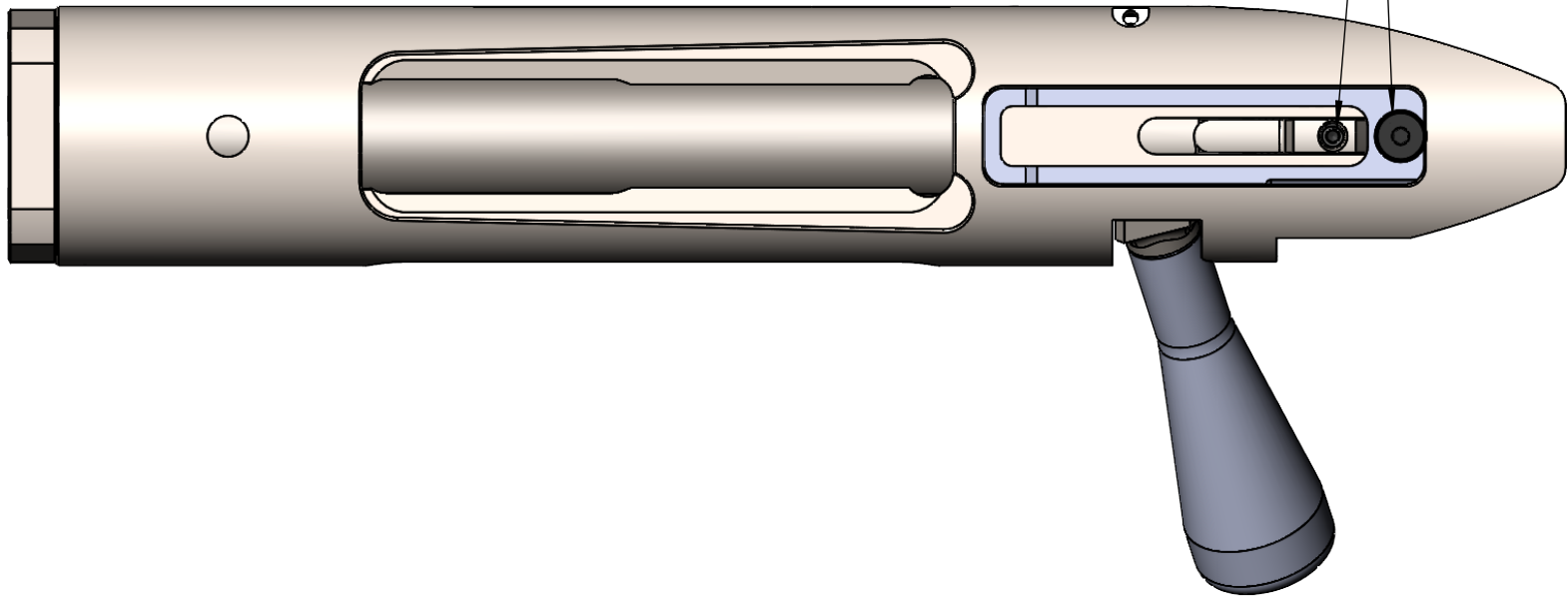


Trigger Hanger Screw and Cocking Piece Set Screw  
Must Be Secured With Blue 243 Loctite Prior to Final Assembly



**DISCLAIMER OF LIABILITY**

Mack Brothers assumes no liability for damage and or injuries that result in whole or in part from improper installation, product malfunctions, negligent, criminal, improper use, and reloaded or defective ammunition.

