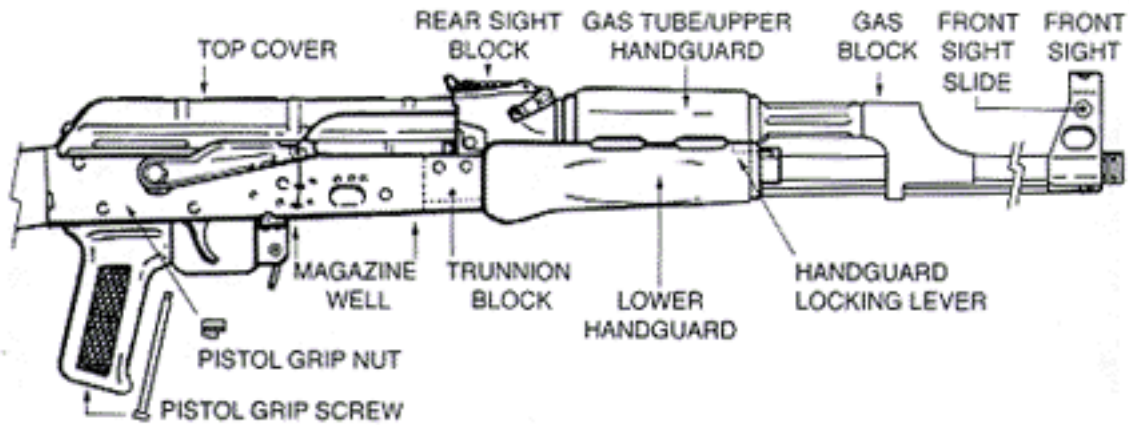


## DISASSEMBLY



[Bolt Disassembly](#)

[Diagrams](#)

[Exploded Parts View](#)

[Field Stripping](#)

[Handguard Removal](#)

[Magazine Disassembly](#)

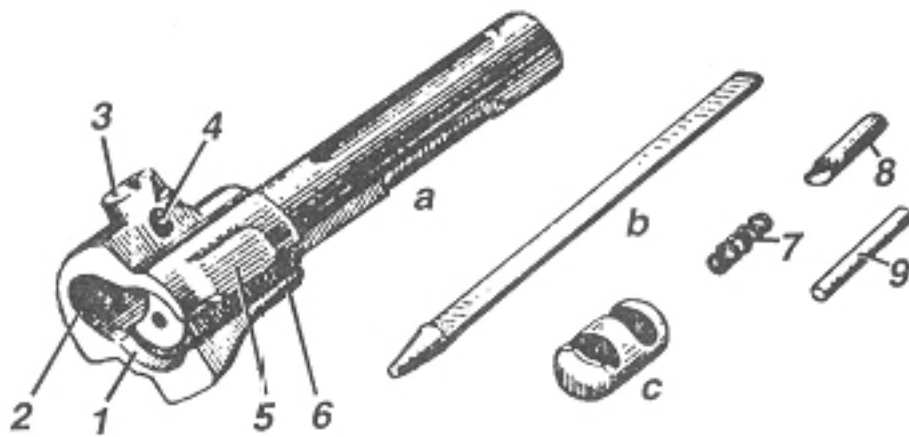
[Recoil Mechanism Disassembly](#)

[Trigger Group Removal](#) Full Auto

[Trigger Group Removal](#) Sem-Auto

AK47 [pdf](#) and dwgs ([1](#), [2](#))

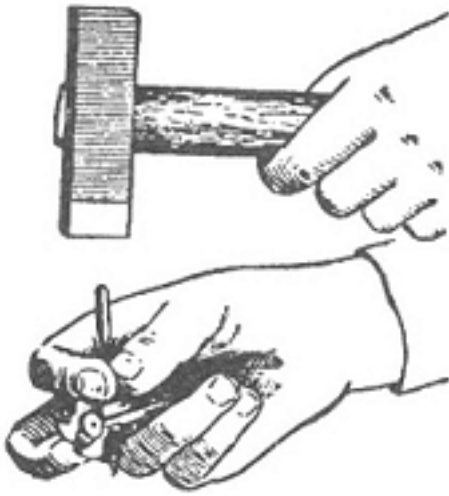
[Krinkov Blueprints](#)

**a - Bolt Body****b - Firing pin****c - Extractor**

- 1 - **Recess for case bottom**
- 2 - **Extractor slot**
- 3 - **Guide lug**
- 4 - **Hole for extractor pin**
- 5 - **Locking lug**
- 6 - **Longitudinal slot for ejector lug**
- 7 - **Extractor spring**
- 8 - **Extractor pin**
- 9 - **Firing pin retaining pin**

