

# INSTRUCTIONS FOR 1874 MODEL

## TUBE ASSEMBLY FOR CARRIAGE

1- Hold the tube about one inch above the position it will hold on the yoke and insert ball (B2) into ball socket (marked B1). After step two is completed, the ball cannot come out of the socket.

2- Place the tube with trunions (marked A3) onto the trunion housings of the yoke (marked A2) and place the trunion caps down over them and lock in place with the trunion keys (A1).

3- By unscrewing knob (marked C2) the elevating screw handle marked C1 may be allowed to turn, thus allowing tube elevation.

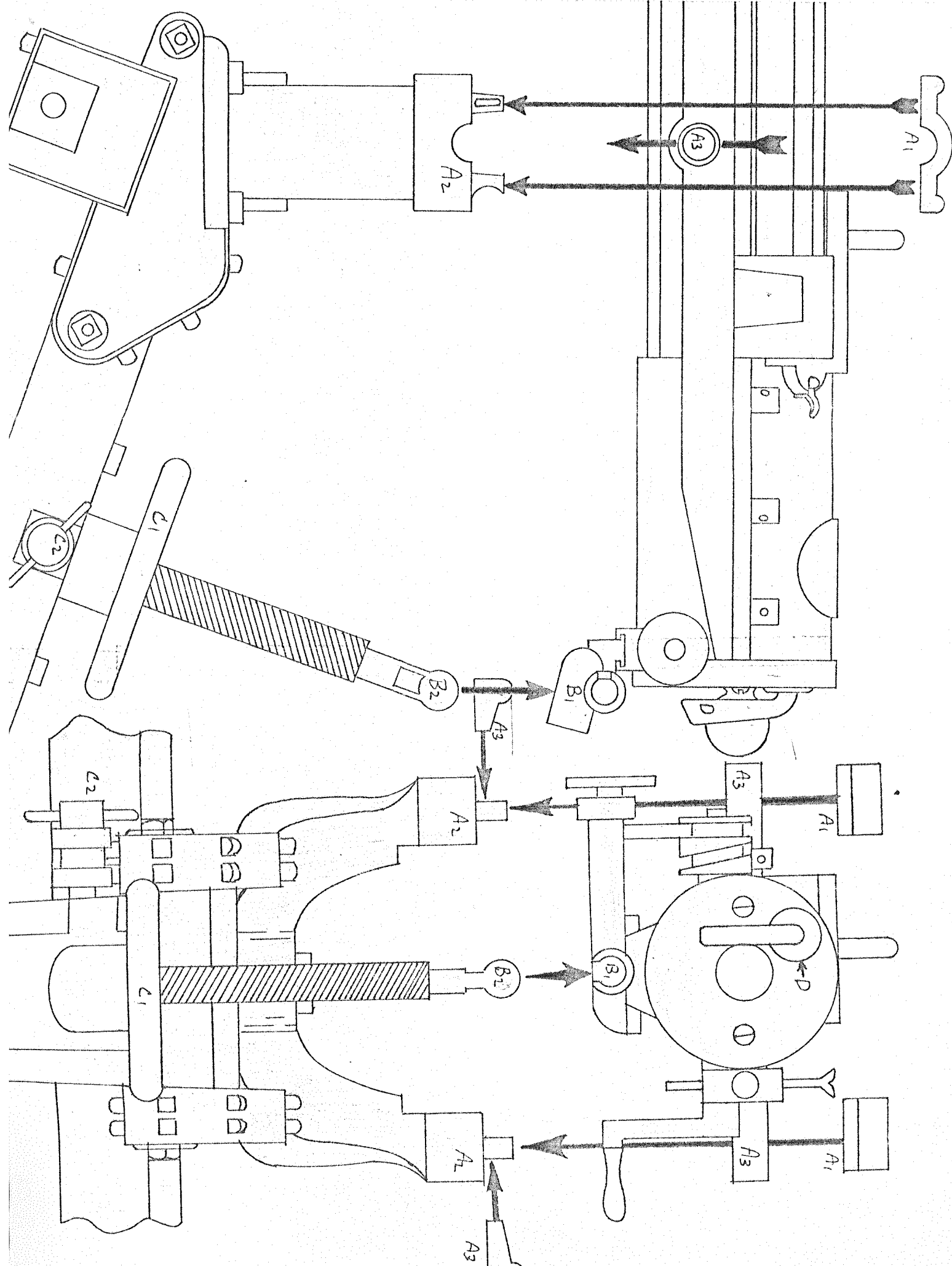
4- The part marked D is called the "breach port bolt access knob". This is a knob which when turned slightly may be removed leaving an access to the bolts. Remove some of these bolts one at a time occasionally to check for broken firing pins.

