

JUNE 1906

U.S.A.

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THE LONDON SMALL ARMS CO. LTD.  
VICTORIA PARK MILLS, OLD FORD,  
LONDON, E.

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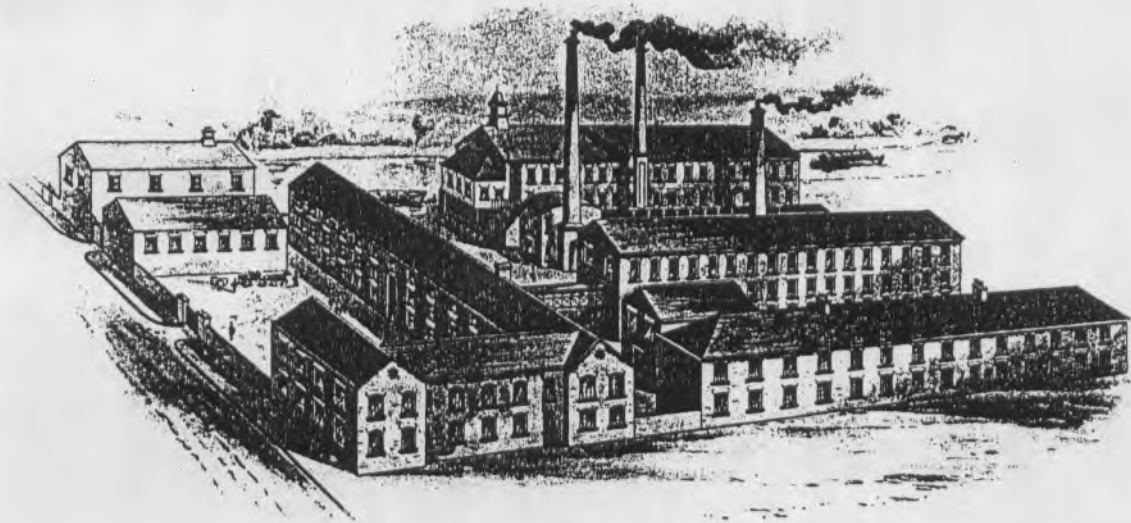
# HE LONDON SMALL ARMS CO.,

LIMITED.

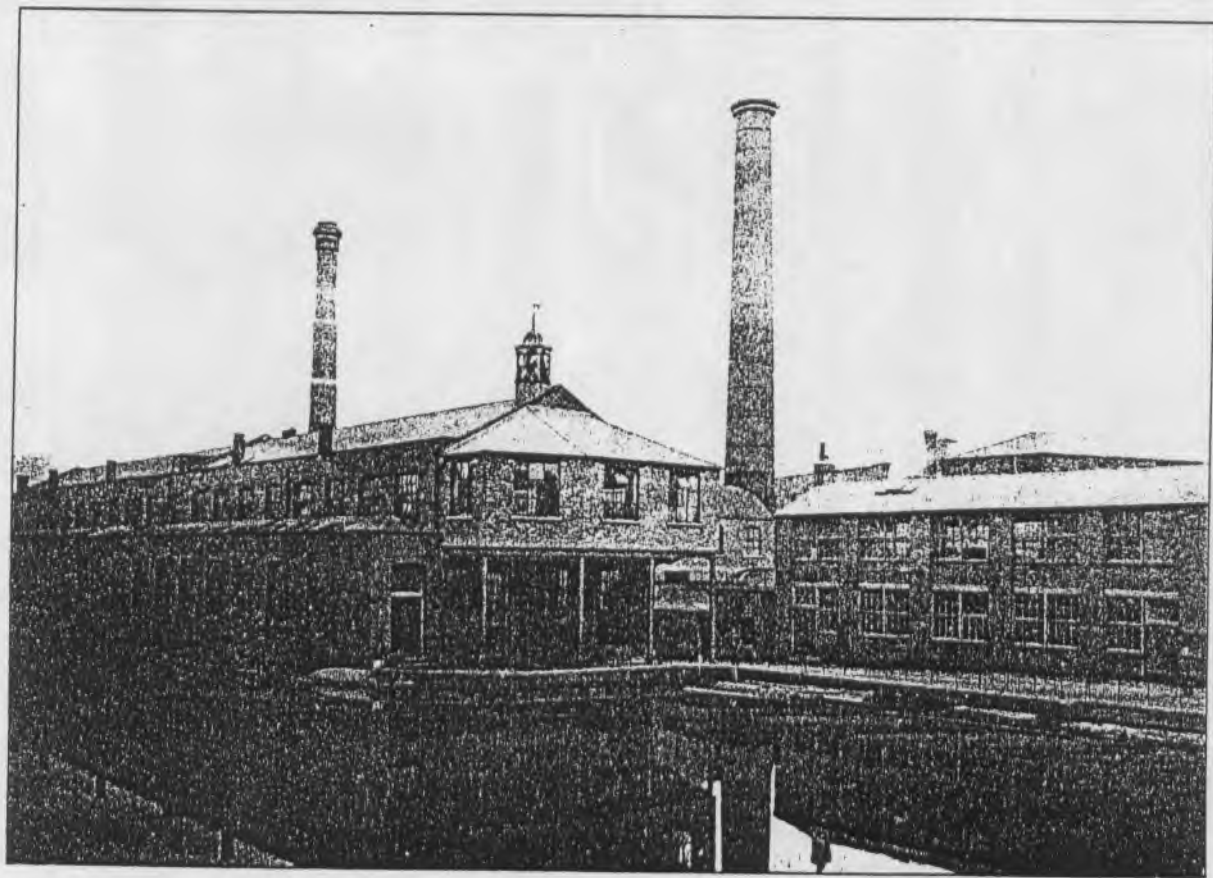
JULY, 1906.