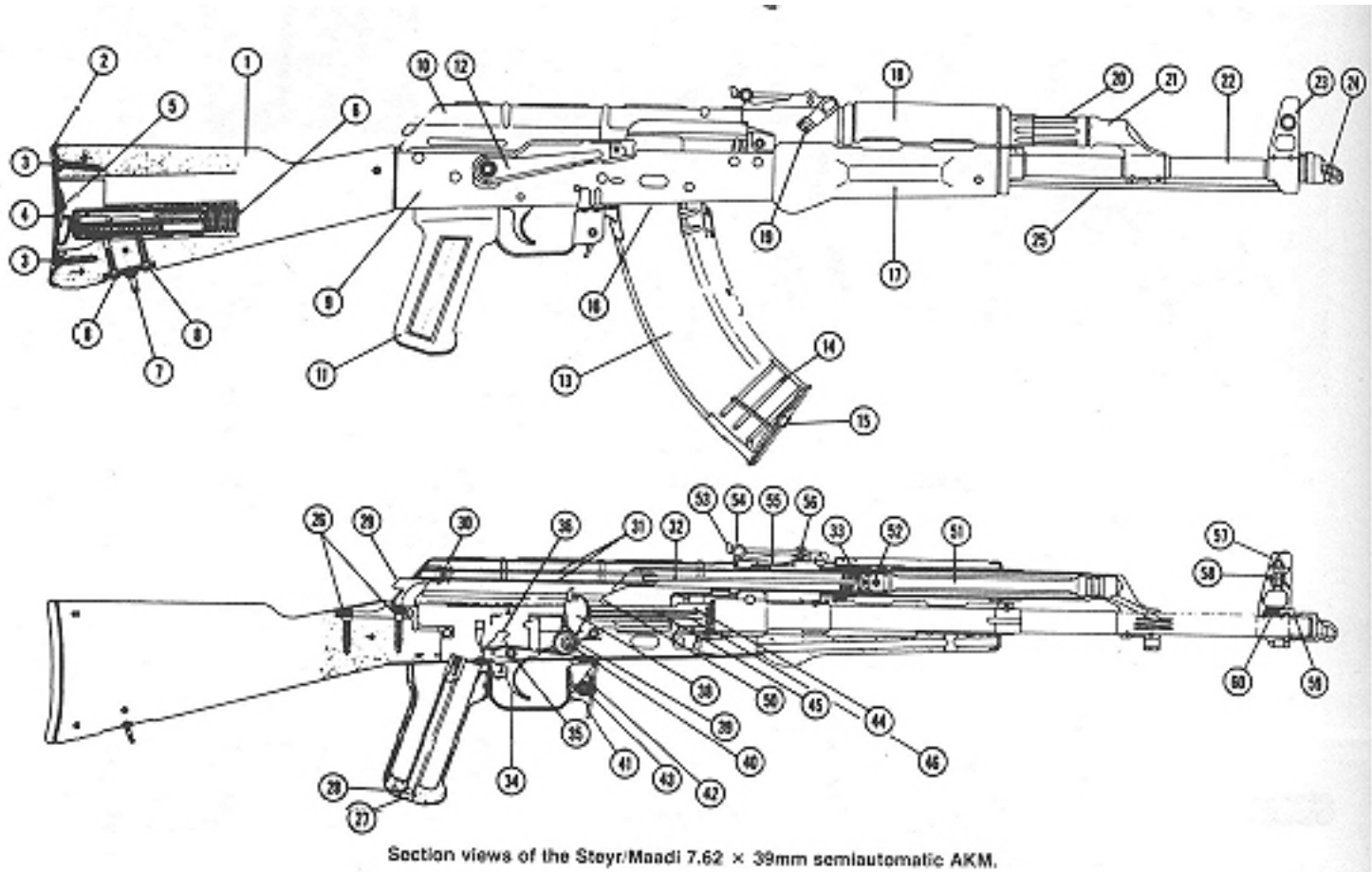
The bolt delivers the cartridge into the chamber, closes the barrel bore, dents the primer, and extracts the case from the chamber. The bolt consists of body, firing pin, extractor with spring and pin, and firing pin retaining pin.

The bolt body has on the front faced- two cylindrical recesses for the case bottom and for the extractor; two locking lugs that engage in the receiver's locking recesses to lock the bolt; on top a guide lug for rotating the bolt during locking; on the left side a longitudinal slot for passage of the receiver's ejector lug ( the slot widens at the end to facilitate the bolt's rotation during locking.) in the slimmer portion of the bolt body are holes for the extractor pin and firing pin retainer pin. The firing pin has a striker and a recess for the retaining pin. The extractor with spring extracts the case from the chamber and holds it until it encounters the receiver's ejector lug. The extractor has a claw for capture of the case, a pocket for the spring, and a notch for the pin. The retaining pin secures the firing pin.



**Disassembly** With the drift or punch set, drive out the pin that retains the firing pin and extractor pin, and remove the extractor with spring from the bolt.

Source: Text and Pictures from "The official Soviet AKM Manual" By Maj.  
James F. Gebhardt



[AK Reciever Types Diagram](#)  
[Parts Diagram 3](#)  
[Under Folding AK Diagram 2](#)

## Exploded Parts View

- 1 - **Barrel with receiver, with rear sight and stock**
- 2 - **Receiver cover**
- 3 - **Bayonet**
- 4 - **Recoil mechanism**
- 5 - **Bolt Carrier with gas piston**
- 6 - **Gas tube with upper hand guard**
- 7 - **Bolt**
- 8 - **Cleaning Rod**
- 9 - **Fore end**
- 10 - **Magazine**
- 11 - **Combination tool with accessories**

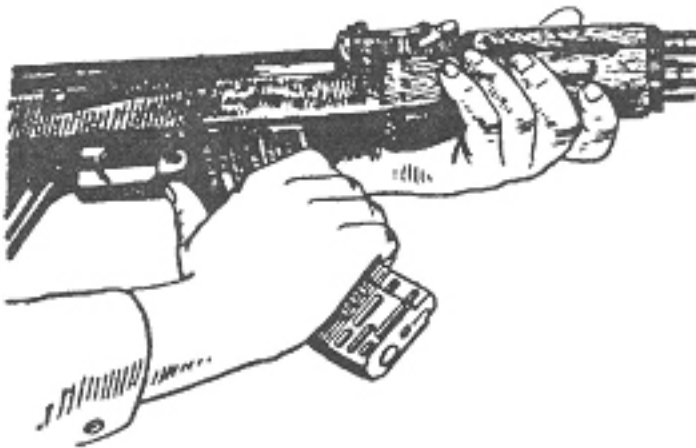
Source: Text and Pictures from "The official Soviet AKM Manual" By Maj. James F. Gebhardt

Like most firearms the AK-47 will start to show adverse wear and or malfunction if the weapon is not kept reasonably clean. Fortunately for the AK it is very easy to field strip, which makes cleaning not much of a chore. The AK requires no special maintenance tools or extensive knowledge of it's parts.

**Materials:**

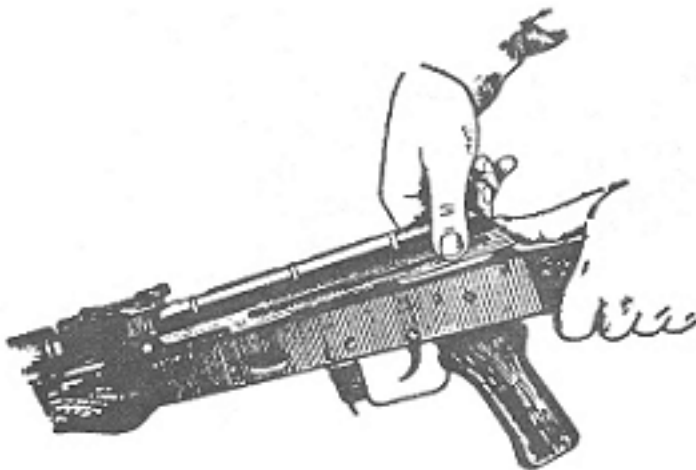
1. Cleaning Kit
2. News Paper or Throwdown

**The Following Procedure should be used to field strip and clean the rifle.**



**Removing the magazine** Holding the rifle in the left hand at the upper hand guard and fore end, grasp the magazine with the right hand and remove it. The magazine is removed by pressing forward on the magazine catch. After this, ensure that there is no cartridge in the chamber by lowering the selector, pulling the bolt carrier handle to the rear, and inspecting the chamber. Release the bolt carrier handle and release the hammer from the sear (squeeze the trigger)

**2) Remove the cleaning rod** Pull the end of the cleaning rod away from the barrel so that its head is disengaged from the stop on the front sight base and pull the cleaning rod upward. The drift may be used when removing the cleaning rod.



