



**Installation Instructions  
No-Weld™ Low Profile Bolt Handle  
for the Mosin-Nagant Rifle  
Crazy Ivan Enterprises, LLC  
US Patent 9658009**

**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 Crazy Ivan Enterprises No-Weld™ Bolt Handle on your Mosin-Nagant rifle. This bolt handle has the proper clearance to function with the Crazy Ivan Quick-On Scope Mount and other low profile after-market scope mounts.

The installation of the bolt handle requires sawing off the old bolt handle and drilling a hole into the bolt body to accommodate the new handle. This procedure requires mechanical and welding skills and the proper tools. Your certified gunsmith should follow these instructions to ensure proper installation.

Items needed:

- Safety glasses!
- Steel cutting saw – hacksaw, grinder or small circular saw with steel blade, band saw, etc.
- 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 because it may chip when striking hardened metal)
- 3/8-inch drill bit
- 1/8-inch drill bit
- Drill press (highly recommended but a hand power drill can be substituted – see note below)
- Lubricating oil for the drill bits
- Grinder, files, sand paper, polishing compound
- High-strength epoxy suitable for metal.

Note: Use of a drill press is highly recommended – it ensures the handle mounting hole in the bolt body is perpendicular to the face of the bolt body. If the hole is slanted, the base of the handle will not fit flush with the face of the bolt body. It also helps ensure the lock pin is evenly positioned and flush in the bolt shoulder.

**STEP 1:** Disassemble the bolt and set all parts aside except the bolt body (the part with the handle on it).

**STEP 2:** Cut off the old bolt handle flush with the bolt body.

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**No-Weld™ Bolt Handle for the Mosin-Nagant Rifle**

**STEP 3:** Using the center punch and hammer, punch mark the center of the old bolt handle location.

**STEP 4:** Drill a 3/8-inch diameter hole through the face of the bolt body, as perpendicular to the surface as possible (use of a drill press is HIGHLY recommended). The hole needs to be at least 5/16-inches deep to accommodate the nub on the bolt handle, but it can extend to the center shaft in the bolt body. If the hole penetrates the shaft, be sure to remove any burrs and cuttings from the shaft before reassembling the bolt.

**STEP 5:** File, sand, and polish the face of the bolt body to achieve the desired finish and fit of the new handle.

**STEP 6:** On the bottom surface of the bolt shoulder, measure a point 1/8-inch from the edge and in line with the hole you drilled in STEP 5. Punch mark this spot.

**STEP 7:** Insert the nub of the bolt handle into the bolt body and adjust it to the desired sweep angle. Clamp the handle in place. At the location you punch marked in STEP 6, drill a 1/8-inch hole all the way through the bolt body shoulder and the bolt handle nub.

**STEP 8:** Disassemble the bolt handle and bolt body, thoroughly clean, apply a high strength epoxy of your choice, and reassemble the bolt handle and bolt body.

**STEP 9:** Drive in the 1/8-inch alloy steel pin supplied with the bolt handle.

**STEP 10:** Clean off any visible epoxy (especially on the inside of the bolt body, if the hole you drilled in STEP 4 penetrates to the center of the bolt body). Allow the epoxy to cure per the manufacturer's recommendations.

**STEP 11:** Reassemble the rifle.

If you have a question or comment, please contact us via email at [Karl@CrazyIvanLLC.com](mailto:Karl@CrazyIvanLLC.com) or via US Mail at Crazy Ivan Enterprises, LLC, 1341 Forsyth Lane, Galena, Ohio 43021. Thank you!

