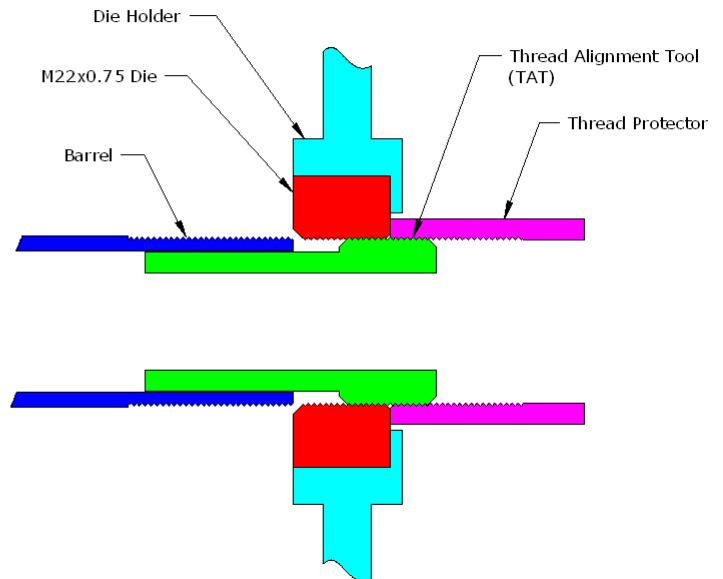
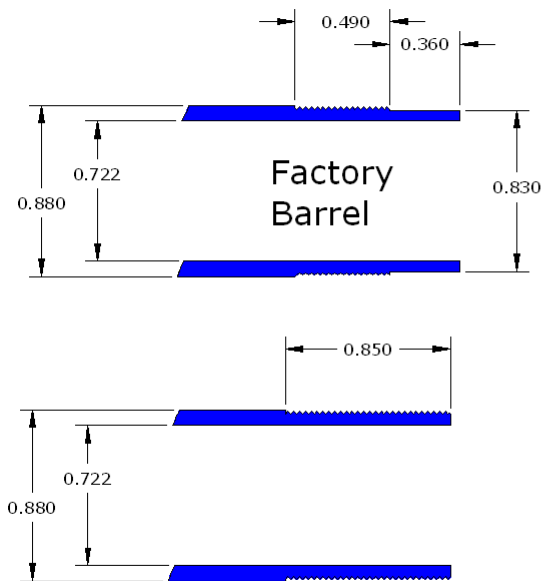




Saiga-12 Threading Instructions

updated 08-22-07



This threading kit is designed to be used with a cylinder bore Saiga-12 shotgun. For the TAT to fit, the barrel I.D. must be 0.722". Typical use would be for a full-choke unthreaded model you have cut back to remove the internal barrel taper. This will give you the ability to use the factory chokes.

First you will assemble the TAT in the die about 1/2 way, then tighten the 2 opposing screws in the die holder. This will tighten the die down on the thread alignment tool, preventing it from turning. The thread protector shown in the pic isn't a necessity because tightening the die is a better method for accuracy.

Wrap some tape around the barrel for the maximum depth you want to thread to. The factory barrels have a flat (unthreaded area) machined near the muzzle before you get to the threads. This can be duplicated by dremeling off the threads once you are finished.

Be sure to keep the die & barrel o.d. lubed up good with a cutting fluid such as Cool Tool or brake fluid.

Also, when cutting, don't force the die, if it gets hard to advance, then back off a little until you hear a click which means it broke the chips, repeat, etc...usually 1/5th to 1/6th of a turn maximum.

One more thing to remember, don't bottom out the TAT against the barrel face because the die will strip threads off your barrel or the TAT or both. Remove the TAT after you have 4 or 5 threads cut as it will no longer be necessary.