



## Saiga and VEPR Bullet Guide Installation

updated 03-01-15

### Intro:

These are the installation instructions for the Saiga and VEPR 7.62x39, 5.45x39 and .223 caliber rifles. The 7.62x51 (.308), 7.62x54R and .30-06 rifles do not require a bullet guide.

Bullet guides are required to use cheap military surplus high capacity magazines. This will cover install for both caliber and trunnion types. Also be sure to check out my magazine options pages for info on what mags to use with my guides and what mods are needed to use them.

### Improvements:

All of my guides have been redesigned to fit under the chamber/barrel now for added support. Also we have just updated the design of the 7.62x39 guides to use the heavier #8-32 hardware. Now all guides will use the same #8-32 taps and #29 drill bits.

### What's Included:

If you purchased the guide only option, you will find the bullet guide, a cap screw and a hex key.

If you got the full kit, you will also find a cobalt drill bit and a tap. The cobalt bits are nice as they have a thicker web and are much more durable than regular high speed steel.

We supply the same HSS taps we use for production in the shop.



*.223 flat trunnion kit*

### Trunnion Identification:

The Saigas and VEPR rifles will come with either a round trunnion or a flat trunnion. The shape is a reference to the area of the trunnion immediately below the chamber face.

Currently we make 6 different guides to cover all variants.

Note: a very select few have a rivet hole drilled in them. If that happens to be the case with your rifle, you need to order the guide kit with the longer screw and nut. Drill and tap aren't necessary for those.



*Round Trunnion*

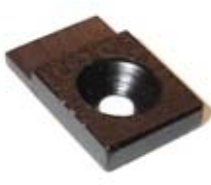


*Flat-Cut Trunnion*

### Bullet Guide Identification:



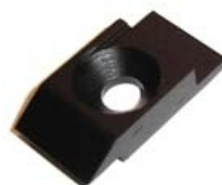
*7.62x39 Round*



*7.62x39 Flat*



*.223 Round*



*.223 Flat*



*5.45x39 Flat*



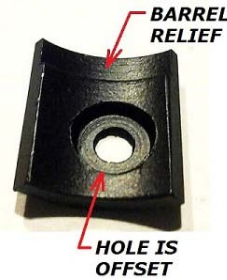
*5.45x39 Round*

*\* pics may or may not reflect current geometry. X39 Round guides have an offset hole.*

## Instructions:

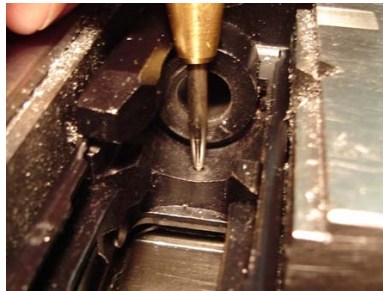
**Note:** The pictures below are for the 7.62x39 round trunnion rifle. All others will be similar with the differences noted. If you have any questions contact me at my website: <http://www.dinzagarms.com/>

1) Place the guide in the gun. You will notice a machined barrel relief on the front. That end tucks under the barrel face. On the 7.62x39 round trunnion rifles, the right hand edge and should line up with the extractor cut in the barrel/chamber face at about 4 o'clock. Make sure it does not go to the right of that boundary or the bolt may contact it. All other guides are centered in the rifle.

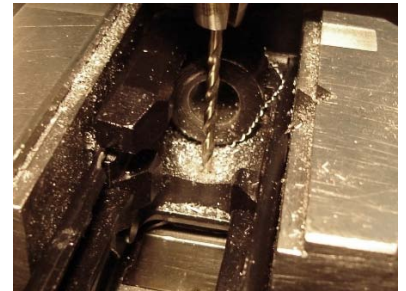


2) Mark the hole location with the guide in place.

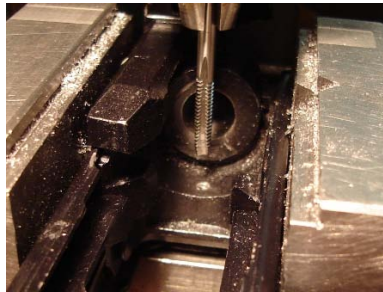
3) Remove the guide and center punch in the middle of your mark. Put a good divot in there.



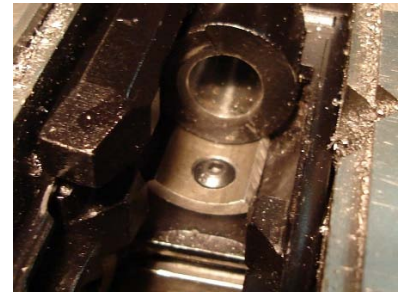
4) Using the cobalt drill bit, drill a hole through the trunnion. Slow and easy - don't rush it. The trunnion is pretty thin there. For best results, use a drill press. (\$30-\$40 at Harbor Freight)



5) Next, it's time to tap. Make sure the tap is straight and in-line with the hole. Go slowly – 1/6 to 1/4 of a turn at a time, then back off a couple turns until it feels free.



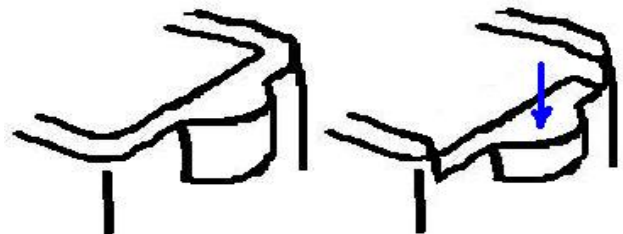
Should you see or feel the tap flexing, back it off to break the chips and resume tapping. Sometimes you need to rock it back & forth to break all the chips. Do not flex the tap!!! Use a cutting fluid for best results.



**NOTE!!!** I only recommend using a drill press, drill through, then put the tap in the chuck and turn in by hand. This will ensure the tap is going in perfectly on axis with the hole you just drilled. You may want to remove the return spring and drive belt. I am not responsible for broken taps due to poor setup.

6) Remove all filings/chips and secure the guide with the supplied screw.

7) Insert a magazine. The factory and aftermarket Saiga magazines will need to be notched out in the front to clear the bullet guide. (see sketch on right →) The guides are longer and protrude into the front of the magazine. This was done to maximize reliability across a wide variety of magazines.



8) Test it out! Pull the charging handle all the way to the rear and let it fly.

9) For added security, remove the screw and apply some blue Loctite to the threads and reassemble.

**Note:** It is normal to have a few jams on a brand new rifle. The same is true with installing a new guide. After only a mag or two, it should be broke in and functioning smoothly. You will notice some wear marks which is normal. These are machined from 4140 and as such, have excellent wear characteristics.