

Enfield 45acp Conversion Kit



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The Enfield 45 acp Conversion By Rhineland Arms Inc.

The Enfield 45acp is a fun and quite rifle to shoot that retains enough power and accuracy for small game and target shooting. The conversion is rapidly becoming a favorite of all those who shoot it and it is sure to be a favorite at your local gun range.

The conversion is very easy to do with a minimal amount of tools and skills. Here are the steps needed to build an Enfield 45acp.

1. Read all warnings before beginning
 2. Install barrel and headspace.
 3. Test fit the adapter, bolt and receiver. Make any needed changes to receiver.
 4. Install the adapter and ejector.
 5. Test the design for safety and make any needed corrections.
 6. Ready for use.
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Visit www.Rhinelandarms.com for the latest updates to instructions and how to.

Step 1

GUNSMITH SAFETY

Before proceeding read all safety rules and warnings.

1. Do not work on any firearm that does not have a safety, unless a new one is to be installed.
2. Before working on a Mauser, or purchasing one. Make 100% certain that the cocking piece and sear are correct; in serviceable condition and that the parts interact correctly and safely.
3. Always record the changes you have done to the rifle or any parts used on it.
4. Do not attempt to use or work on a rifle that is not in good working order.
5. Remember a firearm is always loaded.
6. Never point a firearm at anything but a target.
7. Always check for yourself to make sure a firearm is unloaded.
8. Always check the barrel for obstructions and bulges.
9. Always wear safety glasses
10. Wear hearing protection when shooting.
11. Always heed all warnings when using chemicals.

Do not allow live ammunition in the work area

Step 2 Installing the barrel

This is very easy to do, just follow the step-by-step procedures.

1. Insert a dummy round into the chamber of the barrel
2. Remove the extractor from the bolt
3. Insert bolt into receiver and close it all the way
4. Screw barrel in all the way until it comes to a stop.
5. Cycle the bolt to make sure the dummy round is seated in bolt face properly and that the bolt will close all the way.
6. Re-check the barrel to make sure it is in tight; now back out 1/8- 1/4 turn.
7. Remove dummy round
8. Insert a NO-GO gauge into the chamber and try to close the bolt.
 - a. If the bolt does not close then the rifle is headspaced, proceed to next step.
 - b. If bolt does close, rifle is not head spaced—See trouble shooting
9. Use the locking ring to secure the barrel, use a small drop of blue LOCK-TIGHT on the threads and use a spanner wrench to finish tightening the locking ring. If the slot ends up where it is visible you can remove the ring and sand the back side of it some, this will cause it to rotate, keep trying this until it ends up on the bottom side of the barrel where it is not seen.
10. you are finished.

WARNING ON BARRELS

1.If you have any question about the headspacing please contact Rhineland Arms or visit a professional gunsmith, this is an easy operation for them.

Definitions

Headspace---The relationship of the cartridge between the bolt face and the inside shoulder of the chamber of the barrel. In other words, the distance between the closed bolt face and the end of the chamber. If it is too short, it will crush the rounds or not allow the bolt too close. If too great then the firing pin may not hit the primer, or the round will not get under the extractor claw and fail to extract. Accuracy will fail also.

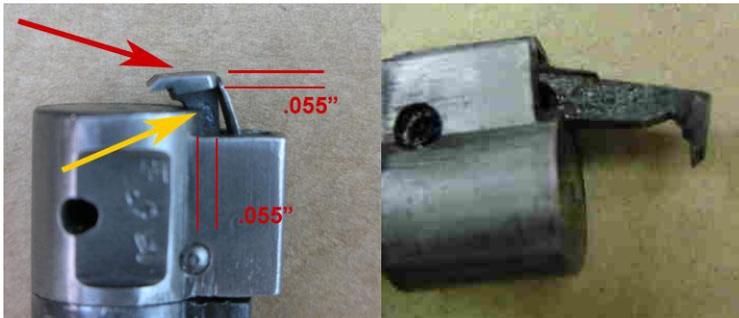
STEP 3 Installation of the Adapter

This is a very easy procedure, just follow the steps below.

