

Number	Description
1	Bolt Sleeve
2	Cocking Sleeve
3	Safety
4	Firing Pin
5	Main Spring
6	Bolt Body
7	Extractor

## Disassembly Instructions



1) Open the bolt as shown in figure 1.



2) Close the bolt.



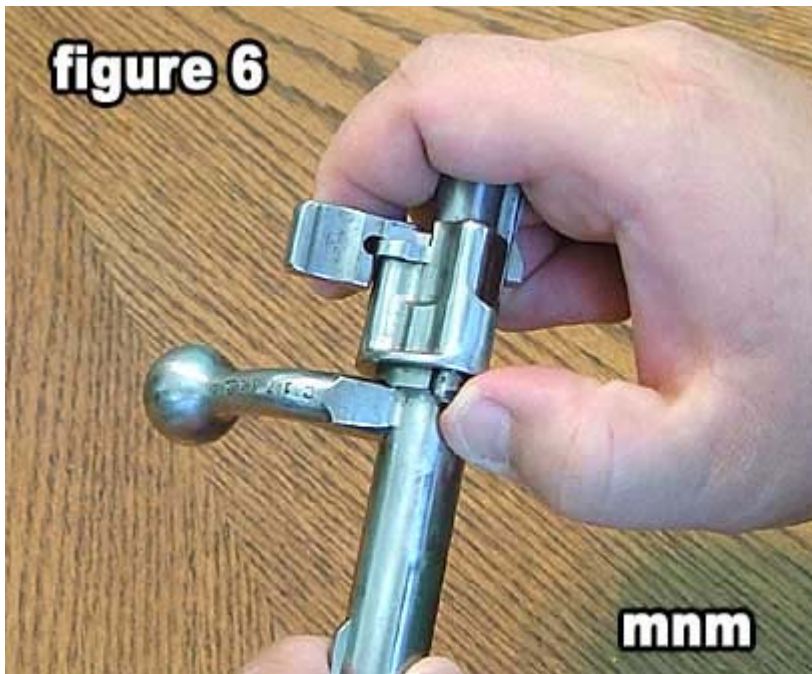
3) Set the safety lever to point straight upward as shown in figure 3.



4) Pull the bolt to the rear of the receiver.



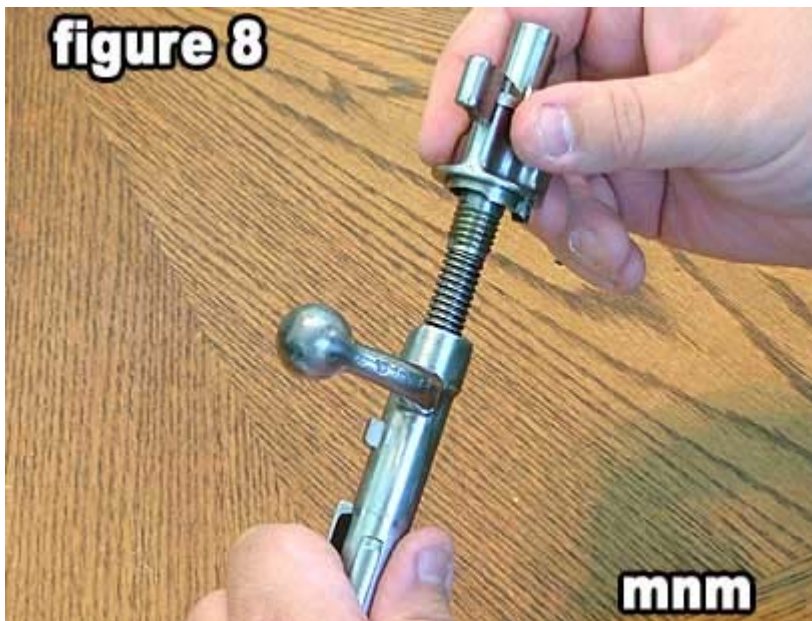
5) Swing bolt release lever on left side of receiver and remove the bolt.



6) Figure 6 shows the retaining pin on the bolt sleeve.



