

PRODUCT INSTALLATION GUIDE

Mosin Nagant Bolt Handle



HARDWARE INCLUDED

- [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

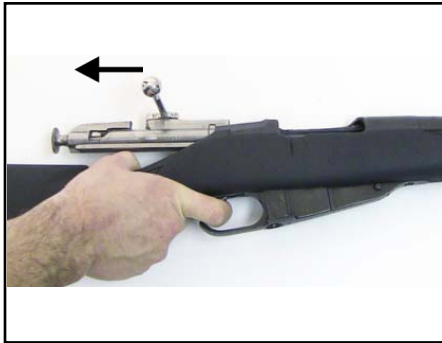
 Flat Head Screwdriver

 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.



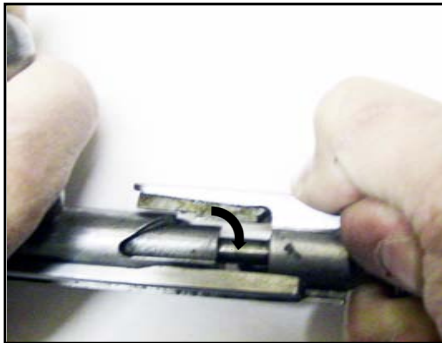
1

Begin by removing the bolt assembly from the action by squeezing the trigger and pulling out towards the rear as seen in Figure 1.



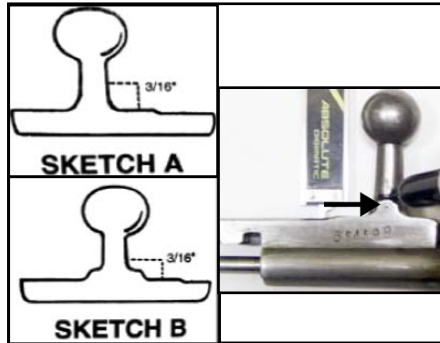
4

Note the position marks at the rear of the bolt as seen in Figure 4. This aligns the firing pin depth correctly and must be returned to exactly the same position for safe operation.



2

To disassemble the bolt, grasp the bolt handle, pull rearward and turn the cocking piece 1/4 turn to the left, making sure the bolt guide bar remains intact as seen in Figure 2.



5

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 5.



3

The bolt head and guide bar slide will remove by sliding them forward off the bolt assembly, exposing the firing pin as seen in Figure 3.



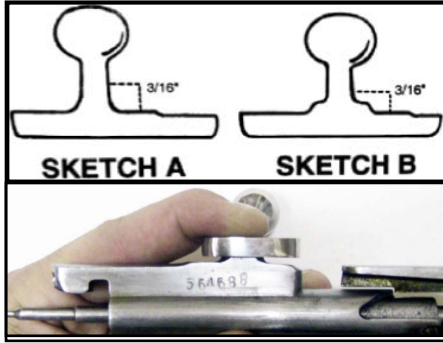
6

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 6.

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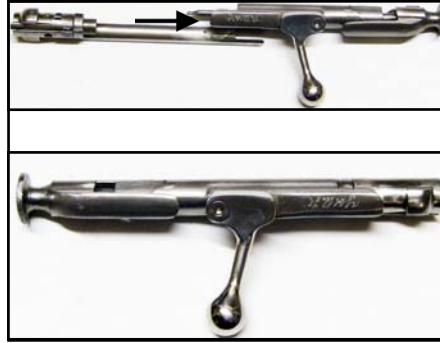
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7

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 7.



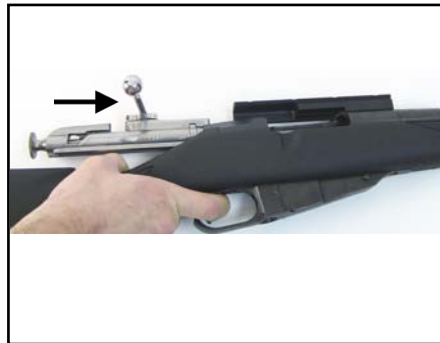
11

To assemble the bolt, place the bolt and bolt guide bar back on the bolt assembly. Grasp the bolt handle, pull rearward and turn the cocking piece 1/4 turn to the right as seen in Figure 11, making sure the bolt guide bar remains intact and lined up with the bolt assembly.



8

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 8.



12

Install the bolt assembly by squeezing the trigger and pushing the bolt into the chamber as seen in Figure 12.



9

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 9. Deburr and thoroughly clean the bolt and handle.



10

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 10.