



**Installation Instructions
Quick-On™ Scope Mount for the
Mosin-Nagant Rifle
Crazy Ivan Enterprises, LLC**

ENSURE THAT YOUR FIREARM IS COMPLETELY UNLOADED BEFORE DOING ANY WORK TO IT!

BE ADVISED: ONLY A CERTIFIED GUNSMITH SHOULD PROVIDE INSTALLATION SERVICES. THESE INSTRUCTIONS ARE PROVIDED TO THE PURCHASER FOR INFORMATIONAL PURPOSES ONLY. INSTALLATION BY ANYONE OTHER THAN A CERTIFIED GUNSMITH WILL VOID ALL WARRANTIES.

These instructions have been prepared to assist in the installation of the Quick-On™ Scope Mount onto your Mosin-Nagant rifle. Be advised that you should consult with your firearm manufacturer's warranty to determine whether any warranty would be void by the installation of this product. These instructions are for use of the standard mounting plate. If your mount was ordered with one of the optional plates (long or long with holes), these instructions may need to be adjusted to fit properly. The installation of the scope mount requires drilling and tapping three holes into the receiver of the Mosin-Nagant rifle and potentially some minor cutting of the stock at the scope mount location. This procedure requires mechanical skills and proper tools. Your certified gunsmith should follow these instructions to ensure proper installation.

Use of this mount requires a low profile angled bolt handle such as the Crazy Ivan Enterprises No-Weld™ Bolt Handle. All other after-market low-profile bolt handles that have been tested were compatible with this mount. However, original Mosin-Nagant sniper bolt handles or reproductions do not have the proper clearance to function with this mount.

IMPORTANT NOTES:

- Do NOT punch, drill and tap all three holes at the same time, this may result in improper alignment. Follow the drilling and tapping sequence in these instructions to help ensure proper alignment.
- Ensure adequate condition of the gunsmithing tools. Old taps may be dull and have stress cracks from prior use, which could greatly increase the chance of the tap breaking.
- Use of a drill press is highly recommended – it ensures the screw holes are perpendicular to the face of the receiver. If the holes are slanted, the heads of the mounting screws will not fit flush with the mounting plate and may require filing to allow the scope mount to be attached.
- Due to the variation in Mosin-Nagant receivers, you may need to file the “feet” on the mounting plate to get an exact alignment of the mount with the barrel. You can adjust the angle of the mount left to right and front to back in this manner. Be careful, a little filing will adjust the angle quite a bit.

Items included:

1. Crazy Ivan Quick-On™ Mosin-Nagant scope mount
2. Thumbscrews (2)
3. Mounting plate
4. Mounting screws (3)

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Quick-On™ Scope Mount for the Mosin-Nagant

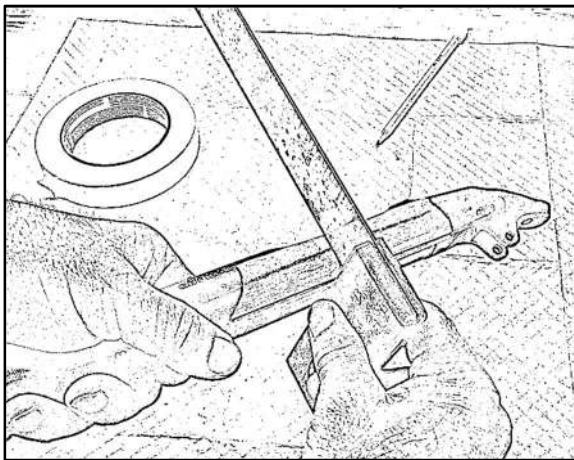
Items needed:

- Safety glasses!
- Masking tape
- Carpenter's square
- Pencil (No. 2 wood not mechanical)
- Steel center punch
- Hammer (ball peen or similar designed to be used with a steel punch – use of a claw or other nail hammer is not recommended)
- No. 29 drill bit and 8-32NC tap (usually sold as a set in most hardware stores)
- 5/32-inch drill bit
- Tap handle (highly recommended but vice grips or pliers can be substituted)
- Drill press (highly recommended but a hand power drill can be substituted)
- Lubricating oil for drill bits and tap (any oil will do)
- 3/32-inch Allen wrench (hex key)
- Thread locker compound (Loctite® or similar)
- Saws, files, and sandpaper to inlet stock to accommodate scope mount.

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STEP 1: Disassemble the gun, including removing the trigger and ejector from the receiver. Place a strip of masking tape on the side of the receiver in the location that you wish to attach the mount. The mount is designed to be centered over the top of the ejection port, but the exact location is up to the installer.

