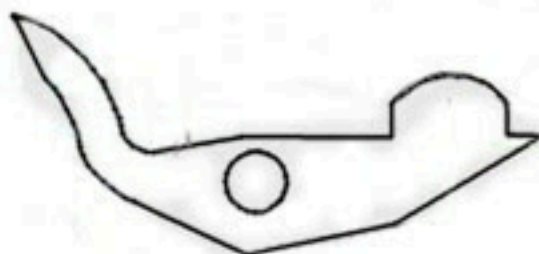


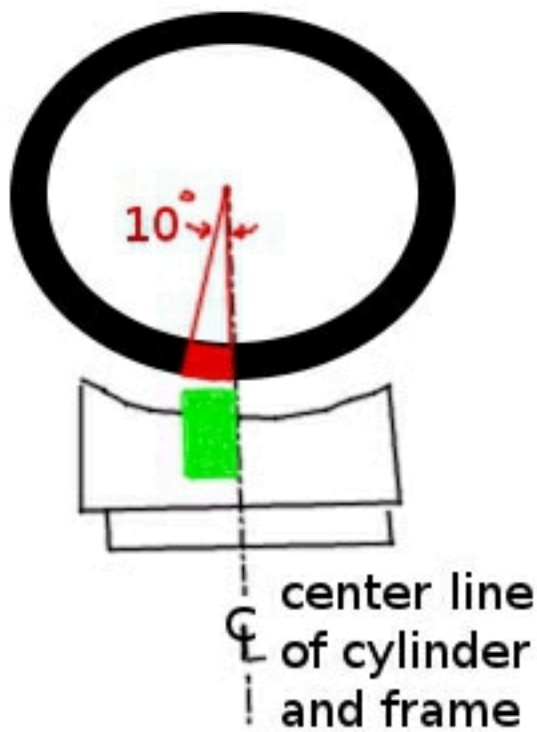
This Is A New Bolt, Before Fitting. Basically A Stamping. The Following Steps To Fit The New Bolt, Are In A Specific Order. When You Adjust One Spot, It Effects The Next. There Is A Method To This Madness, And Here It Is!



AS PAUL HARVEY
WOULD HAVE SAID..

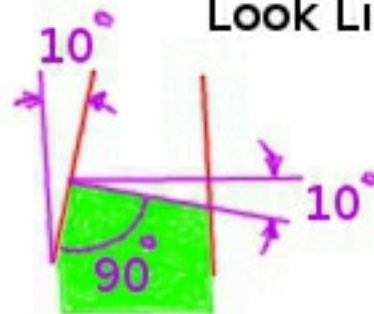
"NOW FOR THE
REST OF THE

STORY!" 1



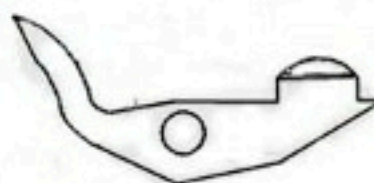
In Our Last Discussion, We Determined That The Bolt Width Was About 10 Degrees. One Side Of The Bolt, is Located On The Center Line Of The Frame, Making The Other Side 10 Degrees Off Center. To Contour The Bolt Face We Need A 10 Degree Shoulder And A 10 Degree Slope To The Face To Fit The Cylinder Stop. So The Bolt Face And Shoulder Need To

Look Like This:

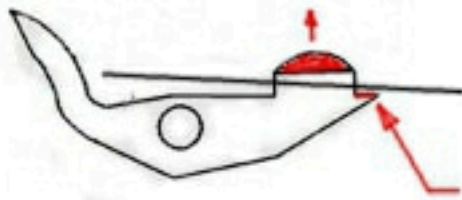


As Viewed From The Front Of The Frame

The Shoulder Is Cut Only The Depth Of The Cylinder Stop. DO NOT REMOVE ANY OTHER MATERIAL FROM THE WIDTH OF THE BOLT OR IT WILL BE LOSE IN THE FRAME. Profile The Face First, Then Cut The Shoulder To Fit The Cylinder Stop. The Shoulder Has To Bear The Load Of The Spinning Cylinder. The Faster The Gun Is Cocked, The More Potential Energy Is Built Up, That The Shoulder Of The Bolt Must Stop. If The Shoulder Is Not Cut To 10 Degrees, The sharp angle will cut into the cylinder stop notch, damaging it. The faster you cock the gun, or even fanning it, will cut into that stop notch sidewall.