# MACK BROTHERS BOLT ACTION RECEIVER

## WARNING

ALWAYS INSURE THE FIREARM IS UNLOADED AND ON SAFE

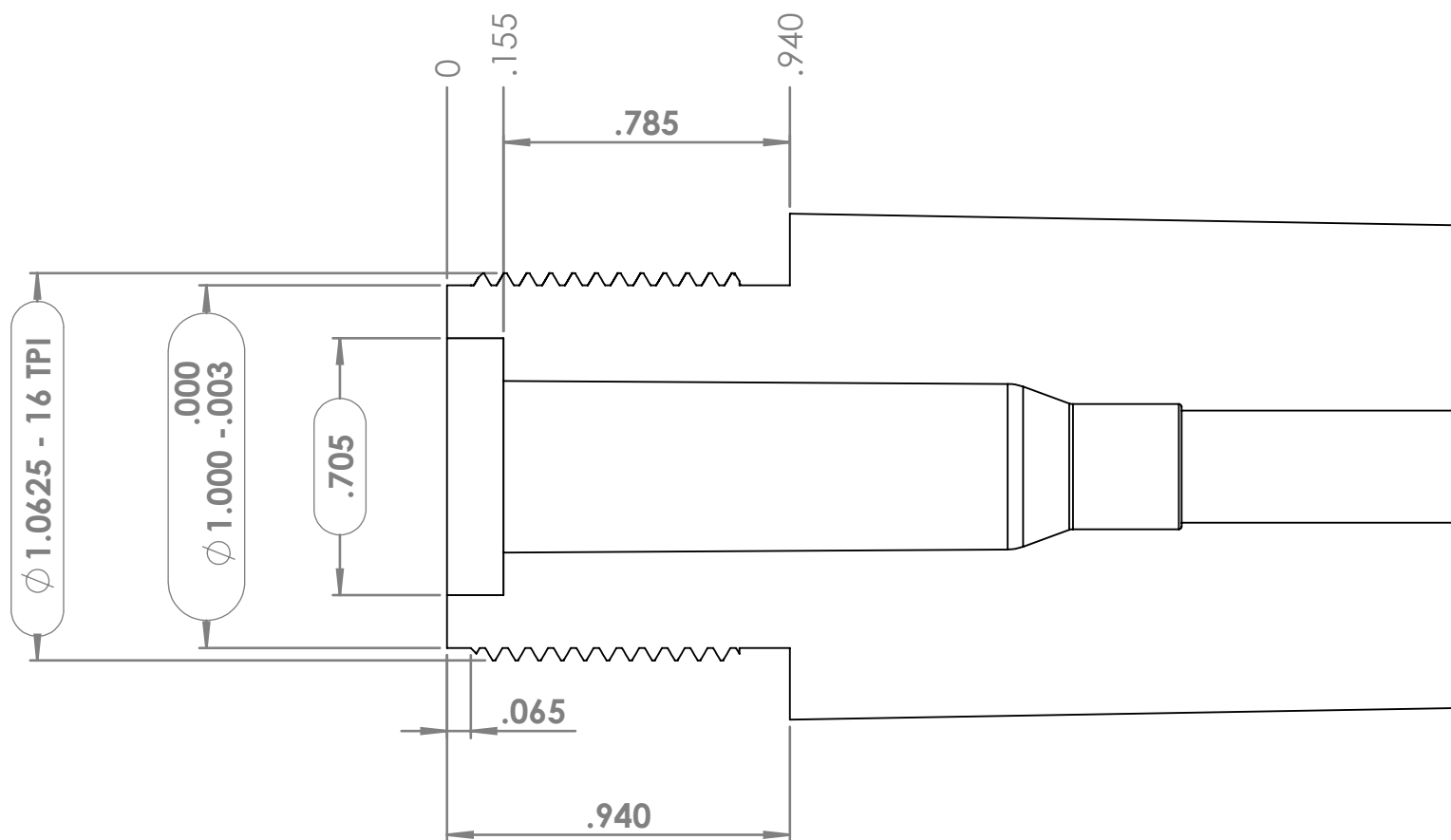
1. Fitting a barrel to the receiver must be performed by a competent gunsmith and the threaded tenon specifications supplied should be confirmed before any barrel and chamber fitting is performed.

### LIMITED LIFETIME WARRANTY

2. This warranty covers any defects in workmanship and materials for the lifetime of the original owner. This warranty does not cover damage to the firearm caused by hand-loaded ammunition, misuse, negligence, abuse, modifications not related to manufacturing defects.

### DISCLAIMER OF LIABILITY

3. Mack Brothers assumes no liability for damage and or injuries that result in whole or in part from improper installation, product malfunctions, negligent, criminal, improper use, and reloaded or defective ammunition.



**PROPRIETARY AND CONFIDENTIAL**  
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF HORIZON MACHINE and MACK BROS. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF HORIZON MACHINE and MACK BROS IS PROHIBITED.

		UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES		NAME	DATE
		SURFACE FINISH $\sqrt{16}$ FRACTIONAL $\pm 1/64"$ ANGULAR: MACH $\pm 0.1$ BEND $\pm 0.5$ TWO PLACE DECIMAL $\pm .005$ THREE PLACE DECIMAL $\pm .002$ FOUR PLACE DECIMAL AS NOTED. INTERPRET GEOMETRIC TOLERANCING PER: ASME Y14.5-2009		DRAWN	RM 7/19/2022
		MATERIAL		CHECKED	
		FINISH		ENG APPR.	
NEXT ASSY	USED ON			MFG APPR.	
APPLICATION		DO NOT SCALE DRAWING		Q.A.	
				COMMENTS: <b>NO BURRS OR SHARP EDGES ALLOWED. UNLESS NOTED INSIDE CORNER RADIUS SHALL NOT BE LARGER THAN .010</b>	

<b>MACK BROS</b>		
TITLE: <b>BARREL TENON DRAWING FOR BOLT ACTION RECEIVER</b>		
SIZE	DWG. NO.	REV
<b>B</b>		<b>A</b>
SCALE: 1:1	WEIGHT:	SHEET 1 OF 2

## EVO Bolt Instructions



Removing the firing pin assembly from the bolt in the cocked position, note Figure 1:  
With the bolt shroud bottom facing you, rotate the shroud and firing pin assembly clockwise.  
The firing pin assembly will pop out as shown in Figure 2.

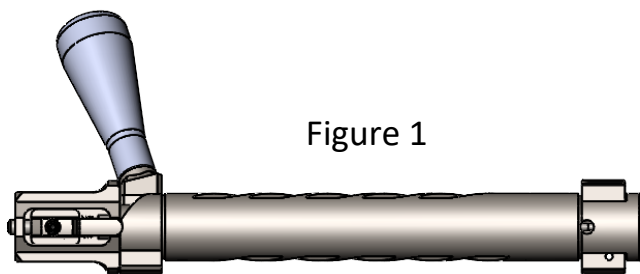


Figure 1

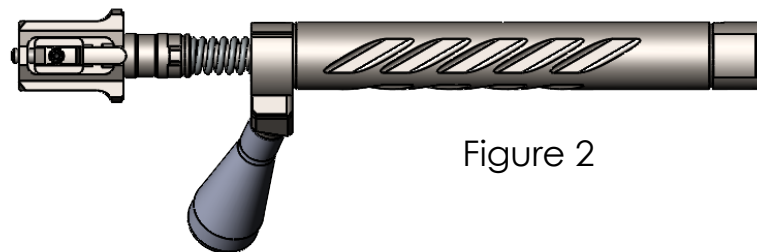


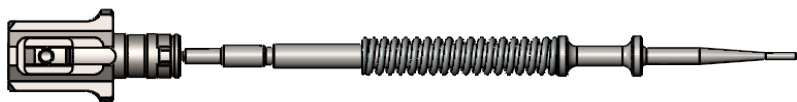
Figure 2

### Firing pin removal:

Remove both 6-32 set screws completely from the cocking piece using a 1/16" hex wrench.  
Now, un-thread the firing pin from cocking piece, NOTE: **firing pin is under main spring pressure.**

### Firing pin replacement:

Align indent in firing pin thread with hole in cocking piece and secure with a 6-32 set screw.  
Now install the 2nd, 6-32 setscrew and **Use Blue 243 Loctite on last set screw only.**