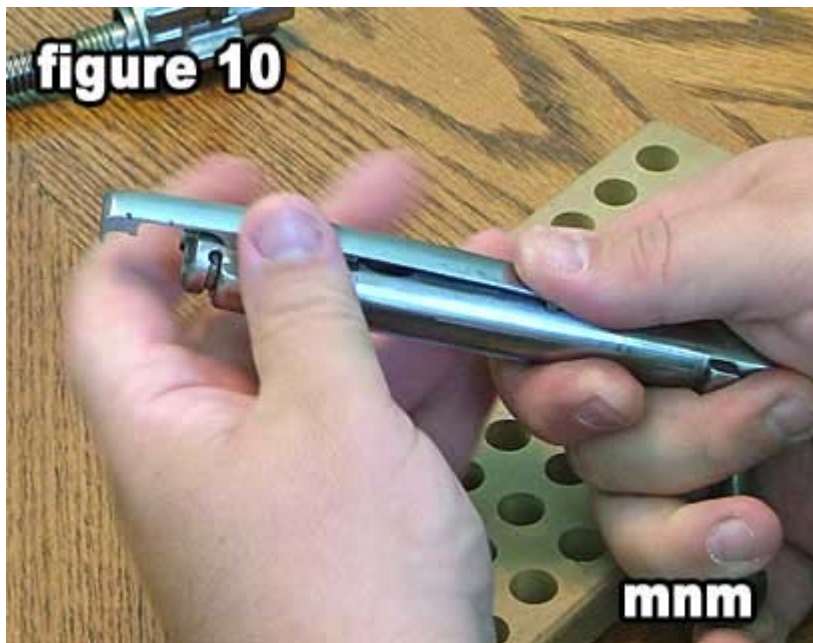
**7)** Push the retaining pin in and rotate the bolt counter clockwise.



**8)** After completely unscrewing the bolt sleeve from the bolt body, remove from the bolt body.



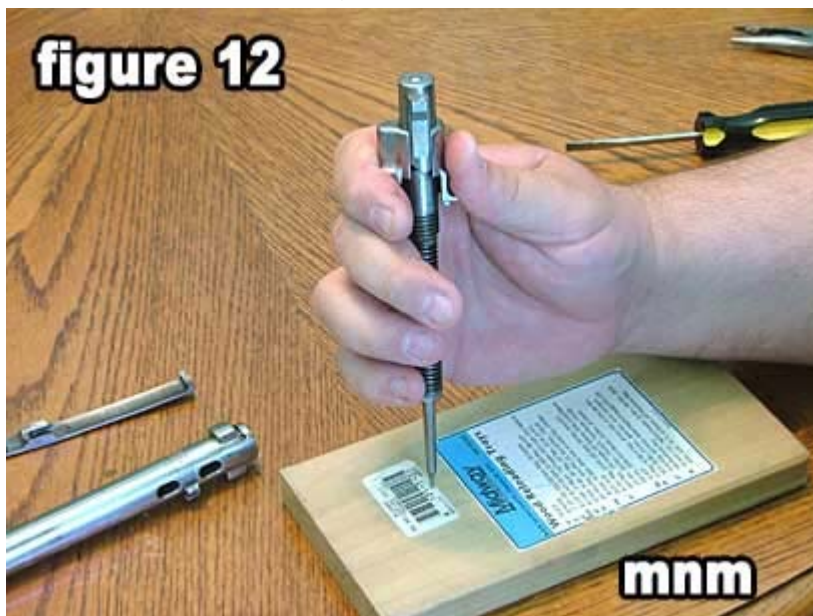
**9)** Rotate the extractor (clockwise if holding bolt as shown in figure 9) until it rest outside the groove on the front of the bolt body.



**10)** Slide the extractor forward and off of the bolt body.



**11)** The bolt has a lug that fits into a channel on the extractor as shown in figure 11.



**12)** Make sure you have a block of wood handy to place the firing pin against as show in Figure 12.

Do not use your wife's dinner table - the tip of the firing pin will leave a very deep indentation in the wood.

