

"CASH SPECIAL"

AND

"SHORT
CASH SPECIAL"
STUNNERS

MAINTENANCE and REPAIR
MANUAL

REVISED EDITION

LOCKING PLATE (710/30)

When the Locking Plate is not unreasonably loose an improvement can be effected by careful use of a centre punch on the rivet and by "bowing" the top plate to restore as much tension as possible, but after a certain degree of wear and tear it is wiser to fit a new Locking Plate complete, to avoid the old one becoming dislodged and perhaps falling into a drain and causing a blockage.

HANDLE/BARREL BOLT (710/13)

Do not try to remove a tight Handle/Barrel Bolt by hitting with a hammer with possible damage to the screw-threads. Use a brass drift and hammer.

REPLACEMENT OF HAMMER (710/18)

Assemble Hammer to Barrel. See replacement of Firing Block (710/4) for details of interlock fit. If clearance exceeds that given, then wear on Firing Block is excessive. A new one will be required.

FINAL CHECK-OVER AFTER ATTENTION

Before issuing any repaired Stunner always take-down, generally check-over, assemble and test with three shots into a pad of books, then strip, thoroughly clean, oil, finally re-assemble making sure that any wad of test-shooting paper in the pole-axe end has been removed by drilling or other means. When finally fitting the Bolt make sure no dirt or foreign matter adheres to the bolt or gets into the Stunner barrel as it may work up between the Bolt piston and Barrel wall or Bolt stem and muzzlepiece bore and cause extensive "pick-up" or "scoring".

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AND

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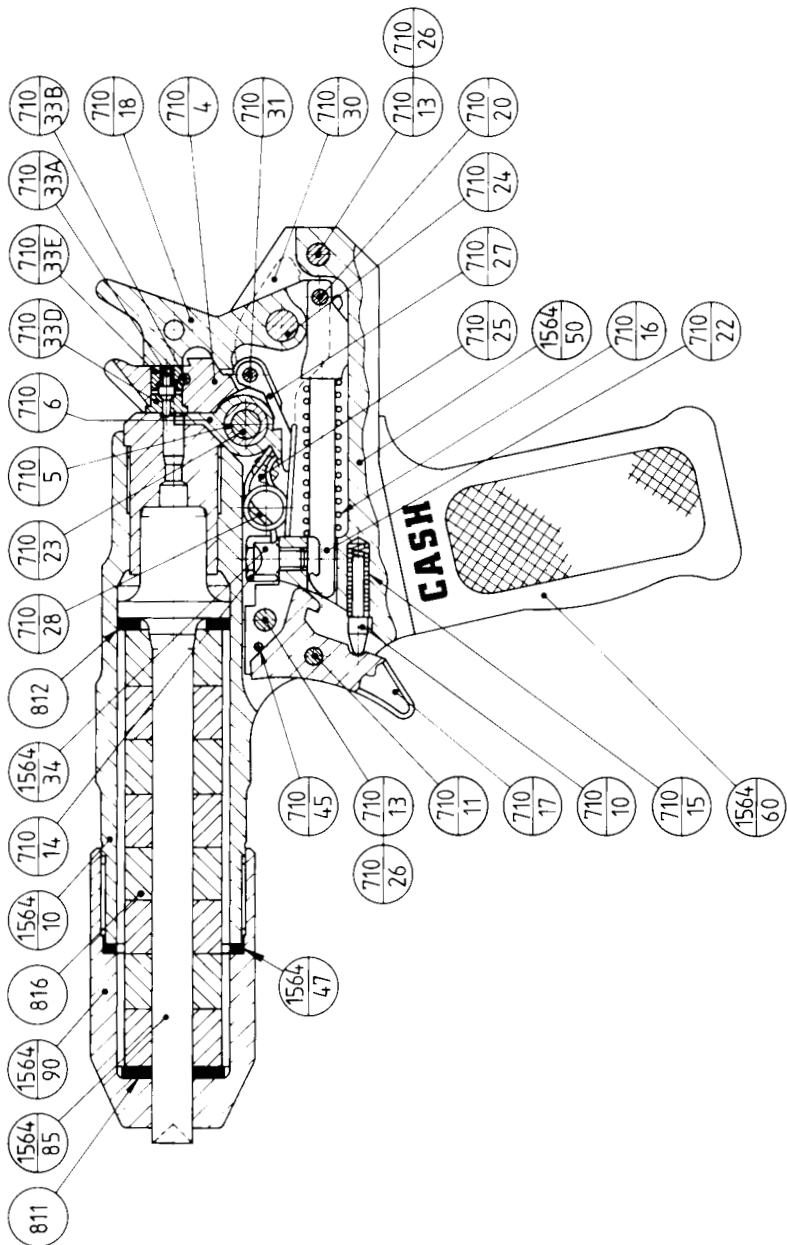
CAPTIVE BOLT STUNNERS

