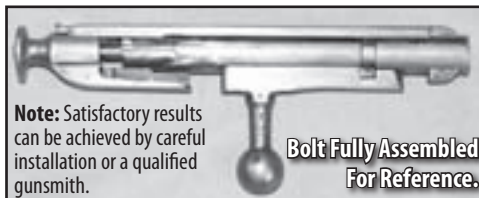


Package Contains

- | | |
|------------------------------------|----------------------------------|
| (1) Instruction Sheet | (1) #11 (.191/larger) Drill Bit |
| (1) Machined Stainless Bolt Handle | Drill Bit |
| (1) Adapter Bushing | (High Speed Steel) |
| (Black Oxide Finish) | (1) #21 (.159/smaller) Drill Bit |
| (1) 82 Degree Counter Sunk Socket | (High Speed Steel) |
| Head 10/32" x 1/2" | |

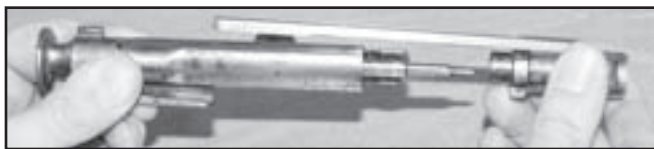
STEP ONE Open bolt to be sure weapon is unloaded.

STEP TWO Remove bolt by lifting bolt, squeezing trigger and pulling bolt out to rear.



- (1) Hardened Aluminum Black Anodized Scope Mount
- (1) 10-32 Tap
- (1) Machine Screw

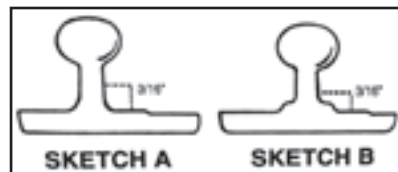
STEP THREE Disassemble bolt. Grasp bolt handle, pull rearward and turn cocking piece 1/4 turn to left, making sure bolt guide bar remains intact. This removes spring tension on bolt. Bolt head and guide bar slide forward as an assembly, exposing firing pin.



Note position marks at rear of cocking piece, this aligns firing pin depth correctly and must be returned to exact position for safe operation. Firing pin (under spring tension) may now be unscrewed using fork-shaped end of guide bar slide.



STEP FOUR Clamp bolt in padded vise with bolt handle upward. Mark bolt handle base shank (marker or paint). Measure upward 3/16" on knob shank from base of bolt and scribe line on shank. **See Sketch A and B.**



STEP FIVE Re-check 3/16" measurement, leaving room for finish filing (if necessary) later. Cut off bolt handle.



STEP SIX For "non-stepped" (Sketch A) press the 1/2" spacer inside the new Advanced Technology, Inc. bolt handle (supplied). "Stepped" (Sketch B) bolt handles DO NOT require spacer. Place the Advanced Technology, Inc. bolt handle over the cut off "nub" on the original bolt. Clamp in padded vise with the back face of the Advanced Technology, Inc. bolt handle FLUSH against front face of original bolt. (Normal bolt position.)

STEP SEVEN Using larger #11 drill, carefully "spot drill" area for mount screw - just deep enough to create a centered starting point for the tap drill - Step #8. Cutting oil is recommended.

STEP EIGHT Using the supplied #21 (smaller) drill bit, drill through the center of the bolt forging. **NOTE: BE SURE THE ADVANCED TECHNOLOGY, INC. BOLT HANDLE IS STILL IN THE ORIGINAL POSITION.**

STEP NINE Still clamped, use 10-32 tap, and tap hole through bolt. Deburr and thoroughly clean bolt and handle.

STEP TEN Place Advanced Technology, Inc. bolt handle in place on the forging. Install and tighten supplied 10/32 countersunk machine screw. Use of thread lock is recommended. Finished bolt handle should fit flush with forging when completed.

STEP ELEVEN Reassemble and reinstall bolt in action.

Other Advanced Technology, Inc. Products:

Enfield Monte Carlo Stock

#ENF0013 (.303 & .308 No 1, Mk3)

#ENF0041 (.303 & No 4, Mk1)

.303 Enfield Scope Mount

#ENF0141 or #ENF0131



Mosin Nagant Monte Carlo Stock

#MOI0300

Also available in Mossy Oak® New Break-Up Camouflage



Mosin Nagant

Scope Mount & Bolt Handle

#MOI0600

Mauser 98 Stock with Built-In Weaver Scope Rail

#MSS1500



Mauser Bolt Handle

#MBH1800

****NOTE:** Straight-bolt or wide-arc bolt Mausers MUST use our Conversion Bolt Handle to convert to bent-bolt!