**3) Remove the receiver cover** Grasp the small of the stock with the left hand, and with the left thumb press on the recoil mechanism's guide rod lug. Lift the rear portion of the receiver cover upward with the right hand and remove the cover.

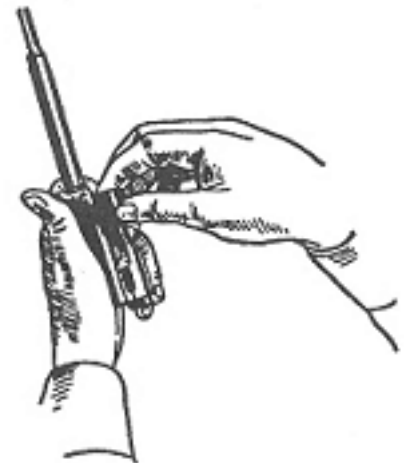
**4) Remove the recoil mechanism.** Holding the rifle in the left hand by the small of the stock, press the recoil mechanism's guide rod forward with the right hand until its heel emerges from the longitudinal slot of the receiver. Lift up the rear end of the guide rod and pull the recoil mechanism from the bolt carrier channel.



**5) Remove the bolt carrier with bolt.**

Continuing to hold the rifle in the left hand, bring the bolt carrier to the rear to stop with the right hand. Lift it up along with the bolt and remove it

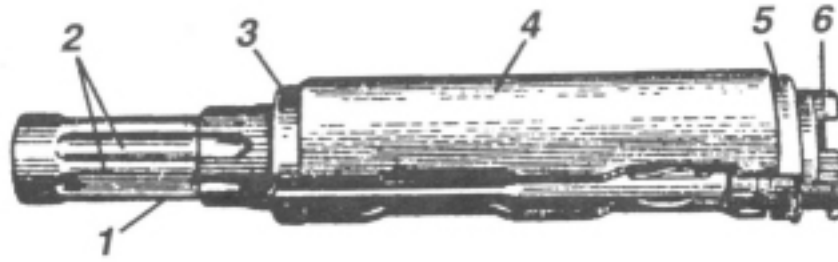
**6) Remove the bolt from the carrier.** Grasp the bolt carrier in the left hand with the bolt upward. Draw the bolt to the rear with the right hand, rotating it so that the bolt's guide lug comes out of the shaped slot of the bolt carrier, and remove the bolt forward.



**7) Remove the gas tube.** Holding the rifle in the left hand, lift the gas tube latch located on the right side of the rear sight block. Rotate the small latch downwards and clockwise at the same time. This should enable you to free the gas tube, lift and remove it.

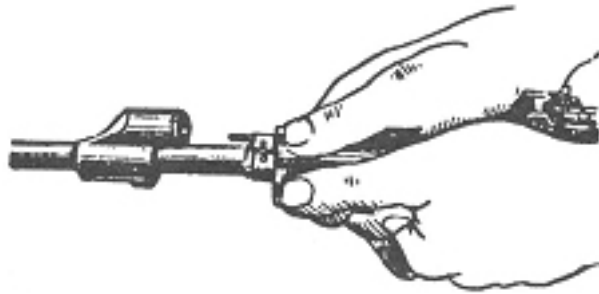
For Complete disassembly instruction please [Enter](#) here.

Source: Text and Pictures from "The official Soviet AKM Manual" By Maj. James F. Gebhardt



- 1 - Gas Tube
- 2 - Guide ribs for gas piston
- 3 - Front joining collar
- 4 - Hand Guard
- 5 - Rear joining collar
- 6 - Lug

The gas tube directs the movement of the gas piston. It has guide ribs. The front end of the gas tube fits on the gas chamber. The hand guard protects the rifleman's hands from burns when firing. It has a channel in which is secured the metal semi-circular spacer that presses the hand guard away from the gas tube. The hand guard is secured on the gas tube by front and rear joining collars; the rear collar has a lug in which the gas tube lock engages.



**Disassembly of the fore end** Grasp the rifle at the fore end in the left hand . With the right hand using a screwdriver rotate the fore end lock on half turn forward. Displace the connecting collar with fore end toward the gas chamber with the thumbs of both hands. Press forward on the fore end and remove it from the barrel.

Source: Text and Pictures from "The official Soviet AKM Manual" By Maj. James F. Gebhardt

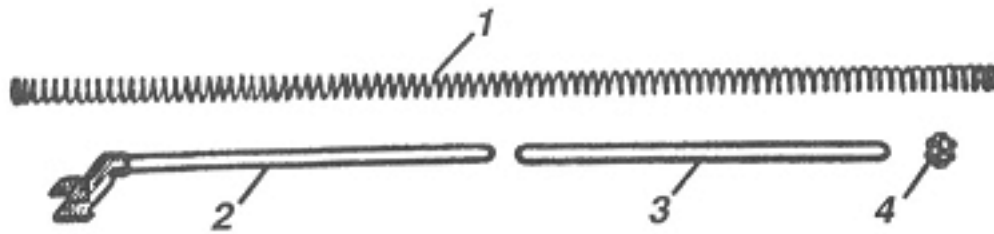


- 1 - **Body**
- 2 - **Floor plate**
- 3 - **Stop leaf**
- 4 - **Spring**
- 5 - **Follower**
- 6 - **Stop Lug**
- 7 - **Catch**

