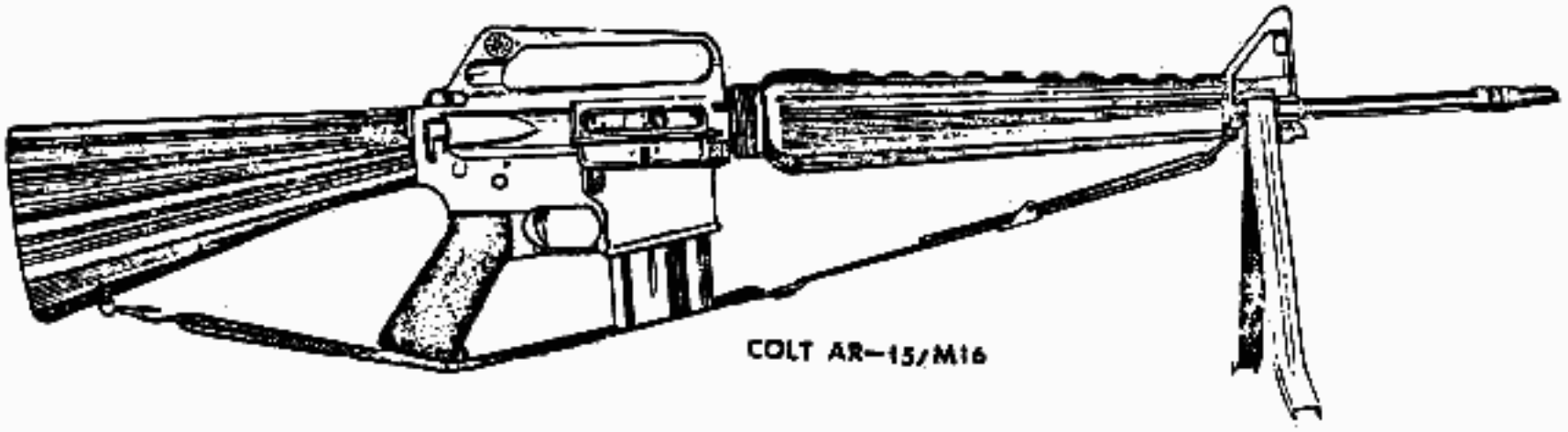
FULLY AUTOMATIC WEAPONS

Fully automatic weapons are notoriously wasteful of ammo but so intriging to gun buffs that underground gunsmiths have been publishing crude instructions for years. Since the ATF has begun cracking down on the sale of auto-conversion kits, the do-it-yourself-from-scratch techniques have gained popularity. So here are four plans I've had lying around for years and now hope some of my readers may enjoy the challenge of figuring them out. Once you've mastered the technique of converting most semi-automatics to full-auto you can make money right away by converting your best friends' guns until you get that job making license plates.

AR-15 TO M16

CONVERSION INSTRUCTIONS



Tools needed:

electric drill
1/4 inch drill bit
Small pointed metal rotary file/rasp bit
1/8 inch drill bit

DIRECTIONS

Strip AR-15 rifle down to lower receiver.
Remove the following parts: hand grip (watch out for that detent and spring), safety selector, hammer, carrier, trigger & disconnector.
Take the necessary parts from the AR-15 carrier and put them into the M-16 carrier.

Take the electric drill and the small rotary rasp bit and grind out the area in the lower receiver housing as shown in the crudely drawn diagram below. BE CAREFUL TO GRIND ONLY ENOUGH METAL OUT TO MAKE ROOM FOR THE SEAR. It is only necessary to grind away the metal for about 1 1/4 inches back towards the buttstock.