Contractors  
for ...  
Lee-Enfield  
Rifles  
to ...  
H.M.  
War Department.

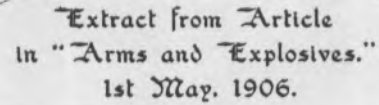
Victoria Park Mills,  
Old Ford,  
**LONDON, E.**



Bird's-Eye View of the Works.



General  
View  
of the  
Works  
from  
Canal  
Side.



Extract from Article  
in "Arms and Explosives."  
1st May, 1906.

..... The particulars now to be given have been obtained at first hand as the result of a visit to the Company's Works, Victoria Park Mills, in East London.

..... The Company has been established in its present premises since 1866, and employs about 750 hands when working full strength.

"The shops were all actively engaged in manufacturing the various parts of the new short Lee-Enfield Rifle. The latest appliances and methods seemed to be in regular use in every portion of the factory.

"..... Reverting more particularly to the precise object of the visit, it was interesting to note that the London Small Arms Company has made wonderful progress in the manufacture of six hand-made models of the new Cadet Rifle. They represent a necessary preliminary to manufacture on the interchangeable basis of the same thing in large quantities. So advanced, in

'Extract from -rticle —continua..

fact, are the preparations for making the various tools, fixtures and gauges that the Company hopes to be ready with the first samples at or about the end of June. Such a record in manufacturing enterprise is to be highly commended, and the fact that such things can be done shows that the English gun trade can rise to the same level which we have hitherto credited as the sole perquisite of the large American and Continental factories.

"The Company's ordinary output of Service Rifles, when the factory is fully employed, extends to the very substantial total of 800 Rifles per week, together with private work representing, say, an additional 10 per cent.

"The arrangements for turning out the Cadet Rifle are based on the anticipation of keeping pace with a large demand for this pattern, and the buildings and plant are capable of considerable extensions should occasion demand it."

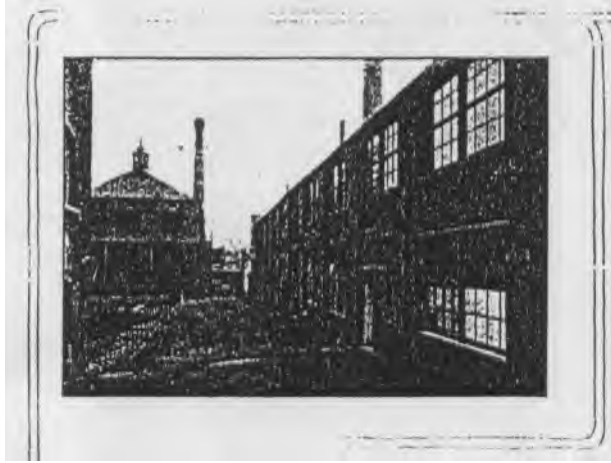
Since this article was written, we have concluded numerous trials of the shooting of the first few of these Rifles made by ourselves, and on page 16 will be found a report by the well-known shot, G. E. Fulton, Armourer-Sergeant to the Queen's Westminster Rifles, which speaks well for the accuracy of the Rifle at the various ranges.