5. The tube may not be disassembled and so cleaning can be simply done from the muzzle of the barrels (especially after firing blanks), and by occasionally oiling the bolts, bolt tray, and loading tray.

*Important!*

*Keep barrels oiled or they will Rust!*

TUBE ASSEMBLY TO CARRIAGE

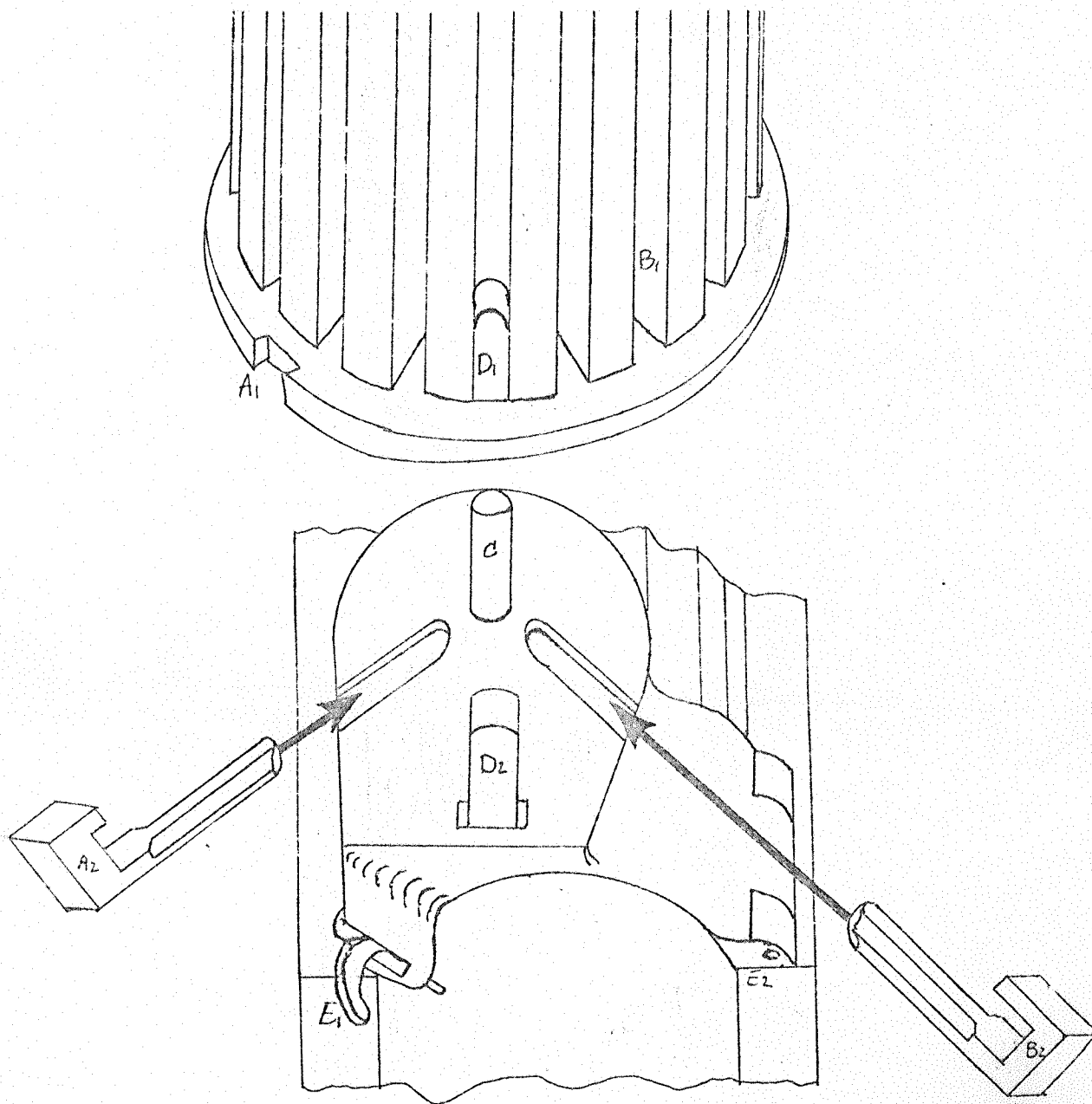


# MAGAZINE ASSEMBLY AND FUNCTION

1- First, it should be noticed that key A1 and key B2 are slightly different in shape. The keys should be placed in and move freely in their respective slots.

2- Assemble magazine by placing it on the magazine post marked C. The base of the magazine should then be locked in place by the left key (A2), while the rest of the magazine can rotate. As the base is locked into place, slot D will line up with slot D2. The bullets may then be fed through these slots by sliding key B2 inbetween the bullet chambers of the magazine Marked B1.

3- The small lever marked E is "spring loaded" and when pulled will allow the loading gate up on its hinges (marked E2).



