



**SOUTH AUSTRALIA POLICE**  
**KEEPING SA SAFE**

# **DEACTIVATION OF YOUR FIREARM**

Prepared

by

**SOUTH AUSTRALIA POLICE**  
**ARMOURY SECTION**



**Government of  
South Australia**

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## **INTRODUCTION**

The following information sheet has been prepared by the South Australia Police Armoury Section to assist you in the deactivation of your firearm. The purpose in deactivating a firearm is to render the firearm incapable of being returned to its original firing condition but at the same time preserving the appearance of the firearm. This may be so that the firearm can be displayed or kept for historical or family reasons. A person can deactivate their own firearms or have the work carried out by a licensed firearms dealer or gunsmith. Deactivated firearms must be inspected by an Armourer at the SA Police Armoury Section, who will issue a "Certificate of Deactivation" if the work is completed to the required standard. Please ring to make an appointment before attending.

**Armoury Section  
Police Barracks  
1 Gaol Road  
Thebarton SA 5031**

**Ph (08) 82074071  
Fax (08) 82074659**

Cost of issue of a Certificate of Deactivation is as per the gazetted hourly rate, payable by either cheque or money order (not cash or credit card) at the Armoury Section at the time of inspection. The Armoury Section can be contacted for a current cost.

Firearm owners who are contemplating having a firearm deactivated should be aware of the two procedures that have been approved by the Registrar of Firearms.

**Welding** This procedure involves ARC or MIG welding only. Where a steel rod is inserted into the barrel, and the welding of all the major parts of the firearm. Firearms of alloy or polymer construction must be sectioned.

**Sectioning** This process involves the machining or milling of all the major parts of the firearm exposing the internal mechanism.

Due to the many variations in design and manufacturing techniques used in the different firearm makes and models, the Armoury Section reserves the right to modify the deactivation criteria to suit a firearm where the guidelines do not affectively or appropriately fulfil the purpose. Guidelines applicable to various firearm models is provided in these instructions.

Regulated imitation firearms will be deactivated using the same process as the live firing example that it represents with the following changes:

1. These firearms must be sectioned; welding is not acceptable due to the materials they are manufactured from.
2. Slots machined into solid barrels and chambers will be to a depth no less than the centre line of the barrel.

**WARNING:** If any deactivated part of a deactivated firearm is modified in any way it immediately reverts to the class of firearm that it was prior to deactivation and becomes subject to the provision and penalties of the Firearms Act.

**Authorised by:**

.....  
Superintendent Stephen Howard  
Officer in Charge, Firearms Branch  
Delegate of the Registrar of Firearms

4 / 4 / 2019



.....  
Superintendent Les Buckley  
Officer in Charge  
Forensic Services Branch

15 / 4 / 2019

## **BOLT ACTION RIFLE**

### **WELDING**

1. Bore a calibre size hole into the chamber.
2. Insert a close fitting steel rod into the barrel and weld to the muzzle and breech.
3. Weld the bolt to both sides of the receiver from the breech face (or as close as possible) for 60% of its length.
4. Weld the trigger to the receiver or trigger guard.
5. If the firearm has a quick detachable barrel it must be welded to the receiver.

### **SECTIONING**

1. Machine away the bolt face with a 45 degree backward facing cut from the firing pin hole. The cut must break through the side of the bolt.
2. Shorten the nose of the firing pin so that it does not protrude beyond the bolt face.
3. Machine a calibre size slot, 20mm long, and approximately half way along the barrel.
4. Machine a slot the full length of the chamber and into the bore for a distance of 20mm. This slot will be large enough to remove at least a 1/3 section from the chamber diameter.
5. Machine a cut into the receiver/breech ring that matches the chamber cut. Only the minimal amount of material should remain to prevent the breech ring from flexing open.
6. Remove a minimum of 50% from the total area of all locking surfaces to a depth of 4mm. In the case of a removable locking shoulder, through the locking shoulder and 4mm into the supporting material.
7. Machine a 3mm vertical slot down both sides of the receiver that reduces the wall thickness by 50%. This cut does not have to be exposed but must be in the area of the locking surface (front locking) or between the locking surface and the breech face.
8. Remove half of the sear mating surfaces.