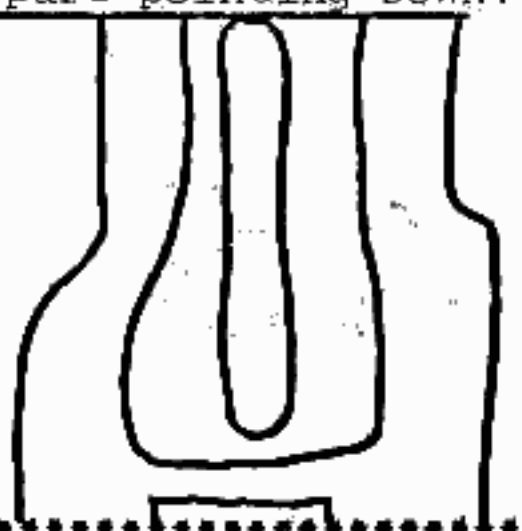
After the above is completed, use the 1/8 inch drill bit to drill the hole in the lower receiver housing for the sear pin. Drill STRAIGHT UP

From the letter "R" in the word "FIRE" and come DOWN EXACTLY 5/32 of an inch. It is very important to drill this hole in the proper place as indicated.

After this step has been completed you are ready to install the M-16 parts in your AR-15.

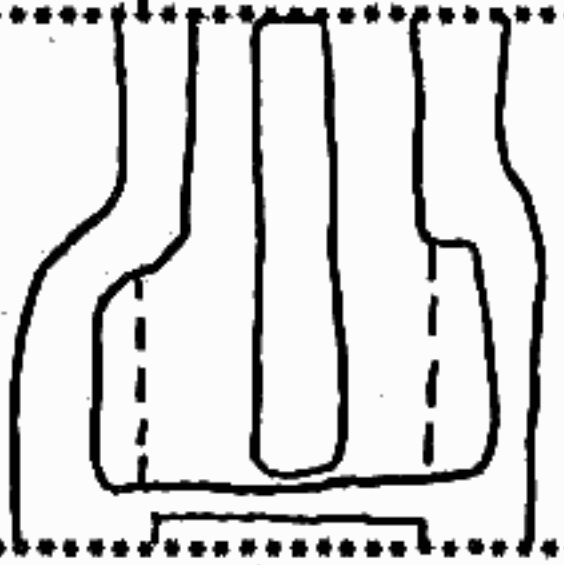
Install the sear with the LONGEST part pointing DOWN.

This is a top view of the inside of the lower receiver BEFORE the metal has been ground away. This MUST be done in order to make clearance for the M16 sear.



To the right is a top view of the lower receiver of your AR-15 AFTER the necessary metal has been removed. Now the correct space and clearance is provided for the M16 sear.

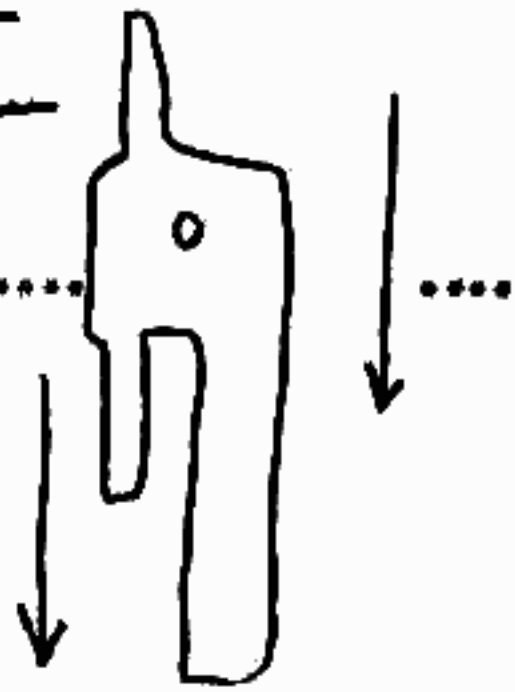
NOTE: dotted line represents metal that was removed by grinding.



