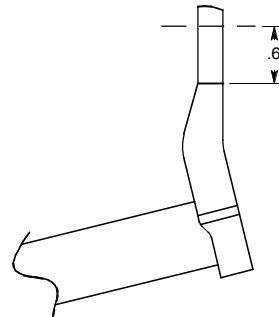
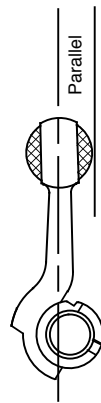
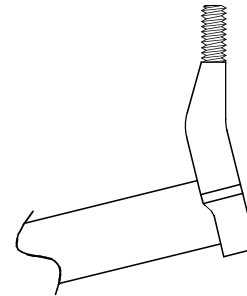


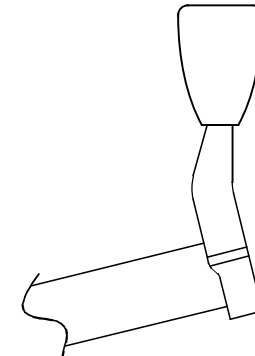
A



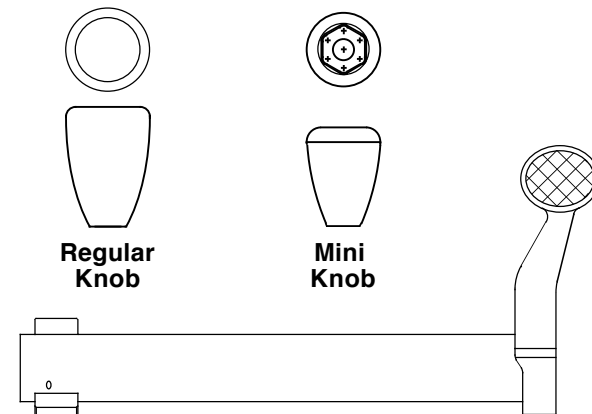
B



C



D



THIS KNOB IS FOR INSTALLATION ON REMINGTON BOLTS ONLY!

Warning: This Bolt knob must be installed by a competent gunsmith.

Making sure that the firearm is unloaded, Remove the bolt from the rifle and disassemble the firing pin assembly.

1. Place the bolt in a machine vise with the back of the handle parallel to the axis of the machines head. (fig. A)
2. Using a hollow mill or a boring head, turn the existing bolt knob down to a boss .313" dia. (fig. B) Then mill the end of the boss off leaving a straight section .6" long.
3. Thread the entire straight section 5/16-24 NF. (fig. C)
4. Degrease the threads and test the fit of the knob, (fig. D) If the knob fits correctly, apply a thread locker to the threads, we suggest acraglass or a similar epoxy.
5. When the thread locker has cured, re-assemble the bolt and install into the rifle.

If this is beyond the scope of your equipment you can send it to Badger Ordnance, See installation instructions.

Made in the USA

Unless otherwise specified Diminisions are in Inches TOLERANCES: ANGLES $\pm .5^\circ$ FRACTIONS $\pm .015$.00- .01 .000- .005 .0000- .0005	BADGER ORDNANCE	
	1209 Swift St 816 421-4956	N. Kansas City, MO. 64116 FAX 816 421-4958
Tactical Bolt Knob		
Dwg No. 306-31-2	Part No. 306-31	
ENGINEER: M. BORDSON	Scale NONE	Date: 16 SEPT 11
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