

VOERE Präzisionstechnik GmbH

Untere Sparchen 56 · A-6330 Kufstein/Tirol
Tel. +43-(0)5372-62547 · Fax +43-(0)5372-65752
office@voere.at · www.voere.com

Installation instructions Security cocking action VOERE for K98

Introduction K98

The installation of a safety cocking piece is critical and must be carried out by a competent gunsmith. For the safety cocking piece with chamber lock a 6 mm hard metal drill is necessary. Since the original bolt sleeve is completely replaced, it can be reinstalled at any time.

Cocking



Before beginning work, ensure that your gun is unloaded. Check visually that no cartridge is in the chamber or the magazine. Cock the weapon and activate the safety. If your gun has a 3-position safety, choose the middle setting (gun safe, chamber lock inactive). If you have a 2-position safety with chamber lock, make the weapon safe and open the bolt. The diagram shows a cocked gun with 3-position safety in the middle setting.

If opening is impossible with the safety on, the gun must be decocked, which requires extra effort since the pressure of the firing pin spring must be overcome.

Remove the bolt



Remove the bolt from the gun by rotating it and pulling it rearwards. By pressing or raising (according to the model) the catch and pulling the bolt further to the rear it can be removed.

Unscrewing the bolt sleeve from the bolt



Press the locking pegs on the front side of the bolt sleeve while unscrewing the bolt sleeve anticlockwise. When the bolt sleeve is unscrewed, pull it fully out.



Preparing the safety cocking piece

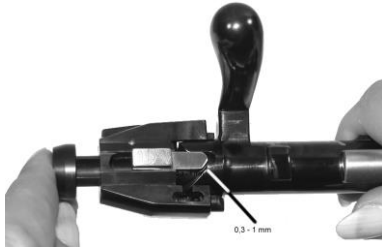


Hold the cocking piece in your hand and, if it hasn't been done already, push the return spring with the impact disk over the firing pin. Push the spring with a slight turning motion right over the guide as far as it will go.

Screw the safety cocking piece in the bolt

Before screwing the safety cocking piece in the bolt, ensure that it is released. The cocking piece is released when the cocking lever projects. If this is not the case, press the knob on the side and pull the cocking lever rearwards. Now push the safety cocking piece into the bolt and screw it in, with the locking pins pressed in.

Checking the travel of the firing pin



After the assembly turn the bolt sleeve so the underside is visible. Press the cocking handle (see diagram) fully in (fired position) and check that there is 0.3 – 1 mm clearance between firing pin rim and bolt sleeve. If the rim contacts the bolt sleeve forwards, the clearance **MUST** be corrected, or the rim will be destroyed when shooting.

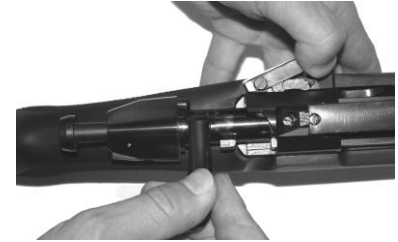
Adjustment of stroke



If the clearance is not correct, release the tension on the bolt sleeve by pulling out the cocking handle. Extract the bolt sleeve by reversing the assembly. Set the clearance with the adjustment nut (see diagram).

Then reassemble the bolt sleeve. Repeat this step until the clearance is correct.

Installation of the bolt



Install the bolt in your gun.

For the first shots with the cocking piece check the firing pin indentation

Installation of the chamber lock



The chamber lock consists of a sleeve and a screw which are built into the bolt. Before installation a 6 mm hole must be drilled in the safety projection of the K98 bolt. Use a 6 mm hard metal drill. The hole should be bored approximately centrally in the safety projection and extend to the inner drilling. Glue and press the sleeve in the hole. The sleeve is an interference fit and must sit firmly, so a strong force is necessary. The screw which is located in the sleeve must be set to be just clear of the wall of the action (no scratching!). If the screw is too long, it must be shortened appropriately.

Reinstallation of original bolt sleeve

Reinstallation is possible at any time. Please follow the sequence of steps in the reverse order. Ensure that all parts of the safety cocking piece are removed from the bolt.

Chamber lock model

Please Note: to open the bolt you must tap the cocking handle or cock the gun.