## THE WAR OFFICE MINIATURE RIFLE, '22 CALIBRE.



IS Rifle has recently been approved by the Army Council, and embodies the chief points which the Small Arms Committee consider essential in a Miniature Rifle for use by Schools, Cadet Corps and Rifle Clubs, which, whilst being a light and inexpensive Rifle, shall, at the same time, be effective and accurate at the ranges to which it is sighted.

The Rifle is a single loader •22 calibre with bolt action, designed on the lines of the Short Lee-Enfield Rifle, and is fitted with a wind gauge back sight of similar pattern, except that there is no rack and fine adjustment screw, the slide being held in position by friction and fine adjustment of elevation obtained by moving it up or down the curved ramps.



### The War Office Miniature Rifle -continued.

It is chambered to take the '22 rim-fire long rifle cartridges.

The action is fitted with a safety catch by which the bolt may be locked when in the firing position ; there is also a simple device by which, if the trigger should be pulled before the breech is properly closed, either prevents the striker from firing the cartridge or closes the breech automatically before this takes place (see page 13) thus rendering it safe in the hands of a careless or inexperienced person. To show the simplicity of the design of the Rifle, it is only necessary to

state that the whole of the woodwork may be detached from the barrel and action without the use of any tools, simply by unscrewing with the fingers the front sling swivel and by using a bronze coin for removing a screw in the trigger guard (see page 11).

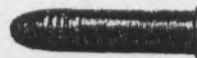
With the exception of using a screw-driver to remove one screw, the whole of the bolt may also be dismantled without the further use of tools. This renders all working parts of the Rifle very accessible for cleaning and repairs.

To take the bolt out of the action, open the breech by raising the bolt handle, then draw back the bolt, pulling the trigger at the same time. To replace, reverse the movements.

## Chief Particulars of the Rifle.

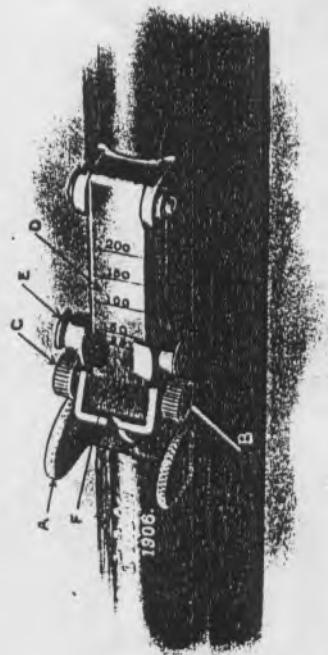
Length from trigger to heelplate - - - - -	13½ inches.
Total length - - - - -	41½ inches.
Length of barrel - - - - -	24 inches.
Distance between backsight and frontsight - - - - -	18 inches.
Weight - - - - -	5½ lbs.
Rifling 8 grooves semi-circular 1 turn in 16 inches right hand.	
Depth of grooves - - - - -	.006 inch.
Width of grooves - - - - -	.05 inch.
Pull (drag) 1st between 1 and 2 lbs. Minimum to fire 4 lbs.	

Cartridge used



.22 Rim-fire Long Rifle.

