



**Installation Instructions for the Pacific Tool & Gauge, Inc. 3 Position Safety Assembly  
for all 98 Mausers & F.N.'s.**

**FOR PROPER OPERATION OF THE 3 POSITION**  
**FOLLOW DIRECTIONS CAREFULLY!!**

1. Disassemble bolt and striker assembly.
2. Remove firing pin for striker.
3. Grind a 25° (degree) angle, surface grinder is best but can be done on a bench grinder if care is taken. Fig. " C "
4. Locate and grind, or mill a .125 diameter 1/2 circle in rear of bolt body (this is for the bolt lock plunger to lock bolt in full safe position). Fig. " A "
5. Grind firing pin at 45° (degrees) as noted to clear safety lever. Fig. " B "
6. Assemble new bolt sleeve and safety; safety should move striker forward .015 to .020. If it does not cam the striker rearward, carefully grind sear back, try again. Repeat if necessary until you get the striker to move rearward .015 to .020.
7. Pull trigger with safety on. Release safety. Do this several times... If gun dry fires, the safety is not camming the striker rearward far enough. You must take more off of the sear until the striker has enough rearward movement to take striker sear off of the trigger sear.