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ONLY "CASH" POWERLOADS BEARING THE "AS" HEADMARK SHOULD BE USED IN THE STUNNER. WHERE POWERLOADS OTHER THAN "CASH" ARE USED THE MANUFACTURERS WILL NOT ACCEPT RESPONSIBILITY FOR:

- 1) THE SAFETY OF THE OPERATOR.
- 2) THE CORRECT OPERATION OF THE STUNNER.
- 3) THE HUMANENESS OF THE STUN.
- 4) THE PREMATURE FAILURE OF THE PARTS.



THE "CASH SPECIAL" CAPTIVE BOLT STUNNER

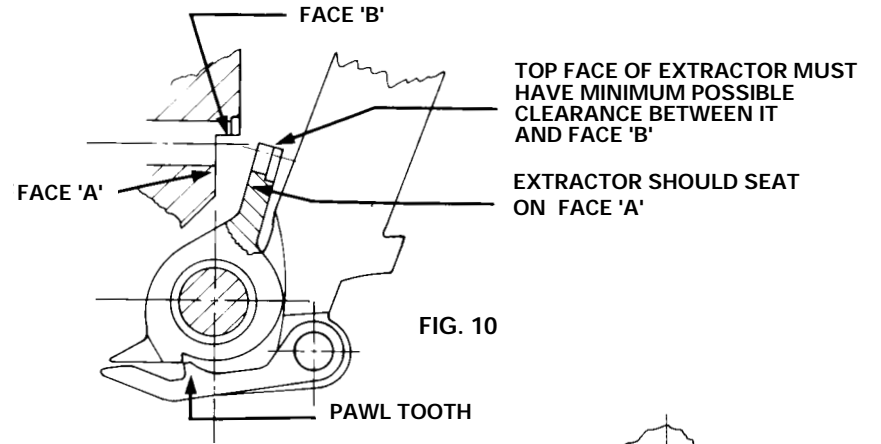


FIG. 10

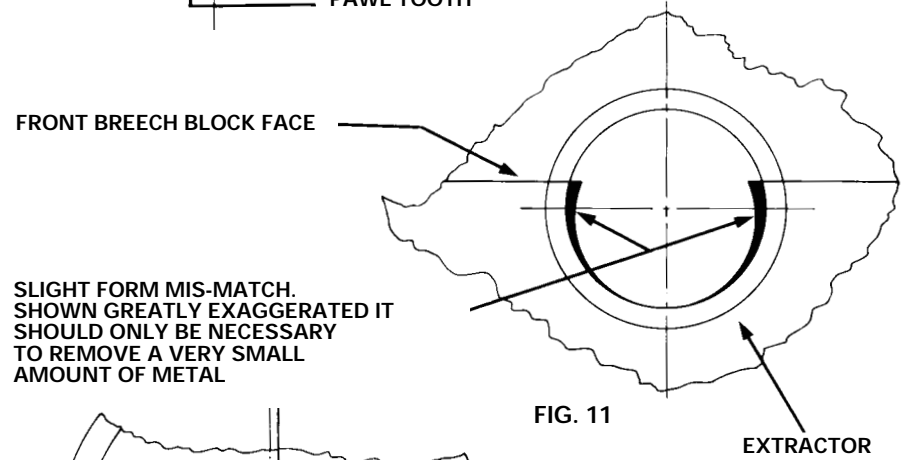


FIG. 11

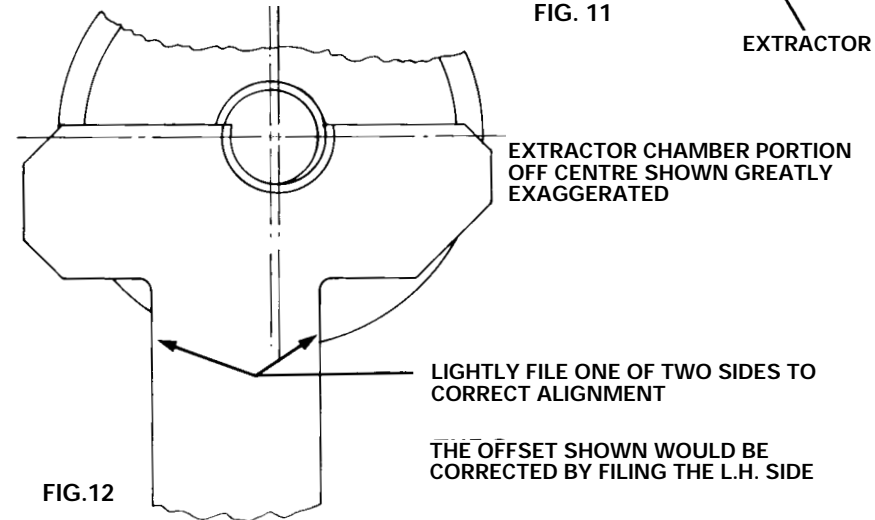


FIG. 12

FITTING NEW EXTRACTOR (710/6)