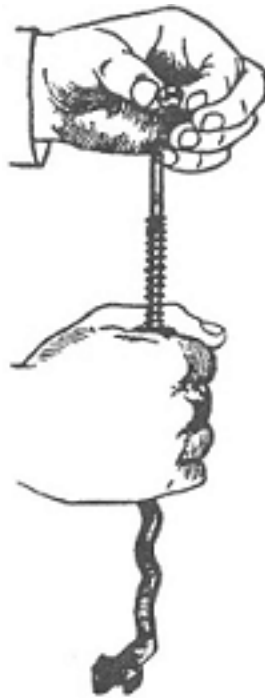
The magazine body joins all of the magazine's components together. Its lateral walls have lips to prevent the cartridges from falling out and lugs that limit the upward motion of the follower. On the front wall is the catch and on the rear wall stop lug, which together hold the magazine in the receiver. On the bottom of the rear wall of the magazine's body is an inspection hold for determining if the magazine is fully loaded. The walls of the magazine are ribbed for strength. The bottom of the magazine is closed with a floor plate. The floor plate has a hole for the lug of the stop leaf. Inside the magazine body are a follower and spring with stop leaf. The follower is fastened to the upper end of the spring by an internal flange on the right wall of the follower. The follower has a lug that ensures the staggered positioning of the cartridges in the magazine. The stop leaf is permanently attached to the bottom end of the follower spring and holds the magazine floor plate from displacement with its lug. Some rifles have plastic magazines that are the same in construction as the metal magazines.

**Disassembly** Depress the small metal notch at the end of the magazine on the floor plate. Slide the floor plate backwards towards the rear or primer area of the magazine. Be careful the spring will shoot out with some force and could cause injury if not done slowly. Remove the spring and follower and the magazine is now disassembled. To reassemble just reverse the order of operation.

Source: Text and Pictures from "The official Soviet AKM Manual" By Maj. James F. Gebhardt

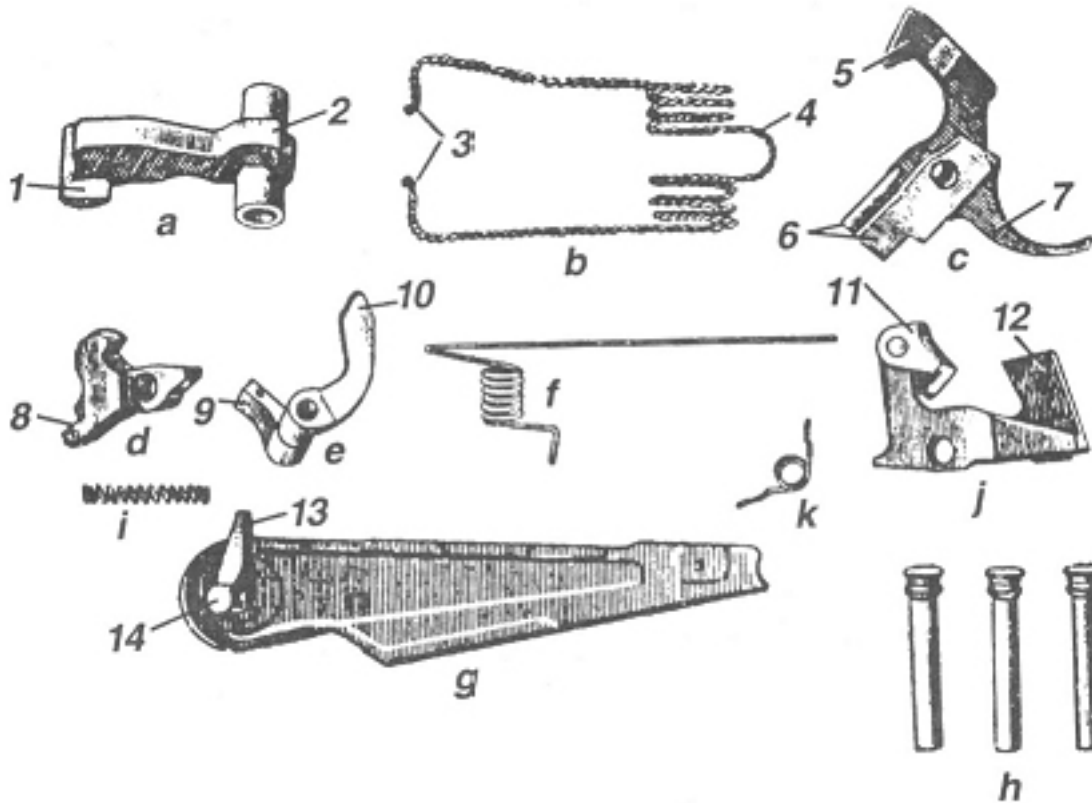


- 1 - Recoil Spring
- 2 - Guide rod
- 3 - Movable guide rod
- 4 - Collar



**Disassembly** Grasp the recoil mechanism in the left hand. Position the guide rod vertically with the heel down on the table or rest. Compress the recoil spring downward, and with the right hand separate the send of the movable rod and remove the collar. Remove the spring from the guide rod. Remove the movable rod from the guide.

Source: Text and Pictures from "The official Soviet AKM Manual" By Maj. James F. Gebhardt



- |                         |                            |
|-------------------------|----------------------------|
| a - hammer              | g - selector               |
| b - hammer spring       | h - pin                    |
| c - trigger             | i - semi-auto sear         |
| d - semi-auto fire sear | j - hammer retarder        |
| e - auto sear           | k - hammer retarded spring |
| f - auto sear spring    |                            |

**Disassembly of Full Auto trigger mechanism.** Holding the rifle with the left hand at the receiver, press on the auto sear and disengage the auto sear from the hammer with the right hand and using the drift. Release the hammer from the sear. Raise the left end of the hammer spring with the tapered end of the drift and guide it past the hammer's sear notch with the fingers. Guide the long end of the auto sear spring out of the circular channel of the trigger pin with the screwdriver. Tap the trigger pin to the left with the drift and remove it. Gradually pulling the drift out, extract the semi-automatic fire sear from the receiver along with its spring, spring retarder, and hammer retarder with the fingers of the left hand. Pressing back in the trigger piece with the left index finger, lift the trigger upward and remove it from the receiver with the right hand. Remove the hammer by pressing with the screwdriver on the long end of the auto sear spring, remove it from the circular channel of the hammer pin. Tap the hammer pin to the left with the drift. Holding the hammer with the right hand, remove the hammer pin with the left hand. Rotate the hammer so the left trunnion is toward the chamber and remove the hammer from the receiver. Remove the hammer spring from the hammer. Remove the auto sear. Tap the auto sear pin to the left with the drift and remove it. Remove the auto sear with spring through the magazine well. Remove the spring from the auto sear. Remove the selector by rotating the selector upward to the vertical position, move it to the right, and remove it from the receiver.

