



MX – FITTING NEW ACTION BLOCK AND TOP LEVER SPRING INSTRUCTIONS

REFER TO THE SCHEMATIC BELOW FOR REFERENCES

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HONESTLY, THIS IS REALLY A TRAINED GUNSMITH'S PROCEDURE. HOWEVER, IF YOU ARE HANDY AND UNDERSTAND THE DYNAMICS OF THIS OPERATION – HAVE AT IT

PLEASE DO NOT USE A WELDED BLOCK AND USE IT IN YOUR GUN

Older MX Perazzi's that do not use the Top Lever Stop Plate #136 (right side of receiver), should disregard these instructions and use the instructions for the TM single barrel gun.

1. Remove trigger and butt-stock from Receiver.

Refer to the attached schematic for part references – I recommend removing receiver parts in a towel-lined box to prevent launching some of the internal parts.

2. Drive out cross pin #128 to permit removal of top lever and firing pins. You may wish to drive the pin out entirely and in doing so, you will release the Top Lever Stop Plate #136 and the Top Lever Stop Plate Plunger #137.

Hopefully, you have kept those from disappearing

3. After removing the firing pins (longer pin is the bottom barrel pin) and both coil springs, inspect both for excessive wear, broken coil(s) and replace as necessary. CLEAN out the firing pin cavities with a Q-Tip or similar, and apply a small amount of very thin grease in this cavity.

→ **This is the tricky part (READ CAREFULLY):**

- A. Place receiver up-side-down on a couple of blocks of wood to keep the receiver up off the table top so that the top lever can be driven out (down), *PLACE A TOWEL UNDER THE RECEIVER to catch any springs, guide, and plungers that will be expelled when you do Step B below.*

S&W Supply, LLC

5308 Timberline Trail • Rapid City SD 57702

☎ (605) 341-4412 Phone/Voice Mail

✉ whiz@swsupply.com • Website: <http://www.swsupply.com>

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- B. With a small drift punch, through the small hole in the underside of the Action Block, tap the top lever down (out) of the receiver. In doing this you will expel the Top Lever Coil Spring #121 and Guide #111.
- C. You should now be able to pull the top lever OUT of the receiver. Thoroughly clean the spring area and the top lever large hole in the receiver, and oil/grease accordingly.
- D. Inspect the Top Lever of any signs of cracking.

FITTING NEW ACTION BLOCK

It is EXTREMELY IMPORTANT that you do not weld-up your old action block. You introduce heat, changing metal properties with the heat and new metal that just cannot be duplicated with the metals in a genuine new action block. Furthermore, any pock mark cavities run the risk of carving on the barrel notches. The metal in an action block is a softer material than the barrel notch areas and this is damn important. Premature wearing of the barrel notches is an expensive fix.

- 3.
- 4. If only replacing only the Top Lever Coil Spring(s), then skip to Step 6 below. Otherwise, to fit a new action block, you will need to fit the action block. In doing this you will simply modify the action block which is a time-consuming process including multiple insertions, testing, removal, etc.
- 4. An often ignored fitting area, but one that is really most important are the surfaces of the two “ears” on the rear-underside of the action block. Mic the inside width of the removed block’s ear and duplicate to get the block to easily slide in the receiver. Rarely any metal needs to be removed from the top or bottom of a new block, and occasionally some on the outer sides.
- 5. You continue fitting until the block slides easily in the receiver.
- 6. Once accomplished, you will need to “test” the fitting of the top lever IN the receiver and its mating with the action block.
- 7. Work the top lever manually back-and-forth to ensure it moves effortlessly. >>> Quite often the top lever will have a hiccup cause from its bottom tip riding in the new action block’s under-sized groove. You may need to polish the tip on the top lever to make for effortless top lever movement.
- 8. Final fitting of the action block involves removing material on the 7° surface until you walk the top lever clockwise until the top lever rear tang just meets the wood at the receiver tang. This can be a lengthy process and is done carefully.
- 9. Each time you remove metal from the 7° surface YOU MUST CHECK IT FIT into the barrel notches. IMPORTANT: BOTH barrel notches must rest equally on BOTH action block surfaces. This is done with the barrel and forearm attached, testing until the top lever sit at approximately 4 o’clock,

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or where the top lever sits where the receiver tang and wood meet. This could take several hours to do it correctly.