Extractors supplied for spares are "fitted" to a new Stunner before despatch and although in other Stunners to which they may be fitted there will be very little difference, it is possible, particularly in an old Stunner where wear has taken place, that the extractor will be required to be fitted to those parts with which it mates.

1. Assemble extractor to Firing Block (710/4), check that tooth of pawl (710/27) fits its working face on the extractor (see Fig. 10). If necessary, file this face on the extractor with a super smooth file to achieve the necessary fit; if possible the tooth of the pawl should be of such a fit that it requires a slight push to engage on its working face on the extractor.
2. The extractor, still assembled to the Firing Block, should be assembled to the Barrel. If the top face of the extractor (see Fig. 10) interferes with the cut out in the breech block it will be necessary to file this face of the extractor so that it just clears to allow the "blade" face of the extractor to seat. It is important that only the minimum amount of material is filed from this top face, with a super smooth file.
3. The Hammer (710/18) should now be assembled to the Stunner and the interlock" checked as outlined under Replacement of Firing Block (p. 12) where it may be necessary to file the front blade face of the extractor.
4. The alignment and form match of the chamber portion in the extractor should be checked by inserting a powerload into the chamber; the extractor should be assembled to the Firing Block. The powerload should be able to be freely pushed into the chamber.
 - (a) If the chamber portion is central to the complete form in the breech block (see Fig. 11) but there is mis-match of the form, then using a super smooth round file, gently remove material until the powerload will insert.
 - (b) If the chamber portion is not central to the complete form of the chamber and breech block (see Fig. 12) even when any side clearance has been taken up by powerload insertion, then lightly file one of the two sides of the extractor boss to correct this alignment.
5. The Stunner should now be test fired (see under Final Check-over after Final Attention). If the extraction of a spent case is tight then:
 - (a) The case must be examined for any obvious swellings or depressions around the extractor intersection into the main chamber. 4 (a) or (b) should be repeated until extraction is eased.
 - (b) If there are no obvious marks on the spent case but it is difficult to extract then the fit of the pawl tooth should be eased.

It must be realised that it should only be necessary to remove a very small amount of material from the extractor when fitting it. Any rough filing or excessive material removal will cause poor extraction, burst cases etc.

PARTS LIST FOR "CASH SPECIAL"

Part No.	Name	Number
1564/10	Barrel Assembly.....	1
1564/34	Lock Washer New Type.....	1
1564/47	Muzzle/Barrel Washer.....	1
1564/50	Handle.....	1
1564/60	Handle Grip Moulding.....	1
1564/85	Bolt.....	1
1564/90	Muzzle Cap.....	1
811	Stop Washer.....	1
812	Flange Washer.....	1
816	Recuperator Sleeve.....	8
710/4	Firing Block Assembly.....	1
710/5	Firing Block Bush.....	1
710/6	Extractor (Part Machined).....	1
710/10	Trigger Plunger.....	1
710/11	Trigger Axis Pin.....	1
710/13	Handle/Barrel Bolt.....	2
710/14	Spring Screw New Type.....	1
710/15	Trigger Spring.....	1
710/16	Sear Rod Spring.....	1
710/17	Trigger.....	1
710/18	Hammer.....	1
710/20	Sear Rod End Pin.....	1
710/22	Sear Rod.....	1
710/23	Firing Block Pivot.....	1
710/24	Hammer Pivot.....	1
710/25	Extractor Stop Screw.....	1
710/26	Nut (for 710/13).....	2
710/27	Pawl.....	1
710/28	Extractor Spring.....	1
710/30	Locking Plate.....	1
710/31	Pawl Pivot.....	1
710/33A	Firing Pin Only.....	1
710/33B	Firing Pin Rivet.....	1
710/33E	Firing Pin Back Bush.....	1
710/45	Trigger Stop Pin.....	1
Cleaning Tools etc. as Extras		
1564/20	3/4" Breech Cleaner.....	1
1564/30	Barrel Brush Cleaner.....	1
1564/40	Breech Face & U/Cut Cleaner.....	1
1564/87	Push Rod.....	1
246/49B	Spanner.....	1
	Cash Stunner Oil	

