

**SPECIFICATIONS FOR THE ADAPTATION OF  
SHOTGUN MAGAZINES AND THE DEACTIVATION  
OF FIREARMS.**

**REVISED 2010**

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## **INTRODUCTION**

Section 1 (3) and (3A) of the Firearms Act 1968, as amended by Section 2 of the Firearms (Amendment) Act 1988, define the types of smooth-bore guns which may be held on a shotgun certificate. By virtue of Section 1 (3) (a) (ii) they include any smoothbore gun which has a non-detachable magazine incapable of holding more than two cartridges. If a gun has been adapted to have such a magazine, the magazine must, by virtue of Section (3A), bear a mark approved by the Secretary of State indicating that this gun falls within Section 1(3)(a) and the adaptation must be certificated in writing by the London or Birmingham Proof House as having been carried out in the approved manner. Schedule I to this guide sets out the Proof House marks approved by the Secretary of State under Section 1(3A). Schedule 2 sets out the manners of adaptations of different types of smooth-bore guns which have been approved by the Secretary of State under that Section.

By virtue of Section 8 of the Firearms (Amendment) Act 1988, a deactivated firearm is (unless the contrary is shown) presumed to have been rendered incapable of firing a shot, bullet or other missile and to have ceased to be a firearm under the firearms legislation, if it carries a mark to that effect approved by the Secretary of State and made by one of the above mentioned Proof Houses, and is certified by one of those Proof Houses as having been deactivated in a manner approved by the Secretary of State. Schedule 3 to this guide sets out the Proof House marks approved by the Secretary of State under Section 8 of the 1988 Act indicating that firearms have been so deactivated. Schedule 4 to this guide sets out the approved manner of deactivation of different types of shotguns, Section 1 firearms and also certain prohibited weapons which are subject to Section 5 of the Firearms Act 1968, as amended, which has been approved by the Secretary of State. Schedule 5 to this guide sets out a more stringent approved manner of deactivation applicable to a special category of Section 5 prohibited weapons. The Proof Masters have the authority to reject any deactivated firearms which in their opinion do not conform to the approved deactivation specifications or are submitted in a condition so as to prevent proper inspection.

The approved deactivation specifications do not extend to incomplete firearms or component parts.

These specifications replace those issued in 1995 and 1989. Additions and alterations to the specifications may be made from time to time in order to ensure that the specifications are properly maintained.

**SCHEDULE 1**

Proof House marks approved by the Secretary of State for indicating that a smoothbore gun has been adapted to have a non-detachable magazine incapable of holding more than two cartridges falls within Section 1(3) (a) (ii) of the Firearms Act 1968 (as amended by Section 2 of the Firearms (Amendment) Act 1988).

London Proof House



Birmingham Proof House



The figures “10” refer to the calendar year 2010 and will change as appropriate in succeeding years.

## **SCHEDULE 2**

### **Approved Specifications for the Adaptation of Magazines for Smooth Bore Guns**

The specifications below set out the approved manner of adaptation of the magazines of repeating smooth-bore guns in order to ensure that they are non-detachable and to limit their capacity to two cartridges. The majority of such guns will be capable of adaptation using these methods. Very minor deviations may be necessitated by the design of individual guns.

Some models of gun may not lend themselves to adaptation in this way. These will have to be converted to single shot weapons if the problems cannot be overcome. Shotguns with removable tubular magazines, such as those models in which the magazine is housed in the buttstock, and certain .22 Rimfire self-loading guns, fall into this category.

Many shotguns are made by smooth-boring the barrels of bolt action repeating rifles; these are usually of military design. By virtue of Section 7(2) of the Firearms (Amendment) Act 1988, they can only be regarded as shotguns for the purposes of the firearms legislation if their original rifled barrels were at least 24 inches (609.6mm) in length and have not at any time been shortened below that length. The majority of these guns are used in the single shot mode because the "rifle" magazine will not accept conventional shotgun cartridges. Although it will be possible to adapt most of these guns using the specifications set out hereunder, in respect of some models it may be necessary to dispense with the magazine facility so that they operate as single shot weapons.

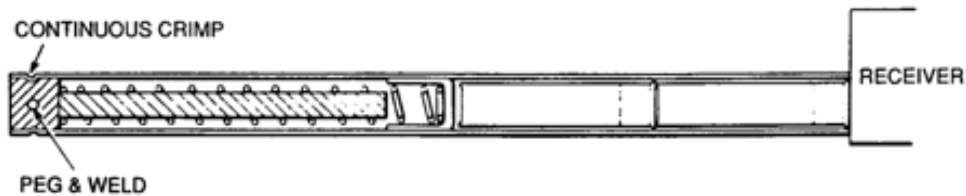
Any restricted magazine marking originally placed upon a pump-action or self-loading shotgun should be struck out where such weapons are restored to their previous large magazine capacity; the magazine restriction certificate should also be returned to the Proof House which issued it.

## SPECIFICATIONS

### A. Tubular Magazines

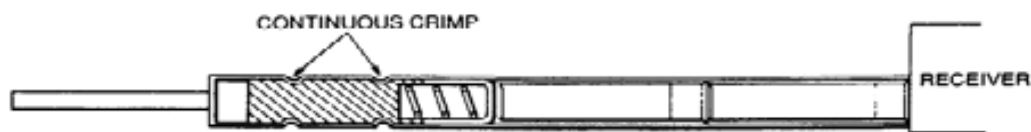
#### Method I

The magazine must incorporate an additional solid metal spacer and the original spring.



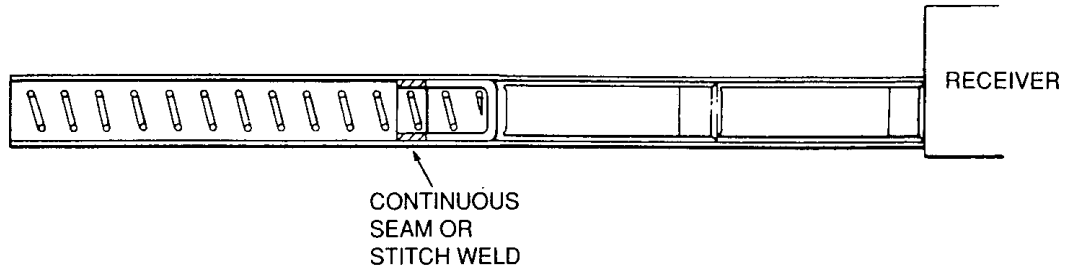
#### Method II

The magazine must incorporate an additional metal spacer and a new spring.



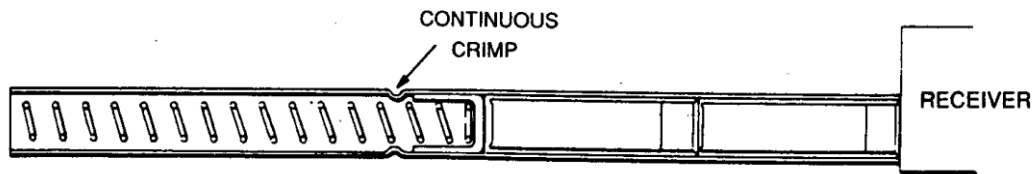
**Method III**

The movement of the magazine follower must be restricted by a metal collar. The original spring must either be retained or be replaced by one of appropriate diameter.



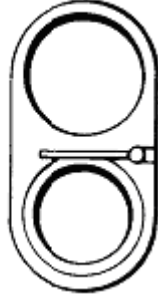
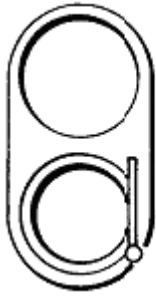
**Method IV**

The tube must be subjected to a continuous crimp in order to restrict the movement of the magazine follower. The original spring must either be retained or be replaced by one of lesser diameter as appropriate.



**Fixing magazine tube to the receiver**

**Method I**



Hardened steel pins into  
blind holes. Counter bore  
for interference fit ball  
bearing.

**Method II**

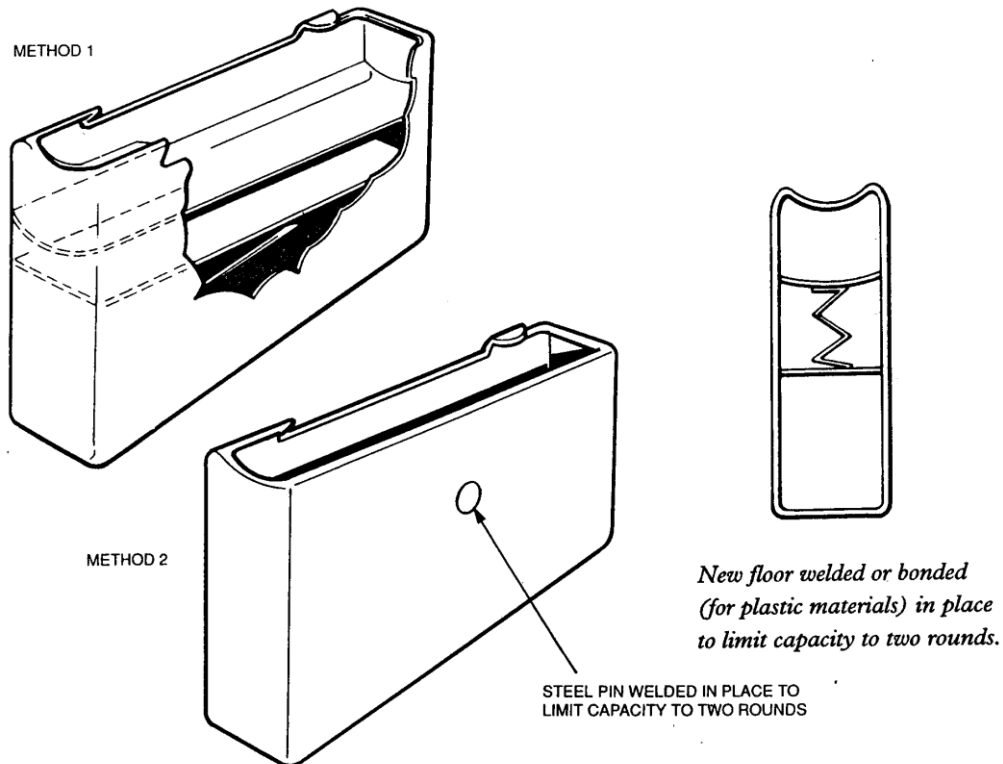
The tube must be brazed or soldered to the receiver.

