

To remove the firing pin assembly from the bolt assembly-Rotate the bolt plug clockwise until the firing pin assembly releases rearward from the bolt body. If the bolt plug is rotated counter-clockwise such that the firing pin head falls into the cam cut, firmly clamp the firing pin head, pull the bolt assembly forward and rotate clockwise aligning the firing pin head to the cocking notch or further until the firing pin assembly releases from the bolt body. The firing pin assembly should not be disassembled, if any component of the firing pin assembly is damaged, replace the entire firing pin assembly. To reassemble, slide the firing pin assembly into the bolt body, align the firing pin head to the left of the cocking notch in the bolt body, depress and rotate the bolt plug until the firing pin head aligns with the cocking notch.

To remove the bolt head from the bolt body-Remove the bolt assembly pin from the bolt body. Slide the bolt head forward from the bolt body. If the bolt head is replaced for any reason, the headspace must be inspected before attempting to fire the firearm. To reassemble, insert the bolt head into the bolt body aligning the assembly pin hole in the two components so that the ejector is located opposite of the bolt handle. Insert the bolt assembly pin so that the cross hole in the pin will align with the firing pin.

To remove the ejector from the bolt head-Remove the ejector retaining pin. **Caution:** The ejector is under spring pressure, prior to removing the retaining pin ensure the ejector is supported so that it does not spring out of the bolt head. To reassemble, insert the ejector spring and ejector into the bolt head, align the slot in the ejector with the retaining pin hole. Depress the ejector to the bolt face and insert the ejector retaining pin.

To remove the extractor from the bolt head-Remove the ejector per instructions above. For non magnum bolt heads, use a small punch to rotate the extractor clockwise until the extractor leg is exposed. Grasp the leg with pointed pliers and continue to rotate until the extractor releases from the bolt head. To reassemble, insert the right leg of the extractor below the bolt shroud and rotate against the dimple, lightly push the left leg toward the center of the bolt head working the extractor in to the bolt shroud. When assembled, the extractor claw should be the only visible portion of the extractor when viewed from the front. The extractor should hold a fired case firmly in place when pointed downward.

For magnum bolt heads, use a pointed punch to drive the extractor rivet inward towards the center of the bolt head and remove. Rotate until an extractor leg is exposed, grasp with pointed pliers and continue rotating until the extractor releases from the bolt head. To reassemble, insert the extractor under the bolt shroud aligning the hole in the extractor and bolt shroud. Insert the extractor dimple into the hole from the inside outward, support and peen the rivet from the outside. Test spring pressure with an empty case, adjustment of tension force may be adjusted by pressing the extractor inward to reduce pressure or pulling outward to increase pressure. The extractor should hold the case firmly in place when pointed downward.