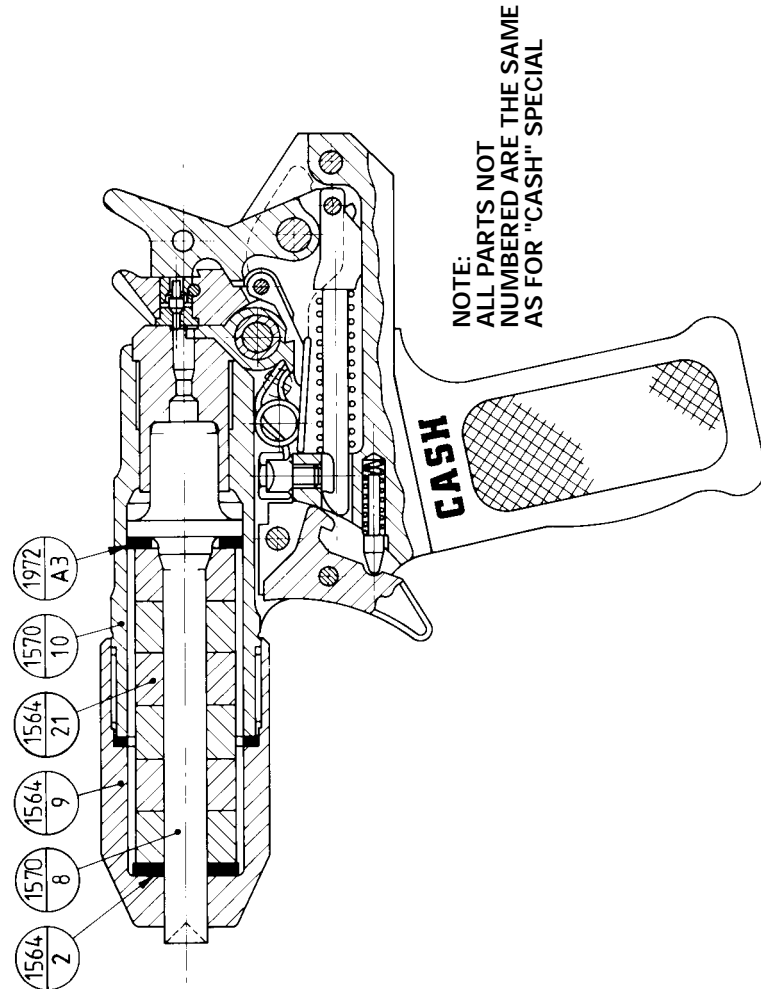
When ordering or referring to Stunners, Accessories or spare parts, please always quote the Serial No. of the Stunner

SEAR ROD SPRING (710/16)

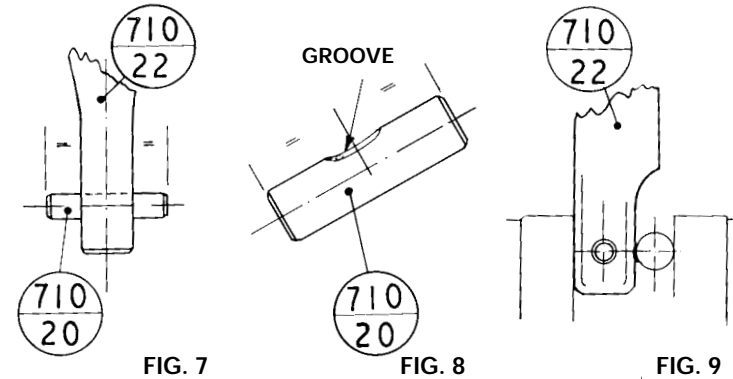
Check free length . If $2\frac{1}{8}$ " (5.5 cm) replace with new spring. If length of spring is less, misfires may occur.

REPLACING BROKEN SEAR-ROD END PIN (710/20)

1. Remove Sear-rod (710/22) and Spring (710/16) from Stunner and with suitable pin punch tap out broken portion of Sear-rod End Pin (710/20) if any part remains in Sear-rod.



THE "SHORT CASH SPECIAL" CAPTIVE BOLT STUNNER



2. Examine the hole, and if badly "bell-mouthed" (enlarged at the ends) fit a new Sear-rod (710/22) complete.
3. If hole is not "bell-mouthed" see that it is still a sliding fit for the new End Pin (710/20).
4. Then file a **small** semi-circular groove in the exact centre of pin (at right angles to axis), approximately $\frac{1}{64}$ " (·4 mm) deep and $\frac{3}{32}$ " (2·5 mm) wide (Fig. 10).
5. Insert the small end of the End Pin (710/20) in the hole, and tap in until the Sear-rod is exactly equidistant between the two ends of the End-pin (Fig. 9). Note - When the Sear-rod is held horizontally with the "Hook" upwards, the groove in the end-pin should face downwards.
6. Insert the assembly in a smooth-jawed vice, and with a $\frac{1}{4}$ " (6 mm) steel rod pressing against Sear-rod side adjacent to position of half-round groove of pin, squeeze up tight (Fig. 11). This will ensure that the Pin is gripped tight in the Sear-rod and prevents it "working" . It is important that the Sear-rod is exactly central on the pin or assembly difficulties will result.