**Method III**

In the case of a threaded magazine tube, the thread must be treated with adhesive before fitting in order to lock the tube to the receiver. The adhesive material must have a strength comparable to that of Loctite 270 or 275 grade.



**B. Box Magazines**



Guns fall into two general categories, namely:

- (a) Those which after conversion allow the top loading of cartridges, or
- (b) Those where the design is such that, after conversion, top loading of cartridges will not be possible.

In the case of a gun which falls into category a) the box magazine must be welded or bonded in place in the receiver and the magazine blocked by a permanent method to limit the capacity to two rounds.

In the case of a gun which falls into category b) a blanking plate must be welded in place in the receiver converting the gun to single shot. The magazine must then be welded or bonded to the receiver only if there is a requirement for it to remain with the weapon.

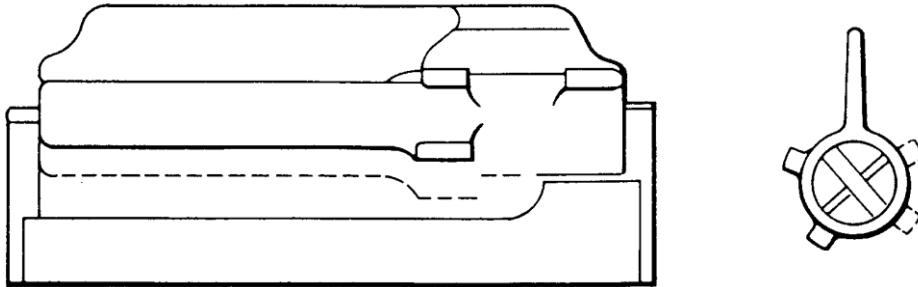
**C. Integral Magazines**

See specification for box magazines.

If necessary a blanking plate must be welded in place in the receiver in order to convert the gun to single shot.

**D. Rotary Magazines**

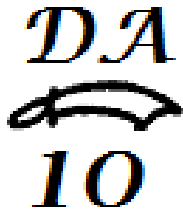
The ridges between cartridge seats must be cut away in order to limit the magazine to two-cartridge capacity. The magazine must be welded or bonded in place.



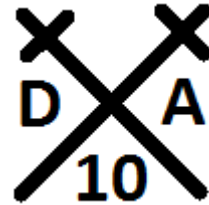
**SCHEDULE 3**

Proof House marks approved by the Secretary of State under Section 8 of the Firearms (Amendment) Act 1988 for indicating that a firearm has been rendered incapable of firing a shot, bullet or other missile and has ceased to be a firearm under the firearms legislation.

London Proof House



Birmingham Proof House



The figures "10" relate to the calendar year of 2010 and will change as appropriate in succeeding years.

## **SCHEDULE 4**

### **Specifications for the deactivation of firearms**

The specifications set out below show the approved manner of deactivation for a wide range of firearms to a standard which must ensure the general principle that the essential components are unsuitable for future use. Wherever possible the deactivation process has been designed so that the outward appearance is unaltered and the majority of deactivated firearms will have the same appearance as their unmodified counterparts.

For the purposes of these specifications, essential components shall include all major pressure bearing components (e.g. the barrel, bolt, action, breech-locking surfaces and systems which delay the opening of the breech during the firing process). Additional components must be subjected to the appropriate deactivation procedures where specified in the relevant sections.

**GENERAL SPECIFICATION**

- (i) A slot must be cut through the chamber wall and into the barrel along the extent of the covered section. Allowance can be made for the retention of the forend securing fixture. The width of the slot in relation to the bore diameter must not be less than that specified unless it is a signal pistol where an exception to the rule occurs. In the case of a self-loading pistol, the exposed section of a barrel must include that section revealed when the slide is moved back to its rearmost position.

<b>Bore Diameter</b>	<b>Slot Width</b>
Up to 8 mm/.32"	4 mm/. 16"
Over 8 mm up to 13 mm/. 32" up to .51"	6 mm/.24"
Over 13 mm/.51"	8 mm/.32"

Slots which are cut as specified in other parts of firearms, with the exception of self-loading pistol guide rails, must be checked with a 6 mm/.24" thick slip gauge.

- (ii) Pins for securing barrels to receivers and frames for weapons with a bore diameter up to 8mm/.32" must be of 4.5mm/.18" minimum diameter. 6mm/.24" pins (minimum size) must be used for bore diameters over 8mm/.32". Minimum original surface hardness of the pins must be 60 Rockwell C.
- (iii) A tight fitting steel rod must be driven into the bore and be securely welded in place. The rod should be positioned as close to the chamber as possible whilst still allowing clear inspection of the pin. Exceptions to this rule occur to accommodate signal pistols, mortars, rocket launcher tubes, smoke dischargers and artillery pieces.  
A shotgun barrel must have a steel plug driven into the chamber cone extending to within 1 inch/25.4 mm of the breech face and secured in place with a continuous run of weld, as viewed from the breech end. The plug must be of a length at least 2/3 of the length of the chamber as marked. (This is to prevent the subsequent chambering of a cartridge). Pins must be driven through the chambers of other weapons for the same reason and welded in place. An alternative method is provided in the case of revolver cylinders.
- (iv) A substantial part of the breech face must be removed in order to remove all support for the cartridge head and to destroy the firing pin tunnel. More stringent standards are set out in respect of certain prohibited weapons.
- (v) In the case of a revolver the walls between the chambers in the central section of the cylinder must be cut away to open up all the chambers to a minimum of 2/3 of their length.

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- (vi) In the case of a self-loading pistol at least 2/3 of the length of the slide rails must be removed from the frame. The recoil face must be cut at a minimum angle of 45 degrees across its entire face.
- (vii) The firing pin must be removed or shortened. A shortened firing pin must have its new tip positioned at least 1/8"/3mm below the breech face established by deactivation.
- (viii) The firing pin or striker aperture must be sealed by welding or by an alternative method as described in general specification (x).  
An exception to this rule occurs for mortars, rocket launcher tubes, smoke dischargers and modern reproduction black powder guns.
- (ix) It is only possible to carry out limited deactivation of the frame or receiver of a firearm; this is especially true in the case of a pressed metal sub-machine gun receiver. One essential feature of the deactivation is that the deactivated barrel must be firmly secured to this component. To ensure this the barrel must be pinned and welded securely in place. This does not apply to self loading pistols.
- (x) In all instances where the words "weld" or "welded" are used, special allowances are made for brazing or hard soldering techniques where one or both of the components are made from a non-ferrous alloy and for the use of secure bonding agents where components are made from plastics and similar non metallic materials. Stricter standards apply to prohibited weapons.
- (xi) The term "securely" and "substantial" when used in relation to the welding of an item mean welded to a standard which will secure permanently the item in question, will ensure that the item cannot be removed even by using substantial force, and will require the key areas of the weld to be broken or removed before the item can be dislodged.  
  
The term "tack welding" means welding sufficient to hold the item in place, but not sufficient to retain it if substantial force is used to dislodge it.
- (xii) All drawings for the chamfering of recoil faces of bolts, slides etc, must specify that the machining be done at a minimum angle of 45 degrees to the recoil face and continue across the entire recoil face removing as much cartridge support as is practicable.
- (xiii) The locking lugs on two-part bolts on rifles and certain shot guns must be weakened by the removal of material at a minimum angle of 45 degrees. The locking lugs on other rifle bolts must be modified in a similar manner.
- (xiv) Revolvers fitted with cross-wedge barrel fixtures (e.g. reproduction COLT percussion revolvers) must have the wedge secured in place by means of a pin driven through the barrel into a blind hole and be secured by weld.

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- (xv) The standing breech face of a shotgun or signaling pistol must be machined away across an area greater than that of the cartridge head. The angle at which this removal of material must take place, relative to the plane of the recoil face must not be less than 60 degrees, except when the breech face does not permit such an angle (e.g. thin-faced Signal Pistols) in which case the maximum angle possible must be used.
- (xvi) The barrel of a signaling pistol must be deactivated with a slot of appropriate size as in the case of other weapon designs. A pin must be fitted through the chamber and welded securely in place. The barrel slotting used for double barreled or multi-barreled shot guns or revolver cylinders shall be used for other multi-barreled guns, as appropriate.
- (xvii) In the case of a hinged-frame (split-frame) revolver the pinning of the barrel to the frame is not required. Barrel slotting can be reduced to the region alongside the axis pin housing.
- (xviii) In the case of a falling-block rifle the diameter of the striker housing passage must be enlarged by at least 50% or to the greatest extent possible. Deactivation standards in respect of the striker assembly are provided in the amended drawings.
- (xix) In the case of a Martini action gun it may not be possible to enlarge the striker passage nor possible to cut through the feed ramp as this forms part of the upper exposed surface of the block. In this case the striker housing passage must be enlarged as far as possible and the retaining plug securely welded into place. The receiver must be weakened adjacent to the chamber opening.
- (xx) Muzzle loading weapons, with the exception of revolver designs, must have a barrel obstruction near to the breech end, to prevent the loading of a powder charge. The breech plug must be welded securely to the barrel. These de-activation standards are applicable for modern reproduction muzzle-loading firearms. There is no requirement for the deactivation of genuine antique muzzle loading firearms which are to be possessed as curiosities or ornaments.
- (xxi) In all instances some form of chamber blockage must be introduced to prevent the chambering of live ammunition.
- (xxii) The fitting of short or dummy firing pins is permitted in the case of old hammer shotguns.
- (xxiii) Difficulties have been encountered with the deactivation of certain hammerless self-loading pistols. In these instances the front section of the firing pin must be removed and the striking face of the (concealed) hammer must be ground off.

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- (xxiv) Smoothbore guns with barrels of less than 24 inches/609.6 mm in length normally, will only be accepted for inspection if it can be demonstrated that they were manufactured as short-barrelled guns. However, it is recognised that there will be the occasional need for such items for use in theatrical performances, for the training of police officers/employees and for display in museums. In such a case each weapon submitted must be accompanied by a signed declaration confirming that it is for police, theatrical use, etc.
- (xxv) Any substantial alteration to a deactivated firearm (e.g. the shortening of shotgun barrels, or adaptation to allow the firing of blank cartridges or to operate as an air weapon) will render the deactivation certificate invalid. Although only a Court can provide a definitive ruling on the subsequent classification of the altered item, the automatic exemption from certificate control provided by Section 8 of the Firearms (Amendment) Act 1988 would no longer apply to the various component parts, unless the weapon is re-submitted to the Proof House for re-certification.
- (xxvi) In special circumstances where normal specifications for the type of arm cannot be fully implemented, the British Proof Authority has discretionary powers to use an individual specification and mark to certify that an arm has been deactivated to a standard sufficiently stringent to comply with the requirements of The Secretary of State.