## **PUMP AND LEVER ACTION RIFLE**

### **WELDING**

1. Bore a calibre size hole into the chamber.
2. Insert a close fitting steel rod into the barrel and weld to the muzzle and breech.
3. Weld the bolt to both sides of the receiver from the breech face (or as close as possible) for 60% of its length.
4. The action arm/lever or link is to be welded to the receiver or barrel.
5. Weld the trigger and hammer to the receiver.
6. Where the firearm has a quick detachable barrel it must be welded to the receiver.

### **SECTIONING**

1. Machine away the bolt face with a 45 degree backward facing cut from the firing pin hole. The cut must break through the side of the bolt.
2. Shorten the nose of the firing pin so that it does not protrude beyond the bolt face.
3. Machine a calibre size slot, 20mm long, and approximately half way along the barrel.
4. Machine a slot the full length of the chamber and into the bore for a distance of 20mm. This slot will be large enough to remove at least a 1/3 section from the chamber diameter.
5. Machine a cut into the receiver/breech ring that matches the chamber cut. Only the minimal amount of material should remain to prevent the breech ring from flexing open.
6. Remove a minimum of 50% from the total area of all locking surfaces to a depth of 4mm. In the case of a removable locking shoulder, through the locking shoulder and 4mm into the supporting material.
7. Machine a 3mm vertical slot down both sides of the receiver that reduces the wall thickness by 50%. This cut does not have to be exposed but must be in the area of the locking surface (front locking) or between the locking surface and the breech face. If the firearm has an upper and lower receiver both parts must be so machined.
8. Remove half of the sear mating surfaces.
9. Machine 3mm from the face of the hammer where it contacts the firing pin.

## **SELF LOADING RIFLE**

### **WELDING**

1. Bore a calibre size hole into the chamber.
2. Insert a close fitting steel rod into the barrel and weld to the muzzle and breech.
3. Weld the bolt to both sides of the receiver from the breech face (or as close as possible) for 60% of its length. Rifles with bolt carriers will have the bolt welded to the carrier and the carrier welded to the receiver.
4. Remove the gas piston and spring where fitted and block the gas port with weld.
5. Weld the trigger and hammer to the receiver.
6. Where the firearm has a quick detachable barrel it must be welded to the receiver.

### **SECTIONING**

1. Machine away the bolt face with a 45 degree backward facing cut from the firing pin hole. The cut must break through the side of the bolt.
2. Shorten the nose of the firing pin so that it does not protrude beyond the bolt face.
3. Machine a calibre size slot, 20mm long, and approximately half way along the barrel.
4. Machine a slot the full length of the chamber and into the bore for a distance of 20mm. This slot will be large enough to remove at least a 1/3 section from the chamber diameter.
5. Machine a cut into the receiver/breech ring that matches the chamber cut. Only the minimal amount of material should remain to prevent the breech ring from flexing open.
6. Remove a minimum of 50% from the total area of all locking surfaces to a depth of 4mm. In the case of a removable locking shoulder, through the locking shoulder and 4mm into the supporting material.
7. Machine a 3mm vertical slot down both sides of the receiver that reduces the wall thickness by 50%. This cut does not have to be exposed but must be in the area of the locking surface (front locking) or between the locking surface and the breech face. If the firearm has an upper and lower receiver both parts must be so machined.
8. The hinge point on the upper and lower receiver must be sectioned by the removal of a one quarter section.
9. Remove half the diameter of the gas port for a distance of half of its length.

10. Machine a slot into the gas cylinder that is half the size of the piston head for the full length of the piston head travel.
11. Remove one third of the diameter of the piston head.
12. Remove half of the sear mating surfaces.
13. Machine 3mm from the face of the hammer where it contacts the firing pin.



## **SINGLE/DOUBLE BARREL SHOTGUN**

### **WELDING**

1. A hole, of approximately sixty percent of the bore size is bored slightly forward of each chamber.
2. Close fitting steel plugs of chamber length inserted in chamber and welded at the breech.
3. The firing pin(s) and trigger(s) are to be welded to the receiver.
4. The locking lever is to be welded to the receiver.
5. The barrel is to be welded to the receiver on one side from the breech face (or as close as possible) for the full length of its contacting surface.
6. Where the shotgun has exposed hammers they are to be welded to either the side plates or receiver.

