

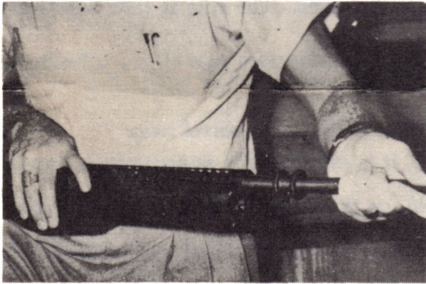
THE JOHNSON CAN BE QUICKLY DISASSEMBLED **WITHOUT TOOLS!**

WITHOUT TOOLS!

1 REMOVING BARREL



A. Disengage Barrel Latch Plunger with cartridge point. While Plunger is depressed, press back slightly on barrel to unlock Barrel Spring & Lock Assembly.

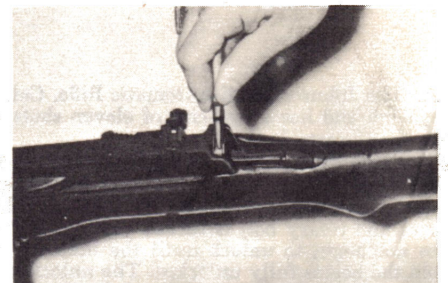


B. Press down on Operating Handle with right forefinger to unlock bolt from barrel. While Operating Handle is depressed, withdraw barrel from receiver.

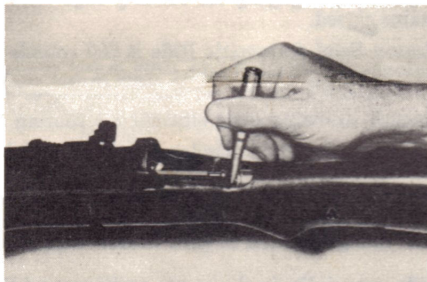
2 REMOVING BOLT GROUP



A. Disengage Bolt Stop Plate Plunger with cartridge point. Slide Bolt Stop Plate up and out with left thumb.



B. Remove Bolt Stop with cartridge point.



C. Compress Plunger with cartridge point and disengage Link from Main Spring Plunger.



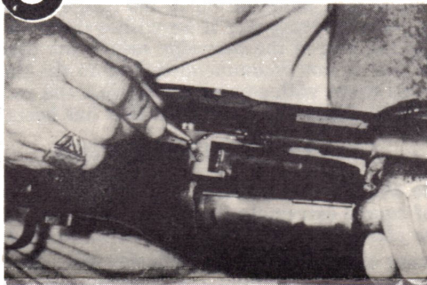
D. Pull-out Operating Handle Spindle (from center of Operating Bolt Handle). Push Operating Bolt Handle completely forward, to point where it can be removed. Bolt Group can then be withdrawn from receiver.

LOADING



The 10-shot Rotary Magazine can be loaded from either a standard Springfield clip, or loaded singly. To unload, depress Magazine Loading Lip and tilt rifle to side. Cartridges will then drop into palm of hand.

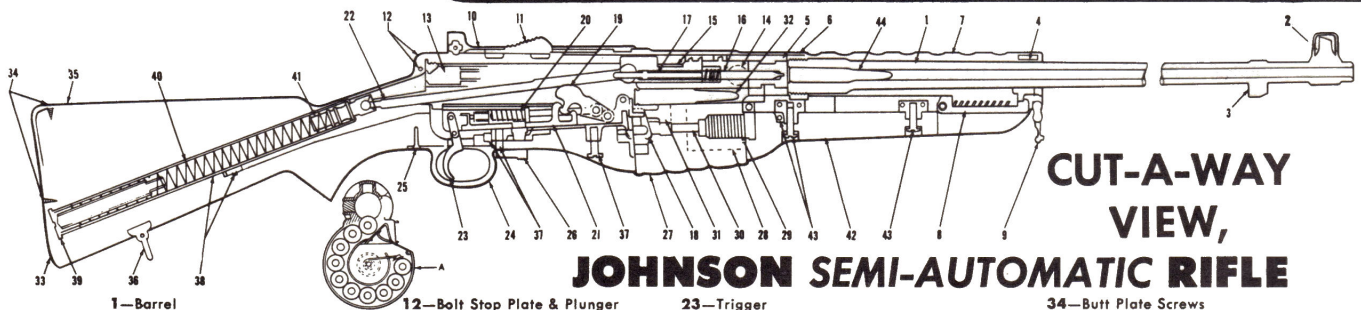
3 REMOVING BUTT STOCK



A. Hammer Block Pin is disengaged with cartridge point, then removed.



B. Butt stock can be withdrawn from receiver by exerting slight pressure to rear, after Bolt Stop Plate and Hammer Block Pin have been removed.