## **SCHEDULE 5**

### **SPECIAL DEACTIVATION SPECIFICATIONS APPLYING TO SUBMACHINE GUNS, MACHINE PISTOLS, AUTOMATIC RIFLES, CENTRE-FIRE SELF LOADING RIFLES AND CARBINES AND ANY OTHER ARMS BASED UPON THE DESIGN OR ACTION OF PROHIBITED WEAPONS WITHIN THIS CATEGORY OF FIREARMS**

The deactivation specifications for this class of firearm have been set at a stricter level than those applicable to other firearms. The fitting together of the deactivated components must be accomplished in a way which will allow access for subsequent inspection of welded areas at the Proof Houses. Unless special circumstances exist, only complete deactivated firearms will be accepted for inspection by the Proof Houses. Separate component parts will not be accepted by the Proof Houses.

In the case of water cooled machine guns, some mortars and other weapons, double inspection may be required. The first inspection for barrel without jacket or shrouds and the second inspection when fully assembled.

### **GENERAL DEACTIVATION STANDARD**

The deactivation specification set out below and described in detail on the specification sheets for individual types of firearm constitute a general approved standard for the deactivation of this class of firearms:

In all cases, the deactivation of the barrel will be similar to that for other firearms. However the deactivated barrel must then be rigidly attached to the receiver of the weapon with secure weld runs and with a pin driven through the barrel chamber. Weld runs must continue into bolt or bolt carrier rails and channels, and also into bolt-locking lug recesses. This will form part of the process of deactivating the receiver to prevent its future use as a firearm component. Where receivers are fabricated from aluminium alloy it is necessary to employ inert gas welding techniques in some of the deactivation processes.

In all designs employing a bolt or bolt-carrier assembly these items must either be removed together with all other items and destroyed with a cutting torch, then replaced with shaped pieces of steel plate or tubing and submitted to the Proof House. Or a maximum of 50% of the bolt/bolt carrier may be retained to restore the original external appearance of the firearm caused by the loss of these major components. They must be securely welded in place with substantial or continuous runs of weld. In the case of one of these weapons being submitted without a bolt/bolt carrier the weapon must have a steel plate or hardened pin securely welded in place to stop the insertion of these components.

In all cases internal hammers, sears, pins and fire selector switches must be welded together to produce a single fused mass which in turn must be welded to the receiver where this is a steel fabrication. This procedure must effectively destroy

these components and make their removal difficult, thus deactivating the body of the weapon further. In all instances, the way in which this is achieved must allow for Proof House inspection to ensure compliance with these specifications.

Flash eliminators, muzzle brakes, sound moderators, combined grenade launcher attachments and any other attachments covered by the Firearms Act fitted to the muzzle ends of barrels must be welded in place to prevent their removal.

Unaltered firearm components which are not major components, whilst remaining part of a deactivated firearm, are covered by the Firearms (Amendment) Act 1988 and are treated as components of a deactivated firearm.

Should any of these components be removed and no longer remain part of a deactivated firearm, it cannot fall within the exemption for deactivated firearms in the Firearms (Amendment) Act 1988 and must revert to its original status.

## SPECIFICATIONS FOR INDIVIDUAL TYPES OF FIREARMS

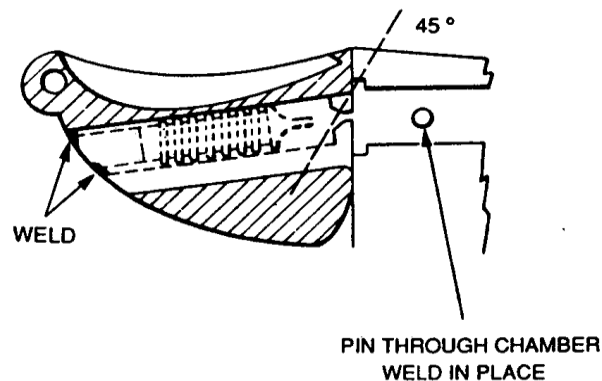
### Type **FALLING BLOCK RIFLE**

#### General

- (a) Ensure essential components are unsuitable for use in any other firearm.
- (b) Slot through chamber wall and receiver into barrel, slot full length of covered section.
- (c) Securely weld tight steel rod minimum 1/2 barrel length.
- (d) Remove substantial part of breech face.
- (e) Shorten firing pin.
- (f) Mark barrel and receiver (near number if possible).
- (g) Drive pin through chamber and weld it in place.

#### Specific

- (1) Remove tip of firing pin. Weld rear end of assembly.
- (2) Enlarge main striker housing diameter by a minimum of 50% where this will not encroach upon the sides of the breech block or feed ramp (Except in the case of Martini Action weapons).
- (3) Pin and weld barrel to receiver.
- (4) Cut away full extent of recoil face of breech block at a minimum angle of 45°.
- (5) Permanently seal firing pin aperture with weld.



**Type REVOLVER**

**General**

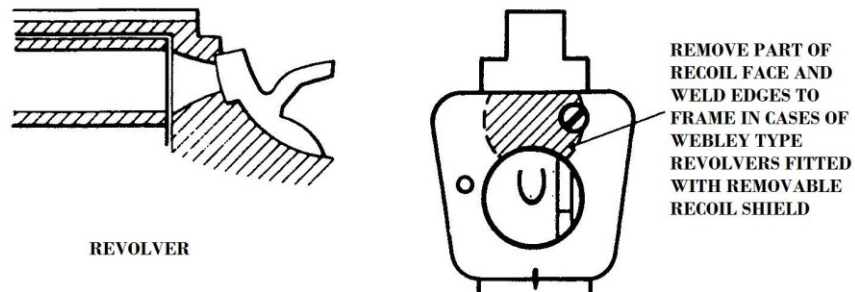
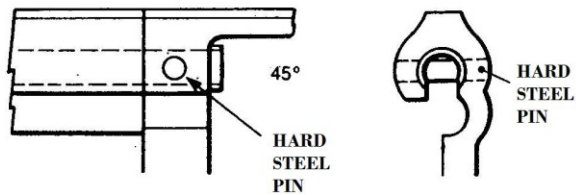
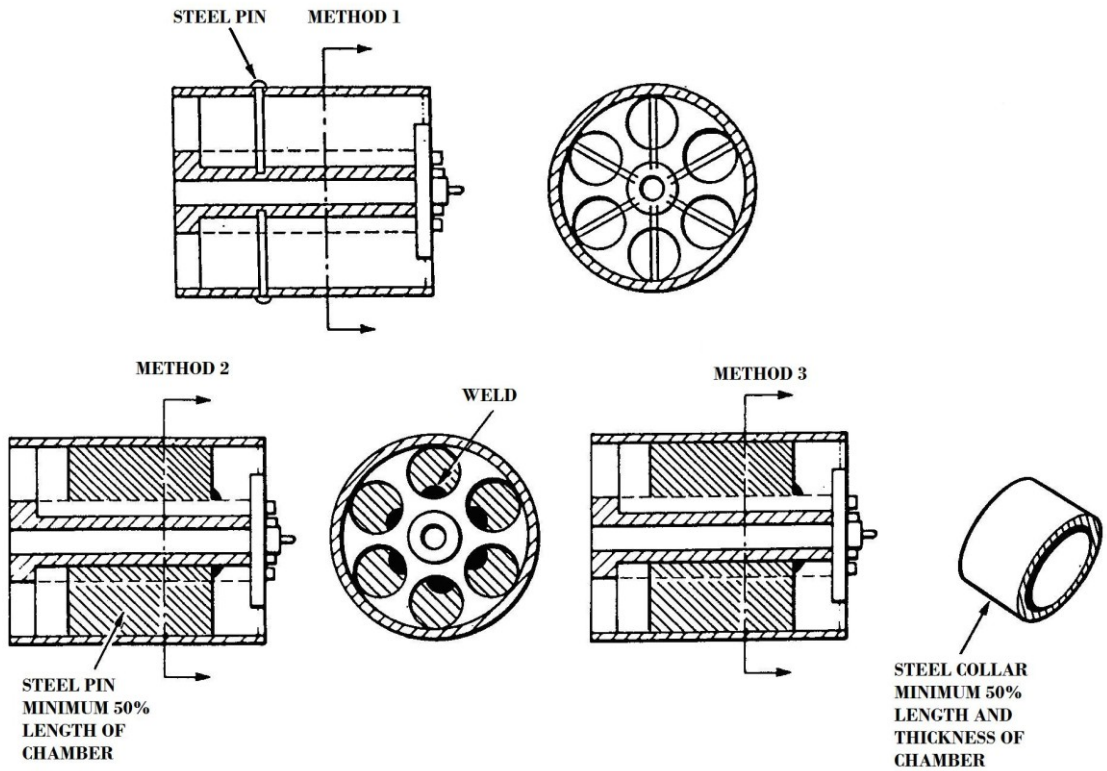
- (a) Ensure essential components are unsuitable for use in any other firearm.
- (b) Slot minimum 1 "/25.4 mm in length in barrel. Alternatively, in the case of a hinged frame revolver, slot area alongside axis pin.
- (c) Securely weld tight steel rod minimum 3/4 barrel length.
- (d) Remove substantial part of breech face.
- (e) Remove or shorten firing pin.
- (f) Mark barrel, cylinder and receiver (near number if possible).
- (g) Use annular shaped hard steel blockage welded in place or steel collar. Minimum length and thickness 50% of chamber.

**Specific**

- (1) Remove section of walls between the chambers of the cylinder to a minimum of 2/3 of their length.
- (2) Pin barrel to frame and weld pin.  
(Not required on hinged frame/split frame model).
- (3) Bore out recoil face around firing pin hole so as to destroy cartridge head support. Weld to frame remains of Webley-type removable recoil shield.
- (4) Permanently seal firing pin aperture with weld.

