Australian Government
Australian Customs and Border Protection Service

Guide on Deactivating Warfare Items

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Customs and Border Protection
Firearms and Weapons section

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Introduction

The importation of appliances or equipment designed or adapted for warfare (or like purposes) is prohibited without PRIOR permission in writing of the Minister (or the Minister's delegate).

Import permission for items of warfare destined for collections are usually subject to a condition that the item must be rendered permanently inoperable (as distinct from 'inert' or 'free from explosive') prior to its arrival in Australia. The purpose of this guide is to provide information on the steps required to deactivate a warfare item to meet the standard required by the 'permanently inoperable' condition.

To avoid doubt, warfare items that are already deactivated in accordance with this guide still require import permission to be granted by the Minister (or the Minister's delegate) prior to its arrival in Australia.

Due to the many variations in design and manufacturing techniques used in the different warfare items, additional or alternate deactivation criteria may need be imposed on particular items to ensure that the relevant item is rendered permanently inoperable prior to import.

Enquiries on individual weapons permit applications can be sent to **weaponspolicy@customs.gov.au**

Firearms and Weapons Section
Cargo Policy Branch

Definitions

Definitions	
Welding	This procedure involves ARC or MIG welding only. Where a steel rod is inserted and welded into the barrel, and the welding of all the major parts of the large calibre armament, in a way that cannot be reversed. **Superficial or spot welding will not be accepted.** Welding will need to result in a strong bond along the total section/length of the nominated parts.
Sectioning	This process involves the machining or milling of all the major parts of the large calibre armament or bomb/grenade/landmine body in a way that cannot be reversed and exposing the internal mechanism.
Other Terminology	
Ordnance (weapons)	"Heavy mounted guns" and includes artillery, howitzers, cannons, self propelled guns, mortars, machine guns etc, flame throwers.
Explosive Ordnance	Ammunition and explosive or pyrotechnic devices
Ammunition	Complete rounds of ammunition of all types and calibres and components thereof (cases, projectiles, primers, etc). For the purposes of this guide, ammunition includes grenades, mortar bombs, mines, etc.

Machine guns or rifles greater than .50 calibre (12.7 mm)

Require Welding or Sectioning

Welding Procedures

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.
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 Procedures

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. 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. Machine guns with trunnion blocks will have a T cut machined into the base. This cut will be no less than 10mm in diameter with the top of the 'T' extending across the full width of the receiver.
6. 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.
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. Machine a 3mm slot through the actuating arm(s) removing 50% of the thickness
10. Remove half the diameter of the gas port for a distance of half of its length.
11. 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.
12. Remove one third of the diameter of the piston head.
13. Remove half of the sear mating surfaces.
14. Machine 3mm from the face of the hammer where it contacts the firing pin.

FIELD GUNS INCLUDING SELF-PROPELLED GUNS, HOWITZERS, CANNONS, RECOILLESS RIFLES, AIRCRAFT AND OTHER AUTOMATIC SHELL FIRING CANNONS OF .79 CALIBRE (20 MM) OR GREATER

1. Bore a calibre size hole (up to a maximum of 20mm diameter in 40mm and larger calibre guns) through the lower half of the barrel.
2. Firing mechanism – the firing pin to be cut off and the firing pin hole welded fully closed.
3. Bore a 15mm hole in the side of the buffer cylinder or otherwise deactivate the recoil mechanism where practicable.

NOTE: AUTOMATIC OR BURST FIRING SHELL FIRING CANNON OF 20mm OR GREATER CALIBRE if designed to be carried and deployed by hand shall be treated as a MACHINE GUN.

MORTARS

1. Bore a hole of half calibre size (up to a maximum of 20mm diameter in any mortar) into the chamber or base end of the barrel.
2. Weld the barrel to the end plug if they separate.
3. Ground back the firing pin nose, and if detachable weld to the barrel.
4. Any firing mechanism is to be welded to the housing.