**CUT-A-WAY
VIEW,
JOHNSON SEMI-AUTOMATIC RIFLE**

- | | | | |
|--------------------------------|------------------------------|--|---|
| 1—Barrel | 12—Bolt Stop Plate & Plunger | 23—Trigger | 34—Butt Plate Screws |
| 2—Front Sight | 13—Bolt Stop | 24—Trigger Guard | 35—Butt Stock |
| 3—Bayonet Lug | 14—Bolt & Unlocking Cam | 25—Trigger Guard Rear Screw (Wood) | 36—Rear Sling Swivel |
| 4—Barrel Guide Collar | 15—Locking Cam Unit | 26—Safety | 37—Rear Stock Screw—Hammer Block Screw and Butt Stock Recoil Stop |
| 5—Barrel Locking Bushing | 16—Firing Pin | 27—Magazine Body | 38—Main Spring Tube & Positioner |
| 6—Receiver | 17—Firing Pin Stop | 28—Magazine Core | 39—Main Spring Tube Screw |
| 7—Radiator Sleeve | 18—Bolt Catch Cam | 29—Magazine Follower Spring | 40—Main Spring |
| 8—Barrel Latch & Recoil Spring | 19—Hammer | 30—Magazine Center Shaft | 41—Main Spring Follower |
| 9—Front Sling Swivel | 20—Hammer Strut & Pin | 31—Magazine Follower | 42—Fore Stock |
| 10—Rear Sight Leaf | 21—Sear | 32—Top Cartridge in Feed Lip of Magazine | 43—Fore Stock Screw & Recoil Stop |
| 11—Rear Sight Elevator | 22—Link | 33—Butt Plate | 44—Cartridge in Chamber |

The Johnson Semi Automatic Rifle

GENERAL DESCRIPTION

A. The Johnson Semi-Automatic Rifle, Cal. .30-06, is a self-loading shoulder weapon of the short recoil type. It is equipped with a rotary feed magazine and has a capacity of eleven shots, ten rounds in the magazine and one in the chamber, loaded from standard Springfield-type clips, or with single cartridges.

The rifle fires semi-automatically only, as slowly or as rapidly as may be required, by a separate pull on the trigger for each shot. The rifle will fire only if the breech is closed and locked. The force of recoil is utilized to operate the mechanism of the rifle. In the first movement of the action, when the cartridge is fired, the barrel and bolt recoil together approximately 3/8ths of an inch. During the rearward passage of the barrel, the rotary bolt is turned through 20° by the action of the camming arm on the bolt against the camming face in the receiver. The bolt does not begin to unlock until the bullet is approximately two feet from the muzzle. The bullet is between four and five feet from the muzzle when the bolt is fully unlocked. The unlocking of the bolt lugs precedes primary extraction. When the bolt is fully unlocked, the barrel is arrested in its rearward movement. The bolt, impelled by its momentum and by residual pressure, continues to travel to the rear, extracting and ejecting the empty case. This movement compresses the recoil spring in the butt stock and cocks the hammer.

The force of the main spring returns the bolt. In its forward movement, the bolt picks up the top cartridge from the magazine and chambers it. In loading, the cartridge is not required to enter the chamber from the side or at an abrupt angle, so that the bolt has full control of the head of the cartridge at all times, and the possibility of jams is minimized.

The locking cam rotates the bolt to the locked position, engaging the locking lugs with the locking abutments. The rifle is then ready to fire. When the last round has been fired, the bolt remains closed.

B. The theoretical cyclic rate of fire of the Johnson Semi-Automatic Rifle is 600 rounds per minute. The deliverable rate of fire is limited only by the dexterity of the operator. Starting with the rifle fully loaded, eleven aimed shots can be fired in eleven seconds. The approximate maximum rate of aimed fire is 15-30 shots per minute, depending upon the range, size, visibility of the targets, etc.

