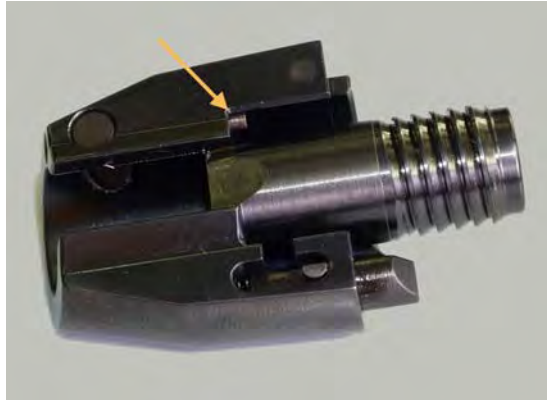


Installation Manual for VOERE – Wing type safety

1.) Shortening of the bolt lock screw



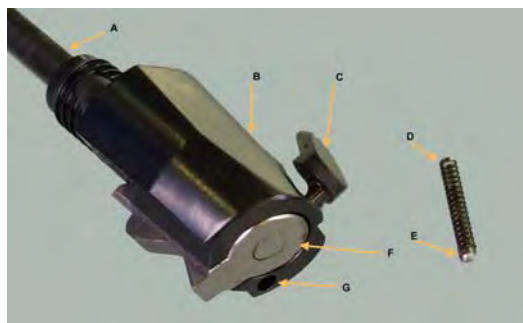
Shorten the bolt lock screw (see illustration) until the bolt can be screwed into the sleeve without touching (there should be a gap of about 0,2 mm). When screwing the bolt into the sleeve the wing of the safety has to be closed.

2.) Disassembling of the safety wing

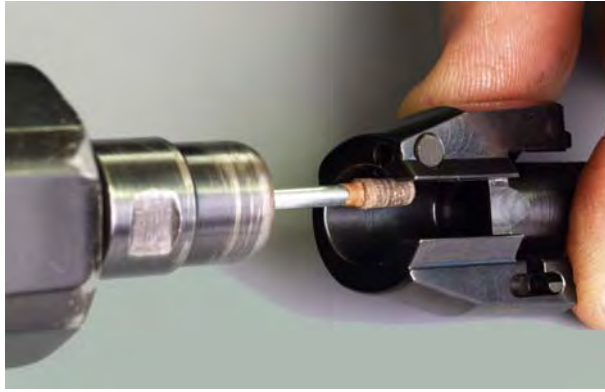


Cover the hole on the front side with your thumb. Open the wing of the safety (180°). Lift the wing up and take the bolt and spring out of hole initially covered with your thumb.

3.) Adopting the wing to the bolt nut



Assemble the bolt nut (F) onto the firing pin (A) and push it into the sleeve (B). (see illustration). The sleeve may not scratch on the bolt. If it does, you need to grind the wing (C) of the safety inside the sleeve.



4.) The bolt lock

Grind a groove on the bolt at the end of the curve.
The groove should be about 1,5 mm deep and as wide that the safety wing. Opens up by 180° when mounted.



5.) Chamfer on the boltsleeve



Grind a chamfer on the bolt nut – on the right hand side on an angle of about 40°-60° around 1,5 mm wide.

6.) Assembling the safety wing



Put bolt and spring into the front side hole use a little screw driver or punch dia. 2 mm to press it into the hole while putting the wing in.

7.) Finishing the notch



Test the safety, the movement of the safety and functioning. If the trigger is pressed when the safety is on, the rifle may not fire when the safety is put off by itself. In this case the notch has to be grinded to the correct distance