

**Procedure for changing the Model 788 Bolt Lock Safety Arm
To a Non-Bolt Lock Safety Arm**

This procedure will remove the bolt lock feature on the Model 788 rifle. It involves marking a line along the top of the safety and the removal of the top portion of the safety by grinding. After being marked the safety arm is removed from the trigger housing for the grinding operation; therefore, it is not necessary to remove the trigger housing from the receiver.

- A. Check chamber and magazine for live ammo.**
- B. Remove the magazine box. Press the magazine release button forward and pull the magazine box downward.**
- C. Remove the bolt. Cycle the bolt to the rearward position. Push and hold the safety button forward, and remove the bolt assembly.**
- D. Remove the front action screw, the rear action screw, and the trigger bow.**
- E. Remove the barreled action from the stock.**
- F. Hold the barreled action securely in the horizontal position. Place the safety into the full rearward position. Note that the top rounded corner of the safety can be seen extending upward into the receiver on the right side.**
- G. Now mark a line on the left side of the portion of the safety that extends above the slot in the receiver. We recommend that a sharp corner of either a small triangular or square stone be used to mark this line. The edge will create a bright line in the black oxide color. (The safety is very hard and difficult to mark with a normal scribe).**
- H. Remove the safety arm from the trigger assembly:**
 - 1. Remove the screw from the housing, which guides the safety through the elongated slot.**
 - 2. Remove the small snap washer from the left end of the safety pivot pin.**
 - 3. Remove the safety pivot pin.**
 - 4. The rear of the safety can now be rotated downward away from the trigger housing. While rotating the safety downward control the safety detent plunger and safety detent plunger spring which are located under the safety in a recessed hole in the right side of the trigger housing. Remove the safety and set the plunger and spring aside.**