REPLACEMENT OF FIRING BLOCK (710/4)

When replacing a Firing Block Assembly (710/4) the maintenance of correct fit at the interlock is vital.

Fig. 4 shows the "interlock". It should ideally be a light rubbing fit but on no account more than $\cdot003"/\cdot004"$ or $\cdot076/\cdot102$ mm clearance. Note that the two "interlock" faces are not flat surfaces but precise and identical circular arcs struck from hammer and pivot centre.

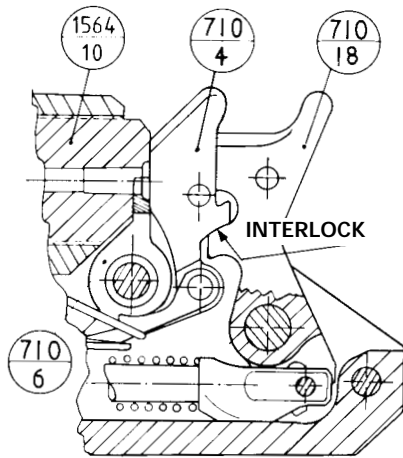


FIG. 5

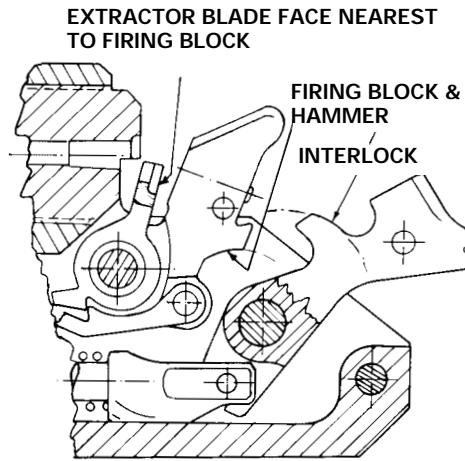


FIG. 6

FITTING PROCEDURE (Fig. 5)

1. Assemble Firing Block (710/4) to Stunner without extractor (710/6) in position.
2. Check "interlock" fit.
3. If adjustment is required use super smooth file on **Hammer** (710/18) "interlock" face until correct rubbing fit is obtained. Take care to retain correct circular arc on face of "interlock".
4. Re-assemble Firing Block with Extractor mounted in place.
5. If interlock is now tight carefully reduce the thickness of the Extractor blade by smooth filing on face nearest to Firing Block.
6. On **no** account must any adjustment at all be made to the new Firing Block - adjust Hammer first and then if necessary the Extractor.

PARTS LIST FOR "SHORT CASH SPECIAL"

Part No.	Name	Number
1564/2	Stop Washer.....	1
1972/A3	Flange Washer.....	1
1570/8	Short Bolt.....	1
1564/9	Muzzle Cap.....	1
1570/10	Short Barrel.....	1
1564/21	Recuperator Sleeve.....	6
Cleaning Tool		
1564/25	1/2" Breech Cleaner.....	1

NOTE:

ALL OTHER PARTS ARE THE SAME AS FOR "CASH SPECIAL"

When ordering or referring to Stunners, Accessories or spare parts, please always quote the Serial No. of the Stunner

