



## **Moving Saiga 308 FSB** **removal and reinstall instructions** - updated 08-03-07

Here's the rundown of some tips to remove and reinstall your 308's front sight block one pin back. This will expose a portion of the barrel so it may be threaded.

Some of the older 308's have a 0.630" barrel diameter under the FSB and others have a 0.670" barrel diameter. 0.630" lends itself to being threaded for 5/8-24 threads and 0.670" lends itself to being threaded for 17x1 threads.

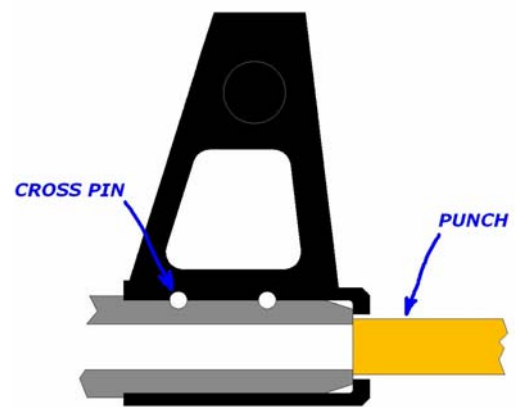
### **Removal**

Remove the cross pins using a hammer and pin punch that is smaller than 3mm (0.118").

Place a 3/8" diameter brass punch against the muzzle face inside the FSB hole.

Attach press plates behind the FSB and press it off with a shop press.

Another option is to use a brass punch and drive it with a hammer on the back lower portion of the FSB tower.



### **Modification**

I cut the muzzle cap off the front sight block to allow the barrel to pass through.

The Saiga 308 barrel steps up in diameter either at the rear of the FSB or just inside it. I bore the FSB out so it is able to be reinstalled about 0.58" rearward.

### **Reinstall**

When you tap the modified FSB back on the barrel, the FSB front pin hole needs to line up with the rear barrel cross pin slot.

Make sure the FSB is vertical and straight with the rear sight and not canted. Ream out the front pin hole with the 3mm drill bit. Install pin.

Next take the 3/32" (0.093") milling cutter and drill/mill a flat into the rear FSB pin hole from each side. A drill press or milling machine works best for this, but you can use a hand drill.

Use the 7/64" (0.109") gold cobalt drill bit to drill in from each side. Try to keep it perpendicular with the side of the FSB. Work in from each side until you meet in the middle.

Finally, ream the hole out with the 3mm (0.118") drill bit and install the rear pin. It is now ready to be threaded.