Source: Text and Pictures from "The official Soviet AKM Manual" By Maj. James F. Gebhardt

When doing extensive work on a firearm, work on a soft surface so that it won't scratch the metal parts of the gun. It is also wise to work where light is good and parts will not be lost. In general it is best not to disassemble a firearm any more than is really necessary to clean it or repair or replace a part. Even then it is seldom necessary to disassemble the rifle beyond the field stripping stage. Every time a firearm is disassembled beyond the field stripping stage, it will take some time for some parts to regain their fit, some parts may tend to shake loose and fall out when firing the weapon. Some parts of the AK-47 line are riveted together. Repairing these can be quite a hassle, since the end of the rivet has to be ground off and a new one set after the part is replaced. Ideally the disassembly steps listed below will **NOT** be carried out by anyone other than a competent gunsmith. A lot of damage can be done if disassembly is done without proper knowledge.

1. Remove the magazine from the gun and cycle the action making sure the firearm is empty.
2. Push in the retaining lever (the little button at the end of the receiver closest to the stock) on the rear of the receiver, then lift the receiver cover off and back to remove it exposing the action.
3. Take out the action spring & retaining rod by pushing them forward to release them, then lift them up slightly and back them out of the receiver.
4. Remove the bolt and bolt carrier (which will also have the gas piston attached to it) By pulling them back and out.
5. Take the bolt out of the carrier by twisting the bolt counterclockwise and pulling it out of the front of the carrier.
6. Remove the gas cylinder by pulling it backward and lifting it out.
7. The extractor and extractor spring are held in place by the large pin (which may be a solid or roll pin depending on the rifle located on the side of the bolt near the locking lugs. Before trying to drift out this pin check to be sure one side isn't staked if it is go out the other side opposite the staked spot in the bolt. Drift the pin out with a drift punch or small nail to free the extractor. Be careful since the spring is under tension.
8. The smaller pin located on the side of the bolt near the locking lugs retain the firing pin (and its spring on models with a firing pin spring) note whether the pin is staked in place. Drifting the pin out frees the firing pin take care since this spring is also under pressure.
9. The gas piston is held to the bolt carrier extension arm by a roll pin. This pin should be drifted out only if the piston needs to be repaired or replaced since damage to the piston can occur during this process.
10. Flash hiders or muzzle nuts are sometimes held in place by a pin but usually are screwed onto the barrel some AK's lack them entirely.
11. The gas port block is generally held in place by cross pins don't remove it unless it's absolutely necessary, this can be a tedious process on some rifles and it may be hard to replace it so it stays in place.
12. The fore grip may be attached to the rifle in a variety of ways the method for removal is best determined by studying the rifle.
13. The trigger groups pins are released by removing the looped retaining spring

on the left inside of the receiver on semi-auto rifles, or the long leg of the disconnector spring on select-fire guns. Before freeing the spring or leg place the selector in the fire position and while restraining the hammer pull the trigger. Hold the hammer and carefully lower it until it is fully forward, facedown. This is done the retaining spring can be pulled forward and out by grasping its loop with a pair of needle nosed pliers and pulling forward and out. On select fire rifles the long leg of the disconnector spring should be pulled up to free the disconnector pin remove the pin out the left side of the receiver and then take out the disconnector and its spring to free the other parts of the trigger group.

14. Once the retaining spring is removed the trigger group is freed by sliding the hammer and trigger pins out the left side of the receiver. This will free the hammer and its spring which can be removed by turning them slightly and lifting them out. Next the trigger and sear can be removed along with the rate reducer and its sear (take care not to lose the sear spring which sits between the sear and trigger.)

15. If the safety/selector needs to be removed rotate its forward end upward so that it can be pulled out the right side of the receiver.

16. Most stocks are held in place by screws or with many folding stocks pins. Do not remove the stock unless absolutely necessary for repair or replacement.

17. The magazine release and its spring are held in place with a rivet. Do not remove the unless absolutely necessary.

18. Pistol grips are generally held in place by a bolt which can be unscrewed through the open base of the grip.

19. The front sight post generally screws into its base. The sight assembly can be removed by drifting a set screw or screws may need to be loosened first. The front sight should not be removed unless absolutely necessary since the tight fit keeps it zeroed.

20. The rear sight is generally pinned or screwed into place with its base welded onto the rifle. Note the leaf springs alignment so that it may be properly realigned.

To reassemble just reverse the process.

Comments or Suggestions?