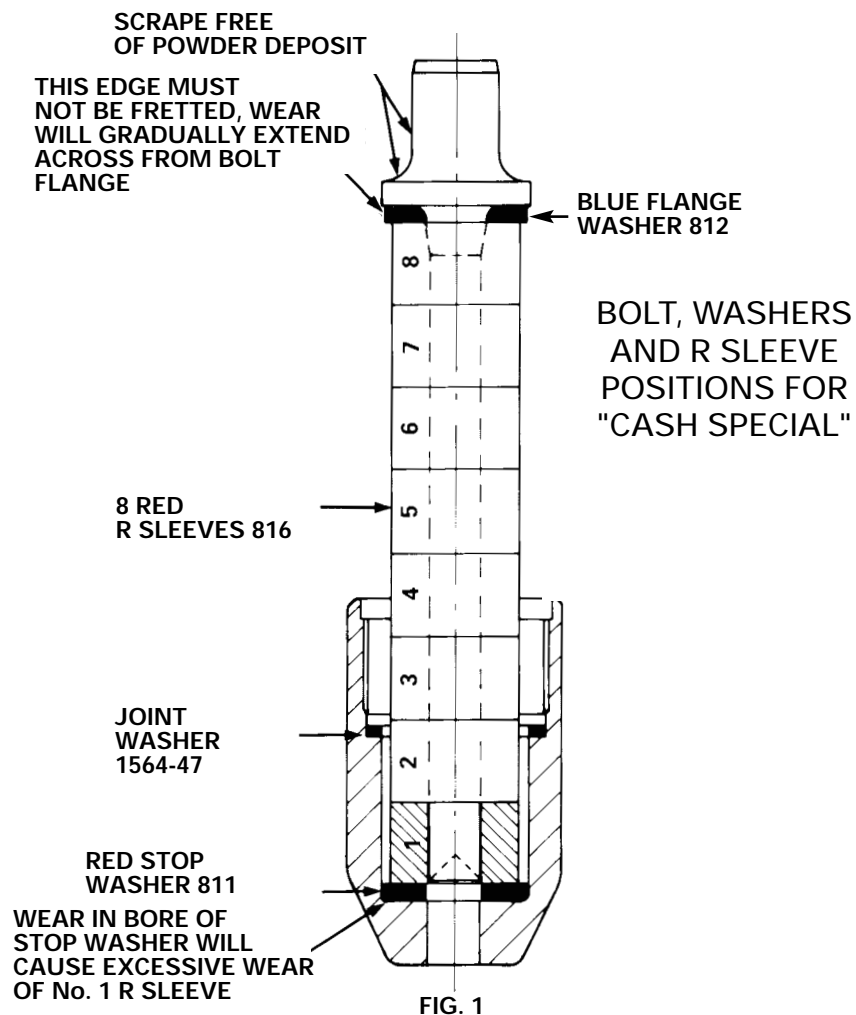


FIG. 1

NOTE: After a few shots with a new set of sleeves they will settle and shorten in length. Expect therefore that with a new set of 8 sleeves the muzzle may be difficult to reassemble to barrel as the sleeves will have to be compressed to engage threads.

NOTE: Providing stop washer is in good condition, the sleeves in position 1, 2 and 3 are less stressed than other positions. To even wear change position of sleeves so that the sleeves which are most worn are in these 1, 2 and 3 positions. If sleeves 4, 5, 6, 7 and 8 are wearing prematurely check that joint washer is in good condition and that the muzzle cap is screwed down to seat on this washer, wear to the outside or the bore of sleeve No. 8 can be caused, by a worn flange washer.

7. If protrusion is greater than $\frac{3}{64}$ " (1 mm), carefully reduce the domed end with smooth file and emery cloth. If the Firing Pin end is filed pointed or square, it will result in burst powerload rims.
8. Replace Firing Block (710/4) in vice with domed end of Firing Pin **downwards**. Replace the Back Bush (710/33E), taking care to line up the Rivet Groove with the Rivet hole in Firing Block. With a suitable punch, drive the Back Bush exactly level with face of Firing Block.
Note. - If driven in too far it will displace the Front Bush (710/33D) and cause serious trouble with Hammer/Firing Block "Interlock".
9. Remove from vice and re-drill through rivet-hole to clear any burrs. (Use $\frac{1}{8}$ " or 3.2 mm drill).
10. Insert countersunk end of new Rivet (710/33B) into rivet hole and tap home until ends are level with sides of Firing Block. Then check Firing Pin protrusion again, and see that the pin moves freely.
11. Using a suitable centre punch, burr over the countersunk end of Rivet.
Notes. - The rear (undomed) end of Firing Pin (710/33A) may protrude up to $\frac{1}{16}$ " (1.5 mm).
If after the Rivet (710/33B) has been removed, it is found difficult to drive out the broken Firing Pin (710/33A) and Back Bush (710/33E), it is permissible to drive out both Bushes (710/33D and 710/33E), together with the Firing Pin (710/33A), using a suitable punch **on the Back Bush** (never on the Front Bush 710/33D, which is shouldered).

In refitting it is very important to see that the Front and Back Bushes are exactly level with the faces of the Firing Block. If they are not, serious trouble will occur with the Hammer/Firing Block "Interlock".

