



LICENSING ENFORCEMENT DIVISION
WESTERN AUSTRALIA POLICE FORCE
January 2023

FIREARM DEACTIVATION GUIDELINES

Licensing Services

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Firearm Deactivation

The purpose in deactivating a firearm is to render the firearm incapable of being returned to its original firing condition whilst at the same time preserving the appearance of the firearm.

There are two procedures: Sectioning or Rendering Innocuous.

Sectioning

This procedure involves the machining (milling) of all the major parts of the firearm to expose the internal mechanism.

This shows the working parts of the firearm for display and instructional purposes whilst also deactivating the firearm such that it is incapable of being returned to its original firing condition.

Rendering Innocuous

This procedure includes welding all major parts of the firearm plus welding a steel rod into the barrel and removing or destroying the functionality of specific parts.

The firearm generally retains its pre-rendered functional appearance but is incapable of being returned to its original firing condition.

The following instructions detail the minimum standards for firearm deactivation required by Western Australia Police Licensing Services.

Further advice can be obtained by contacting:

Licensing Services (Firearms)
Western Australia Police Force
303 Sevenoaks Street
CANNINGTON WA 6107

Phone: 1300 171 011

Email: LicensingServicesFirearms@police.wa.gov.au

Sectioning Innocuous Process

All major parts of the firearm are to be substantially weakened by machining (milling).

Sectioning Minimum Requirements

1. **The bolt/breech face** - Machine away one side of the bolt/breech face with a 45 degree backward facing cut to allow enough material remains to hold the firing pin, extractor and ejector. The cut must break through the side of the bolt. Remove 50% of the locking surface to a depth of 4mm. Shorten the firing pin so that it does not protrude beyond the bolt face.
2. **The barrel** - Remove eighty percent of the chamber length to a depth removing one third of the chamber diameter or $\frac{1}{4}$ section, and at two points further along its length for a distance of 15mm and in the same style as the chamber, one point must be within 10 mm of the muzzle. The remaining 20% of the chamber is to have a close fitting steel rod inserted and welded.
3. **The gas system** - (if fitted): Must be machined the length of the piston head removing $\frac{1}{3}$ of the diameter. A cut must be made in the cylinder which is equal in width to half the cylinder inside diameter for the distance of the piston travel or 10mm whichever is less, and a slot must be machined to remove half the diameter of the gas port for a distance of half its length.
4. **The receiver, slide and locking lugs** - Must have a cut in the ring to match the chamber cut and another cut, which removes 50% of the locking surface to a depth of 4mm (in the case of a removable locking shoulder, through the locking shoulder and 4mm into the supporting material). A cut which removes 50% of the receiver side or slide (left or right) or a minimum distance of 35mm must be made. This cut does not have to be exposed but must be in the area of the locking surface or between the locking surface and the breech face. If the firearm has an upper and lower receiver both areas must be sectioned. The hinge point on the lower receiver must be sectioned by removing a quarter section across it. The rear locking pin must be weakened by machining away 50% of its cross section.
5. **The hammer** - is to have a slot 2mm deep machined across the face so that it cannot contact the firing pin.
6. If the firearm is of a belt fed type the **feed pawls** and **actuating arm/s** are to be weakened by a cut with a minimum width of 5mm through 50% of its thickness or width.

Rendering Innocuous Process

Manual Metal Arc Welding (MMAW): A process that uses an electric arc in which the joining of the metals is accomplished by melting the parent metal and the tip of a flux coated electrode.

Gas Metal Arc Welding (GMAW): A process in which an electric arc is struck between a continuously fed consumable wire and the work piece. The process is shrouded by an inert gas to prevent contamination.

Gas Tungsten Arc Welding (GTAW): A process that employs a heat source in the form of an electric arc between a non-consumable tungsten electrode and the work piece. A manually used filler rod is used to complete the fusion. This process is shrouded by an inert gas to prevent contamination.

Rendering Innocuous Minimum Requirements

Bolt Action Rifle

- A calibre size hole is to be bored through the chamber wall.
- A close fitting steel rod is to be inserted into the barrel and welded at the muzzle and breech. Another bore size hole is to be drilled in the middle of the barrel and the steel rod is to be welded to the interior of the barrel. This hole can be then filled after the welding process.
- The firing pin must be removed or broken off and the firing pin hole welded closed.
- The bolt is to be welded to prevent its removal from the receiver.
- The barrel is to be welded to prevent its removal from the receiver.

