



# PRODUCT

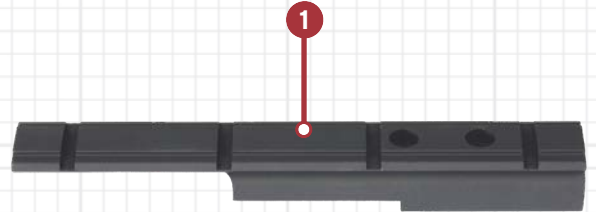
## INSTALLATION GUIDE

Mosin Nagant Scope Mount

A.5.10.2281

### Contents Included

1 Aluminum Scope Mount




### Installed on Firearm








# Mosin Nagant Scope Mount

## Hardware Included

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

## 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. ATI is 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. ATI is not responsible for components that are damaged due to improper installation.

A

## Stock Removal

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

**NOTE:** "Due to the large production quantities and variations of this rifle as well as the manufacturing principles used during the production period some modification may be needed. If you do not possess the equipment or skill set necessary for installation, we recommend that an accredited gunsmith completes the installation process."

1

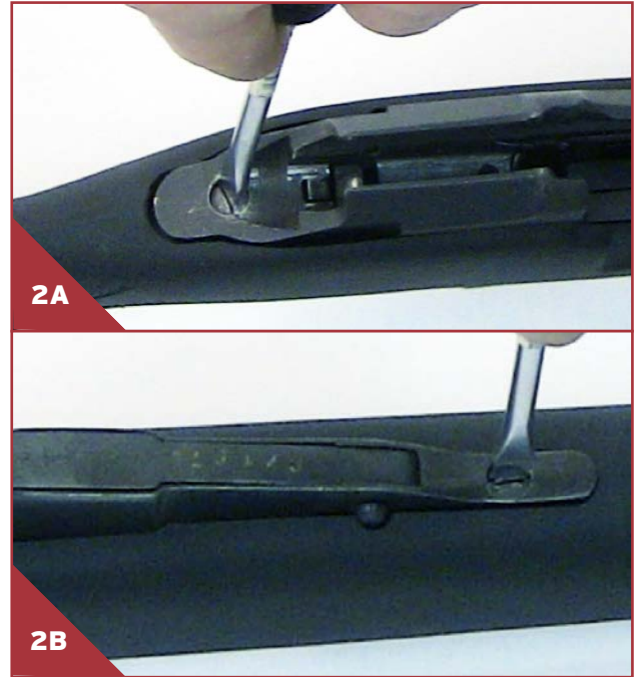
Begin by removing the bolt assembly from the action by squeezing the trigger and pulling out towards the rear as seen in Figure 1.





## A Stock Removal -Continued

2 Using a flat head screwdriver, remove the barreled action from the stock by removing the top receiver screw as seen in Figure 2A and the bottom magazine screw as seen in Figure 2B.



3 Lift the barreled action from the stock by pulling up on the barreled action and removing it from the stock as seen in Figure 3.





## B

### Scope Mount Installation

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**CAUTION:** BEFORE PROCEEDING WITH STEP #1, CHAMBER CLEARANCE MUST BE CHECKED! DRILLING INTO CHAMBER AREA (INCORRECT MOUNT POSITIONING) MAY RESULT IN DAMAGE TO PROPERTY, INJURY OR DEATH!

#### 1

Place the scope mount (holes forward) on the receiver flush with the 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 1.



#### 2

Note the location of the scope mount on the receiver as seen in Figure 2A. The scope mount must be installed onto the receiver portion of the barreled action. **DO NOT MOUNT PASS THE POINT REFERENCED IN FIGURE 2B.**





## C Scope Mount Installation -Continued

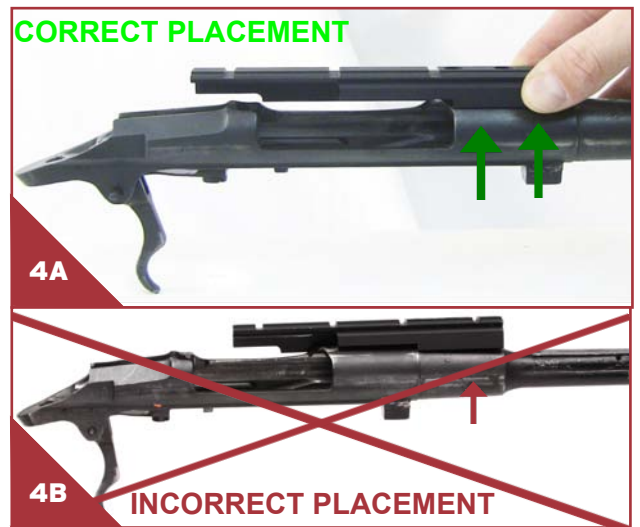
3 For a Hex Barrel note the location of the scope mount on the receiver as seen in Figure 3A. The scope mount must be installed onto the receiver portion of the barreled action.

**DO NOT MOUNT PASS THE POINT REFERENCED IN FIGURE 3B.**



4 Install the scope mount in the proper position as seen in Figure 4A. If you attempt to install the mount in an improper location or on the barrel as seen in Figure 4B, damage to the property, injury or death will occur.

**NOTE: If you do not have the proper tools or do not feel comfortable fitting the scope mount to your firearm, please enlist the services of your local gunsmith.**





## C Scope Mount Installation -Continued

**5** Clamp securely in position. Double check positioning for squareness. A drill press is recommended for this step, use the supplied (larger) #11 drill bit and spot drill the rear screw hole as seen in Figure 5. (Spot drill will "mark" the center of the hole for the next step.)

**Caution:** Only spot drill deep enough to create a centered starting point for the smaller #21 drill bit (step #6). Make sure the mount and drill are square and center, spot drill no more than 1/16th of an inch.

**NOTE:** ATI is not responsible for broken taps or drill bits.



**6** With the mount still clamped, use the supplied (smaller) #21 drill bit as seen in Figure 6, drill slowly so as not to burr the inside of the receiver below the hole. (It is recommended to use cutting oil during the drilling process.)



**7** With the mount still clamped as seen in Figure 7A, use the supplied 10-32 tap (and oil), to tap through the receiver as seen in Figure 7B. Without unclamping, clean area and securely screw in the supplied 10-32 x 1/2" screw. Repeat this process for the forward hole.





## C Scope Mount Installation -Continued

8 Remove the scope mount and clean the mount as seen in Figure 8A and the action as seen in Figure 8B. Remove any burr(s) from the tapped holes.



9 Set the scope mount in place, install and tighten screws the provided 10-32 x 1/2" Slotted Flat Head Screw (Thread lock is recommended.) Check screws to be sure they do not protrude below the inner surface of the receiver as seen in Figure 9.

**NOTE: MOUNT MUST BE USED WITH THE ATI REPLACEMENT BOLT HANDLE OR BOLT WILL NOT OPERATE.**

**NOTE: IF SCREWS PROTRUDE BELOW THE INNER SURFACE, FIRING THE RIFLE MAY RESULT IN DAMAGE TO PROPERTY, INJURY OR DEATH**





C

## Scope Mount Installation -Continued

- 10 Install the barreled action back into the stock by placing the action into the stock as seen in Figure 10.



- 11 Install both the bottom magazine screw as seen in Figure 11A and the top receiver screw as seen in Figure 11B to secure the barreled action to the stock.



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