ROCKET/PROJECTILE LAUNCHERS

1. Bore a hole of half calibre size (up to a maximum of 20mm diameter in any launcher) into the tube approximately halfway along its length.
2. The firing mechanism is to be welded solid. If an electric type, the generator is to be removed and the housing filled with an epoxy resin.

DAZZLE OR DECOY DEVICES

1. All chemical residues removed.
2. Machining or milling of all the major parts of the dazzle or decoy device body by at least an eighth exposing the internal mechanism.

EQUIPMENT DESIGNED OR ADAPTED FOR THE MAKING OF SMOKE SCREENS

1. All chemical residues removed.
2. Machining or milling of all the major parts of the smoke screen body by at least an eighth exposing the internal mechanism.

EXPLOSIVES OR INCENDIARY MATERIALS

Will not be approved for private collections.

FLAME THROWERS

Flame throwers are to be deactivated by either of the following procedures

Welding Procedures

1. All chemical residues removed.
2. All of the internal mechanisms of the weapon are to be welded. The supply equipment is to be rendered inoperable by welding the control valves shut.

Sectioning procedures

1. All chemical residues removed and cut a 15mm hole in the tank/tanks.
2. Remove the ignition source and prevent its replacement by machining or milling its seat to prevent replacement or weld it to the flame thrower body.

Ammunition and Explosive or Pyrotechnic Devices

GASES OR LIQUIDS DESIGNED FOR THE PURPOSE OF KILLING OR INCAPACITATING PERSONS, AND DEVICES OR APPARATUS DESIGNED OR ADAPTED FOR USE WITH THOSE GOODS

Will not be approved for private collections

GRENADES OF ANY TYPE, WHETHER CHARGED OR NOT

Fragmenting grenades

1. All chemical residues removed.
2. Fuse/detonator to be separated from the main body.
3. Removal of striker section where it comes in contact with detonator/fuse.
4. Machining or milling of all the major parts of the grenade (including fuses) by at least an eighth exposing the internal mechanism.

Signal, smoke, light case pyrotechnic use grenades

1. All chemical residues removed.
2. Fuse/detonator to be separated from the main body.
3. Removal of striker section where it comes in contact with detonator/fuse.
4. Drill a 6 – 8 mm hole in the side of the body.

MINES

1. All chemical residues removed.
2. Machining or milling of all the major parts of the mine by at least an eighth exposing the internal mechanism.

MORTAR BOMBS, BOMBS, ROCKETS OR ANY OTHER MISSILE

1. All chemical residues removed.
2. Machining or milling of all the major parts of the item in by at least an eighth exposing the internal mechanism.

TRIP FLARES

1. All chemical residues removed.
2. Machining or milling of all the major parts of the trip flare by at least an eighth exposing the internal mechanism.

PROJECTILES/CASES

1. Uranium depleted rounds or similar items will not be approved for private collections.
2. Rounds containing any tracer, incendiary or explosive compounds similar items will not be approved for private collections.

SOLID PROJECTILES

1. Solid projectiles without internal components or compartments are not required to be sectioned and must not be seated in any cartridge/shell casings.

HOLLOW OR COMPARTMENTED PROJECTILES

1. All chemical residues removed.
2. Machining or milling of all the major parts of the item in by at least an eighth exposing the internal mechanism or compartment (including timing fuse).

CARTRIDGE/SHELL CASES

1. All chemical residues removed and the primer/ignition device removed or expended to ensure that the case is free from all explosive compounds.
2. For cases less than 40mm in calibre and direct fire tank ammunition of any calibre, a 1mm hole must also be drilled through the side of the cartridge/shell case on the lower 1/3 of the case.
3. Cartridge or shell cases 40mm or greater in calibre (excluding direct fire tank ammunition) do not require the drilling of any hole, and must be free from all explosive compounds as noted above.

PARTS AND ACCESSORIES DESIGNED OR ADAPTED FOR WARFARE, OR FOR USE WITH, ANY OF THE ABOVE ITEMS

Deactivation procedures for parts and accessories will be determined on a case by case basis on receipt of an application for permission to import a particular part or component.