To fit new Firing Pin, Part No. 710/33A - see Figs. 3 and 4

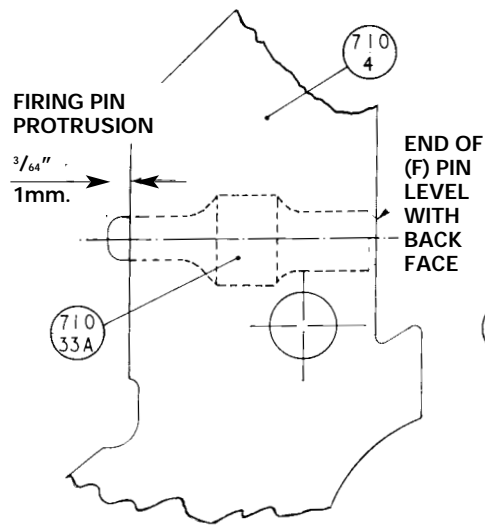


FIG. 3

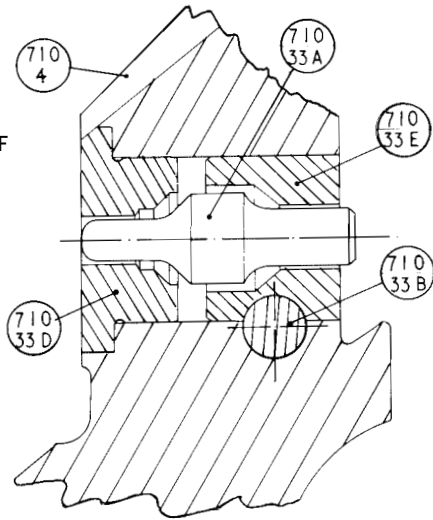


FIG. 4

1. Hold Firing Block (710/4) vertically in smooth-jawed vice.
2. With suitable ($3/32$ " dia.) hand pin punch, drive out the Back Bush Rivet (710/33B) driving from the countersunk end of hole.
3. Replace Firing Block (710/4) horizontally in vice with Firing Pin point uppermost i.e. Pawl (710/27) is underneath. With a small diameter hand pin punch inserted in the Firing Pin Hole drive out the broken Firing Pin (710/33A) and Back Bush (710/33E).
4. Remove Firing Block from vice and examine Firing Pin seating for damage or burrs and remove these if necessary.
5. Insert new Firing Pin (710/33A) and push it in as far as it will go. It should fit snugly on its seating.
6. Hold in position and check that the protrusion of the domed point of Firing Pin (710/33A) is $3/64$ " (1 mm).

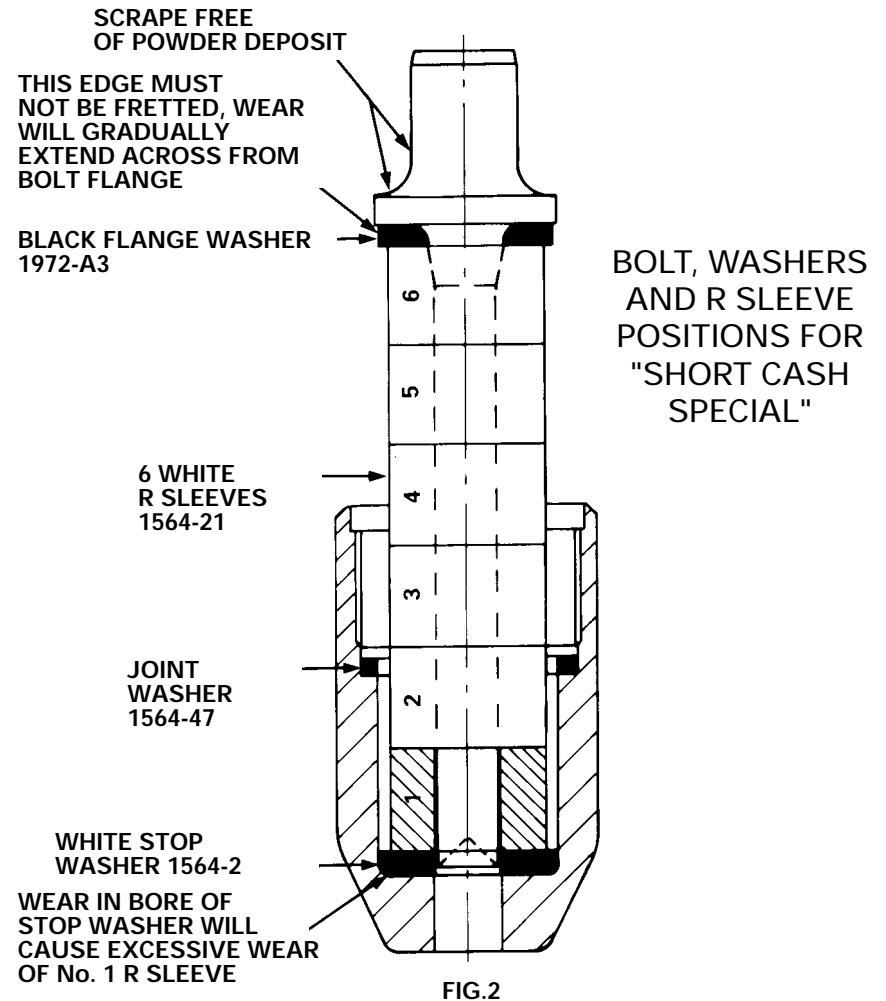


FIG. 2

NOTE: After a few shots with a new set of sleeves they will settle and shorten in length. Expect therefore that with a new set of 6 sleeves the muzzle may be difficult to reassemble to barrel as the sleeves will have to be compressed to engage threads.

