



Mosin Nagant Bolt Handle

Installation Instructions

PART# MOI0700

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Bolt Handle Installation

Point the rifle in a safe direction and place the safety in the "on" position. Next remove the magazine, pull back the bolt, and carefully inspect the chamber to be sure the rifle is unloaded.

Note: Satisfactory results can be achieved by careful installation or by a qualified gunsmith.

Step #1

Remove the bolt assembly from the action by squeezing the trigger and pulling out towards the rear.



Figure 1

Step #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. The bolt head and guide bar slide will remove by sliding them forward off the bolt assembly, exposing the firing pin.



Figure 2A

Figure 2B

Note the position marks at the rear of the bolt, this aligns the firing pin depth correctly and must be returned to exactly the same position for safe operation.



Figure 3

Step #3

Mark the bolt handle base with a marker or paint, measure upward 3/16" (.1875") on the knob shank from the base of the bolt and scribe a line. (See Sketch A and B)

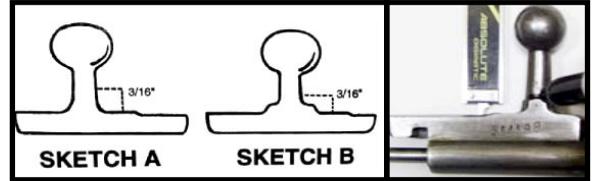


Figure 4A

Figure 4B

Step #4

Clamp the bolt in a padded vise with the bolt handle upward, re-check the 3/16" measurement, leaving room for finish filing. Cut off bolt handle.



Figure 5A

Figure 5B

Step #5

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.

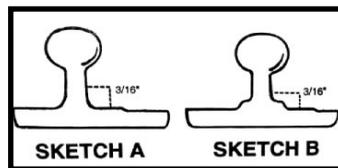


Figure 6A

Figure 6B

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Step #6

Mark the hole location then using the larger #11 drill, carefully "spot drill" are for mounting screw, just deep enough to create a centered starting point.

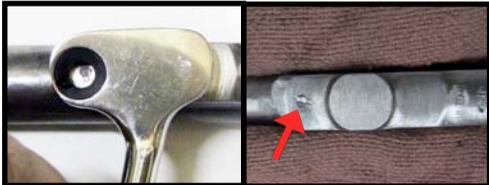


Figure 7A

Figure 7B

Step #7

Using the supplied #21 (smaller) drill bit, drill through the center of the bolt forging. (Cutting Oil Recommended)



Figure 8

Step #8

Still Clamped, use 10-32 tap and tap the hole drilled into the bolt. Deburr and thoroughly clean the bolt and handle.



Figure 9

Step #9

Place the ATI bolt handle in place on the bolt, install and tighten the supplied 10-32 countersunk machine screw. Use of thread lock is Recommended.



Figure 10A

Figure 10B

Step #10

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



Figure 11A

Figure 11B

Step #11

Reinstall the bolt assembly by squeezing the trigger and pushing the bolt into the barreled action.



Figure 12

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