10. When you have correctly fitted to new action block, the receiver should be placed in a protected vice, up-side-down.

BE CERTAIN THAT THE TOP LEVER STOP PLATE RELEASE PIN #135 IS INSTALLED

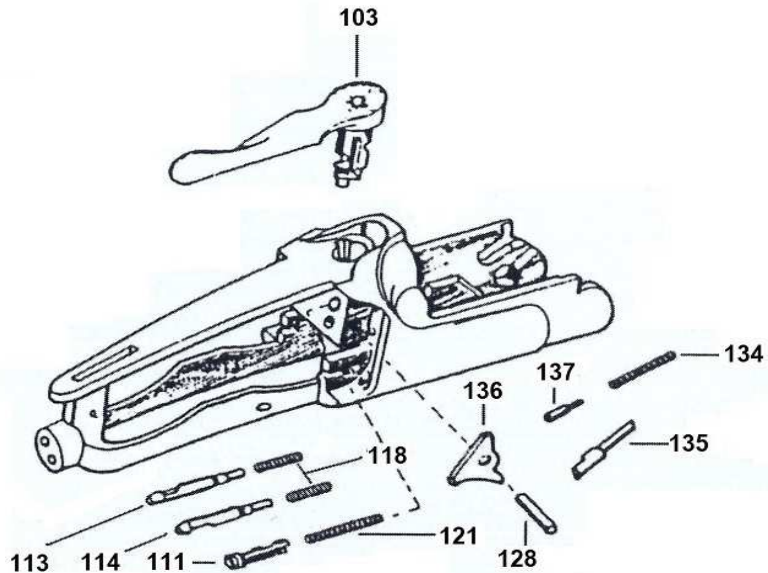
11. Insert the Action Block into the receiver and position it in a position such that the top lever tang will sit in its slot. **DO NOT INSERT TOP LEVER YET!**
12. Slightly oil the top lever spring #121 and guide #111 and insert into the receiver.
13. It is difficult to seat the Top Lever properly and completely because you must press in on the Top Lever Return Spring Guide (slotted head piece), *JUST* far enough to let the top lever drop into place. If you tap on the top lever, be darn careful to be gently; Tapping too hard will disfigure its slot that accepts the guide #111.
14. Reinstall pin #128 removed in Step 2. It is driven in from the RH side of the receiver. This can be very tricky because you need to hold the Stop Lever Release Plate #136 in position, at the same time making sure the Stop Plate Plunger #137 does not launch, and the Release Pin #135 is orientated correctly then tap in the #128 cross pin. Drive in the #128 pin only slightly just enough to keep the #136 in place, then insert a NEW firing pin recoil spring #118, and the bottom barrel firing pin #114.
15. Always use new #118 springs; they are very thing and can break, causing firing pin malfunctions at the most inappropriate time... and they are cheap.
16. Orientate the bottom firing pin's slot to ensure the #128 pin slips past it, holding it in position,
17. Repeat this process for the top barrel firing pin #113 and recoil spring #118, driving in the #128 cross pin to be flush on both sides of the receiver.
18. You are done!

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NOMENCLATURE**

- 103 - Top Lever
- 111 - Top Lever Locking Piece
- 113 - Top Barrel Firing Pin
- 114 - Bottom Barrel Firing Pin
- 118 - Bottom and Top Barrel Firing Pin Return Coil Spring
- 121 - Top Lever Return Spring
- 128 - Lock Pin, Top Lever & Firing Pins
- 134 - Top Lever Lock Pin Return Spring
- 135 - Top Lever Stop Plate Release Pin
- 136 - Top Lever Stop Plate (newer guns)
- 137 - Top Lever Stop Plate Release Spring Plunger

A SMALL PERSONAL NOTE REGARDING THESE INSTRUCTIONS: I have spent a considerable amount of time, developing these and other sets of instructions so that you could circumvent the high costs of a gunsmith and attempt these repairs yourselves, free of any charges.

If these instructions have helped, then that is my intention.

To this end, I don't see much in the way of donations for all my efforts to support the Perazzi shooters. What I do see are higher costs in maintaining this website, beyond my control.

I may be forced to cease making these available, should I have to continue operating this "free" website.

I would appreciate your donation(s), big or small, as they tell me my efforts have not been wasted.

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