



# Mauser Bolt Handle



## Warning:

When handling a firearm, always follow the proper handling procedures at all times. Failure to follow these procedures could result in serious damage, injury, or death. WE are not responsible for damage to property, injury, or death resulting from improper installation, misuse or modification of products. If you are not comfortable completing any of the following steps, or do not have the proper tools enlist the help of your local gunsmith. We are not responsible for components that are damaged due to improper installation.

## Parts List



A. Bolt Handle

## Hardware List



1. Screw 1/4-20 x 3/8"
2. Drill Bit - #5
3. Tap - 1/4-20

## 1 Bolt Handle Installation

Begin by removing the entire bolt from the rifle. Place the bolt in a vise leaving the bolt handle extending out.

Refer to Figure 1. Use a hack saw to cut the existing handle at the dotted line. This point is where the round of the handle meets the square portion. NOTE: Cut off the handle as square as possible.

Refer to Figure 2. Use a metal file to clean up any burrs and file a small radius around the end of the remaining bolt handle.

Place the new bolt handle at the end of the remaining bolt handle stub and check for fit. Refer to Figure 2, lightly file all 4 sides slightly more than 1/8" down from the top and file a small radius on the outside corner. Again check for fit. Repeat the process until the new bolt handle fits onto the remaining stub. NOTE: You want a tight fit to eliminate any movement to the new handle when installed.

With the new bolt handle fitted on the remaining stub, use a center punch to mark the dead center of this spot.

Use the supplied drill bit (#5 - .205) and drill a hole 1/2" deep. Thread this hole with the tap supplied (1/4-20).

Place the new bolt handle on the stub and use the 1/2 - 20 x 3/8" stainless steel screw supplied. Tighten securely. NOTE: To prevent this screw from loosening use LOC-TITE or similar adhesive on the threads.

**You're finished.  
Now enjoy your new mount!**

**Add additional ATI Accessories to  
your Builds!**



ATI's Bolt



Standard Bent Bolt  
(No Conversion Necessary)



"Wide Arc" Bolt  
(Must Convert to use a scope)



Straight Bolt  
(Must Convert to use a scope)