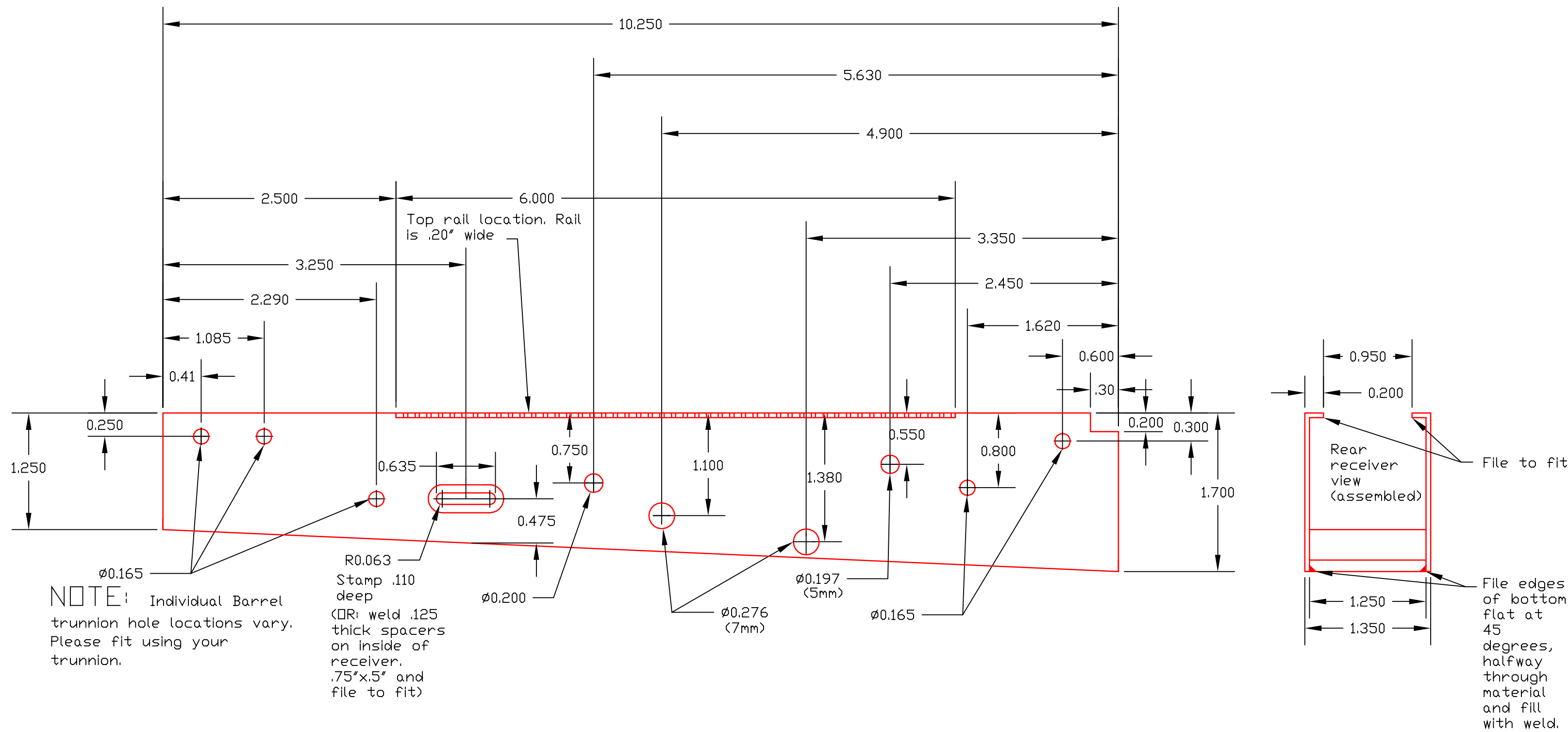
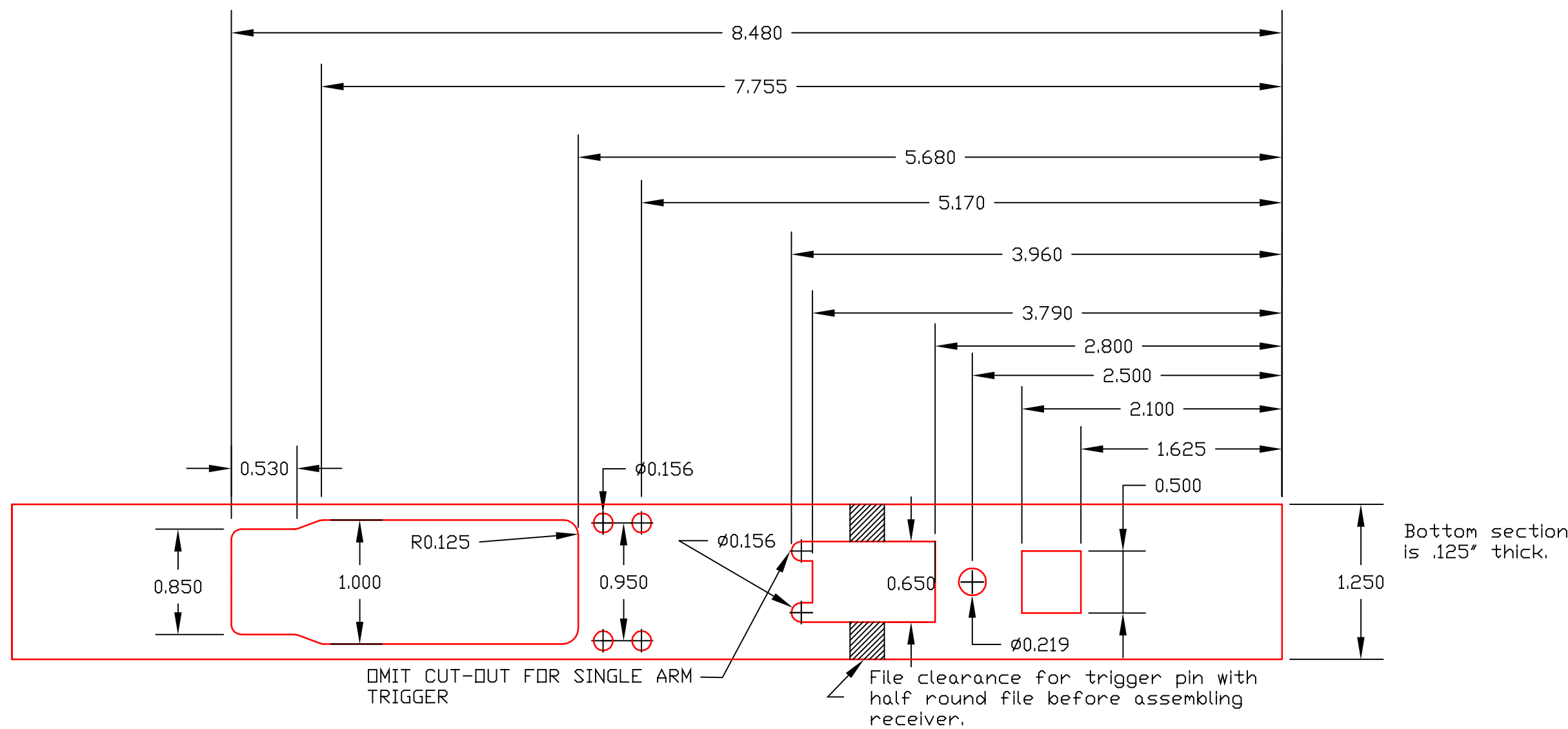
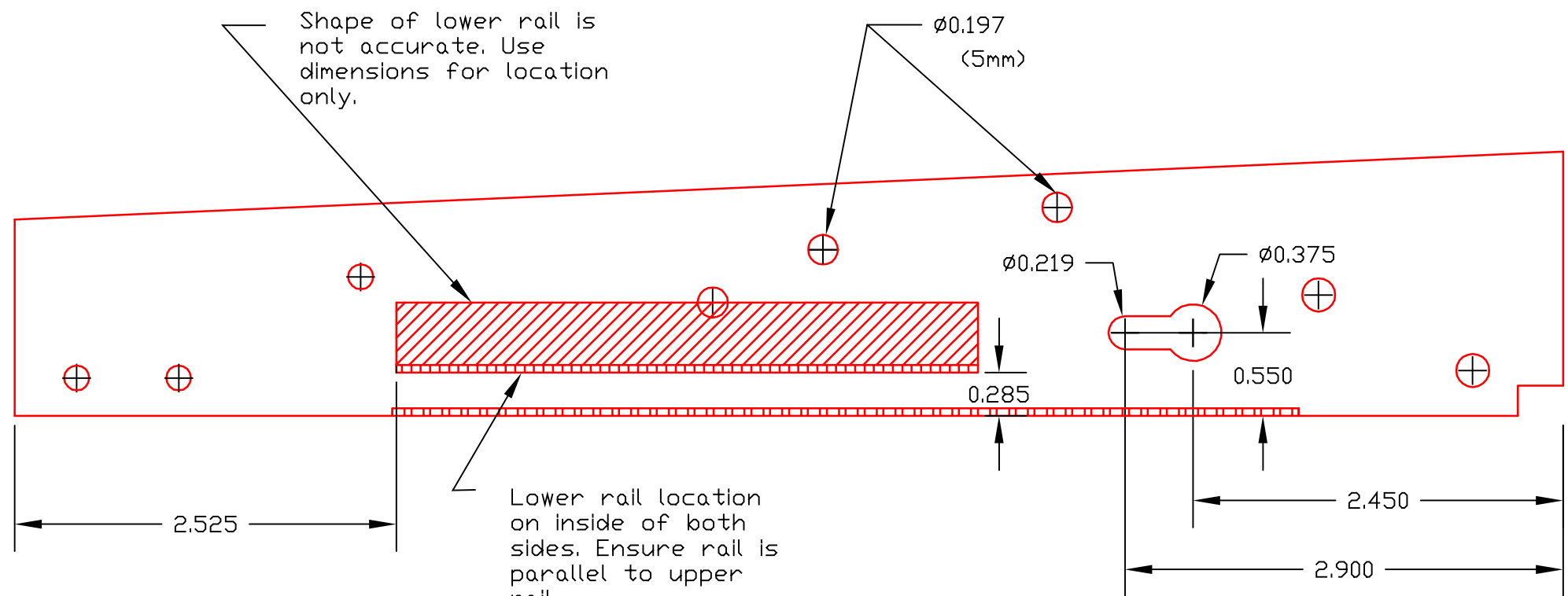
Source: AK-47 The complete Kalashnikov Family of Assault Rifles By Duncan Long