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**Type DISGUISED FIREARM**

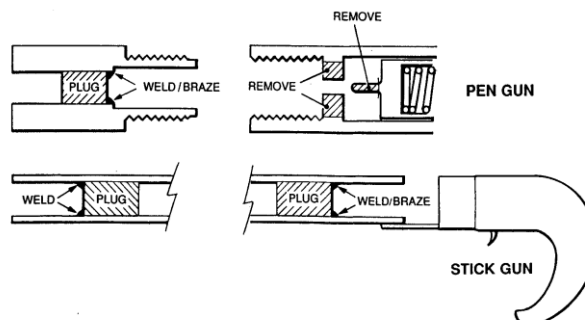
**General**

- (a) Ensure essential components are unsuitable for use in any other firearm.
- (b) Plug barrel and secure plug with circular run of weld or run weld for the length of the slot (where chamber is slotted). (braze in the case of non-ferrous barrels).
- (c) Cut off firing pin.
- (d) Drill out firing pin hole to destroy breech face, leaving thin collar of metal only to act as stop for striker unit.
- (e) Permanently seal firing pin aperture with weld.

**Note:** It is not possible to cover all types and variations of such firearms. The specifications set down for pen guns, stick guns and other arms are, therefore, to be applied in all other cases, depending on which specification is the most appropriate. Discretionary powers of inspection will be exercised by the two Proof Masters.

**Specific**

- (1) **PEN GUN** - cut slot in barrel at breech end where it will not normally be exposed.
- (2) **WALKING STICK GUN** - force fit 1"/25.4 mm long plug into breech end of barrel. Weld in place with continuous run of weld (braze if barrel is non-ferrous) to secure to barrel and prevent chambering of a cartridge. Fit and weld similar plug at muzzle end of barrel a short distance up the bore. Alter breech face and striker as in the case of a pen gun, and bolts as for bolt action weapons where they are of this design, and as for pen guns where they are of similar design.
- (3) **OTHER DISGUISED FIREARM** - use appropriate procedures as indicated above.



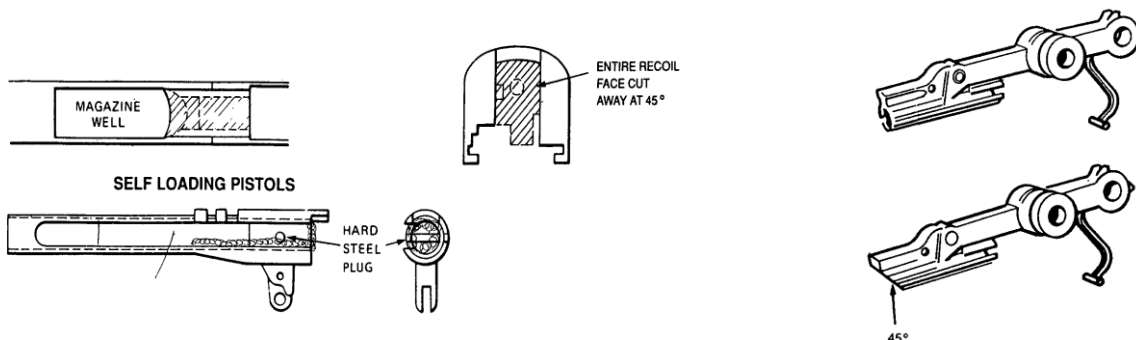
**Type SELF-LOADING PISTOL**

**General**

- (a) Ensure essential components are unsuitable for use in any other firearm.
- (b) Slot through chamber wall and feed ramp into barrel, slot full length of covered section when the slide is pulled to the rear.
- (c) Securely weld tight steel rod minimum 3/4 barrel length.
- (d) Remove substantial part of breech face.
- (e) Remove or shorten firing pin (subject to paragraph 5 below).
- (f) Mark barrel, bolt/slide and receiver/frame (near serial number if possible).

**Specific**

- (1) Slot barrel and chamber through feed ramp.
- (2) Cut away recoil face at minimum angle of 45 degrees.
- (3) Permanently seal firing pin aperture with weld.
- (4) Remove bulk of slide rails (at least 2/3 length).
- (5) If the feed ramp is part of the frame, slot to the width of magazine well through feed ramp.
- (6) In the case of a hammerless pistol, where paragraph (e) above is unsuitable, cut off and discard front half of firing pin and spring. Grind off forward part of hammer.
- (7) If the design of the pistol incorporates a locking cam system, this must be substantially weakened.



**Type** REVOLVER (MODERN REPRODUCTION PERCUSSION BLACK POWDER).

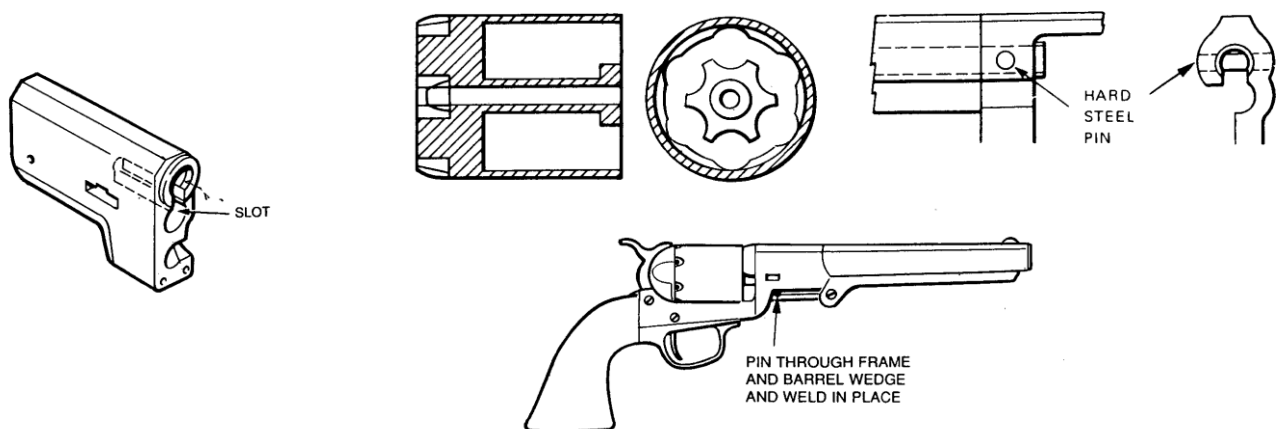
**General**

- (a) There is no requirement for the deactivation of genuine antique muzzle loading guns.
- (b) Ensure essential components are unsuitable for use in any other firearm.
- (c) Slot 1"/25.4 mm in length in barrel.
- (d) Securely weld tight steel rod minimum 3/4 barrel length.
- (e) Mark barrel, cylinder and receiver (near serial number if possible).

**Specific**

- (1) Remove walls between the chambers in the centre section of cylinder, minimum 2/3 length.
- (2) Pin barrel to frame and secure pin in place with weld.
- (3) Block nipples with weld.
- (4) Where appropriate, drive pin through barrel-securing wedge and weld in place.

**COLT NAVY TYPE REVOLVER**





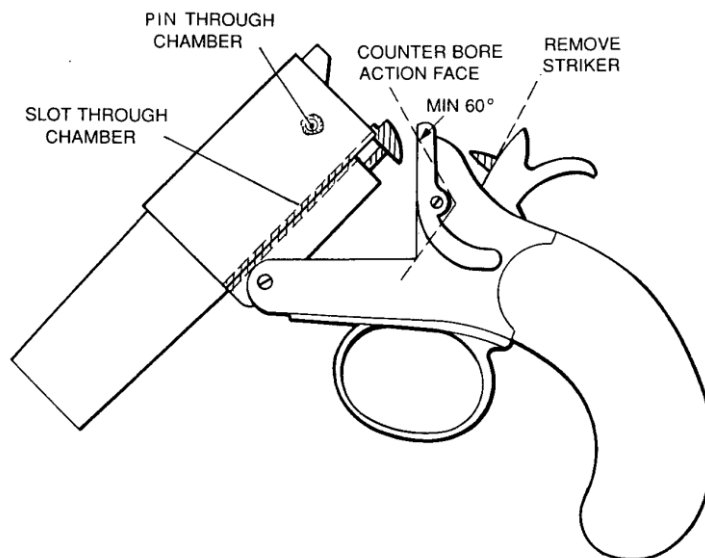
**Type SIGNAL PISTOL**

**General**

- (a) Ensure essential components are unsuitable for use in any other firearm.
- (b) Slot through chamber near extractor hole. Cut through lower chamber section of barrel. The slot width must be such that it is just concealed by the upper surface of the pistol frame when the breech is closed. Multi-barrelled guns must be treated as double-barrelled shotguns or revolver cylinders.
- (c) Remove substantial part of action face. Where breech will allow, general specifications (xv) refers.
- (d) Remove striker.
- (e) Permanently seal firing pin aperture with weld.
- (f) Mark barrel and receiver (near serial number if possible).

**Specific**

- (1) Drive hard steel pin through chamber, weld in place or braze if non-ferrous. A suitable bonding agent may be used to secure a chamber plug where gun has plastic barrel.



SPECIFICATIONS FOR THE ADAPTATION OF SHOTGUN MAGAZINES AND  
THE DEACTIVATION OF FIREARMS: REVISED 2010

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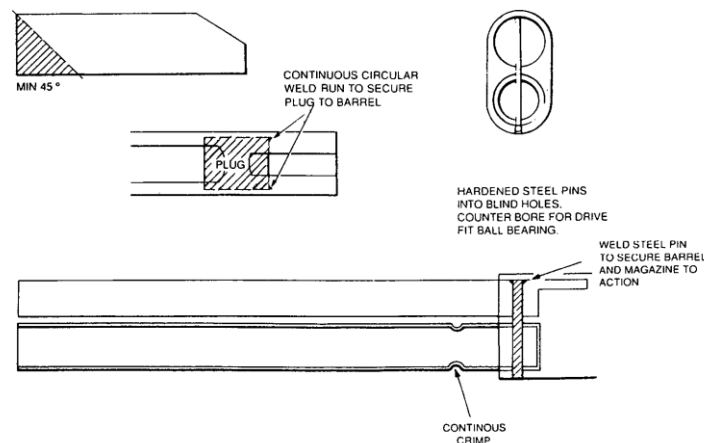
**Type** SINGLE BARRELED SHOTGUN  
PUMP & SELF-LOADING (FIXED ACTION)

**General**

- (a) Ensure essential components are unsuitable for use in any other firearm.
- (b) Slot chamber and feed ramp into barrel, slot covered length of barrel.
- (c) Weld tight steel plug in chamber and cone to prevent the chambering of a cartridge. The plug must be of at least 2/3 length of the chamber as marked. Use continuous circular run of weld or continuous line of weld along one side of barrel slot.
- (d) Remove or shorten striker.
- (e) Mark barrel, bolt and receiver (near serial number if possible).

