

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.**

- I. The line scribed on the left side of the safety should be approximately 100 thousandths of an inch inward from the rounded top of the safety. The line should be straight, bright and clear to use as a guide for hand grinding.
- J. Using a suitable bench grinder, with a work support, carefully grind away all the material above the marked line. The material removed must be to the marked line and can go as far as 1/32 of an inch below the line. The resulting edge should be square and straight. Carefully smooth the corner of this edge by additional light grinding or stoning to remove any burrs. Use a cold blue to cover the bare material.
- K. Reassembly the safety:
1. Place the safety plunger and plunger spring in proper position under the safety and rotate the safety into the receiver slot.
 2. Reassemble the screw to the trigger housing through the elongated slot in the safety.
 3. Install the safety pivot pin and snap washer.
 4. Move the safety button back and forth between the "safe" and "fire" positions several times to make sure that it moves freely between the detented positions.
 5. Look into the receiver to be sure that the cup top edge of the safety is at or below the slot in the receiver and that it does not bind during movement.

Reassemble the bolt and move it forward to the closed position. Check to see that the bolt can be cycled in both the "safe" and "fire" positions. Check to see that the safety functions properly.

Once the rifle passes the safety tests, reassembly the rifle and repeat the safety tests in the assembled rifle.