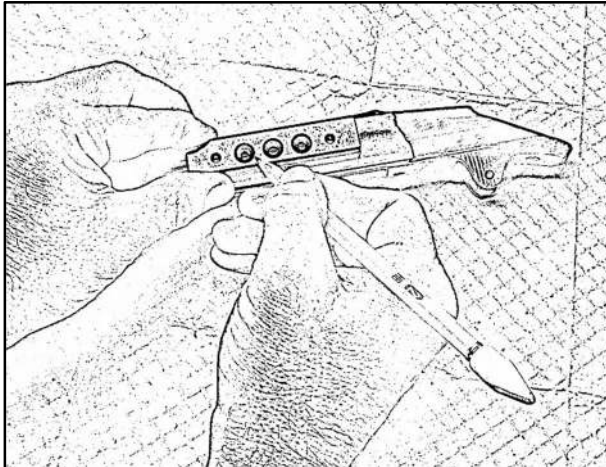
STEP 2: Take the Carpenter's square and apply a layer of graphite from the pencil on the inside edge of



one limb of the square. It may help to roughen the edge of the square with sandpaper to hold the graphite. Place the square against the left side of the receiver with the graphite edge against the masking tape and the other edge flush with the flat bottom of the receiver. Rub the square back and forth on the masking tape to mark the center line of the side of the receiver.

STEP 3: Line the holes in the mounting plate up with the pencil mark on the tape and mark the location of the first hole on the tape with the pencil. Punch mark the receiver at that location.

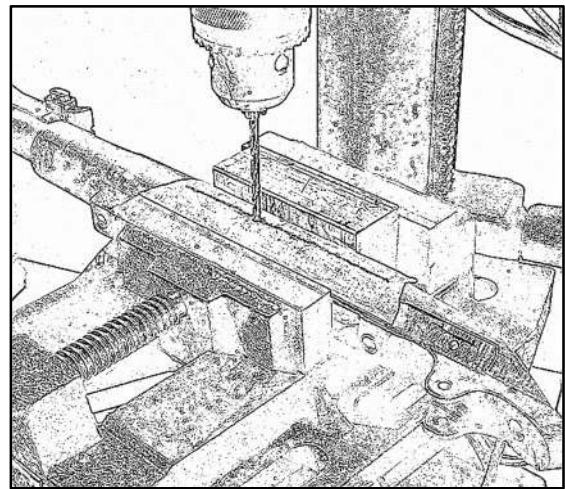
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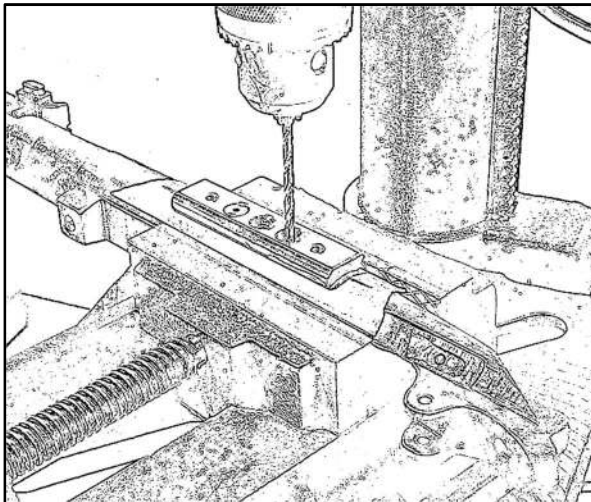
STEP 4: Using the No. 29 drill bit, drill the first mounting hole at the location you marked in STEP 3. Use of lubricating oil is recommended (only one or two drops is needed).

STEP 5: Using the 8-32NC tap, tap the hole you drilled in STEP 4. Use of lubricating oil is essential for a smooth tapping job. **GO SLOW!** Only turn a partial turn then back off – repeat until you have tapped the entire hole and the tap moves freely back and forth. It also helps to periodically remove the tap from the hole and clean the threads on the tap and the hole.

STEP 6: Attach the mounting plate using one of the screws provided. A 3/32-inch Allen wrench or hex key is needed. Leave the template in place and **DO NOT** apply the thread locker yet. Make sure the plate is aligned properly with the pencil line on the tape and the bottom edge of the receiver and securely tighten the mounting screw.