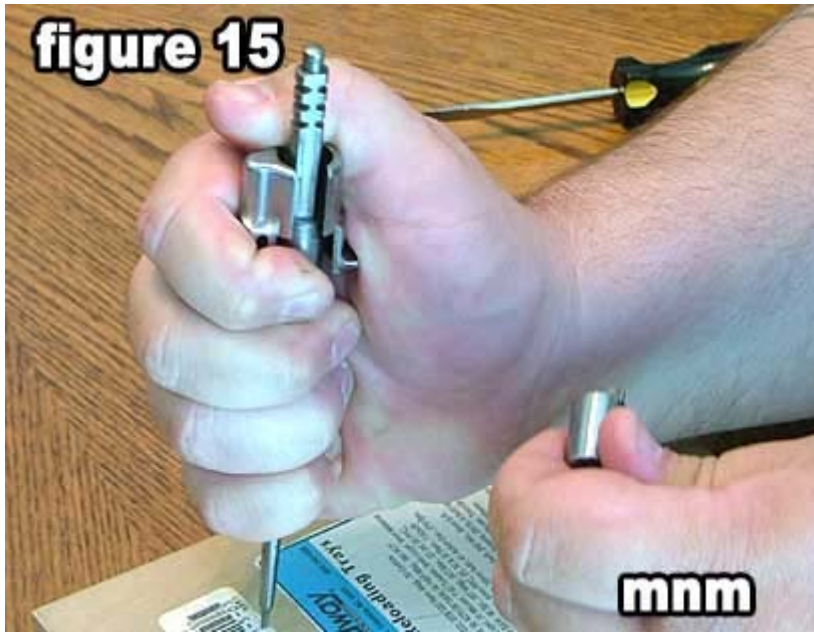
You should use wood - because most other surfaces will allow the firing pin to slip and could cause harm to you or damage to your surroundings. I use a wooden reloading tray that can be picked up for about \$6.00, but any wood block will work.



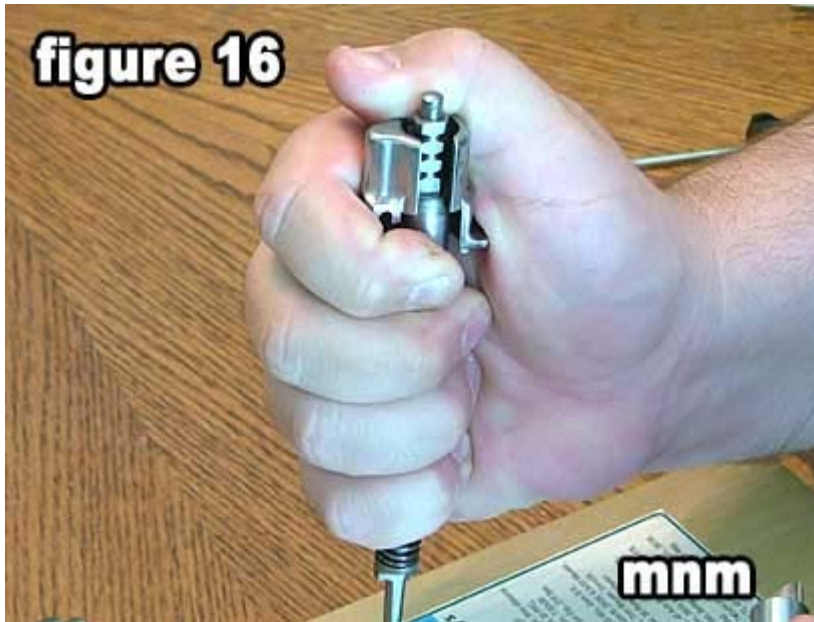
**13)** Slide the bolt sleeve until the cocking sleeve clears and can be turned in either direction.



**14)** Turn cocking sleeve 1/4 turn in either direction.



15) Remove cocking sleeve and set aside.



16) Slowly release pressure on the bolt sleeve and main spring as shown in Figure 16.

