

SAVAGE ARMS B.MAG BOLT HANDLE AND CAP RETROFIT INSTRUCTIONS

Please review these instructions carefully. If you are uncomfortable, have any questions or are unable or unwilling to replace these components, please call NIOA on 1800 017 573 (free call) Monday to Friday, 8:30 am–5:30 pm. CAUTION—Parts under tension. Wear eye protection while performing this retrofit.

BOLT HANDLE AND CAP REMOVAL

1. Remove the DETACHABLE BOX MAGAZINE and open the BOLT. Ensure the firearm is unloaded and remove the bolt (see pages 23-27 of the INSTRUCTION MANUAL). Do not rely on the bolt's extractor, physically look into the chamber to be sure.
2. Remove the BOLT ASSEMBLY by pressing the BOLT RELEASE while pulling the BOLT rearward and out of the receiver (see FIGURE 1).



FIGURE 1

TAKE A MOMENT TO FAMILIARIZE YOURSELF WITH THE BOLT ASSEMBLY COMPONENTS YOU WILL BE REPLACING (see FIGURE 2).

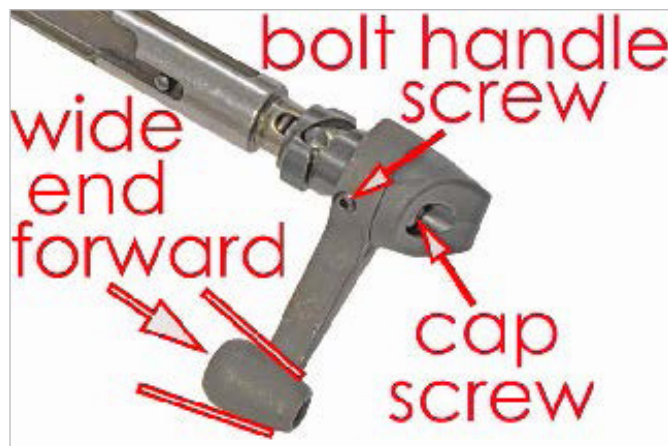


FIGURE 2

- Using the supplied 3/32" Allen wrench (silver color), remove the BOLT CAP screw and cap (see FIGURE 3)



FIGURE 3

- With the BOLT CAP removed, notice there is a SNAP RING (see FIGURE 4).



FIGURE 4

- Using the supplied SNAP RING PLIERS insert one tip into each SNAP RING hole to open the SNAP RING so it could be removed (see FIGURE 5). Gentle pressure should be used since the SNAP RING could slip off the pliers tips.

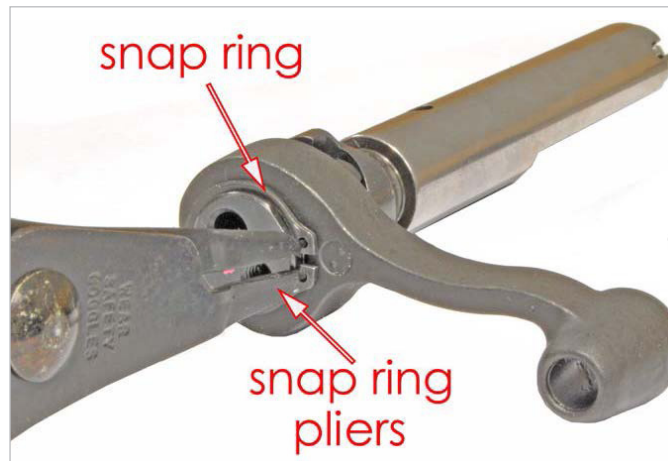


FIGURE 5

- Using the supplied 5/64" Allen wrench (black color), remove the BOLT HANDLE screw and pull the BOLT HANDLE off of the BOLT BODY (see FIGURE 6).



FIGURE 6

DISCARD THE OLD BOLT HANDLE AND CAP — DO NOT USE THEM ON ANOTHER FIREARM.

RETROFIT WITH NEW BOLT HANDLE AND CAP

1. Position the new BOLT HANDLE (see FIGURE 7) on the BOLT BODY, making sure that the BOLT HANDLE SCREW aligns with the BOLT SLOT (see FIGURE 8).



