barrel
104E	Rear Sight Leaf (meters)
225D	Forearm Cover
227B	Gas Cylinder Tube
233	Barrel Locking Spring
234	Barrel Adapter Locking Plunger
235	Barrel Adapter Locking Plunger Spring
236	Barrel Adapter
237	Gas Cylinder Tube Block
238	Gas Cylinder Tube Block Washer (2)
239	Gas Cylinder Tube Washer (2)
240	Gas Cylinder Tube Link, Short — Right

PART NO.	NAME OF PART
241	Gas Cylinder Tube Link, Short — Left
242	Gas Cylinder Tube Link, Long (2)
242½	Gas Cylinder Tube Link Joint Rivet (2)
243	Gas Cylinder Tube Bar
244	Barrel Changing Handle Clamp, Upper
245	Barrel Changing Handle Clamp, Lower
246	Barrel Changing Handle Tube
247	Barrel Changing Handle Screw (2)
248	Barrel Changing Handle Nut (2)

These parts pertain only to the R 75 Rifle and are not used in R 75 A Rifle. Parts Nos. 52, 56, 60, 104, 225.

Factory Assemblies

380	Receiver comprises Parts 1, 2, 3, 4, 5(6), 221, 234, 235, 236	382	Barrel comprises Parts 56B, 57, 59, 60K, 61, 62C, 63, 64, 244, 245, 246, 247(2), 248(2)
381	Gas Cylinder Tube comprises Parts 227B, 237, 238(2), 239(2), 240, 241, 242(2), 242½(2), 243		