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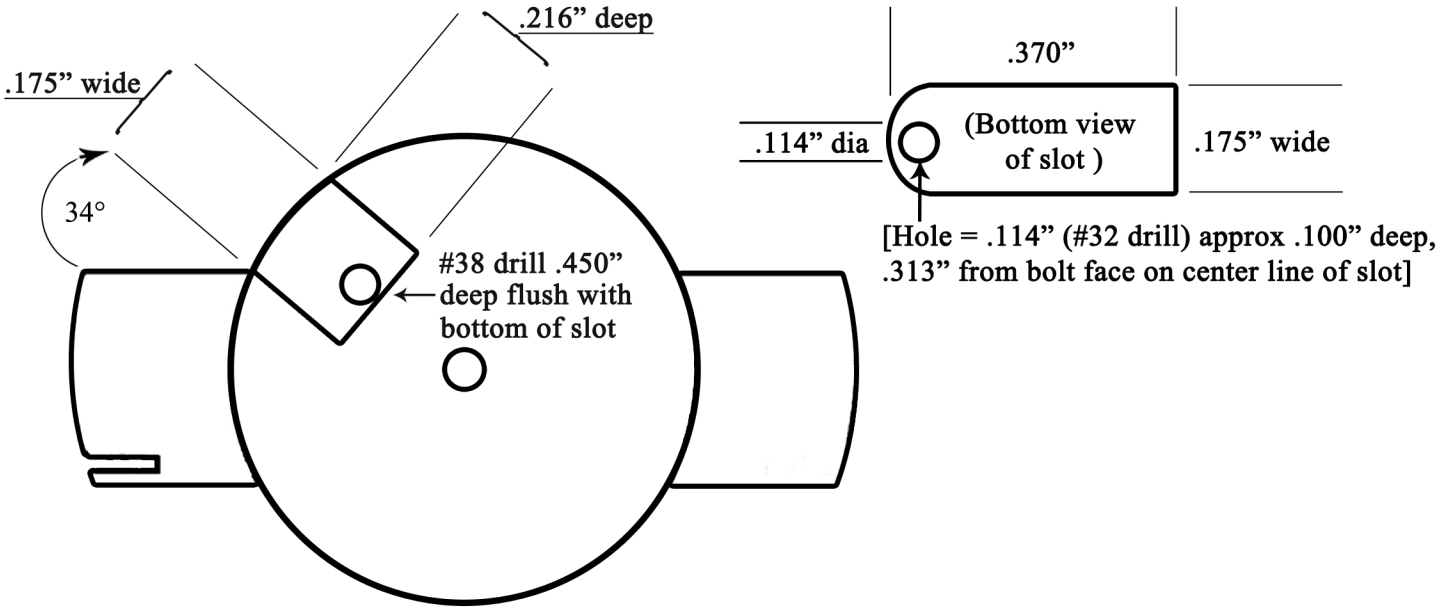
Sako Style Extractor Kit Instructions for .223 Action Bolts



(Note: Illustration dimensions are not drawn to scale.)

Milling Instructions (.223 Action Bolts):

1. Remove Remington or other type extractor
2. Mill extractor slot into the side of the bolt body a width of .175" to a depth of .216" on the center line a distance of .370" from the forward edge of the bolt.
3. For the stud on the extractor, drill a .114" diameter hole (#32 drill) approximately .100" deep (.313" from end of the bolt). Penetrating the firing pin cavity of the bolt body is acceptable.
4. Turning the bolt in a vertical direction, drill a .102" diameter hole (#38 dril), for the retaining plunger pin and spring at a depth of .450" with a flat bottom.

Installation Instructions:

1. Insert the plunger pin spring into the vertical .102" hole. Then, insert the plunger pin inside of the spring. Be sure the flat edge is located close to the bolt body.
2. Using a punch or small screwdriver, push the plunger pin as far down into the .102" diameter hole as is possible to allow insertion of the extractor into the extractor slot.
3. When releasing pressure on the plunger pin, the flat side (or "shovel") should slide over the detent in the rear of the extractor, thereby holding the extractor in the bolt while allowing it the freedom of movement over the edge of the case head.
4. Fill the old extractor slot with JB Weld, flush with the wall of the bolt (if the bolt face has not been opened) to prevent the cartridge case from dropping into the slot and binding in the bolt face.