



GENTRY CUSTOM LLC
314 N. HOFFMAN ST.
BELGRADE, MT 59714

*Installation instructions for the Gentry 3-position safety assembly for all 98, F.N., and Mark X Mausers.
For proper operation of the 3-position safety follow directions carefully.*

1. Disassemble the bolt and striker assembly.
2. **COMPLETELY disassemble new bolt sleeve. Remove the plunger, spring and lever BEFORE INSTALLING on your bolt.**
3. To disassemble new bolt sleeve, remove the cross screw which holds the safety lever in place with the allen wrench provided. Screw the new bolt sleeve into the bolt and try it in the action. If it is too tight use fine lapping compound to fit parts to each other.
4. If lapping compound is used, make sure to clean with solvent.
5. Put layout dye on the rear of the bolt. Install bolt sleeve and put bolt into the action in the closed position. With a long scribe reach in and mark where the safety plunger will contact the rear of the bolt. The dimensions in Diagram A may alternately be used.
6. Remove the sleeve and with a 1/8" carbide cutter remove metal to the scribe line.
7. Assemble the safety lever, plunger and springs into the bolt sleeve. With the safety lever in the middle position try to screw the sleeve into the bolt, until the sleeve lock latches into the detent for it. You will have to remove the safety plunger and remove metal from the small end of the plunger until you can screw the sleeve into the bolt and close it in the action. Also check to see if the safety plunger is too long when the safety lever is in the forward position.
8. **BEFORE YOU MODIFY YOUR STRIKER CHECK FOR FUNCTION: YOU MAY NOT HAVE TO MODIFY FOR THE 30 DEGREE ANGLE AS IN THE DIAGRAM B.** If function is improper modify. A surface or tool and cutter grinder is strongly recommended.
9. Assemble the new bolt sleeve and safety. Safety should move striker rearward .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 - .020.
10. Pull trigger with safety on. Release safety. Do this several times. If the gun dry fires the safety is not camming the striker rearward far enough. You must take off the sear until the striker has enough rearward movement to take striker sear off the trigger sear.
11. Remember to install the cross screw with the provided allen wrench once everything checks out.
12. When installing safety on Interarms Mark X, the safety lever cam face on the striker needs to be further back to function. Grind it until it will be in the correct position for the lever to cam it back from the trigger. A Wolf Bitzschneel striker spring must be used.

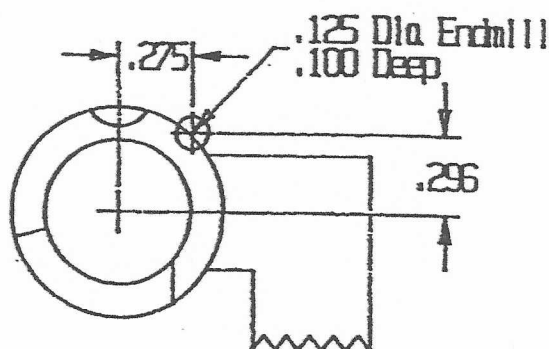


Diagram A

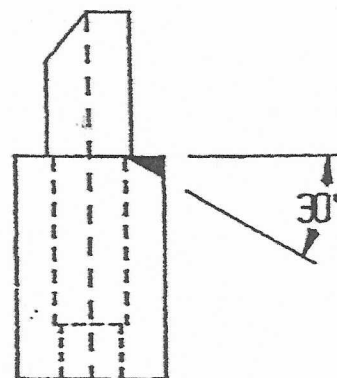


Diagram B

NO LIABILITY EXPRESSED OR IMPLIED FOR IMPROPER FIT BY NON QUALIFIED PERSONS.