



Brownells Mauser Bolt Shrouds are intended to replace the military bolt shrouds on Model 98 and Swedish Model 96 (including the M-38) type military rifles. Some commercial variations of the Mauser 98 had bolt shrouds equipped with a safety, and the M-98 replacement Shroud can also be used on these actions. They **MUST** be used with aftermarket triggers incorporating a safety unit, as the new shroud is not equipped with its own safety.



WARNING



Never attempt to disassemble or reassemble a firearm unless you are absolutely certain that it is empty and unloaded. Visually inspect the chamber, the magazine and firing mechanism to be absolutely certain that no ammunition remains in the firearm. Disassembly and reassembly should follow the manufacturer's instructions. If such instructions are not immediately available, contact the manufacturer to see if they are available. If they are not available at all, then you should consult other reference sources such as reference books or persons with sufficient knowledge. If such alternative sources are not available and you have a need to disassemble or reassemble the firearm, you should proceed basing your procedures on common sense and experience with similarly constructed firearms.

With regard to the use of these tools, the advice of Brownells Incorporated is general. If there is any question as to a specific application it would be best to seek out specific advice from other sources and not solely rely on the general advice and warnings given.

HOW TO USE

Strip the bolt of the firing pin/bolt shroud assembly. Make certain there are no machining burrs, chips, etc., present on the threads of the new Shroud or in any holes or slots. Lightly lubricate the threads, and screw the Shroud into the bolt to check the thread fit of the new Shroud. The shoulder of the Shroud should stop against the root of the bolt handle and the threads should have a smooth fit. **NOTE:** Mauser '98 and '96 Military rifles were made for a period of about sixty years in numerous factories around the world. It is possible that if the new Shroud does not easily fit into the bolt, your bolt may have tight threads or the bolt's threads may have become damaged during alteration of the bolt handle. You can clean up the bolt threads with a **Brownells Mauser 98 Bolt Shroud Tap (#080-598-513)** so the Shroud will thread easily into the bolt.

When the Shroud will turn smoothly into the bolt, make sure the firing pin and cocking piece will enter the Shroud and slide smoothly. For the '98 Mauser Shroud, transfer the bolt sleeve stop and bolt sleeve stop spring from the original shroud into the new one. Reassemble the bolt. The new bolt shroud does not have the military safety to hold the cocking piece back. Use a small, flat washer or penny to retain the cocking piece while screwing the new Shroud/firing pin assembly into the bolt. Insert the penny into the machined recess (located on the side of the cocking piece) so it wedges between the rear surface of the Shroud and the top of the cocking piece. After the shroud is assembled into the bolt, grip the sides of the cocking piece's "foot" in a smooth jawed vise and pull back on the cocking piece. This will compress the spring to the point where the penny can be removed.

Turn the bolt shroud/firing pin assembly into the bolt to the locked and fired position, so the firing pin tip protrudes through the bolt face and check the protrusion with a firing pin protrusion gauge. Correct firing pin protrusion should be .055" minimum, .065" maximum. The Swedish '96 Mausers were built with a vertical extension on their cocking pieces to allow manual cocking in case of misfires. Misfires were something that occurred often with turn of the century, military ammo. This extension can be left alone, although it may prove to be a "finger-pincher", or it can be removed. If you choose to remove it, there are two methods generally used. The first is to simply saw off the extension above the body of the cocking piece. Next, file, grind, or use a machine lathe to turn the rear of the cock-

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ing piece into a round shape, leaving it full length. Match the radius of the lower section of the cocking piece where the extension has been removed.

The second method is to shorten the cocking piece and the firing pin by about 1/4" to eliminate the extension. This method has the added benefit of lightening the cocking piece and firing pin assembly, giving the shooter a little quicker lock time. Do not shorten the cocking piece or firing pin past "flush" with the rear of the bolt shroud when the firing pin is in the full forward or "fired" position. Slightly radius the corner of the cocking piece, and round the rear of the firing pin.

The Shroud is made of steel and shipped in-the-white. After installation, the Shrouds should be removed and blued, or treated with Brownells Teflon[®]/Moly Oven Cure Gun Finish.

Reassemble the firearm according to the manufacturer's instructions. Check for proper functioning using **ACTION PROVING DUMMIES**. Make sure **ALL SAFETY MECHANISMS** are fully functional as designed and approved by the manufacturer. If these tests prove satisfactory, test-fire the firearm with live ammunition in a **SAFE** and **APPROPRIATE** manner. **IMPORTANT!** Start the live ammunition tests by first loading an **ACTION PROVING DUMMY**, then a live round, into the magazine. Only after several tests have been conducted in this manner should additional rounds be placed in the magazine and fired.

For further information about working on Mauser bolt action rifles, we strongly recommend the book *The Mauser M91-M98 Bolt Actions, A Shop Manual*, by Jerry Kuhnhausen. Additional information can be found in *Bolt Action Rifles* by Frank de Haas, and *The NRA Gunsmithing Guide, Updated*. All of these books are available from Brownells.