**Specific**

- (1) Pin and weld barrel to action. Where action is made of alloy, weld the steel pin to the top of the inside of the chamber; this can also retain the magazine tube.
- (2) Permanently seal firing pin aperture with weld.
- (3) Cut bolt face more than 1/2 diameter.
- (4) Remove any gas piston assemblies.
- (5) Remove magazine tube spring and follower, crimp tube.
- (6) Weld or drive pin through magazine tube to action.



SPECIFICATIONS FOR THE ADAPTATION OF SHOTGUN MAGAZINES AND  
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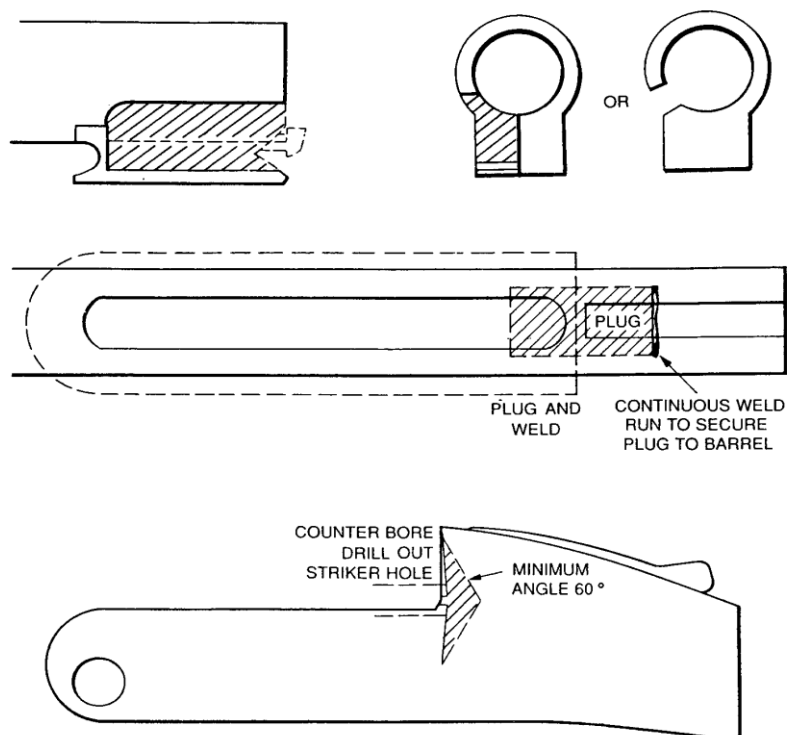
**Type SINGLE BARRELLED SHOTGUN (BREAK ACTION)**

**General**

- (a) Ensure essential components are unsuitable for use in any other firearm.
- (b) Remove or shorten firing pin.
- (c) Mark barrel and action (near serial number if possible).

**Specific**

- (1) Slot into chamber, leaving the forend retaining fixture as necessary.
- (2) Slot through barrel covered by forend.
- (3) Weld tight plug in chamber and cone to prevent the chambering of a cartridge. The plug must be of at least  $2/3$  length of the chamber as marked. Weld in place with continuous circular run of weld or with continuous line of weld along one side of barrel slot.
- (4) Counterbore breech face to remove cartridge head support.
- (5) Drill through striker hole to remove striker guide holes.
- (6) Permanently seal firing pin aperture with weld.



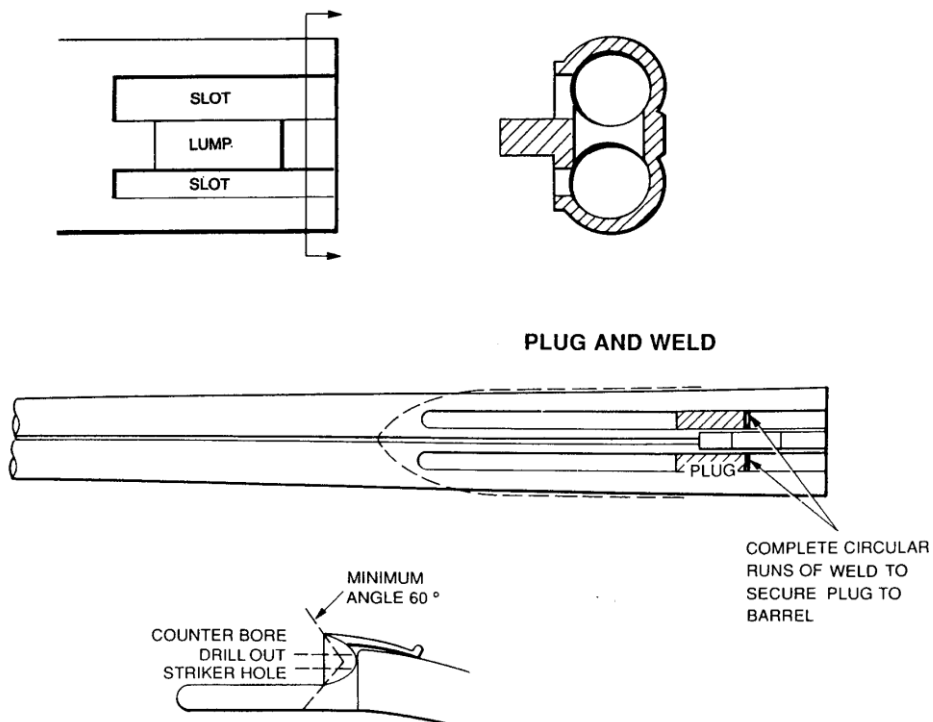
**Type SIDE BY SIDE DOUBLE BARRELLED SHOTGUN**

**General**

- (a) Ensure essential components are unsuitable for use in any other firearm.
- (b) Remove or shorten strikers.
- (c) Mark barrel and action (near serial number if possible).

**Specific**

- (1) Slot through barrel flats.
- (2) Slot through barrels covered by forend, leaving forend securing fixture in place as required.
- (3) Weld tight plugs in chambers and cones to prevent the chambering of cartridges. The plug must be of at least 2/3 length of the chamber as marked. Secure with continuous circular runs of weld, or continuous line of weld along one side of barrel slots.
- (4) Counterbore breech face to remove cartridge head support.
- (5) Drill through striker holes to remove striker guide holes.
- (6) Permanently seal firing pin aperture with weld.



SPECIFICATIONS FOR THE ADAPTATION OF SHOTGUN MAGAZINES AND  
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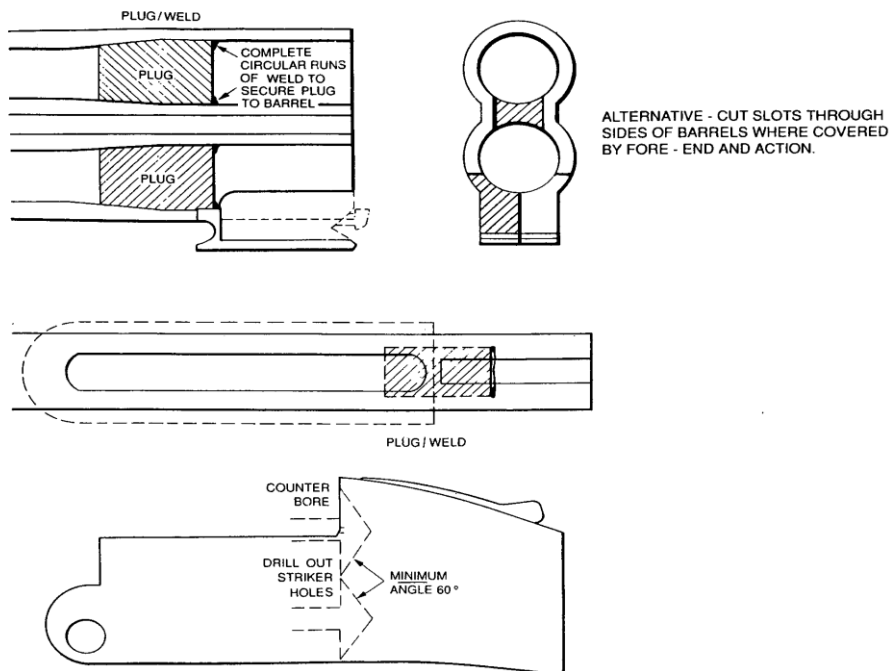
**Type OVER & UNDER SHOTGUN**

**General**

- (a) Ensure essential components are unsuitable for use in any other firearm.
- (b) Remove or shorten strikers.
- (c) Mark barrel and action (near serial number if possible).

**Specific**

- (1) Cut away most of bottom barrel chamber, leaving forend securing fixture in place as required.
- (2) Remove material between chambers (full length).
- (3) Weld tight plugs in chambers and cones to prevent the chambering of cartridges. The plug must be of at least 2/3 length of the chamber as marked. Secure with continuous circular run of weld or continuous line of weld along one side of the barrel slots.
- (4) Counterbore breech face to remove cartridge head support.
- (5) Drill through striker holes to remove striker guide holes.
- (6) Permanently seal firing pin aperture with weld.



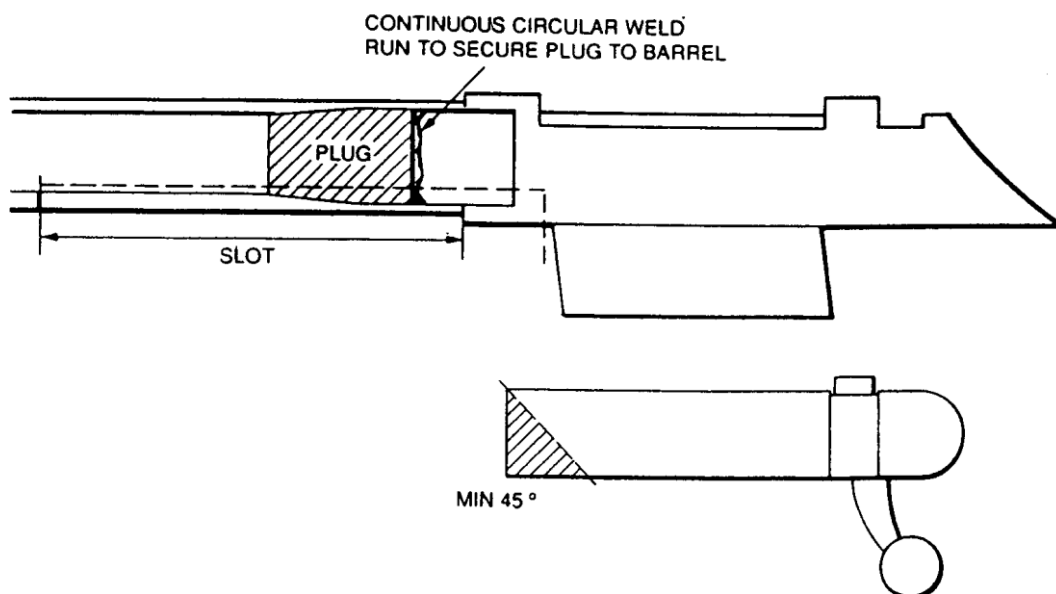
**Type BOLT ACTION SHOTGUN**

**General**

- (a) Ensure essential components are unsuitable for use in any other firearm.
- (b) Remove or shorten strikers.
- (c) Mark barrel and action (near serial number if possible).

