



## Installation Instructions Weld-On™ Bolt Handle for the Mosin-Nagant Rifle



**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 trouble-free installation of the Crazy Ivan Enterprises Weld-On™ Bolt Handle on your Mosin-Nagant rifle. The instructions are the same for either the original sniper or low profile handles.

The installation of the bolt handle requires sawing off the old bolt handle, drilling a hole into the bolt body to accommodate the new handle, and welding the handle in place. 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)
- 1/4-inch drill bit
- Drill press (highly recommended but a hand power drill can be substituted – see note below)
- Lubricating oil for the drill bit
- Grinder, files, sand paper, polishing compound
- Welding equipment.

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.

**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.

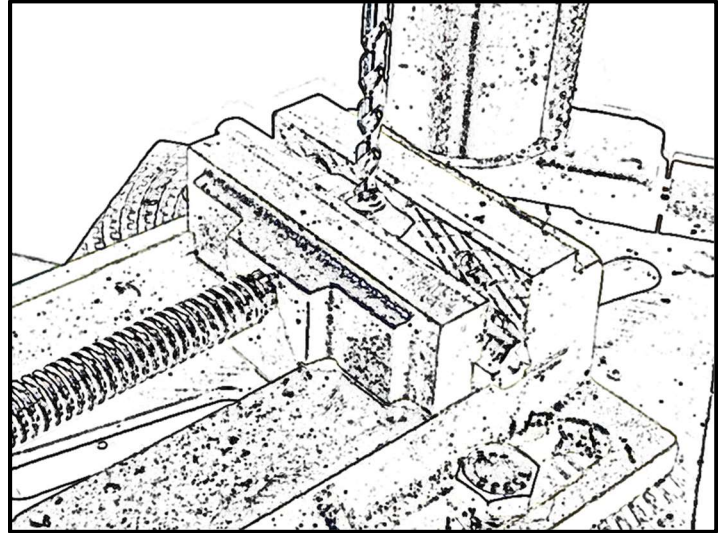
**STEP 3:** Using the center punch and hammer, punch mark the center of the old bolt handle location.

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**Weld-On™ Bolt Handle for the Mosin-Nagant Rifle**

**STEP 4:** Drill a 1/4-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. It is easier to grind and polish the face of the bolt body before the handle is installed.

**STEP 6:** Insert the nub of the bolt handle into the bolt body and adjust it to the desired sweep angle. The original sniper handles are usually installed perpendicular to the bolt body (0° sweep). The low profile handles are typically installed with a 15° rearward sweep.



**STEP 7:** Weld in place. The choice of welding method can vary widely, so no details are given here.

**STEP 8:** Grind and buff the weld area to desired finish.

**STEP 9:** 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!