# DETAILS OF BACK -SIGHT.

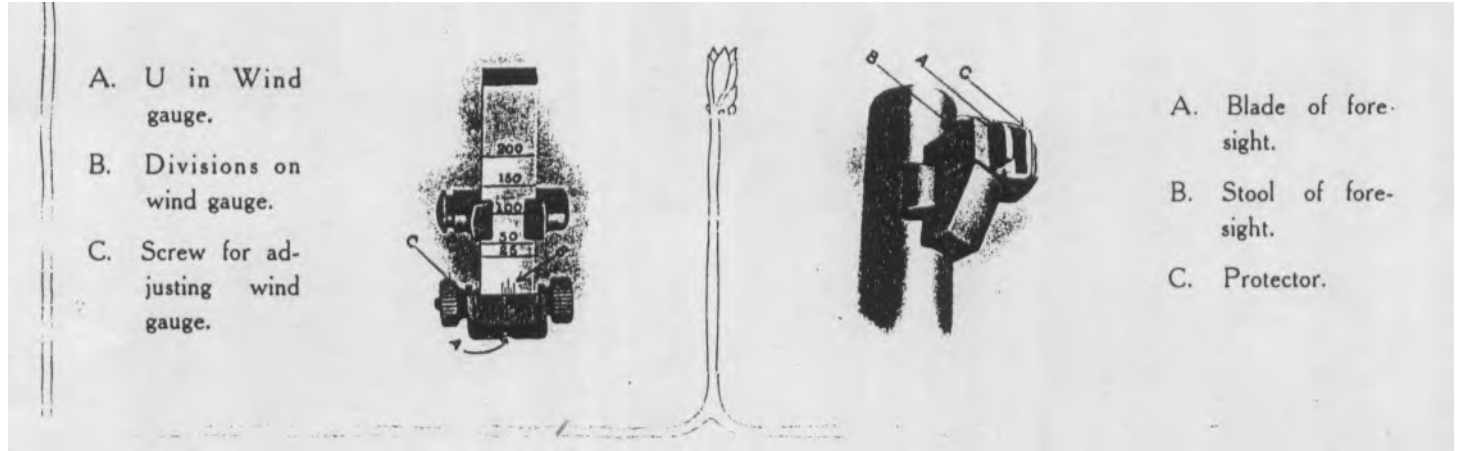


- A. Sight Protector.
- B.C. Heads of wind gauge actuating screw.
- D. Leaf on which ranges are marked.
- E. Slide moveable on leaf and held in position by friction.
- F. Wind gauge.

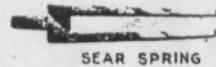


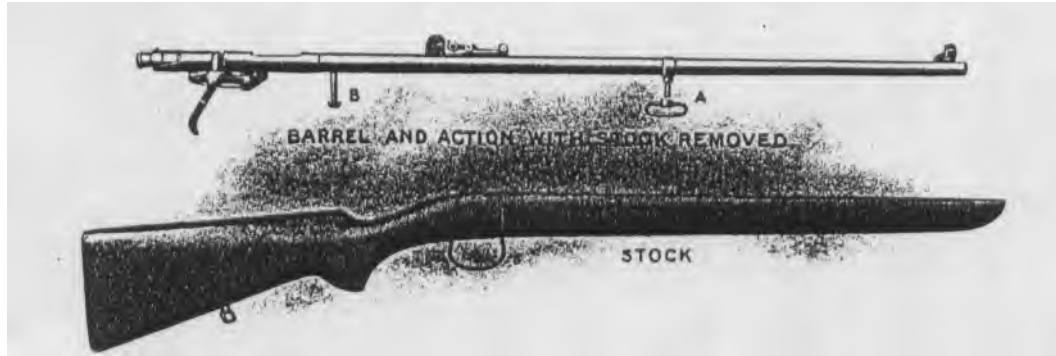
### !Details of

THE usual V in the backsight is in this Rifle replaced by a U, which, with the knife blade foresight fitted, is considered to be the most suitable combination. In the head C of the wind gauge screw are four small holes spaced 90 degrees apart on the circumference. By means of these holes it may be readily seen, when the screw has been revolved a quarter turn, which, as the screw has 50 threads per inch, gives a movement of  $1/200$ th of an inch to wind gauge, equal to an alteration of direction of one inch at 100 yards.