### **SECTIONING**

1. Cut a 4mm slot (4mm deep) across the middle of the breech face that passes through the firing pin hole(s).
2. Shorten the nose of the firing pin so that it does not protrude beyond the breech face.
3. Machine a slot the full length of the chamber and into the bore for a distance of 20mm. This slot will be large enough to remove at least a 1/4 section from the chamber diameter.
4. Remove a minimum of 50% from the total area of all locking surfaces to a depth of 4mm.
5. Machine a 3mm vertical slot down both sides of the receiver that reduces the wall thickness by 50%. This cut does not have to be exposed but must be in the area of the locking surface.
6. Remove half of the sear mating surfaces.
7. Machine 3mm from the face of the hammer where it contacts the firing pin.

## **PUMP ACTION SHOTGUN**

### **WELDING**

1. Bore a hole, of approximately sixty percent of the bore size slightly forward of the chamber.
2. Insert a close fitting steel plug of chamber length into the chamber and weld at the breech.
3. Weld the bolt, for 60% of its length to the receiver and weld the barrel to the bolt and receiver.
4. Weld the action arm(s) to the receiver.
5. Weld the trigger mechanism parts together to prevent movement. The mechanism can still be removable from the receiver.

### **SECTIONING**

1. Machine away the bolt face with a 45 degree backward facing cut from the firing pin hole. The cut must break through the side of the bolt.
2. Shorten the nose of the firing pin so that it does not protrude beyond the breech face.
3. Machine a slot the full length of the chamber and into the bore for a distance of 20mm. This slot will be large enough to remove at least a 1/4 section from the chamber diameter.
4. Remove a minimum of 50% from the total area of all locking surfaces to a depth of 4mm.
5. Machine a 3mm vertical slot down both sides of the receiver that reduces the wall thickness by 50%. This cut does not have to be exposed but must be in the area of the locking surface.
6. Remove half of the sear mating surfaces.
7. Machine 3mm from the face of the hammer where it contacts the firing pin.

## **SELF LOADING SHOTGUN**

### **WELDING**

1. Bore a hole, of approximately sixty percent of the bore size slightly forward of the chamber.
2. Insert a close fitting steel plug of chamber length into the chamber and weld at the breech.
3. Weld the bolt, for 60% of its length to the receiver and weld the barrel to the bolt and receiver.
4. Weld the trigger mechanism parts together to prevent movement. The mechanism can still be removable from the receiver.
5. Remove all gas pistons and return springs where applicable.

### **SECTIONING**

1. Machine away the bolt face with a 45 degree backward facing cut from the firing pin hole. The cut must break through the side of the bolt.
2. Shorten the nose of the firing pin so that it does not protrude beyond the breech face.
3. Machine a slot the full length of the chamber and into the bore for a distance of 20mm. This slot will be large enough to remove at least a 1/4 section from the chamber diameter.
4. Remove a minimum of 50% from the total area of all locking surfaces to a depth of 4mm.
5. Machine a 3mm vertical slot down both sides of the receiver that reduces the wall thickness by 50%. This cut does not have to be exposed but must be in the area of the locking surface. If the firearm has an upper and lower receiver both parts must be so machined.
6. Machine a flat on the gas piston, removing one quarter of the diameter.
7. Remove half of the sear mating surfaces.
8. Machine 3mm from the face of the hammer where it contacts the firing pin.

## **PISTOLS**

### **WELDING**

1. A calibre size hole bored into the chamber.
2. A close fitting steel rod inserted in barrel and welded at muzzle and breech.
3. The trigger is to be welded to the frame.
4. The barrel is to be welded to the slide.
5. The slide is to be welded to both sides of the frame along a minimum of half its length.
6. If the pistol has an exposed hammer it is to be welded to the frame.
7. The top of the magazine well is to be filled with weld.

### **SECTIONING**

1. Machine a calibre size slot the full length of the chamber and into the bore for  $\frac{1}{2}$  the cartridge case length. Where the barrel is fixed to the frame the slot must pass through the barrel support.
2. Remove half of the width of the barrel lug where it contacts the locking surface and takedown pin/slide lock.
3. Machine a slot into the breech block for  $\frac{1}{4}$  of its length, opening into and removing half of the breech face.
4. Remove half of the locking surfaces from the barrel, slide and frame.
5. Remove  $\frac{1}{4}$  of the length from the muzzle end and  $\frac{1}{4}$  of the length from the mid-point from one side of the slide rail.
6. Remove two thirds of the length of the opposite side frame rail. Where the pistol uses two point insert rails. Remove 50% of the length and depth of both the front and rear rail.
7. Where the frame rails and/or the locking shoulder is removable. Machine into the supporting material for 50% to a depth of 2mm.
8. Machine a 3mm vertical slot down both sides of the frame that reduces the wall thickness by 50%. This cut does not have to be exposed but must be in the area rear of the locking shoulder/barrel support (not in the magazine well).
9. Remove half of the sear mating surfaces.
10. Machine 3mm from the face of the hammer where it contacts the firing pin.
11. Shorten the nose of the firing pin / striker so that it does not protrude beyond the breech face.