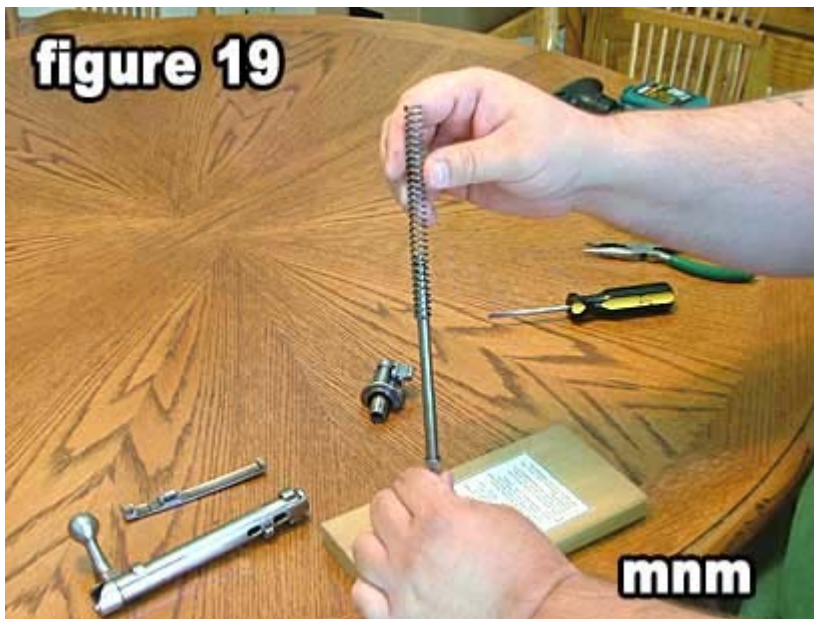




17) Allow main spring to fully expand as shown in Figure 17.



18) Remove the bolt sleeve.



19) Remove main spring as shown in Figure 19.



20) Turn safety lever all the way to the right.



21) Remove the safety lever and set aside.



22) Figure 22 shows the completed Mauser bolt disassembly.

## Reassembly Instructions



**23)** To reassemble the bolt - first take the bolt body and the extractor and slide the extractor's channel over the lug on the bolt body.



**24)** Figure 24 shows the extractor lined up with the channel near the bolt face.



25) Rotate the extractor counter clockwise until it fits into the channel.



26) Once the extractor is installed and in the channel, rotate the extractor counter clockwise as shown in figure 26.



27) Insert safety into rear of bolt sleeve as shown in figure 27.



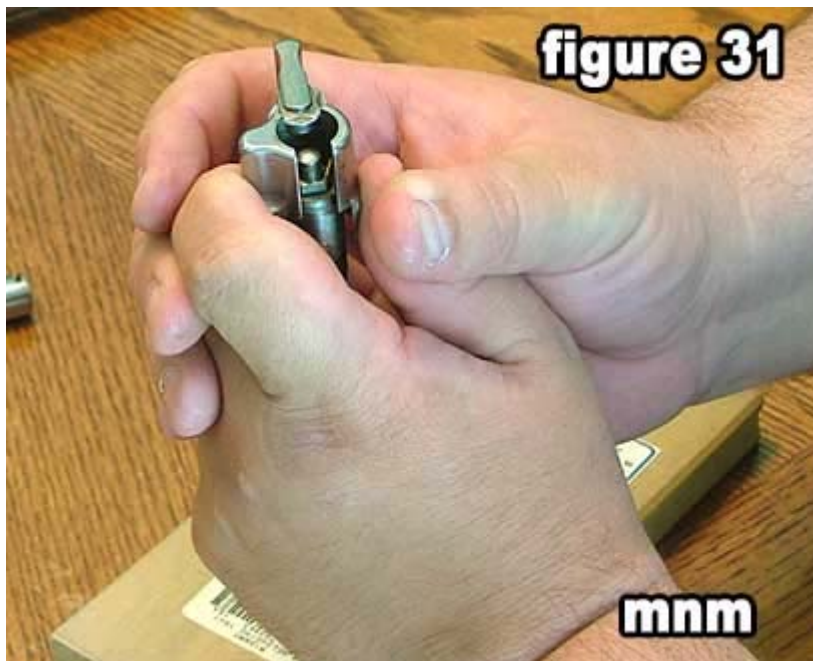
28) Figure 28 shows the safety properly installed.