FIGURE 7

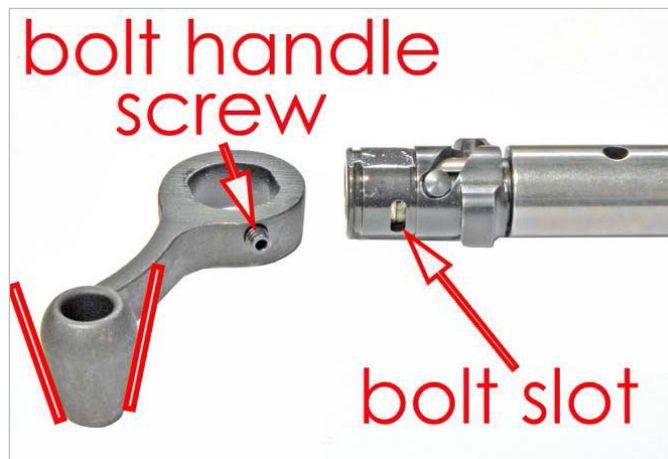


FIGURE 8

- Using the supplied SNAP RING PLIERS to open the SNAP RING, slide the SNAP RING over the end of the bolt body and into the SNAP RING GROOVE, making sure the SNAP RING holes are aligned as shown in FIGURE 9.

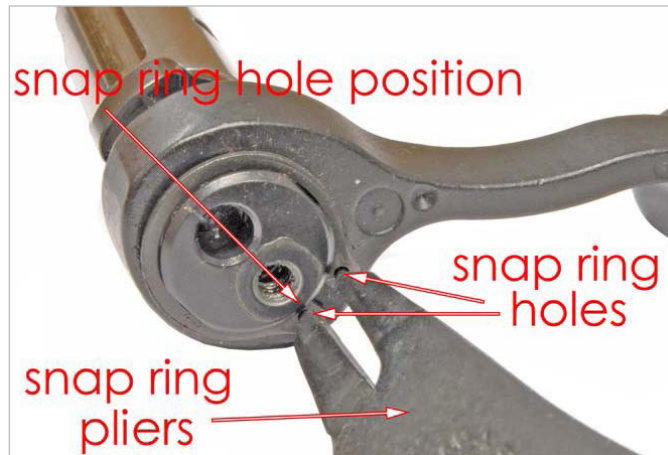


FIGURE 9

- With the SNAP RING securely in place and the 'holes' aligned as shown in FIGURE 9, use the supplied 5/64" Allen WRENCH (black color) to tighten the BOLT HANDLE SCREW (see FIGURE 10).

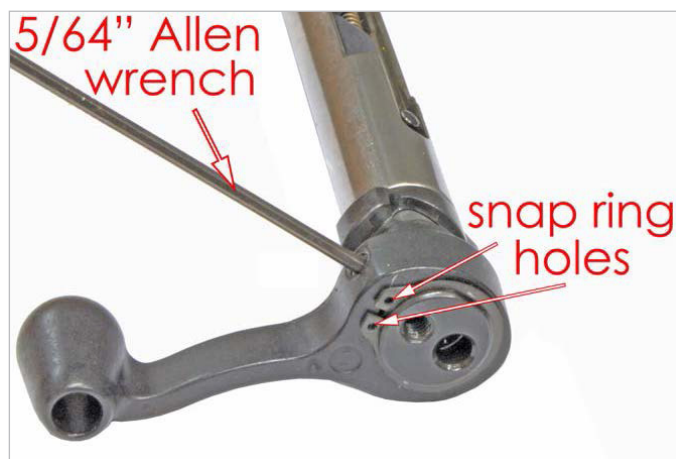


FIGURE 10

- Using the supplied 3/32" Allen wrench (silver color), install the **new** BOLT CAP, tightening the CAP SCREW securely (see FIGURE 11).



FIGURE 11

- As directed on PAGE 23 of the INSTRUCTION MANUAL, insert the **retrofitted** BOLT ASSEMBLY into the firearm.
- Place the SAFETY BUTTON in the FULL SAFE position as detailed on PAGE 22 of the INSTRUCTION MANUAL.
- With the bolt open and fully rearward, slowly push the BOLT ASSEMBLY forward making sure that no portion of the BOLT HANDLE contacts the SAFETY BUTTON (see FIGURE 12) **in its entire length of travel.**



FIGURE 12

Read and fully understand your B.MAG instruction manual before using your firearm.
If you have lost or misplaced your manual, you can download a free replacement at
www.savagearms.com (111214 - 08/15)