

INSTRUCTIONS FOR AKS TO AK-47 DRILLING FIXTURE

WARNING: ANY ATTEMPT TO CONVERT A FIREARM INTO A MACHINEGUN WITHOUT PRIOR BATF APPROVAL IS ILLEGAL. THESE INSTRUCTIONS ARE PROVIDED AS INFORMATION ONLY!

THE DRILLING FIXTURE HAS FIVE HOLES, EACH HOLE IS MARKED WITH ONE OR MORE LETTERS EXCEPT FOR THE .125 (1/8") HOLE FOR DRILLING THE SELECTOR DETENT. THESE REPRESENT WHERE THE HOLES FIT IN CONJUNCTION WITH EXISTING HOLES ON THE WEAPON. THEY ARE AS FOLLOWS: T=TRIGGER, H=HAMMER, R= A CLEARANCE HOLE TO FIT OVER THE RECEIVER SUPPORT RIVET, AND AS=AUTO SEAR (THIS IS THE HOLE TO BE DRILLED).

HOW TO USE THE DRILLING FIXTURE (TO BE USED ON BATF APPROVED CONVERSIONS ONLY!!)

- 1) DISASSEMBLE THE WEAPON.
- 2) FIND THE TWO ENCLOSED SLAVE PINS APPROX. 1.5" LONG WITH THE LARGER DIAMETER BEING .277" AND THE SMALLER STEP BEING .197"
- 3) PLACE THE DRILLING FIXTURE ON THE LEFT SIDE OF THE RECEIVER, TAKE THE TWO SLAVE PINS AND PUT THE SMALL END FIRST THROUGH THE DRILLING FIXTURE HOLES MARKED "H" & "T". THE PURPOSE OF THE SLAVE PINS IS TO PROPERLY ALIGN THE DRILLING FIXTURE IN RELATIONSHIP TO THE HAMMER AND TRIGGER HOLES SO THAT THE AUTO SEAR HOLE WILL LINE UP PERFECTLY. THE SMALL END OF THE SLAVE PIN (.197) WILL FIT THROUGH THE OTHER SIDE OF THE RECEIVER.
- 4) CENTER PUNCH LEFT SIDE OF THE RECEIVER AND USING THE DRILLING FIXTURE AS A GUIDE, ~~DRILL THROUGH THE LEFT SIDE ONLY~~ WITH A .277" DRILL.
- 5) SHORTEN THE SELECTOR STOP, WHICH IS GENERALLY A STEEL TAB WELDED ONTO THE RIGHT SIDE. REMOVE BY GRINDING OR FILING, MAKING SURE THAT YOU LEAVE ENOUGH MATERIAL TO STOP THE DOWNWARD TRAVEL OF THE SELECTOR AND KEEP IT FROM SLIDING PAST THE BOTTOM EDGE OF THE RECEIVER. THIS IS ALSO REQUIRED TO PROVIDE CLEARANCE FOR THE DRILLING FIXTURE TO MOUNT ON THE RIGHT SIDE OF THE RECEIVER.
- 6) INSERT THE SMALL ENDS (.197) OF THE SLAVE PINS INTO THE TRIGGER AND HAMMER PIN HOLES ON THE RIGHT SIDE OF THE RECEIVER. SLIDE THE DRILL FIXTURE OVER THE SLAVE PINS. THIS WILL ALIGN THE DRILL FIXTURE FOR INSTALLATION OF THE AUTO SEAR PIVOT PIN HOLE AND THE SELECTOR DETENT.

PLACE THE DRILL BUSHING (INCLUDED) INTO THE HOLE MARKED "AS". DRILL THROUGH THE RIGHT SIDE ONLY OF THE RECEIVER WITH A .197" DRILL USING THE BUSHING AS A GUIDE. THE HOLE FOR THE AUTO SEAR PIVOT PIN IS .197" DIAMETER ON THE RIGHT SIDE AND .277" DIAMETER ON THE LEFT SIDE OF THE RECEIVER. THE HOLE ON THE RIGHT SIDE IS SMALLER.

7) WITH THE DRILL FIXTURE STILL IN PLACE DRILL A DETENT INTO THE RIGHT SIDE OF THE RECEIVER. THIS DETENT IS INTENDED TO FIT THE STAMPED "BALL" ON THE SELECTOR AND HOLD THE SELECTOR IN THE SEMI-AUTO POSITION. USE THE 1/8" HOLE ON THE FIXTURE LOCATED IN THE LOWER RIGHT HAND CORNER OF THE DRILL FIXTURE AS A GUIDE. DO NOT DRILL ALL THE WAY THROUGH THE RECEIVER!!! USE A .125" (1/8" DRILL) AND A MANUAL HAND DRILL OR SET A STOP ON YOUR POWER DRILL TO LIMIT THE DEPTH OF THE DETENT. THE DETENT SHOULD BE SHALLOW ONLY ABOUT THE WIDTH OF THE DRILL (.125") AND ABOUT .025 - .050" DEEP. JUST ENOUGH TO HOLD THE SELECTOR IN PLACE YET ALLOW IT TO SLIDE IN AND OUT OF THE DETENT WITH REASONABLE PRESSURE.

8) TO INSTALL AN AUTO SEAR INTO THE RECEIVER, A CLEARANCE CUT WILL HAVE TO BE MADE FROM A TAB ON THE RIGHT INSIDE OF THE RECEIVER TO ALLOW THE AUTO SEAR TO MOVE FREELY.

