



Threading Tips

(updated 07-05-10)

Contents (required tools)

Die Holder

Thread Alignment Tool (**TAT**)

Threading Die

Cutting Fluid

We no longer rent tooling out however we now sell everything previously available. Check out our tools page.

Threading Prep (Setting up to thread)

- #1 - Insert die in die holder, lettered (front) side up. Sometimes you need the die upside down due to the location of the external die divots.
- #2 - Align the pointed "**spreader**" screw with the die split if possible.
- #3 - Align the other 2 "**tightening**" screws with the divots in the o.d. of the die. They will either be 90 degrees apart if 180 degrees apart.
- #4 - Screw in the TAT about 4-5 threads from the back side of the die with the pilot going the rest of the way through the die.
- #5 - Loosen the **spreader** screw and tighten the **tightening** screws. The **TAT** should now be tight.
- #6 - If need be, use the adjustment screw in the die as well.

Threading - starting

Hold the barrel firmly for threading. A vise with padded jaws works best.

Apply a good cutting fluid/oil to the die teeth and pilot and start cutting. It will take a little bit to get it started. Apply even pressure towards the receiver and take your time. Threading goes much smoother with a little linear force.

I recommend advancing the die 1/5th to 1/6th of a turn, then back it off until you hear a "click" to break the chips. You want to keep it from loading up and chipping the teeth.

After you have 4-6 threads cut, **Remove the TAT**. Loosen the 2 tightening screws on the die holder. Tighten the pointed spreader screw. Unscrew the TAT. Hand tighten the 2 tightening screws. Do not allow the TAT to bottom out on the barrel face and rip the teeth out, ruining TAT and possibly the threads on the barrel.

Threading - first pass

Resume threading as above, breaking the chips very frequently. Remember to apply cutting fluid to the die and pilot. Thread to the desired depth, wipe off threads and check tightness of fit with whatever brake/hider you plan on using. You want the threads firm and not too loose.

Threading - final pass

If the threads are too tight, loosen the "spreader" screw in the die holder and tighten the "tightening" screws. Then hand tighten the "spreader" screw. Apply more cutting fluid and run over the threads again. Wipe off threads and check fitment again.

Barrel size & die selection

Ensure the die size you selected will work for the barrel diameter you have. Calipers are a must. We also now offer muzzle cutters to shave barrel diameters down, check those out on the tools page.

Saiga 5.45x39, .223 or 7.62x39

You will need to remove the shroud and thread the barrel. A dremel cutting disc works best for this, just be careful to not cut too deep into the barrel.

Saiga .308

You will need to remove the front sight block to determine barrel diameter and thread size needed. See our 308 FSB removal/reinstall tips on our downloads page.

Saiga 12

We have additional information on the downloads page for threading the Saiga-12. Can be applied to the other shotguns as well.

Indexing Muzzle Devices

If you need to index a certain type brake or hider, like a '74 brake or hider, you can index with teflon tape or I can supply a crush washer or muzzle nut.

Final Word

Hopefully these tips will help you out. If you have any questions, please let me know. Always verify the caliber of the muzzle device you are using and make sure there is proper clearance. If you do not feel comfortable threading, please take it to a qualified gunsmith.

Thanks! Dinzag Arms - dinzag@yahoo.com