**Specific**

- (1) Cut slot in under side of action, chamber and barrel covered by forend retaining fore-end securing fixture as required.
- (2) Weld tight plug in chamber and cone to prevent the chambering of cartridges. The plug must be of at least  $2/3$  length of the chamber as marked. Secure with continuous circular run of weld or continuous line of weld along one side of barrel slot.
- (3) Cut bolt face with chamfer across entire recoil face.
- (4) Permanently seal firing pin aperture with weld.
- (5) Remove platform and spring from box magazine, or weld or bond magazine body to action.
- (6) Pin and weld barrel to receiver through chamber.



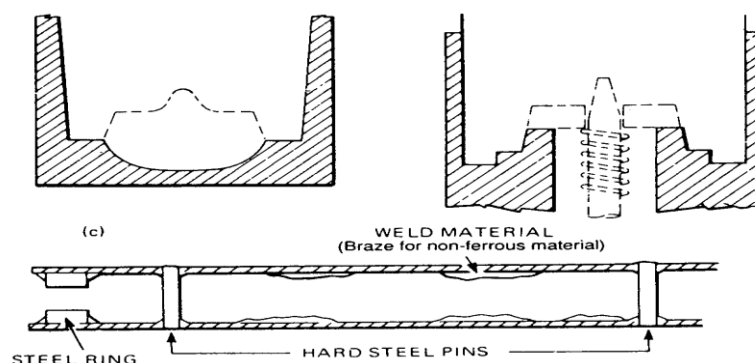
**Type MORTAR, ROCKET LAUNCHING TUBE AND SMOKE DISCHARGER**

**General**

- (a) Ensure essential components are unsuitable for use in any other firearm.
- (b) Weld breech block (if appropriate) to main tube.
- (c) Cross pin the main tube. Weld the hard steel pins in place. Pins to be 10mm minimum diameter. In plastic tubes, use threaded pins to help, securing in place with resin. Pass threaded pins through tight fitting tube across inside of bore. Where tube is made of alloy, continuous circular crimps, similar to tubular shotgun magazines, may be used or use hard steel pins bonded inside plastic sleeves across bore.
- (d) Weld a large steel ring in place close to the breech. (Use alternative bonding processes as indicated at (e), where this is appropriate).
- (e) Add weld material to various places along interior of the tube. In the case of small diameter tubes, holes can be drilled through sides to allow insertion of weld material (In the case of fibre glass, carbon fibre or thin-walled light alloy tubes, tightly fitting tubes can be bonded in place using epoxy adhesive material).
- (f) Mark barrel (near serial number if possible).

**Specific**

- (1) In the case of a fixed firing pin mortar - machine away pin and part of breech.
- (2) In the case of a spring loaded striker - remove firing pin and mechanism, and machine away part of firing pin housing.
- (3) In the case of a rocket launcher, remove any electrical or mechanical firing devices. Weld or bond covers back in place.



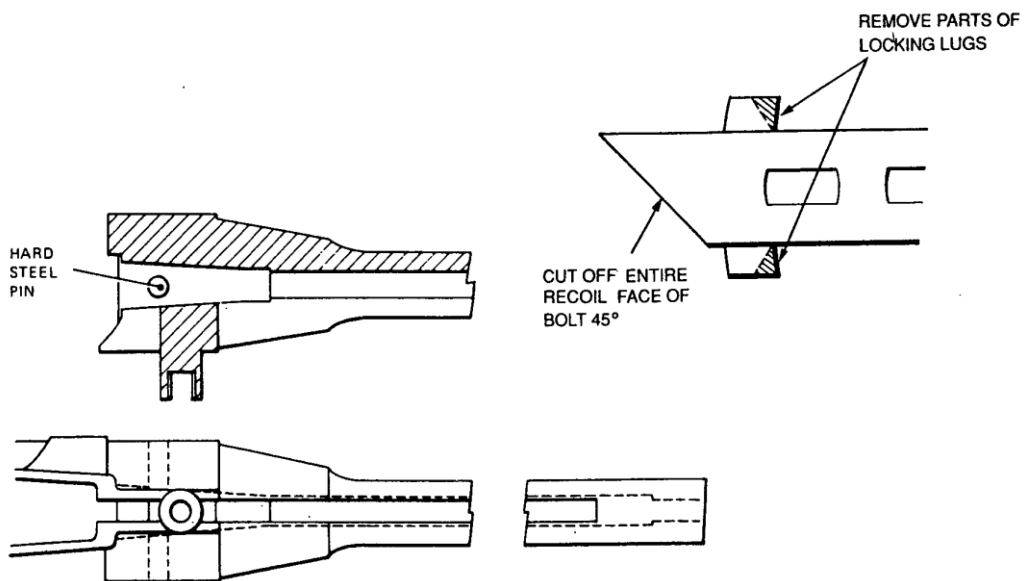
**Type BOLT-ACTION RIFLE - ONE PIECE BOLT  
(ALSO PUMP ACTION AND UNDER LEVER ACTION RIFLE)**

**General**

- (a) Ensure essential components are unsuitable for use in any other firearm.
- (b) Slot through chamber wall and receiver at feed ramp into barrel, and slot full length of covered section.
- (c) Securely weld tight steel rod minimum 1/2 barrel length.
- (d) Remove substantial part of breech face.
- (e) Remove or shorten firing pin.
- (f) Mark barrel, bolt and receiver (near serial number if possible).

**Specific**

- (1) Pin barrel to receiver, pin to pass through chamber, weld in place.
- (2) Bolt face, cut with chamfer across entire recoil face at an angle of at least 45 degrees.
- (3) Permanently seal firing pin aperture with weld.
- (4) Remove part of locking lugs to significantly reduce strength and support.





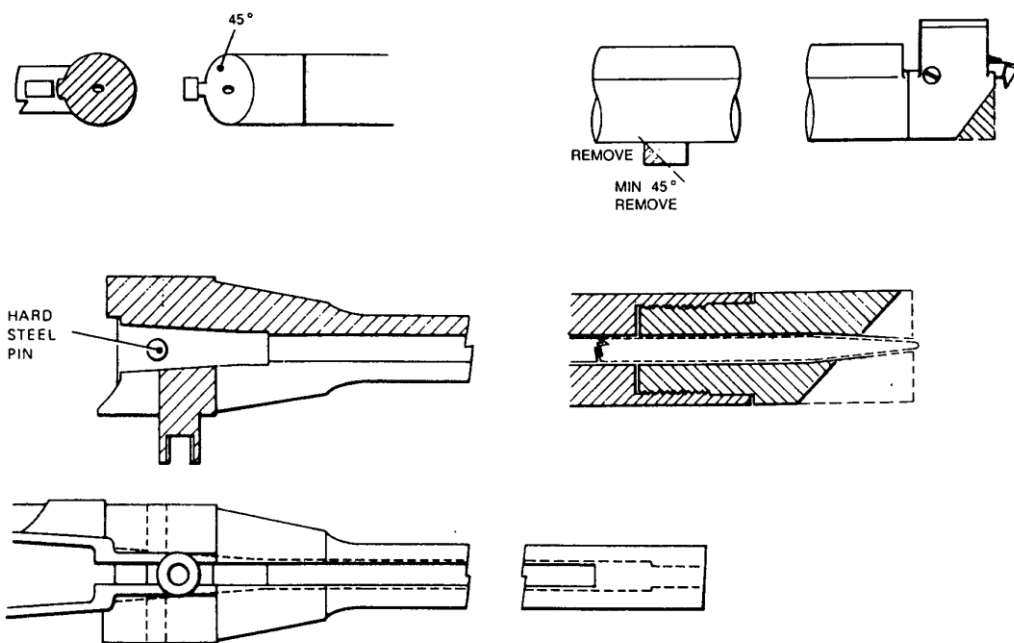
**Type BOLT ACTION RIFLE - SEPARATE BOLT HEAD**

**General**

- (a) Ensure essential components are unsuitable for use in any other firearm.
- (b) Slot through chamber wall and receiver at feed ramp into barrel, and slot full length of covered section.
- (c) Securely weld tight steel rod minimum 1/2 barrel length.
- (d) Remove substantial part of breech face.
- (e) Remove or shorten firing pin.
- (f) Mark barrel, bolt and receiver (near serial number if possible).

**Specific**

- (1) Pin and weld barrel to receiver through chamber.
- (2) Bolt face, cut with chamfer across entire recoil face at an angle of at least 45 degrees.
- (3) Permanently seal firing pin aperture with weld.
- (4) Mark separate bolt head.
- (5) Remove part of locking lugs to significantly reduce strength and support.



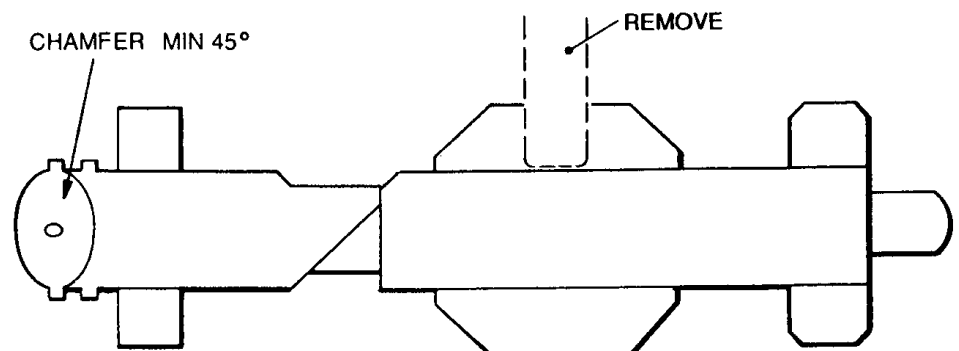
**Type MACHINE GUN (MG34 TYPE AND DESIGN VARIANTS)**

**General**

- (a) Ensure essential components are unsuitable for use in any other firearm.
- (b) Slot through chamber wall and feed ramp into barrel, and slot full length of covered section. Drive pin through chamber, and weld in place.
- (c) Securely weld tight steel rod minimum 1/2 barrel length.
- (d) Remove substantial part of breech face.
- (e) Remove or shorten firing pin.
- (f) Mark barrel, bolt and receiver (near serial number if possible).