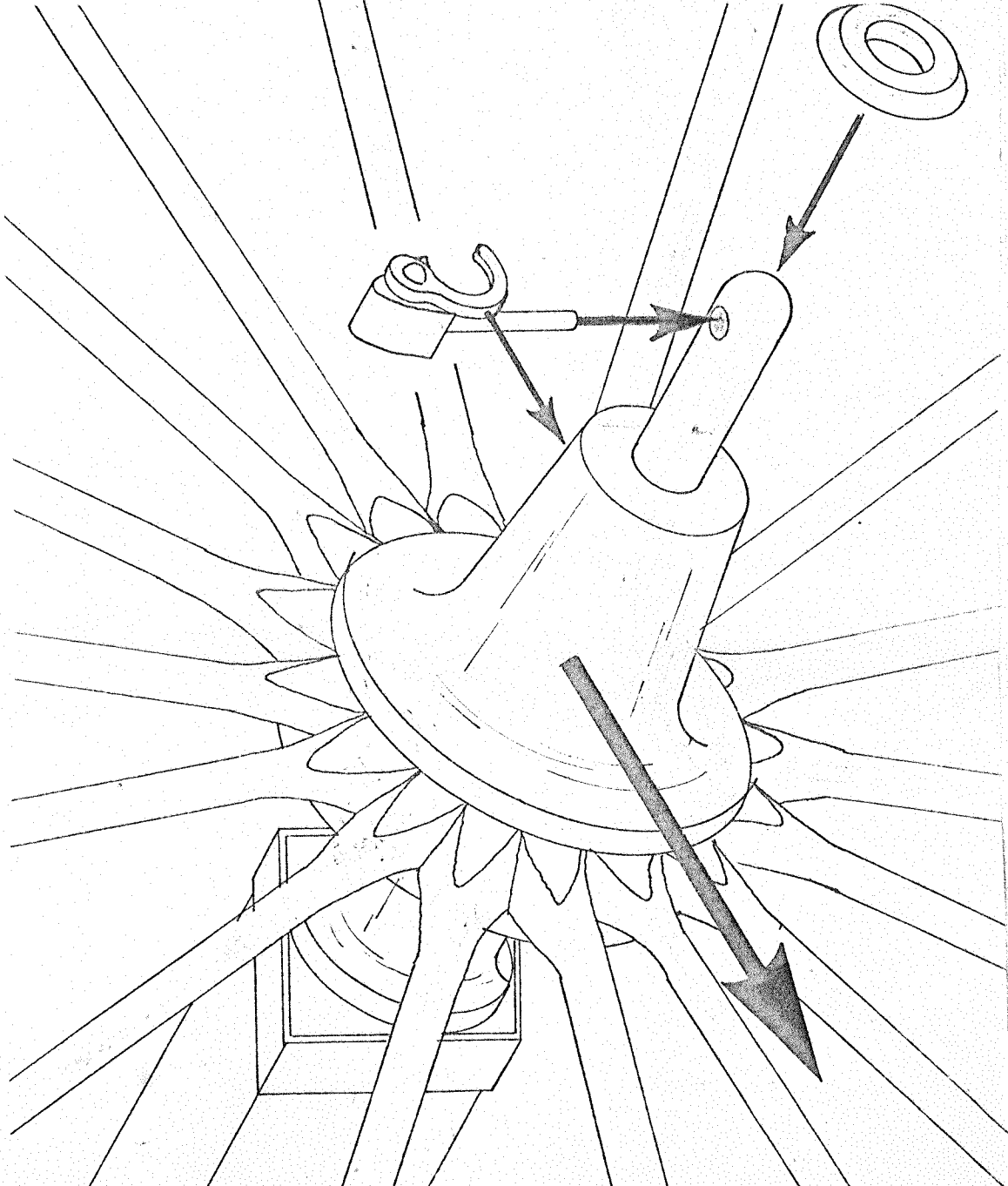
# WHEEL & LOCK PIN ASSEMBLY

1- First, notice that the spokes are set into the hub at a 5° angle. In the older days, this added to the strength of the wheel. The wheels must be put on so that the angle of the wheel is outward from the Gun.

2- The pin is then placed vertically downward with the snap arm facing toward the front of the gun. The large arrow in the diagram left, is pointing toward the rear of the Gun or toward the trail-piece end.

3- Before step two is completed the washer should be placed on the axle shaft.

In Gatlings original "1874" M. Gun, the pins were facing in this direction so that as the Gun was being transported from place to place, the pins wouldn't be knocked loose, but still would be able to lock. There are two pins which are opposite of each other.



# LOADING THE MAGAZINE

It is advisable to hold the magazine by the left hand and drop the bullets through the bullet slot. Then, by rotating the magazine base slightly either right or left, a new slot will be lined up for loading. Maximum capacity is about 220 shells.