STEP 7: In this step you will use the 5/32-inch drill bit to



create a centered starting point for your second screw hole. The 5/32-inch drill bit is just slightly smaller than the holes in the mounting plate. Therefore, the tip of the bit will mark the receiver at the center of the hole. It is important that the mounting plate does not move during this step, so be sure the first mounting screw is tight. You may also wish to add a clamp to the mounting plate prior to proceeding.

Once the plate is aligned and secure and the 5/32 bit is centered in the next mounting hole, advance the bit until a mark is made on the receiver. Note that you are only creating a small depression in the receiver, not a hole, so that the No. 29 bit does not wander when you drill the hole for the screw.

STEP 8: Using the No. 29 drill bit, carefully center it in the mark you created in STEP 7 and drill the next screw hole in the receiver.

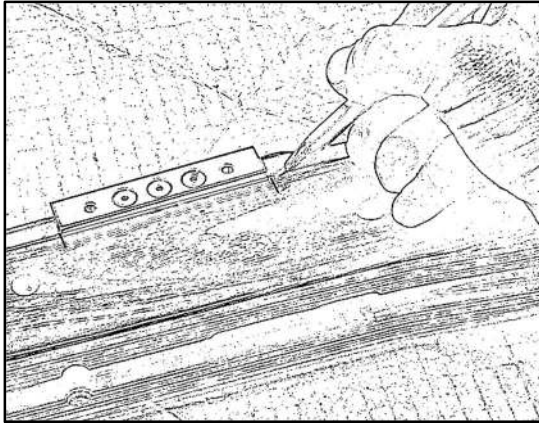
STEP 9: Tap the new hole and install the mounting screw.

STEP 10: Using the 5/32-inch bit, repeat STEP 7 and make a pilot mark in the third screw-hole location.

STEP 11: Drill and tap the third screw hole.

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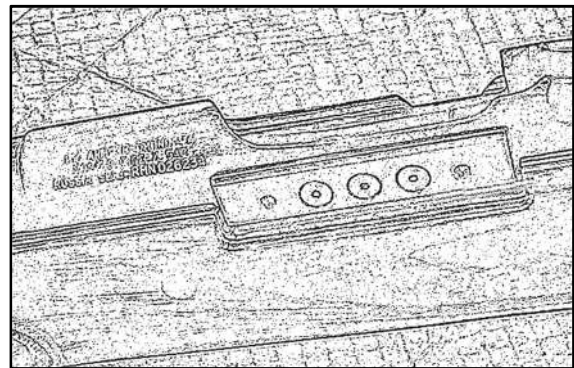
STEP 12: Remove the mounting plate and masking tape from the receiver, clean the plate and receiver to remove the cutting oil and cuttings, and reattach the mounting plate with all three screws using thread locker compound. You might wish to apply a thin film of oil between the mounting plate and receiver before you attach it to inhibit corrosion.



STEP 13: Install the barrel and receiver assembly on the stock you plan to use for your finished rifle. The stock will most likely require a small amount of cutting to accommodate the scope mount. Mark how big the stock cut needs to be. It is best to be conservative with your first cut – obviously you can always remove more stock material, but you can't go back!

STEP 14: Repeat STEP 13 until you can seat the barrel and receiver all the way into the stock. It is best to start with a saw then proceed to a file, then sandpaper, to obtain a tight fit.

STEP 15: Attach the scope mount to the plate to make sure it clears the stock. Even though the cut might be large enough to accommodate the plate, you might need to remove some additional stock material at the bottom of the plate to get the scope mount to seat.



STEP 16: Attach the optic.

A FEW ADDITIONAL NOTES:

- Due to the tight machining tolerances of the scope mount, thumbscrews, and mounting plate, you might find it difficult to tighten the thumbscrews at first. After a few removal and reattachment cycles, the thumbscrews will turn with less effort.
- Although the thumbscrews are machined with a 40 thread per inch (TPI) pitch to achieve a high mechanical advantage for tightening, use of a large coin, key, or flat-edged tool will probably be needed for final tightening to keep the mount from loosening during shooting. Use of a screw driver (other than one with a very large blade) IS NOT recommended since it can mar the slots in the thumbscrews.
- The thumbscrews should be checked periodically during shooting to ensure they are properly tightened. Use of removable thread locker (e.g. Loctite Blue 242) is also recommended.
- The mounting plate screws should be inspected whenever the mount is removed to verify they have not loosened.
- If you have a question or comment, please contact us via email at Karl@CrazyIvanLLC.com or via US Mail at Crazy Ivan Enterprises, LLC, 1341 Forsyth Lane, Galena, Ohio, 43021. Thank you!