Self-Loading Rifle

- A calibre size hole is to be bored through the chamber wall.
- A close fitting steel rod is to be inserted into the barrel and welded at the muzzle and breech. Another calibre size hole is to be drilled in the middle of the barrel and the steel rod is to be welded to the interior of the barrel. This hole can be then filled after the welding process.
- The firing pin must be removed or broken off and the firing pin hole welded closed.
- The bolt is to be welded to prevent its removal from the receiver.
- The barrel is to be welded to prevent its removal from the receiver.
- The gas piston and spring are to be removed and the gas port filled with weld.

Pump Action Rifle

- A calibre size hole is to be bored through the chamber wall.
- A close fitting steel rod is to be inserted into the barrel and welded at the muzzle and breech. Another calibre size hole is to be drilled in the middle of the barrel and the steel rod is to be welded to the interior of the barrel. This hole can be then filled after the welding process.
- The firing pin must be removed or broken off and the firing pin hole welded closed.
- The bolt is to be welded to prevent its removal from the receiver.
- The barrel is to be welded to prevent its removal from the receiver.

Lever Action Rifle

- A calibre size hole is to be bored through the chamber wall.
- A close fitting steel rod is to be inserted into the barrel and welded at the muzzle and breech. Another calibre size hole is to be drilled in the middle of the barrel and the steel rod is to be welded to the interior of the barrel. This hole can be then filled after the welding process.
- The firing pin must be removed or broken off and the firing pin hole welded closed.
- The bolt is to be welded to prevent its removal from the receiver.
- The barrel is to be welded to prevent its removal from the receiver.

Air Rifle / Air Pistol

- A close fitting steel rod is to be inserted into the barrel and welded at the muzzle and breech. Another bore size hole is to be drilled in the middle of the barrel and the steel rod is to be welded to the interior of the barrel. This hole can be then filled after the welding process.
- Where applicable, the spring piston and spring are to be removed and the gas port filled with weld.
- A cut must be made along the full length of the compression chamber/internal reservoir/pressure reservoir/gas cylinder such that it can hold no pressure. Where the pressure reservoir/gas cylinder is removable, it is to be welded to prevent its removal from the firearm.
- The barrel is to be welded to prevent its removal from the receiver/compression chamber/internal reservoir (or from being broken-open/pumped).

Muzzle Loading Rifle

- A hole 60% the size of the bore is to be bored through the chamber wall.
- Close fitting steel rods of minimum 50 mm length are to be fitted and welded at the chamber and muzzle ends of the barrel. Another hole 60% the size of the bore is to be drilled in the middle of the barrel and a steel rod plug is to be welded into the interior of the barrel. This hole can be then filled after the welding process.
- The barrel plug is to be welded in place.
- The flash hole is to be welded over.

Single or Double Barrel Shotgun

- A hole(s) is to be bored just forward of the chamber(s) of 60% of the bore size.
- Close fitting steel rods of minimum 50 mm in length are to be fitted and welded at the chamber and muzzle ends of the barrel. Another hole, 60% the size of the bore is to be drilled in the middle of the barrel(s) and a steel rod plug is to be welded into the interior of the barrel(s). This hole can be then filled after the welding process.
- The firing pin(s) is to be removed, broken off or welded to the receiver and the firing pin hole(s) welded closed.
- The breech lever is to be welded to the receiver.
- The barrel is to be welded with a substantial weld to the receiver to prevent its opening. This may be completed by welding the barrel lug or barrel to the receiver.

Pump Action Shotgun

- A hole is to be bored just forward of the chamber of 60% of the bore size.
- Close fitting steel rods of minimum 50 mm in length are to be fitted and welded at the chamber and muzzle ends of the barrel. Another hole, 60% the size of the bore is to be drilled in the middle of the barrel and a steel rod plug is to be welded into the interior of the barrel. This hole can be then filled after the welding process.
- The firing pin must be removed or broken off and the firing pin hole welded closed.
- The bolt is to be welded to prevent its removal from the receiver.
- The barrel is to be welded to prevent its removal from the receiver.

Self-Loading Shotgun

- A hole is to be bored just forward of the chamber of 60% of the bore size.
- Close fitting steel rods of minimum 50 mm in length are to be fitted and welded at the chamber and muzzle ends of the barrel. Another hole, 60% the size of the bore is to be drilled in the middle of the barrel and a steel rod plug is to be welded into the interior of the barrel. This hole can be then filled after the welding process.
- The firing pin must be removed or broken off and the firing pin hole welded closed.
- The bolt is to be welded to prevent its removal from the receiver.
- The barrel is to be welded to prevent its removal from the receiver.