**Specific**

- (1) Remove bolt, carrier and spring, and replace with tube welded in place. Alternatively, cut away bolt face with chamfer across entire recoil face, weaken bolt carrier.
- (2) Permanently seal firing pin aperture with weld.
- (3) Remove any gas piston(s) and destroy fixing point by welding or cutting.
- (4) Slot through frame weakening the locking shoulders.
- (5) Weld barrel-locking pin to prevent barrel removal. Pin and weld barrel to receiver through chamber.



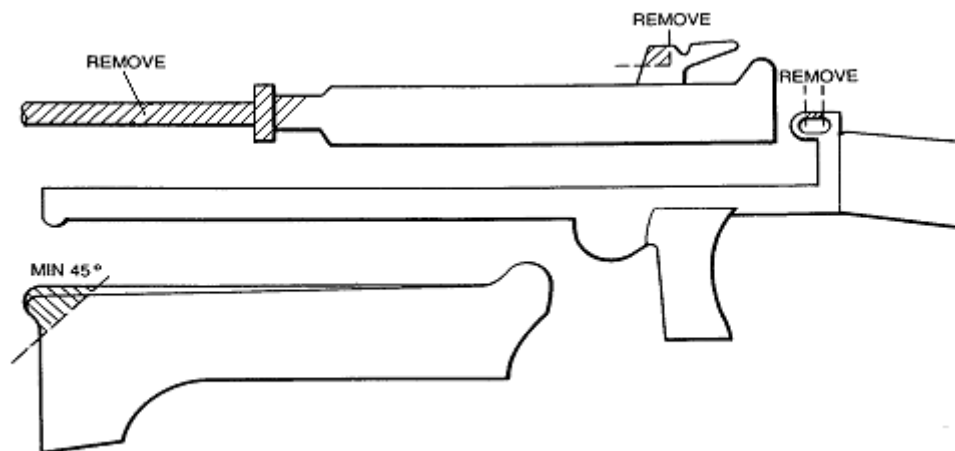
**Type MACHINE GUN (BREN TYPE AND DESIGN VARIANTS)**

**General**

- (a) Ensure essential components are unsuitable for use in any other firearm.
- (b) Slot through chamber wall and feed ramp into barrel, and slot full length of covered section. Drive pin through chamber, and weld in place.
- (c) Securely weld tight steel rod minimum 1/2 barrel length.
- (d) Remove substantial part of breech face.
- (e) Remove or shorten firing pin.
- (f) Mark barrel, bolt and receiver (near serial number if possible).

**Specific**

- (1) Remove bolt, carrier and, spring, and replace with tube welded in place. Alternatively cut away bolt face with 45° chamfer across entire recoil face, weaken bolt carrier.
- (2) Permanently seal firing pin aperture with weld.
- (3) Remove any gas piston and destroy fixing point by welding or cutting.
- (4) Pin and weld barrel to receiver through chamber.
- (5) Weaken frame by removal of the locking shoulders and support.



**Type MACHINE GUN – AS LISTED BELOW**

**General**

- (a) Ensure essential components are unsuitable for use in any other firearm.
- (b) Slot through chamber wall and feed ramp into barrel, and slot full length of covered section. Drive pin through chamber, and weld in place.
- (c) Securely weld tight steel rod minimum 1/2 barrel length.
- (d) Remove substantial part of breech face.
- (e) Remove or shorten firing pin.
- (f) Mark barrel, bolt and receiver (near serial number if possible).

**Specific**

- (1) Remove bolt, carrier and, spring, and replace with tube welded in place. Alternatively cut away bolt face with 45° chamfer across entire recoil face, weaken bolt carrier.
- (2) Permanently seal firing pin aperture with weld.
- (3) Remove any gas piston(s) and destroy fixing point by welding or cutting.
- (4) Pin and weld barrel to receiver through chamber.
- (5) Weaken frame by removal of any locking shoulders and support.

**Machine Guns accepted as this type and class**

FN Minimi – M249 (SAW) and design variants  
General Purpose Machine Gun (GPMG) – FN MAG, L7, M240 and design variants  
Vickers Medium Machine Gun – including Maxim  
Lewis Light Machine Gun  
RPD Light Machine Gun – RPD, RPDM, Type 56-1 and design variants  
DP Light Machine Gun – DPM, DP-28 and design variants  
Browning Machine Gun - .30/.50 and design variants. Does not include BAR.  
PK Light Machine Gun – PK/PKM and design variants  
DShK Heavy Machine Gun

Additions and alterations to the list may be made from time to time in order to ensure that the specifications are properly maintained.

**DEACTIVATION TYPE 5(A)**

**Type AK47/AKM/P.56/AK74/VALMET AND DESIGN VARIANTS**

**General**

- (a) Ensure essential components are unsuitable for use in any other firearm.
- (b) Slot through feed ramp along chamber and for length of covered area of barrel. Drive pin through receiver across chamber and weld in place.
- (c) Securely weld tight steel rod minimum 1/2 barrel length.
- (d) Mark barrel and receiver (near serial number if possible).

**Specific**

- (1) Either, remove bolt-carrier, bolt and gas piston and destroy with a cutting torch, submitting remains to the Proof House for retention at the same time as the deactivated firearm is submitted, replacing with formed thin sheet of metal welded in place and using bolt-carrier handle as necessary to simulate presence of bolt-carrier OR by using a maximum of 50% of the bolt/bolt carrier, securely weld into place using substantial or continuous runs of weld in order to maintain external appearances.
- (2) Fill bolt-carrier rail slot with weld. Continue weld run through hammer, sears and selector switch fusing all of these items to wall and floor of receiver.
- (3) Refit mainspring with rear catch fitted to its detent. Replace top cover in the normal way, which is by using spring catch, to allow Proof House inspection of internal work.
- (4) Weld breech end of barrel securely to receiver and continue weld run to fill bolt-locking recess.

**DEACTIVATION TYPE 5(A)**

**Type** ARMALITE AR18/180 & ANY SIMILAR RIFLE AND DESIGN VARIANTS

**General**

- (a) Ensure essential components are unsuitable for use in any other firearm.
- (b) Slot through chamber wall and receiver into barrel, and slot full length of covered section.
- (c) Securely weld tight steel rod minimum 1/2 barrel length. Pin and weld barrel to upper receiver through chamber.
- (d) Mark barrel and receiver (near serial number if possible).

**Specific**

- (1) Cut off gas take-off fitting under plastic fore-end covering. Remove piston rod with fitting. Destroy these components with cutting torch. Submit remains of these, together with deactivated firearm, to the Proof House for inspection and, in the case of the remains of the destroyed components, retention.
- (2) Run weld across piston tappet in upper receiver and into both of the spring guide holes. Run weld into bolt-locking lug recesses next to breech-end of barrel, thus securing barrel to upper receiver. Pin through barrel chamber and receiver, and weld in place.
- (3) Either, remove and destroy bolt and bolt carrier with a cutting torch, submitting remains to the Proof House for retention at the same time as the deactivated firearm is submitted, replacing with thin sheet of metal incorporating bolt retracting handle welded to upper receiver to simulate presence of bolt-carrier. Weld run along sides of this plate to deactivate upper receiver running weld into and along the length of the bolt guide channel OR by using a maximum of 50% of the bolt/bolt carrier, securely weld into place using substantial or continuous runs of weld in order to maintain external appearances. Rear locking latch for upper/lower receivers should operate normally to allow Proof House inspection of the welds.
- (4) Weld flash eliminator to barrel.

**DEACTIVATION TYPE 5(A)**

**Type ANY DESIGN INCORPORATING ROLLER DELAY LOCKING  
MECHANISMS SUCH AS HK MP5/33/91/93, CETME, ETC**

**General**

- (a) Ensure essential components are unsuitable for use in any other firearm.
- (b) Slot through chamber wall and receiver into barrel, and slot full length of covered section.
- (c) Securely weld tight steel rod minimum 1/2 barrel length. Pin and weld barrel to receiver through chamber.
- (d) Mark barrel and receiver (near serial number if possible).

**Specific**

- (1) Weld securely underside of de-activated barrel to receiver along each side, as far as is possible and at front and rear, filling roller-bearing lock recesses.
- (2) Either, remove the bolt-carrier, roller-locking assembly, spring and strut and destroy them with a cutting torch, submitting the remains to the Proof House for retention at the same time as the deactivated firearm is submitted, replacing with thin plate or hollow tubing to simulate presence of bolt in ejector port OR by using a maximum of 50% of the bolt/bolt carrier, securely weld into place using substantial or continuous runs of weld in order to maintain external appearances. This operation should still allow Proof House visual inspection through the magazine well.
- (3) Remove metal trigger grouping from plastic pistol grip. Weld hammer, sears, spring and spring strut together. Refit in plastic housing with selector switch. Arc weld selector switch spindle to weld build-up from previous operation.
- (4) Weld flash eliminator or muzzle attachment to barrel.

**DEACTIVATION TYPE 5(A)**

**Type SUB-MACHINE GUN (THOMPSON TYPE)**

**General**

- (a) Ensure essential components are unsuitable for use in any other firearm.
- (b) Slot through chamber wall and feed ramp into barrel, and slot full length of covered section.
- (c) Securely weld tight steel rod minimum 1/2 barrel length. Pin and weld barrel to receiver.
- (d) Mark barrel and receiver (near serial number if possible).

**Specific**

- (1) Either, remove bolt and spring and destroy them using cutting torch, submitting remains of these to the Proof House for retention at the same time as the deactivated firearm is submitted, replacing with half section of piece of hollow tubing welded along both sides and at rear end in place to simulate presence of bolt OR by using a maximum of 50% of the bolt, securely weld into place using substantial or continuous runs of weld in order to maintain external appearances.
- (2) Pin barrel to receiver through chamber. Weld in place and use ring of weld to secure rigidly barrel to receiver at breech end.
- (3) Weld "H" piece fusing it to its housing. Weld in place activator knob block to receiver along both sides and its end to rigidly secure it in place in the closed position.
- (4) Move trigger back to depress sear; then weld sear assembly in place, fusing it to trigger linkage. Refit lower receiver to allow removal for Proof House inspection of weld.