The barrel is exposed to the air for its entire length, allowing most efficient air cooling by the natural radiation of barrel heat.

C. The accuracy of aim is not impaired by the automatic action. Under condition of deliberate fire, it is substantially as accurate as any standard bolt action military rifle.

Under conditions of sustained rapid fire, it is far more accurate by comparison. Sights can be held on the target and recoil on the shooter's shoulder is reduced considerably, as recoil is partially absorbed in actuating the mechanism.

This being the case, modification of some of the firing position to give firmer support to the rifle may be made without receiving the jarring that a bolt action rifle would give.

The body should be more directly behind the rifle, especially in the prone position, and the rifle should be held firmly to the shoulder in all positions. Increased accuracy as well as better manipulation of the rifle will be the result.

AMMUNITION

The Johnson Semi-Automatic Rifle was originally designed as a military rifle for use with the U.S. Caliber 30/06 M1 ammunition. It has been determined by exhaustive test-firing that a 150 grain and 180 grain commercial 30/06 ammunition manufactured in the United States and Canada will give excellent results when used in the Johnson Semi-Automatic Rifle.

It will be of interest to all owners of Johnson Semi-Automatic Rifles, including all Sporter Models, that it has also been determined by Winfield Arms Corporation's test-firing crews, after firing many thousands of rounds of various types of ammunition, that any given Johnson Rifle will perform most perfectly with one particular commercial brand and weight of 150 grain or 180 grain ammunition. The shooter can determine by test-firing a number of rounds of various brands and weights of ammunition in his rifle exactly which brand and weight gives him maximum performance and accuracy. The shooter should make a point of doing this if he wishes the most out of his Johnson Rifle.

It should be noted that as the correct relation of the size of the cartridge case to the barrel chamber is very important to the correct functioning of all semi-automatic weapons, reloaded ammunition is not recommended. Due to the short recoil action of the Johnson Semi-Automatic Rifle, it extracts the cartridge cases so rapidly that it throws them with some force against the receiver rails on ejection thus causing some denting of the cartridge case. As a consequence, no attempt should be made to reload brass that has been fired in the Johnson Rifle.

CARE AND CLEANING

The thorough cleaning of the rifle bore and the chamber after firing is of the utmost importance in the Johnson Semi-Automatic Rifle. Proper cleaning of the bore and chamber of any rifle is of course extremely important, however *this is especially so with the Johnson Rifle, in that any foreign matter in the barrel and particularly the chamber will definitely tend to cause the rifle to malfunction.*

NOTE: It has been our experience that 80 per cent of malfunctioning difficulty with the Johnson Rifles results from failure to properly clean the bore and chamber of the rifle after firing it. There is not the slightest question but that a small amount of dirt or fouling, or any foreign matter, particularly in the chamber of the Johnson Rifle, will cause various types of malfunctioning.

The Johnson Rifle should be cleaned as follows:

1. After firing the rifle, if it is impossible to give it a thorough cleaning as indicated below, the bore and chamber should be immediately oiled and the complete cleaning procedure should be carried out as soon thereafter as possible.
2. As soon as possible after firing the rifle, the barrel should be removed and placed in pan or bucket of scalding water and soap suds. Using a cleaning rod and cleaning patch, swab the bore with the scalding water and soap suds taking care not to allow the patch to project beyond the muzzle. If the patch and cleaning rod are used as indicated, the patch tends to act with a pump-like action enabling a more thorough cleaning of the bore.
3. After cleaning the bore with hot water and soap suds, run dry patches through the bore until it is completely dry.
4. Special care should be given to the chamber of the barrel, washing it thoroughly with hot water and soap suds until absolutely sure that all fouling has been removed. It can then be completely dried with patches.
5. When the bore and chamber are completely dry, they should be swabbed with a good gun oil.

NOTE: After firing military ammunition with corrosive primers, the above cleaning process should be repeated for *three consecutive days* if barrel damage is to be prevented.

LUBRICATION

Ordinary lubrication with standard gun oils should be satisfactory in normal temperatures. However, if the rifle is used in very cold climates and sub-temperatures, all parts should be wiped off so that no oil remains in the mechanism. If possible, the weapon should be lubricated with graphite or one of the gun oils which are especially adaptable to use in freezing temperatures. The firing pin and the hammer mechanism must be kept absolutely dry. However, oil can be applied with a patch lightly on the operating cam.