THE AUTO SEAR TRIP LEVER SHOULD BE INSTALLED ONTO ITS PIVOT PIN THROUGH THE "AS" HOLES IN RECEIVER SO AS TO MARK THE INNER LIP ON THE RECEIVER FOR CUTTING. THE LEVER SHOULD FIT UP AGAINST THE RIGHT SIDE OF THE RECEIVER. THE PROTRUDING LIP ON THE RECEIVER MUST BE CUT OUT ENOUGH FOR CLEARANCE. THIS CAN BE DONE WITH A MILLING MACHINE OR A DREMEL TYPE MOTOR TOOL OR WITH A FILE. REMOVE AN APPROX. 1/2" LONG AREA TO PROVIDE CLEARANCE FOR THE TRIP LEVER TO BE TRIPPED BY THE BOLT CARRIER USED IN SELECT FIRE WEAPONS. THE DIMENSIONS OF THE CLEARANCE CUT IS NOT CRITICAL JUST SO AUTO SEAR CAN MOVE FREELY BACK AND FORTH. THIS CUT IS ACROSS FROM AND JUST FORWARD OF THE EJECTOR.

TO COMPLETE A CONVERSION FROM AKS TO SELECT FIRE IT WILL REQUIRE THE FOLLOWING FULL AUTO COMPONENTS;

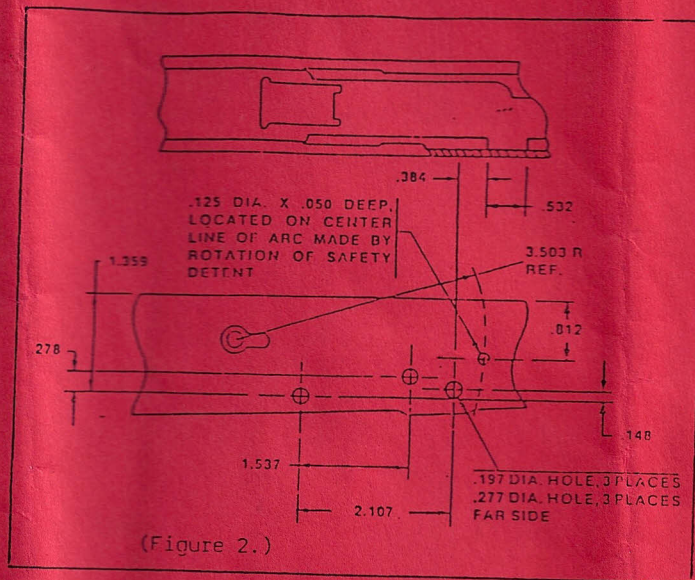
AK-47 HAMMER, AUTO SEAR & SPRING, AUTO SEAR PIVOT PIN, DISCONNECTOR AND A FULL AUTO BOLT CARRIER.

THE AUTO SEAR FOR AN AKS CONVERSION IS DIFFERENT THAN AN AK-47 AS IT IS SHAPED TO CLEAR THE SUPPORT RIVET INSIDE THE RECEIVER (SEE FIGURE 1). AN ORIGINAL SEAR CAN BE MODIFIED TO CLEAR THE RIVET OR RIVET CAN BE REMOVED, HOWEVER THIS IS NOT RECOMMENDED.

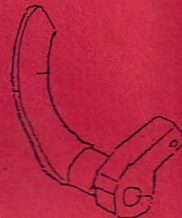
FOR ASSEMBLY REFERENCE SEE FIGURE 2 WHICH SHOWS THE RELATIONSHIP OF PARTS IN AN AK-47.

WARNING!!!

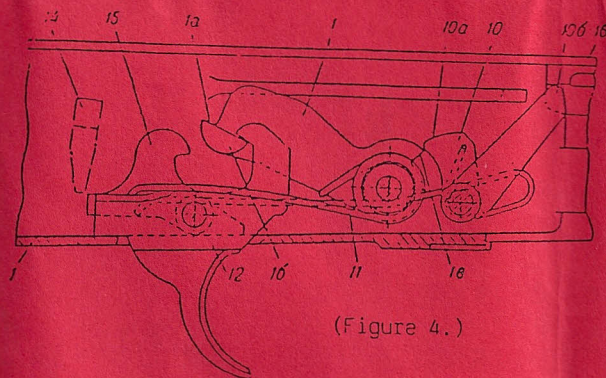
THE POSSESSION OF CONVERSION PARTS MAY CONSTITUTE POSSESSION OF AN UNREGISTERED MACHINEGUN WITH OR WITHOUT THE GUN. CHECK WITH THE BUREAU OF ALCOHOL, TOBACCO & FIREARMS TO OBTAIN THE PROPER PERMITS AND APPROVALS BEFORE ATTEMPTING TO CONVERT ANY WEAPON TO FULLY AUTOMATIC.



AK AUTO SEAR (Figure 3.)



AUTO SEAR (AKS Replacement)



CATCo. DOES NOT SELL ANY AK-47 OR AKS PARTS OF CONVERSION PARTS. PLEASE DO NOT ASK!!!

THE POSSESSION OF AN UNREGISTERED FULLY AUTOMATIC WEAPON (Machinegun) IS A FELONY. POSSESSION OF CONVERSION PARTS WITH OR WITHOUT A WEAPON MAY BE CONSIDERED A MACHINEGUN. CONTACT BATF FOR APPROVAL BEFORE ANY ATTEMPT TO CONVERT A WEAPON TO FULLY AUTOMATIC.