**DEACTIVATION TYPE 5(A)**

**Type** STERLING SUB-MACHINE GUN, CARBINE PISTOL  
AND ANY DESIGN VARIANT

**General**

- (a) Ensure essential components are unsuitable for use in any other firearm.
- (b) Slot through chamber wall. Slot full length of covered section of barrel. Pin barrel to body through chamber. Weld in place.
- (c) Securely weld tight steel rod minimum 1/2 barrel length. Pin and weld barrel to receiver.
- (d) Mark barrel and receiver (near serial number if possible).

**Specific**

- (1) Weld deactivated barrel securely to body with ring of weld at breech end. Grind off ends of Allen screw heads at muzzle and weld cap to end of body.
- (2) Either, remove bolt with spring and guide and destroy them with cutting torch, submitting remains of these to the Proof House for retention at the same time as the deactivated firearm is submitted, replacing with piece of hollow tubing with circular weld run at rear of body to simulate presence of bolt when viewed through ejection port. Bolt retracting handle may be attached to tubing. Cut away side of tube next to magazine opening so as to allow Proof House inspection of welds OR by using a maximum of 50% of the bolt, securely weld into place using substantial or continuous runs of weld in order to maintain external appearances. Replace end closure cap normally so as to allow Proof House inspection of welds.
- (3) Remove trigger-group from pistol grip. Cut through sear with torch and fuse components together. Group must be removable to allow Proof House inspection.

**DEACTIVATION TYPE 5(A)**

**Type CZ 23/25 SUB-MACHINE GUN & S/A CARBINE COPIES  
(LDP & KOMMANDO)**

**General**

- (a) Ensure essential components are unsuitable for use in any other firearm.
- (b) Slot through barrel along full covered length. Pin barrel to body and weld in place.
- (c) Securely weld tightly fitting steel rod minimum 1/2 barrel length.
- (d) Mark barrel and receiver (near serial number if possible).

**Specific**

- (1) Deactivate bulk of barrel as at (c) above. Cut off 4"/100 mm long section at breech end. Destroy cut-off portion with cutting torch and submit the remains to the Proof House, together with deactivated firearm, for inspection and, in the case of the remains of the destroyed component, retention.
- (2) Cut off part of threaded section of barrel retaining ring. Screw remainder in place and weld to body at edges.
- (3) Either, remove bolt and springs and destroy them with a cutting torch, submitting remains of these to the Proof House for retention at the same time as the deactivated firearm is submitted, replacing these components with hollow tubing welded inside body to simulate presence of bolt. Bolt retracting knob can be welded to tubing as required OR by using a maximum of 50% of the bolt, securely weld into place using substantial or continual runs of weld in order to maintain external appearances. Refit end-cap to body so as to allow removal during Proof House examination of interior.
- (4) Weld sear to body, at same time cutting through operating surface of sear. Fuse solidly to body with other components.

**DEACTIVATION TYPE 5(A)**

**Type** UZI SUB-MACHINE GUN, CARBINE, MINI, MICRO and PISTOL

**General**

- (a) Ensure essential components are unsuitable for use in any other firearm.
- (b) Slot through chamber wall and along full covered length of barrel. Pin barrel to body through chamber and weld in place.
- (c) Securely weld tight steel rod minimum 1/2 barrel length.
- (d) Mark barrel and receiver (near serial number if possible).

**Specific**

- (1) Barrel slot must be in upper surface to allow Proof House inspection. Weld deactivated barrel securely to body with continuous weld runs along both sides of barrel to its floor, sides and across feed ramp.
- (2) Run weld across ejector onto floor of body.
- (3) Either, remove bolt and springs and destroy them with a cutting torch, submitting remains of these to the Proof House for retention at the same time as the deactivated firearm is submitted, replacing with thin piece of steel plate securely welded to inside of body to simulate presence of bolt when viewed through ejector port OR by using a maximum of 50% of the bolt, securely weld into place using substantial or continuous runs of weld in order to maintain external appearances. Run weld across floor and sides of inside of body at rear. Re-fit top cover in unaltered condition to allow Proof House inspection of welds.
- (4) Remove grip assembly. Run weld to fuse together sears and selector switch to floor of grip assembly. Re-fit normally with cross pin so as to allow Proof House inspection.

**DEACTIVATION TYPE 5(A)**

**Type COLT AR-15, M-16, RIFLES, AND ANY DESIGN VARIANT**

**General**

- (a) Ensure essential components are unsuitable for use in any other firearm.
- (b) Slot through chamber wall and receiver into barrel, or slot full length of covered section.
- (c) Securely weld tight steel rod minimum 1/2 barrel length.
- (d) Mark barrel and receiver (near serial number if possible).

**Specific**

- (1) Either, remove bolt carrier, bolt and gas feed tube, and destroy them with a cutting torch, submitting remains of these to the Proof House for retention at the same time as the deactivated firearm is submitted, replacing with thin plate or hollow tubing to simulate presence of bolt in ejector port OR by using a maximum of 50% of the bolt/bolt carrier, securely weld into place using substantial or continuous runs of weld in order to maintain external appearances.
- (2) Use inert gas welding technique to weld bolt guide section of bolt retracting fixture to upper receiver. Use continuous weld runs along both sides of guide and run weld into gas feed tube hole.
- (3) Pin and weld barrel to upper receiver, driving pin through chamber. Use ring of weld to secure barrel to bolt-locking recesses.
- (4) Without the hammer cocked, run weld across bolt stop catch, hammer, sears and selector switch to fuse items together.
- (5) Remove bolt-carrier return spring and cap from stock housing, run weld across spring follower stop of lower receiver and into spring housing tube.
- (6) Weld flash eliminator or muzzle attachment to barrel.

**DEACTIVATION TYPE 5(A)**

**Type SMG - OPEN ACTION (STEN TYPE AND DESIGN VARIANTS)**

**General**

- (a) Ensure essential components are unsuitable for use in any other firearm.
- (b) Slot through chamber wall and freed ramp into barrel, and slot full length of covered section.
- (c) Securely weld tight steel rod minimum 1/2 barrel length. Weld barrel to body.
- (d) Mark barrel and body (near serial number if possible).

**Specific**

- (1) Either, remove bolt and destroy with cutting torch, submitting the remains of this item to the Proof House for retention at the same time as the deactivated weapon is submitted, replacing with thin hollow tubing welded to body to simulate bolt presence as viewed through ejector port. Cut away side of tube next to magazine housing opening so as to allow Proof House internal inspection. Use bolt retracting knob as required to enhance appearance. Use circular run of weld to secure tube to body at rear end and also along underside after removal of trigger assembly cover OR by using a maximum of 50% of the bolt, securely weld into place using substantial or continuous runs of weld in order to maintain external appearances.
- (2) Weld sear, spring and selector switch together. Fused mass must be welded to body of weapon. Refit trigger assembly cover in normal manner to allow Proof House inspection.
- (3) Weld barrel securely to body with circular run of weld at front and rear. Pin and weld barrel to body through chamber.
- (4) Refit stock using part of mainspring plunger to fill hole. Fixture of stock to body should allow Proof House removal for inspection of welds.

**DEACTIVATION TYPE 5(A)**

**Type** AUTOMATIC SELF LOADING RIFLE  
(FN, FAL, SLR TYPE AND DESIGN VARIANTS)

**General**

- (a) Ensure essential components are unsuitable for use in any other firearm.
- (b) Slot through chamber wall and feed ramp into barrel, and slot full length of covered section.
- (c) Securely weld tight steel rod minimum 1/2 barrel length. Weld and pin barrel to receiver.
- (d) Mark barrel and receiver, (near serial number if possible).

**Specific**

- (1) Either, remove bolt, bolt carrier and spring and destroy with a cutting torch, submitting remains of these to the Proof House for inspection and retention at the same time as the deactivated firearm is submitted, replacing with thin piece of plate welded to receiver upper cover to simulate presence of bolt OR by using a maximum of 50% of the bolt/bolt carrier, securely weld into place using substantial or continuous runs of weld in order to maintain external appearances. The cover along with the rear locking latch must be left so as to be removable in order to allow Proof House inspection.
- (2) Weld barrel at breech end rigidly to receiver with circular run of weld. Continue weld run along the extent of both sides of the bolt carrier rails and down across ejector. Incorporate pin through chamber and receiver; and weld in place.
- (3) Weld together to form fused mass, the hammer, sears and selector bar with spring and strut. Weld these securely to lower receiver.
- (4) Weld edges of mainspring cap at rear of lower receiver in place.
- (5) Cut off gas push rod housing with rod so as to remove section normally covered by forend.
- (6) Weld flash eliminator or muzzle attachment to barrel.

**Type** ARTILLERY PIECES

**General**

- (a) Ensure essential components are unsuitable for use in any other firearm.
- (b) Plug chamber with minimum 2 inches (50.8mm) thickness solid steel plug. Plug should be positioned as near to breech as individual piece will allow. Ring weld plug using continuous and substantial run of weld to 95% of circumference.  
A water drainage hole at the 6 o'clock position is acceptable.
- (c) Cut a slot into the breech end of the barrel of at least 1 inch (25.4mm) wide and 2 inches (50.8mm) long. This should ideally be done from the exposed barrel face.
- (d) Machine or grind the internal breech face to reduce strength and to prevent a gas seal from forming. A minimum of 4 intersecting cuts of 0.5 inch (12.7mm) width and depth is required.
- (e) Substantially weaken and interrupt obturation rings where fitted, by weld, machining or grinding.
- (f) Remove or shorten striker/firing pin if fitted, along with any mechanical linkage within the breech block that relate to the firing mechanism.
- (g) Weld striker/firing pin aperture on rearward face of breech block.
- (h) Mark barrel, bolt and receiver (near serial number if possible).

As a proposed guide, the above specification should only be used on calibres generally 1.57 inches (40mm) and above where size of the weapon type, e.g. Armoured fighting vehicles, Anti-Aircraft guns, Field guns, makes it impractical to apply the current Home Office specification for a specific/similar weapon type. For weapon types with calibres below 1.57 inches (40mm), e.g. recoilless rifles/automatic cannon, where practical, the current Home Office specification for Machine Guns or Mortars should be adhered to.

Weaponry within this genre on occasions may be difficult to categorize regarding practicalities of work needed for deactivation, therefore, it is difficult to have an established absolute specification. In some cases it may be necessary for Proof Masters to use discretion.