NOTE: Providing stop washer is in good condition, the sleeves in position 1, 2 and 3 are less stressed than other positions. To even wear change position of sleeves so that the sleeves which are most worn are in these 1, 2 and 3 positions. If sleeves 4, 5 and 6 are wearing prematurely check that joint washer is in good condition and that the muzzle cap is screwed down to seat on this washer, wear to the outside or the bore of sleeve No. 6 can be caused by a worn flange washer.

DAY TO DAY MAINTENANCE FOR "CASH SPECIAL" AND "SHORT CASH SPECIAL"

1. Unscrew the Muzzle Cap by hand. If too tight hold on flats in bench vice and use Handle Grip Moulding as lever.
2. Withdraw Bolt Assembly complete. It may be necessary to tap the bolt out by cocking the Hammer, pulling back Firing Block and inserting Push Rod through the hole in the Firing Block thumb-piece into the Breech Chamber. Tap out carefully.
3. Remove Stop Washer and Recuperator Sleeves and clean free of powder deposit and sludge. To even wear rate of Sleeves, always place the most fretted Sleeves to the less stressed position nearest the Muzzle.
4. The Flange Washer should be cleaned and replaced if damage to its outside diameter has extended across to the full width of the washer. The edge nearest the Bolt Flange always tends to wear or be fretted first. Always replace with the good edge of the outside diameter facing the Sleeves.
5. The Bolt should be scraped free of powder deposit, particularly on the back of the flange and the neck of the Piston.
6. Clean out the inside of the Muzzle Cap and wipe threads free of deposit. Finish off with clean oily rag.
7. Examine the Muzzle/Barrel Washer which is inside the Muzzle at the bottom of the threads. This should not be removed unless it is seen to be broken, torn or ragged. When it is replaced, care must be taken to see that it is bedded down flat on its seating.
Important: On no account must the Stunner be used without the Muzzle/Barrel Washer. This will result in damage to Recuperator Sleeves and Muzzle Cap.
8. When re-assembling it is ESSENTIAL that Flange Washer, Recuperator Sleeves and Stop Washer are assembled in their correct positions, exactly as in Fig. 1 OR Fig. 2 for 'Short' model.
Note: The Stop Washer will probably remain firmly in the Muzzle Cap. This is in order.
9. Place Breech face & u/cut cleaner in a vice and clean off any hard powder deposits from the front of the Breech Block and the Barrel Bore immediately in front.
Clean the $\frac{3}{4}$ " bore in the Breech Block with the Breech Cleaner.
Clean the full length of the Barrel Bore with the Brush Cleaner.

10. MOST IMPORTANT

Failure to keep the Muzzle Cap screwed up tight (by hand). This abuse leads to early damage of the Muzzle Washer Part No. 1564-47 and to very early destruction of the Recuperator Sleeves.

Failure to Replace a Worn Flange Washer as described under 4 will lead to early destruction of Recuperator Sleeves and probably cause the Bolt to stick in the animal's head.

Failure to Replace Stop Washer when its hole becomes worn and enlarged can cause early damage to the bore of the Recuperator Sleeve next to it. Premature wearing of this Stop Washer is caused by a Muzzle having a worn bolt stem hole.

If the stem of the Bolt is allowed to become badly pitted and corroded through failure to clean the Stunner after use, in accordance with our Instructions, damage will occur to the bore of the Recuperator Sleeves and early failure will result.

11. Reassembly of Bolt and Muzzle after cleaning. Insert Bolt Assembly with Sleeves and Washers in their correct position into the Barrel. Place two drops of oil on the Barrel threads before screwing home Muzzle Cap. The edge of the Muzzle Cap, when it has been screwed home hard by hand, should just cover the groove in the Barrel which is immediately behind the threads.

12. LUBRICATION

All "Cash" Stunners require lubricating sparingly with thin non-gummy oil such as "Cash" Stunner Oil - motor oils will cause trouble. Put two spots of oil only on firing block pivot joint and in oil hole of hammer.

Too much oil in powerload chamber or around Firing Block will cause misfiring.