**29)** Slide the main spring onto the rear of the firing pin.



**30)** Place the bolt sleeve over the rear of the firing pin (as shown in figure 30) and place the tip of the firing pin pointing down into a block of wood.

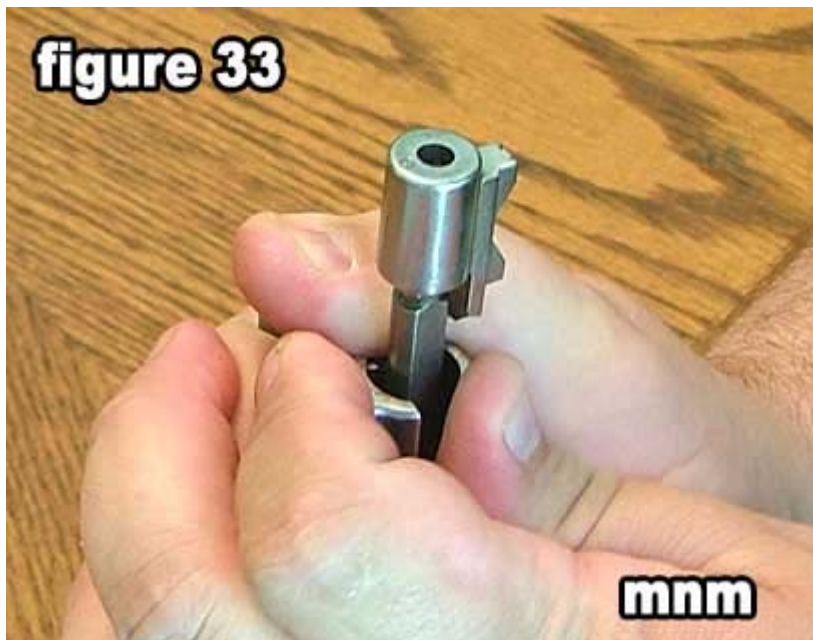


**31)** Slowly compress the main spring while pushing down of the bolt sleeve. It is a good idea to place the safety back into the middle position as it will give you a better grip as you are compressing the main spring.