## **REVOLVER**

### **WELDING**

1. Bore a calibre size hole through the frame and into the barrel as close to the forcing cone as possible.
2. A close fitting steel rod inserted through the barrel and cylinder that butts up to the breech face and welded at the muzzle.
3. Weld the trigger and hammer to the frame.
4. Weld the cylinder to the frame. This weld is to be as close to the breech face as possible.
5. If the revolver is a break type the top strap is to be welded closed.

### **SECTIONING**

1. Machine a calibre size slot from the forcing cone for a length of 20mm, this slot must pass through the frame.
2. Machine a 3mm deep slot across the breech face that breaks into the firing pin and centre pin holes.
3. Machine a slot at the breech end of the chamber that circumferences the centre line of the charge holes to a depth of half the cartridge length.
4. Shorten the nose of the hammer nose/firing pin so that it does not protrude through the breech face.
5. Remove half of the sear mating surfaces from the hammer, trigger and cylinder stop.



## **MACHINE GUN (SUB, LSW, GPMG)**

### **WELDING**

1. Bore a calibre size hole into the chamber.
2. Insert a close fitting steel rod into the barrel and weld to the muzzle and breech.
3. Where the firearm has a quick detachable barrel it must be welded to the receiver.
4. Weld the bolt to both sides of the receiver from the breech face (or as close as possible) for 60% of its length. Firearms with bolt carriers will have the bolt welded to the carrier and the carrier welded to the receiver.
5. Remove the gas piston and spring where fitted and block the gas port with weld.
6. Belt fed firearms are to have the feed mechanism (pawls) welded to the feed tray.
7. Weld the trigger and hammer/sear to the receiver or trigger mechanism.
8. Body covers and/or end caps are to be welded closed to the receiver.
9. Removable assemblies (trigger/butt group) are to be welded to the receiver.

### **SECTIONING**

1. Machine away the bolt face with a 45 degree backward facing cut from the firing pin hole. The cut must break through the side of the bolt.
2. Shorten the nose of the firing pin so that it does not protrude beyond the bolt face.
3. Machine a slot the full length of the chamber and into the bore for a distance of 20mm. This slot will be large enough to remove at least a 1/3 section from the chamber diameter.
4. Machine a calibre size slot, 20mm long approximately half way along the barrel.
5. Remove 50% from all locking surfaces to a depth of 4mm. In the case of a removable locking shoulder, through the locking shoulder and 4mm into the supporting material.
6. Machine a cut into the receiver/breach ring that matches the chamber cut. Only the minimal amount of material should remain to prevent the breech ring from flexing open. Machine guns with trunnion blocks will have a T cut machined into the base. This cut will be no less than 10mm wide with the top of the 'T' extending across the full width of the receiver.

7. Machine a 3mm vertical slot down both sides of the receiver that reduces the wall thickness by 50%. This cut does not have to be exposed but must be in the area of the locking surface (front locking) or between the locking surface and the breech face. If the firearm has an upper and lower receiver both parts must be so machined.
8. Where the receiver is manufactured using sheet stamped metal or thin walled tubular steel point 7 is not required. Where this occurs the cut into the breach ring (point 6) must be the full length of the receiver block / barrel extension.
9. The hinge point on the upper and lower receiver must be sectioned by the removal of a one quarter section.
10. Machine a 3mm slot through the actuating arm(s) removing 50% of the thickness.
11. Remove half the diameter of the gas port for a distance of half of its length.
12. Machine a slot into the gas cylinder that is half the size of the piston head for the full length of the piston head travel.
13. Remove one third of the diameter of the piston head.
14. Remove half of the sear mating surfaces.
15. Machine 3mm from the face of the hammer where it contacts the firing pin.