### Disclaimer of Liability:

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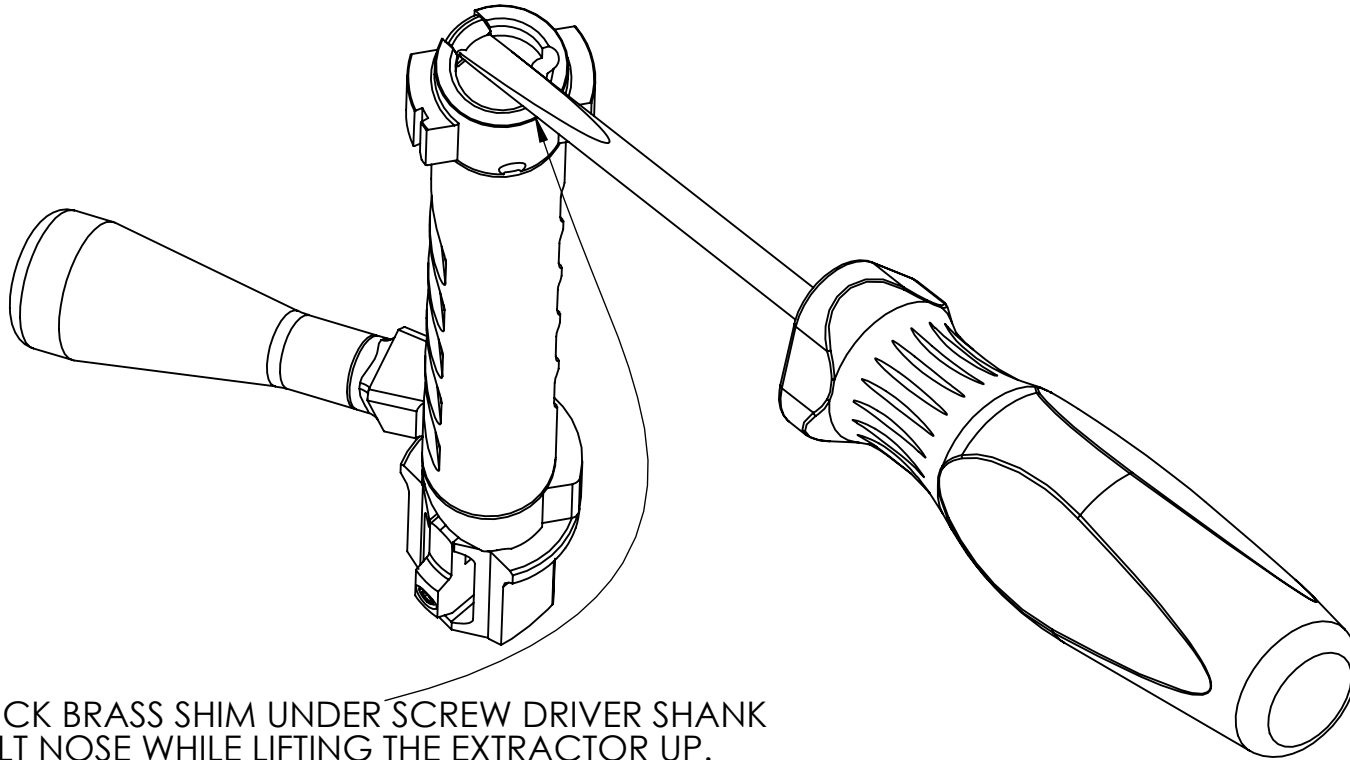
	NAME	DATE	Mack Brothers	
DRAWN	RM	6/15/2022		
CHECKED			TITLE:	
ENG APPR.			EVO Bolt Instructions	
MFG APPR.				
Q.A.				
COMMENTS:			SIZE	DWG. NO. 1
			A	REV
				1
			SCALE: 1:2	WEIGHT:
				SHEET 1 OF 2

### Extractor Removal



**Removal:**

With bolt face toward you, slide flat head screw driver under extractor lip and push extractor away from bolt. Be careful not to mar the face of the bolt. While extractor is being pushed away from bolt, lift extractor up to unseat the extractor and continue lifting up until the extractor is completely removed.



NOTE : USE A THICK BRASS SHIM UNDER SCREW DRIVER SHANK TO PROTECT BOLT NOSE WHILE LIFTING THE EXTRACTOR UP.

**Replacement (No Tools Needed):**

To replace extractor, insert extractor into bolt body groove. Press into place until extractor is seated flush with bolt face.

	NAME	DATE	<b>Mack Brothers</b>	
DRAWN	RM	3/23/2022		
CHECKED			TITLE:	
ENG APPR.			<b>EVO Bolt Instructions</b>	
MFG APPR.			SIZE	DWG. NO. 2
Q.A.			<b>A</b>	REV
COMMENTS:				<b>1</b>
	SCALE:	WEIGHT:	SHEET 2 OF 2	