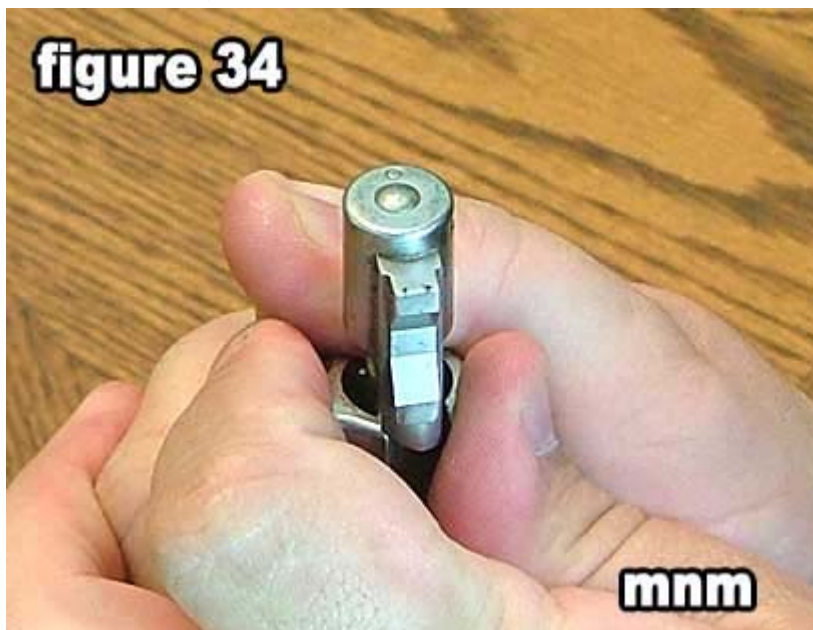


**32)** Fully compress the main spring.





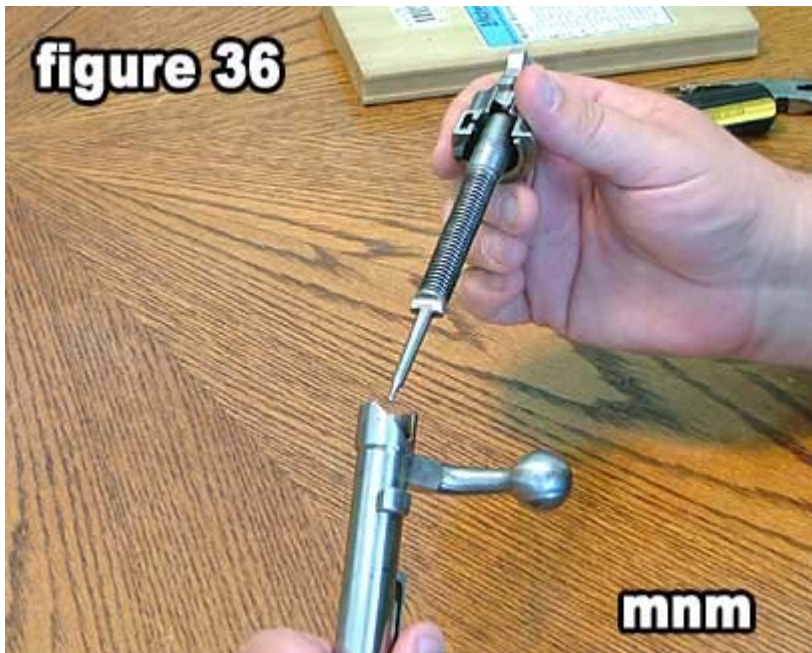
**33)** Return the cocking sleeve to the rear of the firing pin as shown in figure 33.



**34)** Rotate the cocking sleeve 1/4 turn so the bottom is facing the bottom side of the bolt.



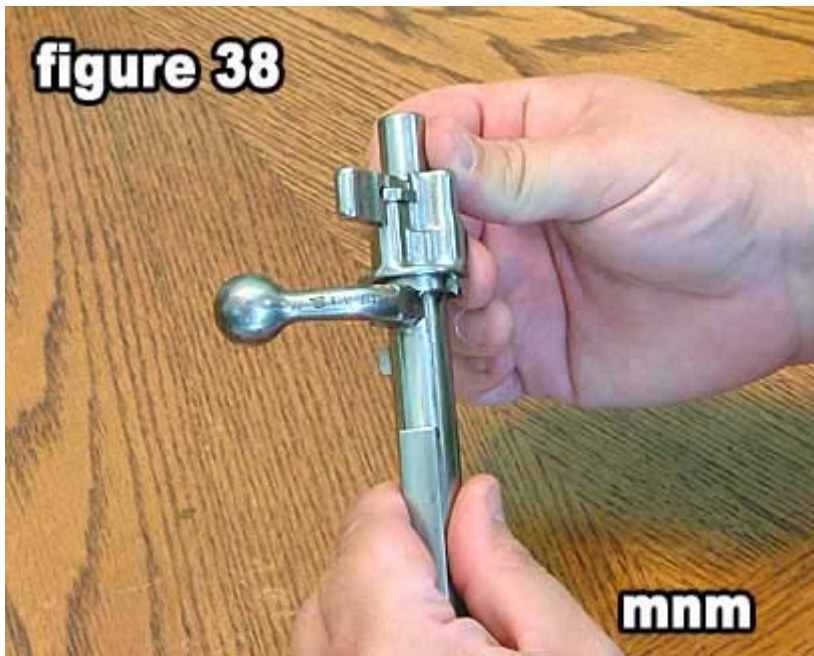
**35)** Allow the main spring and bolt sleeve to expand locking the cocking sleeve into place as shown in figure 35.



**36)** Insert the firing pin assembly into the back-end of the bolt body.



37) Rotate the bolt sleeve clockwise.



38) Figure 38 shows the bolt sleeve in its final resting position.



**39)** Rotate the extractor to be directly over the right hand bolt lug as shown in figure 39.



**40)** Insert bolt back into the rifle's receiver.



41) Close the bolt.



42) Move safety from middle position and you are finished disassembling and reassembling the Mauser bolt.

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