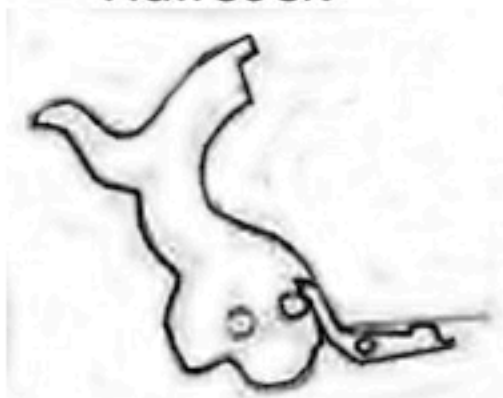
So Now Your New Profiled Bolt Should Look Like This And Should Fit The Cylinder Stop Perfectly. Next We Need To Get It To The Right Depth Into The Cylinder Stop.



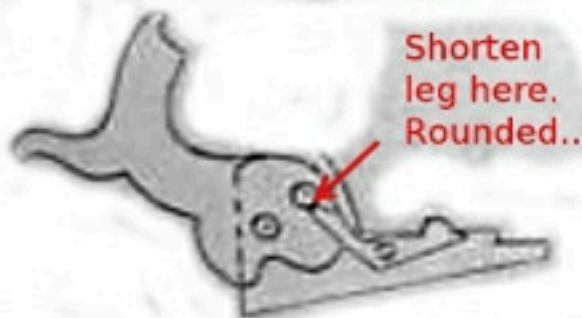
Frame

File Here Until The Bolt Just Touches The Bottom Of The Cylinder Stop. Adjust a little at a time, then push it up with your thumb, and wiggle the Cylinder.. You Will Feel When It Touches.

Leg on cam at Halfcock



5 degrees before Fullcock, Bolt drops Off the cam..



The next step is The TIMING! WHEN IT DROPS, IS WHEN IT POPS! Many People Get Confused, When I Say "When The Bolt Drops" Because it is when the bolt Pops up through the frame. I Say When It Drops, because that's when the bolt leg drops off of the cam on the hammer. We want the timing to be, that the bolt drops at the beginning of the lead in groove. To make it easy, cock the hammer back and watch as the lead in approaches the center of the hammer channel, on top. When It Is Centered, Put A Pencil Mark On The Hammer, Where It Intersects The Frame. Then Take The Parts Out And Reassemble On The Right Side Of The Frame. You Can Aproximate the picture above To Adjust The Leg Length, For The Right Timing.

Hammer Down
Just Clear Of
Nipples



Hammer Face
Flush With Frame

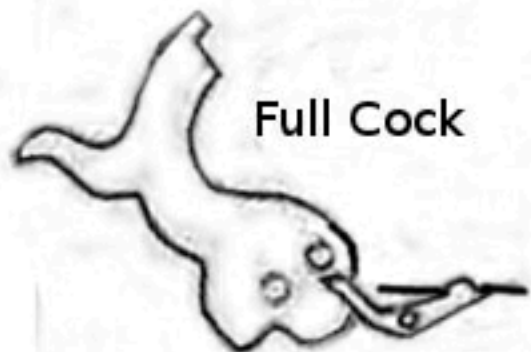


The Last Step, Is The Timing Of The Bolt Reset. It Should Reset On The Hammer Cam Just As The Hammer Face Comes Flush With The Frame. If It Does Not Reset Before Full Hammer Drop, It Will Not Reset When You Have Caps On The Nipples, And The Gun Will Lock Up. To Adjust The Reset, Again Mark The Hammer Where It Intersects The Frame, When The Face Is Flush, Then Assemble The Parts On The Right Side Again, And Fit The Bolt Leg For Reset.