RIGHT SIDE

CENTER  
(TOP  
VIEW)

ALL MEASUREMENTS ON CENTER

LEFT SIDE

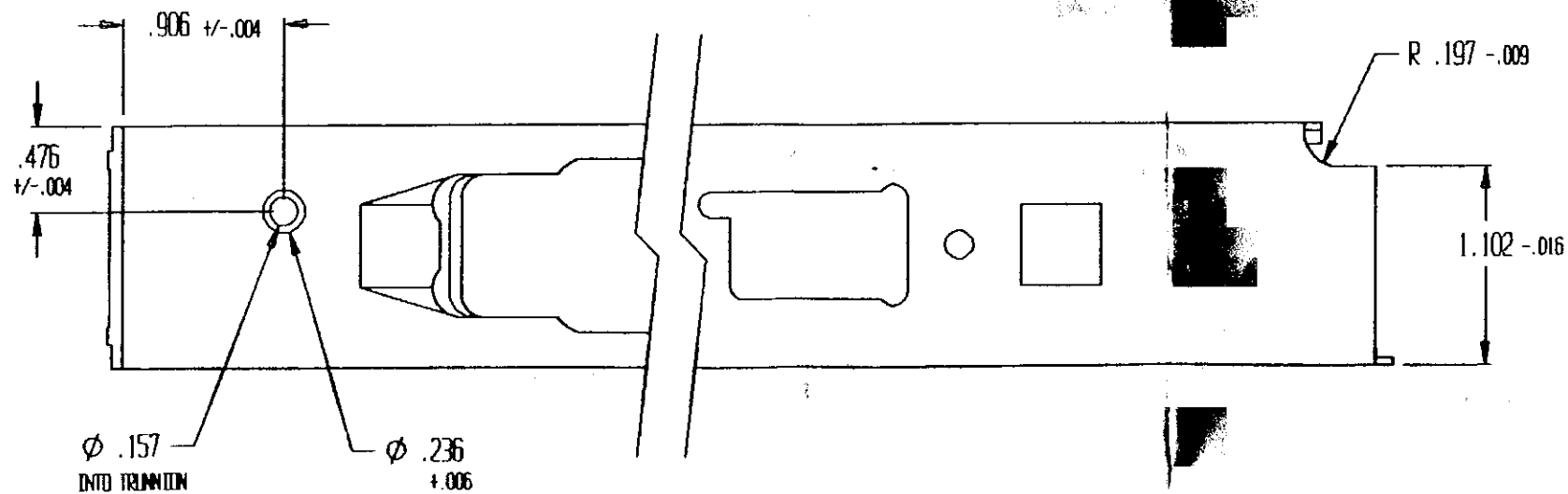
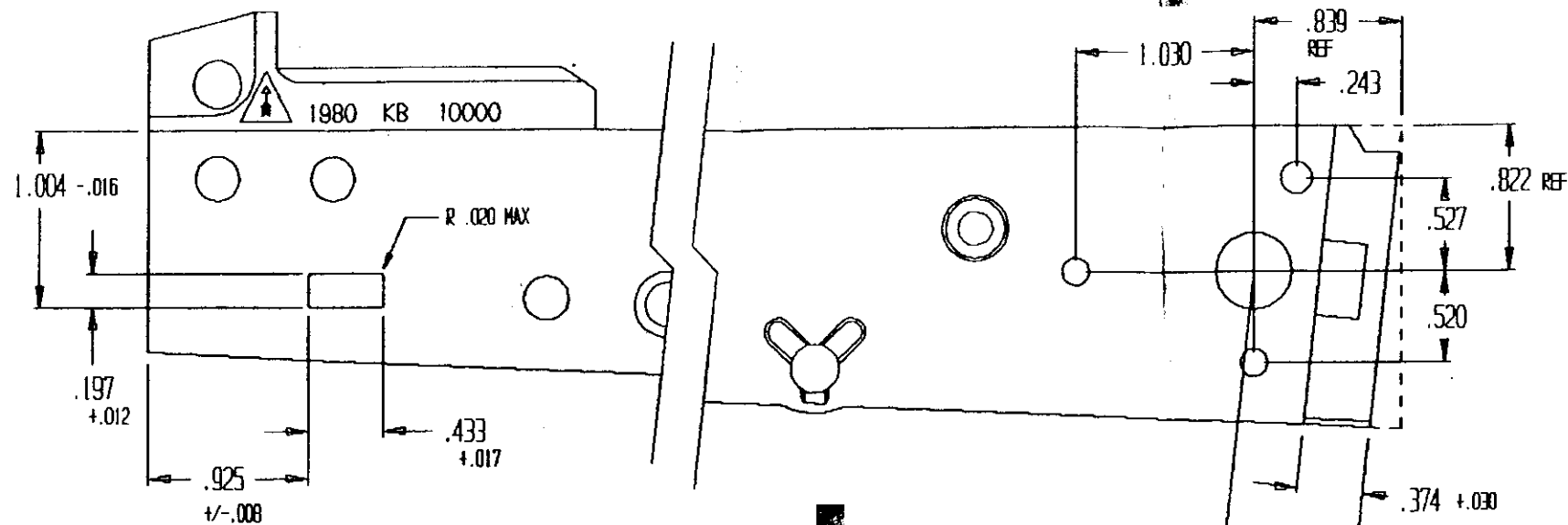


