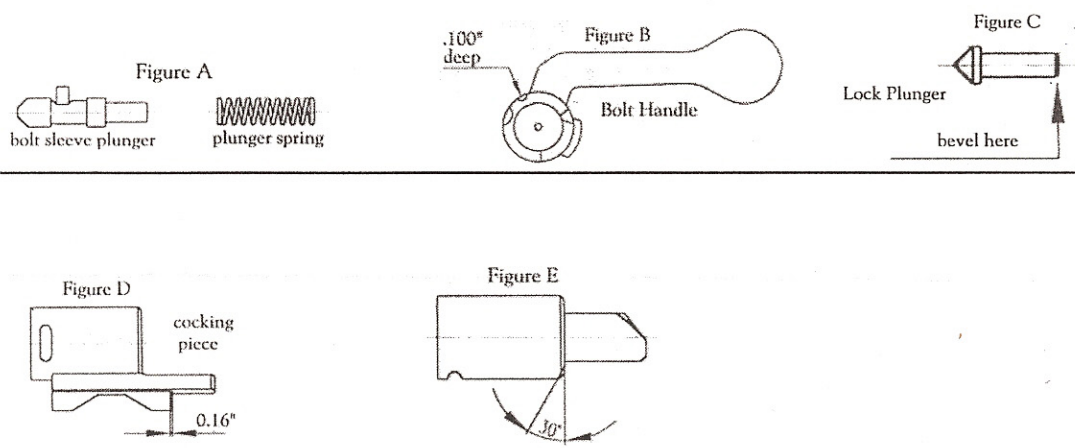


## Installation Instructions For Mauser Bolt Sleeve with 3 Position Safety

1. Dis-assemble original Mauser bolt sleeve. Lock plunger and spring will be used in new bolt sleeve. (Figure A)
2. Dis-assemble new safety by removing lever, plunger & spring.
3. Screw safety into the back of the bolt to check that it turns freely on the bolt.
4. Dykem back of bolt, screw the safety shroud into the bolt, insert bolt into action and close bolt all the way. Mark end of bolt through plunger hole in bolt sleeve with small scribe.
5. Remove bolt and bolt sleeve and create half round cut where marked .100" deep with a carbide burr. (Figure B)
6. Assemble all bolt components without firing pin spring and check that lock plunger engages the bolt body freely when safety moves to safe position. Bevel lock plunger if necessary. (Figure C)
7. Remove .016" from cocking piece as shown in drawing. (Figure D) Create 30 flat on cocking piece as shown in drawing (Figure E), just enough to achieve a .012" to .016" lift.
8. Final function check:  
 Free turning of bolt sleeve  
 Free movement of safety, bolt must be locked in full safe position but open in middle position.  
 Safety must lift cocking piece .012" to .016", sear must move freely.  
 With safety in forward position, rifle must fire and bolt must open freely, cocked or fired.  
 Check firing pin protrusion if longer than .055. Shorten to .055.



Warning: Mauser actions come from many sources and tolerances can vary. Safe operation is the responsibility of the installer not the maker of the safety!