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Half Cock

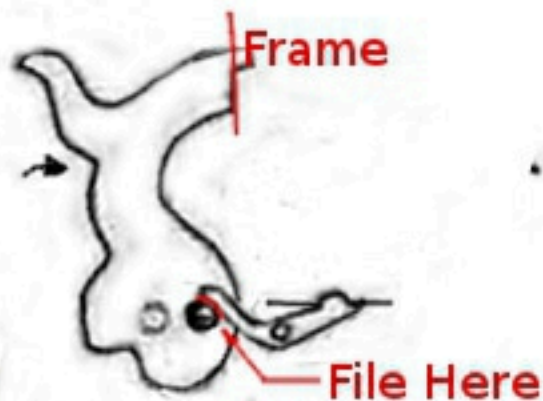


Full Cock



Hammer
Falling

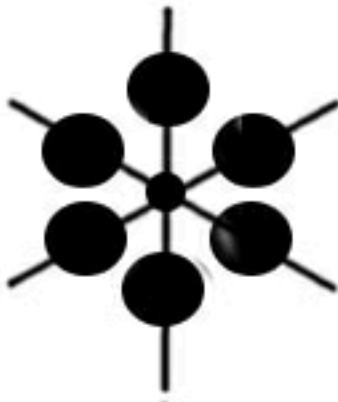
As The Hammer Is Cocked, The Bolt Leg Rides The Cam, At 5 Degrees Before The Cylinder Stop, The Bolt Leg Drops Off The Cam, And The Cylinder Locks. When Fired, The Hammer Falls, And The Bolt Leg Slides Over The Cam. When The Hammer Face Is Flush With The Frame, The Leg Snaps Back Over The Cam, And Resets To Begin Again!



4

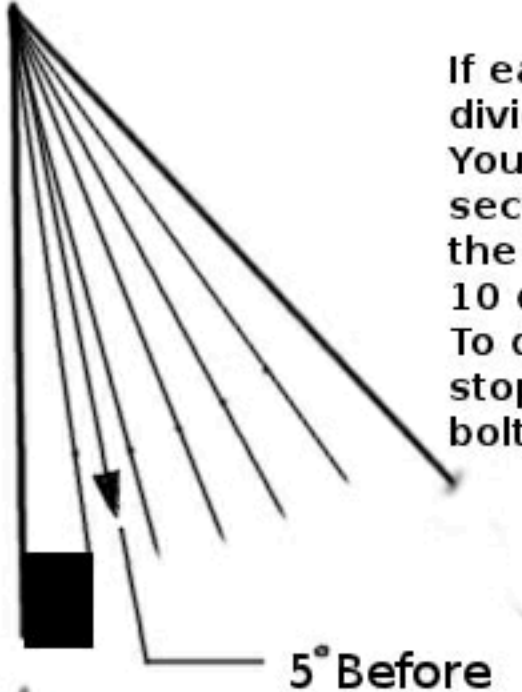
Bolt Should Pop up 5° before the stop

Cylinder
each
Part 1/6



So what does 5 degrees mean?
Let's look at the layout of the
cylinder. It is equally divided by 6.
Each section being 60 degrees.

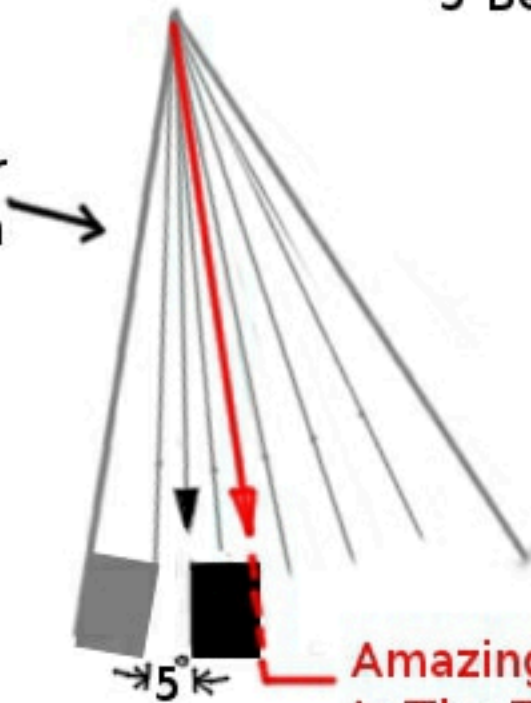
Each
Section
is further
divided
into 1/6.
(Bolt Width)



If each 60 degree section is
divided into 6 equal pieces,
You would get 10 degree
sections. It so happens, that
the width of the bolt, is about
10 degrees. So if the Bolt is
To drop 5 degrees before the
stop, it is half the width of the
bolt. That point is shown Here.

Cylinder
Rotation

Bolt
Drops
Here!