Side plates can be fabricated from .05 thick 4130 sheet that has folded upper rails. Alternately the sides can be made from rectangular 4130 tubing (1"x2") that is .065 thick. Cut the tube down the center and then cut to shape.

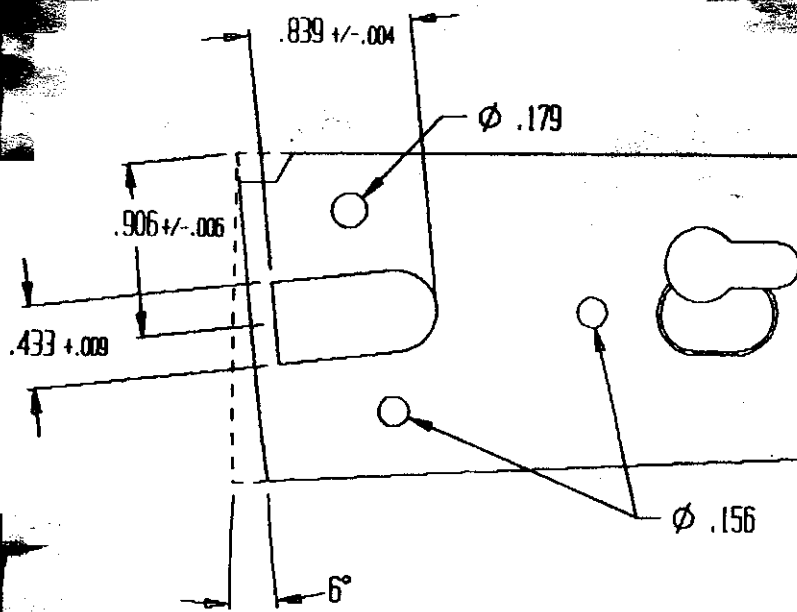
Heat treating is NEEDED if using 4130 of this thickness. To do so, clamp side plates back to back (helps prevents warping when quenched) and heat RED HOT with MAPP torch. Quench IMMEDIATELY in mineral oil or water. In this hardened condition (approx. Rockwell 60C) the metal is too brittle, therefore tempering is required. REHEAT the metal to BLUE HOT and let AIR COOL. Repeat with center section if desired.

NOTE: If metal becomes RED HOT when tempering the hardness WILL BE LOST and the above procedure will need to be repeated.

|                                 |           |                      |              |
|---------------------------------|-----------|----------------------|--------------|
| AK-47 Home Built Receiver Plans |           | ALL BATF RULES APPLY |              |
|                                 | SIZE      | FSCM NO.             | DWG NO.      |
|                                 | SCALE 1:1 | Dr. Strangelove      | NOV. 21 2001 |
| SHEET 1 of 1                    |           | REV 2                |              |



AKS-74 FOLDING S



LOCK CONVERSION

## AK RECEIVER IDENTIFICATION:

### AK ONE PIECE MILLED STYLE:

MACHINED FROM FORGED OR BILLET STEEL BLOCK.  
1950s SOVIET MANUFACTURING METHOD STILL USED  
BY CHINA AND BULGARIA ON SOME COMMERCIAL  
WEAPONS.

#1

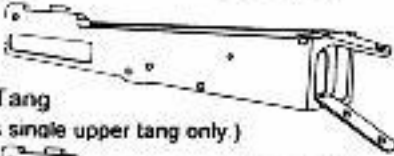
UNDER FOLDING STOCK



#2

FIXED STOCK - Double Tang

(NOTE! Later Bulgarian has single upper tang only.)



#3

MAK90 "MODIFIED" to Single Tang

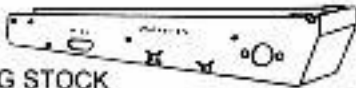


### AKM & AK74 RIVETED STAMPED STYLE:

RIVETED TOGETHER FROM MACHINED COMPONENTS  
AND SHEET METAL RECEIVER SHELL. STYLE USED BY  
MOST OF THE WORLD'S GOV'T. MANUFACTURES AND  
BY THE CHINESE ON SOME COMMERCIAL WEAPONS.

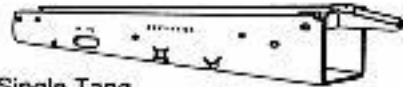
#4

UNDER FOLDING STOCK



#5

FIXED STOCK - Single Tang



#6

MAK90 & Romanian "Modified".

