Mauser Bolt Handle

Parts List

A

A. Bolt Handle

Hardware List

1
2
3

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 dotteed line. This point is where the round of the handle meets the square portion. NOTE: Cut off the handle as sqaure as possible.

Refer to Figure 2. Use a metal file to clean up an 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 ont he 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 Coversion Necessary)

1.25"+

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

Straight Bolt
(Must Covert to use a

Figure 1

File this area to fit

File Radius

Slightly more than 1/8"

CUT-OFF Bolt Handle

Figure 1

Bolt