Revolver

- A calibre size hole is to be bored into the barrel as close to the forcing cone as possible.
- A close fitting steel rod is to be inserted into the barrel and welded at the muzzle and forcing cone. Another calibre size hole is to be drilled in the middle of the barrel and the steel rod is to be welded to the interior of the barrel. This hole can be then filled after the welding process.
- The cylinder is not to be removable from the frame and each cylinder chamber is to be welded closed.
- The hammer nose/firing pin must be removed or broken off and the firing pin hole welded closed.

Self-Loading Pistol

- A calibre size hole is to be bored through the chamber wall.
- A close fitting steel rod is to be inserted into the barrel and welded at the muzzle and breech. Another bore size hole is to be drilled in the middle of the barrel and the steel rod is to be welded to the interior of the barrel. This hole can be then filled after the welding process.
- The barrel is to be welded to prevent its removal from the slide.
- The slide is to be welded to prevent its removal from the frame.
- The firing pin must be removed or broken off and the firing pin hole welded closed.
- All internal working parts not seen from the outside are to be removed.

Submachine Gun

- A calibre size hole is to be bored through the chamber wall.
- A close fitting steel rod is to be inserted into the barrel and welded at the muzzle and breech. Another bore size hole is to be drilled in the middle of the barrel and the steel rod is to be welded to the interior of the barrel. This hole can be then filled after the welding process.
- The firing pin must be removed or broken off and the firing pin hole welded closed.
- The bolt is to be welded to the receiver for 80% of its length.
- The barrel is to be welded to prevent its removal from the receiver.
- All internal working parts not seen from the outside are to be removed.

Machine Gun

- A calibre size hole is to be bored through the chamber wall.
- A close fitting steel rod is to be inserted into the barrel and welded at the muzzle and breech. Another bore size hole is to be drilled in the middle of the barrel and the steel rod is to be welded to the interior of the barrel. This hole can be then filled after the welding process.
- If the firearm has a feed cover, it is to be welded to the receiver.
- The firing pin must be removed or broken off and the firing pin hole welded closed.
- The bolt is to be welded to the receiver for 80% of its length.
- The barrel is to be welded to prevent its removal from the receiver.
- All internal working parts not seen from the outside are to be removed.

Mortar

There are two approved methods for rendering innocuous a mortar.

Option 1:

- A hole at least 50% of the bore diameter is to be cut into the barrel.
- The hole is to be between 100 and 300 millimetres from the bottom of the barrel.
- The firing pin must be removed or broken off and the firing pin hole welded closed.

Option 2:

- Four (4) cuts, a minimum of 2 millimetres wide are to be cut along the length of the barrel, divided equally around the diameter of the barrel.
- The cuts are to extend from the bottom of the barrel to a minimum height of 300 millimetres.
- The firing pin must be removed or broken off and the firing pin hole welded closed.

Related Documentation

LICENSED FIREARM DEALER, MANUFACTURER OR REPAIRER

FORM 20 / FORM 21

- The firearm is brought into stock via a Form 20 under the listing of 'To Be Rendered'
- Once the firearm has been rendered innocuous and returned to the owner, the firearm is removed from stock via a Form 21 under the listing of 'Rendered Innocuous'

LICENSED FIREARM MANUFACTURER OR REPAIRER

SERVICEABILITY CERTIFICATE / PHOTOGRAPHS / WA POLICE CONFIRMATION LETTER

- Once the firearm has been rendered innocuous, the licensed firearm manufacturer or repairer should complete a firearm Serviceability Certificate detailing the firearm particulars and clearly marking on the Certificate that the firearm has been rendered innocuous.
- Photographs of the rendered firearm should be attached to the Serviceability Certificate and sent via mail or email to Licensing Services (Firearms) at the address listed on page 3 above. Please send (1) email for each firearm.
- Licensing Services (Firearms) will review the Serviceability Certificate and attached photographs. If Licensing Services (Firearms) are satisfied that the firearm has been successfully rendered innocuous, a confirmation letter will be sent to the licensed repairer or manufacturer who completed the process.
- The confirmation letter should be on-forwarded to the owner of the (now rendered) firearm as proof that the item is not considered a firearm and is no longer subject to firearm licensing or storage requirements under the Western Australia *Firearms Act, 1973* or *Firearms Regulations, 1974*.

Version Control

Date	Version	Author	Approval
31/01/2023	Version 1.1	PD11882 Tilt	PD11475 Primmer