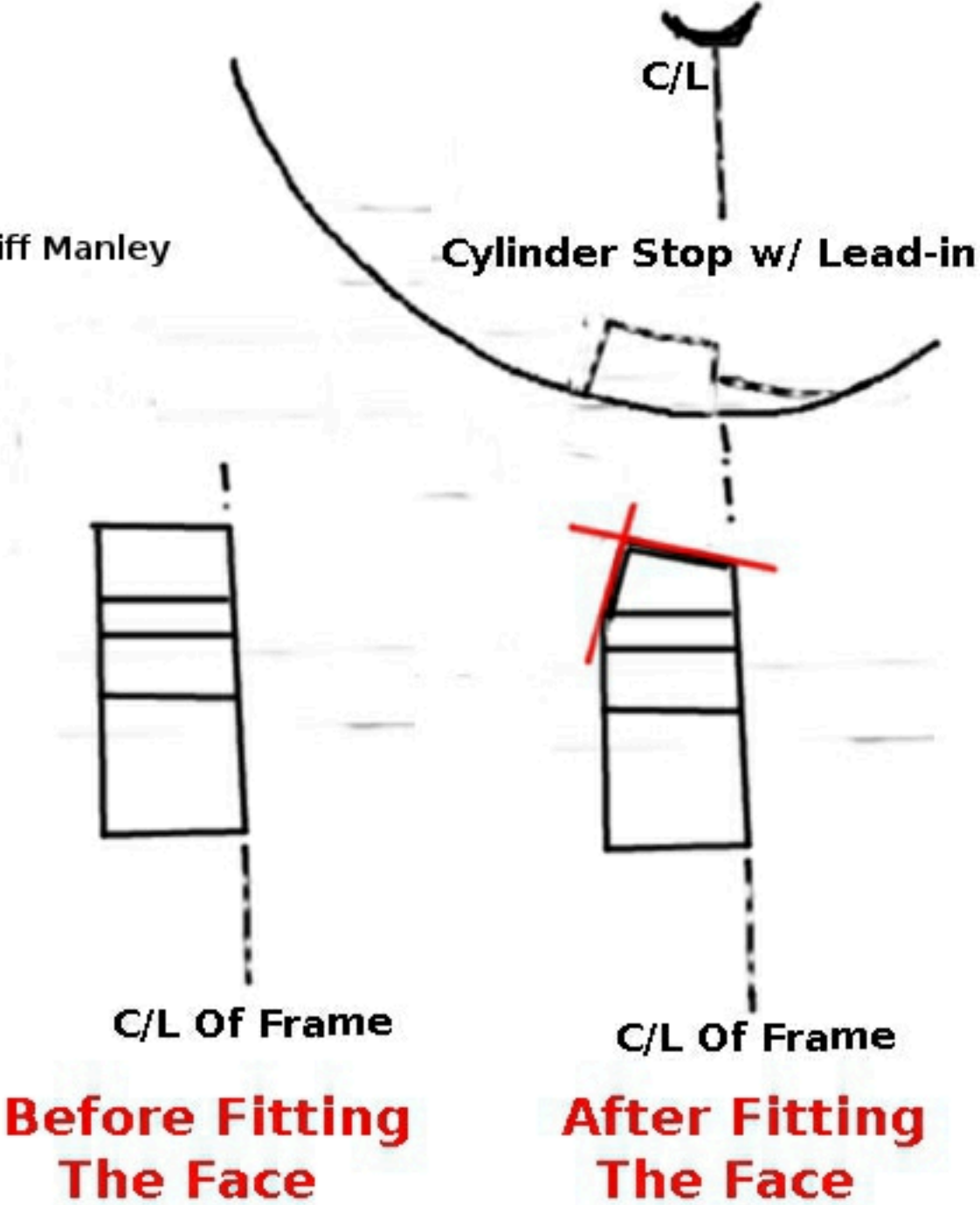


If The advancing Bolt face, Drops
5 degrees before the cylinder stop,
the rear, or following bolt face is
at about 15 degrees, before the
cylinder stop. Width of the bolt,
plus 5 degrees. Amazing at it is,
This point is where Colt decided
to start the lead in channel. Huh..
Pretty Smart, those old guys were!

Amazing As It May Seem, This Point
Is The Top Of The Lead In Channel

Looking At The Bolt From The Front Of The Gun.

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**Before Fitting
The Face**

**After Fitting
The Face**