## **MUZZLE LOADING RIFLE**

### **WELDING**

1. Bore two calibre size holes into the chamber. One of these holes must be as close as possible to the breach plug and the second hole will be 50mm from the first hole.
2. Insert a close fitting steel plug of at least 75mm in length into the chamber and securely weld to the barrel through the bored holes.
3. Weld the barrel plug to the barrel.
4. Weld the trigger to the receiver or trigger guard.
5. The hammer or lock is to be welded to the receiver or side plate.

### **SECTIONING**

1. Increase the vent hole by double the original diameter.
2. Machine a slot into the bore at the chamber end of the barrel that is large enough to remove at least a 1/3 section from the chamber diameter. This slot will include the full length of the barrel plug thread and into the chamber three calibres long.
3. Machine a calibre size slot, 20mm long, and approximately half way along the barrel.
4. Remove half of the sear mating surfaces.

## **GAS AIR RIFLE OR PISTOL**

### **WELDING**

1. Bore a calibre size hole into the barrel as close to the 'chamber' as possible.
2. Insert a close fitting steel rod into the barrel and weld to the muzzle and breech.
3. Weld the barrel and cocking arm to the receiver.
4. Weld the end cap to the receiver.
5. Weld the trigger to the receiver or trigger guard.
6. Any solenoid switches are to be removed and the mounting screw holes drilled out.

### **SECTIONING**

1. Machine a slot, 4mm deep into the breech face. The cut must pass through the sealing groove and open through the side of the barrel block.
2. Machine a calibre size slot of 20mm in length, at the commencement of rifling and again approximately half way along the barrel.
3. Machine a 12mm slot into the receiver that runs the full length of piston travel.
4. Remove the piston spring.
5. Remove half of the sear mating surfaces.
6. Any solenoid switches are to be removed and the mounting screw holes drilled out.

## **PAINTBALL FIREARM**

### **WELDING**

1. Weld the barrel to the front of the receiver and through the feed port.
2. Weld the bolt and valve to the receiver.
3. Remove the air inlet plug and fill the threaded hole with weld.
4. Bore a hole of no less than 10mm into the valve chamber.
5. Remove the sear and retaining pin from the firing mechanism. Machine away sufficient material from the sear housing to remove the supporting surfaces of the sear pin.

### **SECTIONING**

Sectioning of paintball firearms has not been approved.



## **MORTARS**

### **WELDING**

1. Bore a hole of half calibre size into the chamber or base end of the tube.
2. Removable balls are to be welded to the tube.
3. Ground back the firing pin nose. Removable firing pins are to be welded in place or removed completely and the thread in the ball fouled with weld.

### **SECTIONING**

Sectioning of mortars has not been approved.

## **ROCKET LAUNCHERS**

### **WELDING**

1. Bore a hole of half calibre size into the tube approximately halfway along its length.
2. The trigger / firing mechanism is to be welded solid.

### **SECTIONING**

1. Bore a hole of half calibre size into the tube approximately halfway along its length.
2. Shorten the nose of the firing pin so that it does not protrude into the tube.
3. Reduce the actuating arm (hammer face/cam plate) so it will not contact the firing pin.
4. The cartridge guide or indexing channel is to be removed / machine out
5. Where a trigger mechanism is fitted remove half of the sear mating surfaces.

## **RELIC FIREARMS**

Firearms in 'relic' condition can be submitted to the Armoury for inspection. Where a firearm is determined to be a relic a deactivation certificate will be issued. A relic is a method of deactivation in itself as the firearm cannot function due to being a relic.

A firearm will be considered to be a relic where:

1. Rust, oxidation or corrosion is significant and obvious, and.
2. All working surfaces including the internal mechanism and any other moving parts are seized, bound or damaged so they cannot be restored through force, lubrication, temperature or electrolysis.

Where the original serial number cannot be clearly identified, a serial number will be allocated by the Armoury utilising a PD316 for recording purposes, and will be recorded against the certificate. It will not be necessary for the serial number to be stamped on the firearm and it can be stamped onto a metal tag and attached to the firearm.

If any attempt is made to restore any part of this firearm, such firearm reverts to its class of firearm and again becomes subject to the provisions of the Firearms Act as amended.

*Approved as per Armoury + Firearms Branch advice.*



Les Buckley  
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Forensic Services Branch

*22.3.19.*