1. Test fit the adapter into the magazine well. First remove the new mag catch on the adapter. Now insert the adapter like it is a regular Enfield magazine. It should be a tight fit and the Enfield mag catch should snap in.
2. Test the adapter to make sure it is locked into the rifle by trying to pull it out. It should not want to pull out.
3. Once the adapter is installed mark the areas on the trigger guard that need to be cleaned up with a Dremmel for the new Mag catch to work. Next remove the magazine adapter and using a Dremmel and a little drum sander remove the material from the trigger guard. Now reinstall the magazine catch on the adapter and re-install the adapter into the rifle. Check the new mag catch in the adapter to make sure it freely moves from right to left.
4. If you are having problems with the Enfield mag catch locking into the adapter, try moving the adjustable catch. You can either trial and error it or use caliper.
5. Once the magazine adapter is installed you are ready to move to the next step.

Modify the Extractor

This is very easy to do and a necessity for proper feeding and extraction of the 45acp cartridge. The hardest part is removing and reinstalling the extractor. You can also try the Indian .308 cal extractor, it should not need any modifications. To remove the extractor first remove the screw at the rear of the bolt head. Now push the extractor out from the rear. Now make a beveled cut as shown in the picture and then grind or file the face down so that it will not hit the barrel----- See the Diagram for modifying the unit



Installation of Sights

Scope rail systems. There are a couple types available from different manufactures. We have not tried them at this time.

Sights on the barrel.

Front sight. There are many different types that can be used. However, the original Enfield sights are too small to use. Some options are the M14 sight, M1 carbine and others. We use the Marbles front sight.

To install the sights, use solder. It is very easy to do. Simply mark where you want the sight to go and then heat the barrel, apply some solder to the bare barrels. Now repeat the same procedure to the bottom of the sight. Now reheat them both and stick them together, they should lock tightly. You can use the same method for the rear sight.

Parts Included in the kit



Barrel and locking ring assembly



Adapter: rear mag catch on the left (it is adjustable), main 1911 mag catch on the right.

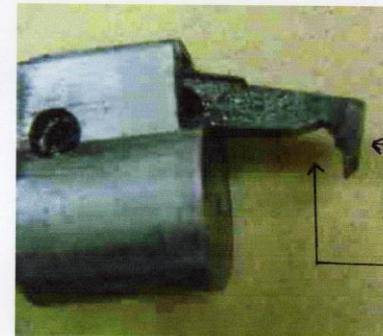
STEP 4 Testing

At this point the rifle should be built up and the action properly install in the stock. Now you want to make sure that the conversion works safely. The first item to test is the feeding and extraction. Insert a dummy round into the magazine and insert magazine into the mag well. Now test to see if the round will feed and extract easily. If it does, then it is time to test the firing pin protrusion. Using a brass case with a live primer only (no bullet or primer) insert it into the chamber and pointing the barrel at a safe target, fire. Now extract the case and inspect the primer. The firing pin should not have penetrated the metal primer and it is safe to proceed. Now re-inspect the bore to make sure it is clean and unobstructed. Using a live round and aiming at a safe target fire the round and again inspect the primer and case for any deformations. If the case and primer appears normal, the rifle is ready for use. If you experience any problems during any of the testing, stop work and contact Rhineland Arms or a professional gunsmith.

Methods of use.

To get reliable feeding you will find that the bolt needs to be pushed rapidly and firmly. To eject the cases, the rifle needs to be rotated so the ejection port is slightly downward. We are working on an improved ejection system.

Supplemental pictures of the ejector and extractor.



Bolt Head

Ejector

Grind face of Extractor so it can get closer to the Barrel.

Remove metal on inside of extractor so it can curl over and grab the .45acp