

PRODUCT INSTALLATION GUIDE

Mosin Nagant Scope Mount with Bolt Handle



HARDWARE INCLUDED

-  [2] 10-32 x 1/2 Slotted Flat Head Screw
- [1] 10-32 x 1/2 Allen Head Screw
- [1] #11 Drill Bit
- [1] #21 Drill Bit
- [1] 10-32 Tap

 NON APPLICABLE

TOOLS Needed

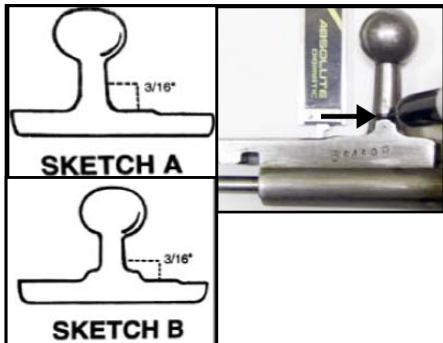
 Flat Head Screwdriver

 Drill

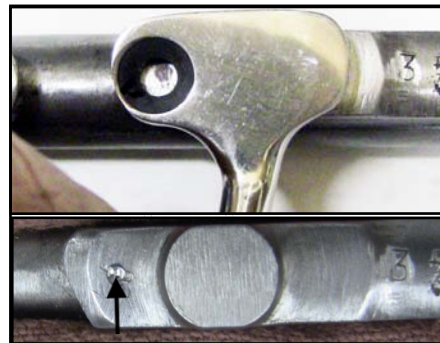
 Allen Set



Warning: When handling a firearm, always follow the proper handling procedures at all times. Failure to follow these procedures could result in serious damage, injury, or death. We are not responsible for damage to property, injury, or death resulting from improper installation, misuse or modification of products. If you are not comfortable completing any of the following steps, or do not have the proper tools enlist the help of your local gunsmith. We are not responsible for components that are damaged due to improper installation.



1 Begin by removing the bolt assembly from the action and then disassembling the bolt. Mark the bolt handle base with a marker and measure upward 3/16" on the knob shank from the base of the bolt and scribe a line as seen in Figure 1.



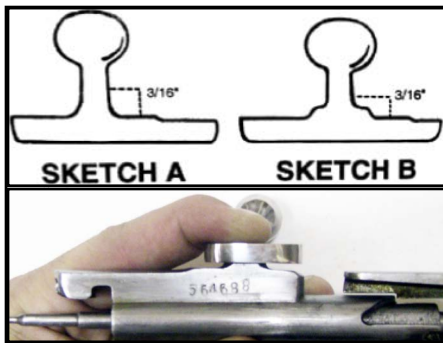
4 Mark the hole location, then using the (larger) #11 drill bit, carefully spot drill for the mounting screw, just deep enough to create a centered starting point as seen in Figure 4.



2 Clamp the bolt in a padded vise with the bolt handle upward. Re-check the 3/16" measurement, leaving room for finish filing. Next, cut off bolt handle as seen in Figure 2.



5 Using the supplied #21 (smaller) drill bit, drill through the center of the bolt forging. While still clamped, use the 10-32 tap and tap the hole drilled into the bolt as seen in Figure 5. Deburr and thoroughly clean the bolt and handle.



3 For "non-stepped" (sketch A) press the 1/2" spacer inside the ATI bolt handle. If "stepped" (sketch B) the bolt handle does NOT require a spacer. Place the ATI bolt handle over the knob on the original bolt as seen in Figure 3.

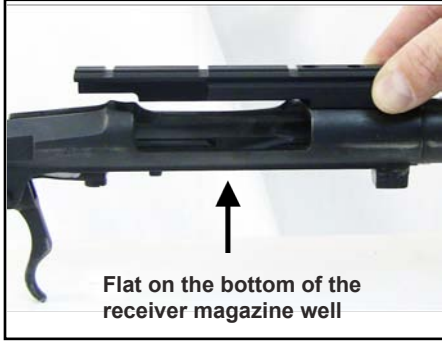


6 Place the ATI bolt handle in place on the bolt and install and tighten the supplied 10-32 countersunk machine screw as seen in Figure 6. Re-assemble the handle to the stock at this point. Before moving to the next step remove the barreled action from your stock.

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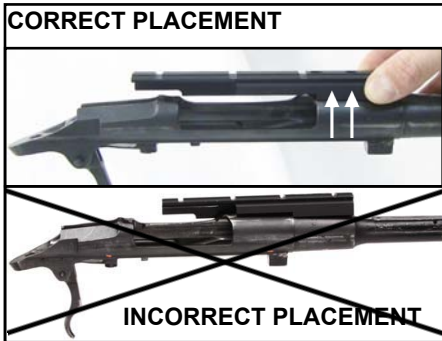
7

CAUTION: Before proceeding with step 7, chamber clearance must be checked. Begin by placing the scope mount on the receiver flush with receiver ring front face. Square the mount on the receiver using the flat area on the bottom of the receiver magazine well as seen in Figure 7.



11

Clean the area and securely screw in the supplied 10-32 x 1/2" screw as seen in Figure 11. Repeat this process for the forward hole.



8

Install the scope mount in the proper position as seen in Figure 8. If you attempt to install the mount in an improper location or on the barrel damage to the property, injury or death may occur. **NOTE:** If needed please enlist the services of a gunsmith.



12

Remove the scope mount from the clamp and the clean the mount and action as seen in Figure 12. Remove any burrs from the tapped holes.



9

Double check the positioning for squareness. Use the supplied #11 (larger) drill bit and spot drill the rear screw hole as seen in Figure 9. (Spot drill will "mark" the center of the hole for the next step. **NOTE:** Only spot drill deep enough to create a centered starting point for the next step.



13

Set the scope mount in place, install and tighten the provided 10-32 x 1/2" flat head screws. Check screws to be sure they do not protrude below the inner surface of the receiver as seen in Figure 13. **NOTE:** Mount must be used with the ATI replacement bolt handle or the bolt will not operate. IF the screws protrude below the inner surface, firing the rifle may result in damage to property, injury or death. You may now reinstall the barreled action into your stock and install the bolt assembly to complete your scope mount and bolt handle installation.



10

With the mount still clamped use the supplied #21 (smaller) drill bit and drill slowly so as not to burr the inside of the receiver below the hole. Next, use the supplied 10-32 tap (and oil) to tap through the receiver as seen in Figure 10.