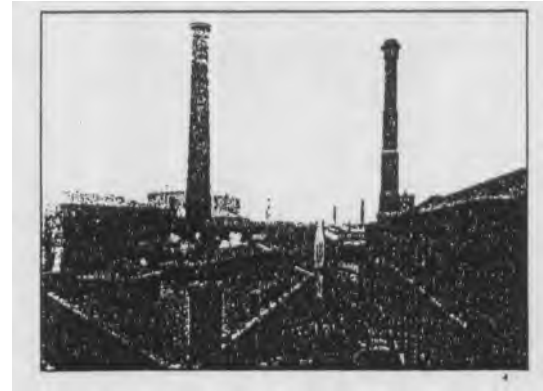


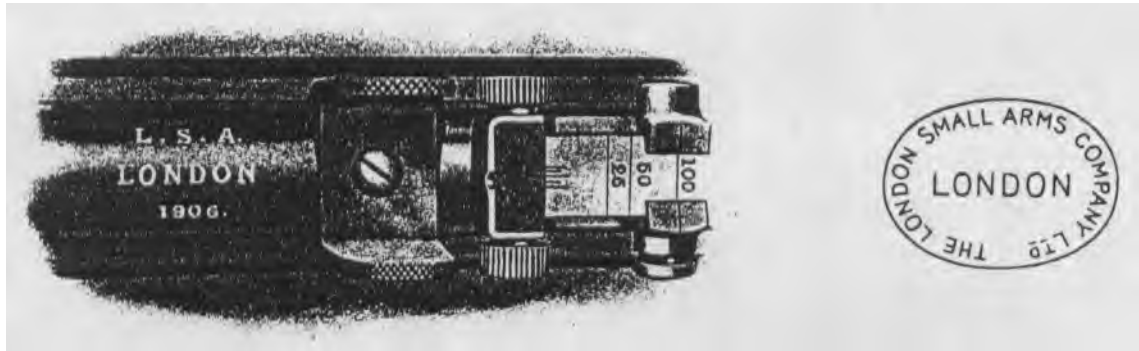
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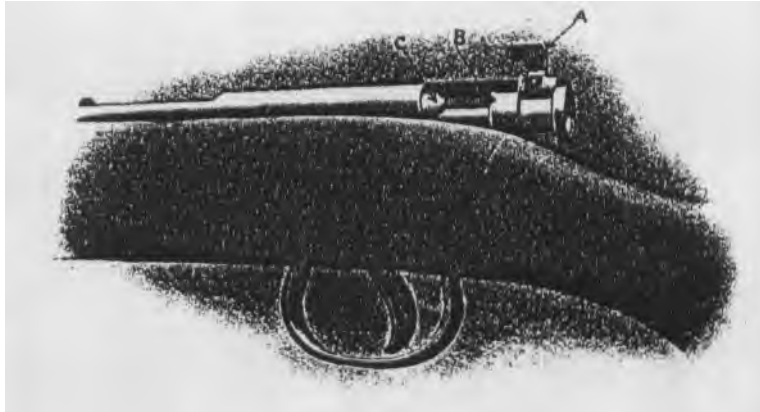




To detach stock, unscrew sling swivel (A) with the fingers, and screw (B) with a bronze coin, when barrel and action may be lifted out.







° (H E illustration above shows the cocking piece in the firing position with safety catch **A** partly raised, and is also intended to explain the action (mentioned on page 6) which takes place in the event of the trigger being pulled before the breech bolt is properly closed.

In order that the striker may fire the cartridge when trigger is pulled, it is necessary for the notch B in cocking piece to be exactly opposite the angular projection C on the bolt. Unless this is the case, as will readily be seen, the striker and cocking piece cannot travel the full distance through the bolt and bolt head to reach the cartridge rim. They can necessarily only be exactly in line when the breech is closed and the bolt handle is pressed as close to the body as it will go.

OIL BOTTLE AND PULL-THROUGH CONTAINED IN BUTT OF RIFLE.



○ To get the best results from any small bore rifle, good ammunition only should be used, and the barrel cleaned out with the pull-through frequently; this will tend towards better shooting and add to the length of life of the barrel.

When shooting is finished, the barrel should be thoroughly washed out with hot water and soda. The best way to do this is to remove the bolt and pour the hot water down the barrel from the breech end with a funnel, afterwards wiping dry with clean flannel on the pull-through, and oiling afterwards. An anti-corrosive oil is the best for this purpose.

**Report made by Armourer-Sergt. G. 1E. Fulton**  
**on the shooting Of**

- I am returning the Cadet Rifle you sent me for trial. This is, indeed, an excellent little weapon, and should well meet the increasing demand for reliable Miniature Rifles. I find it extremely accurate ; the diagrams forwarded to you, made respectively at 20, 25, 50, 70, and 100 yards, prove this. Up to this last distance it is absolutely reliable, shoots well at 150 yards, and at 200 yards (a very extreme distance for '22 bore) will give fairly good results in quiet weather or on a sheltered range. It is a weapon that must quickly find favour, affording, as it will, most excellent target practice at a small outlay. The well-known '22 Long Rifle Cartridge, to which the Rifle is adapted, being inexpensive, and its shooting always to be relied on."



A Copy of this Booklet  
sent post free  
on application.

THESE Rifles sold only to the Trade,  
Rifle Clubs and Associations.

Price £2 5 0 Nett.

TERMS ON APPLICATION.