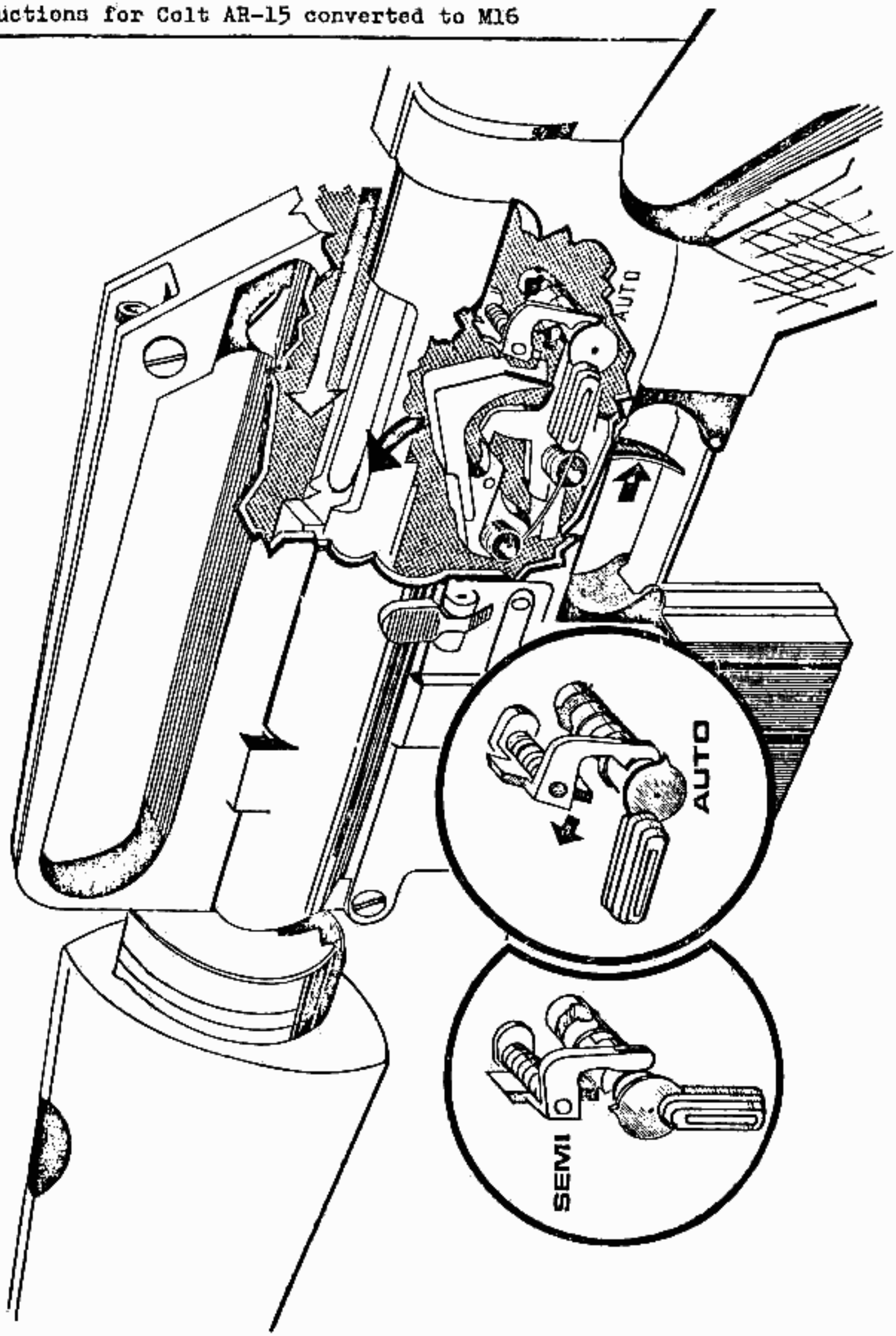
BEFORE sear pin hole has been located and drilled.

AFTER sear pin hole has been drilled.

NOTE : the M16 sear is now positioned in the lower receiver as shown at right.
LONG END POINTING DOWN.

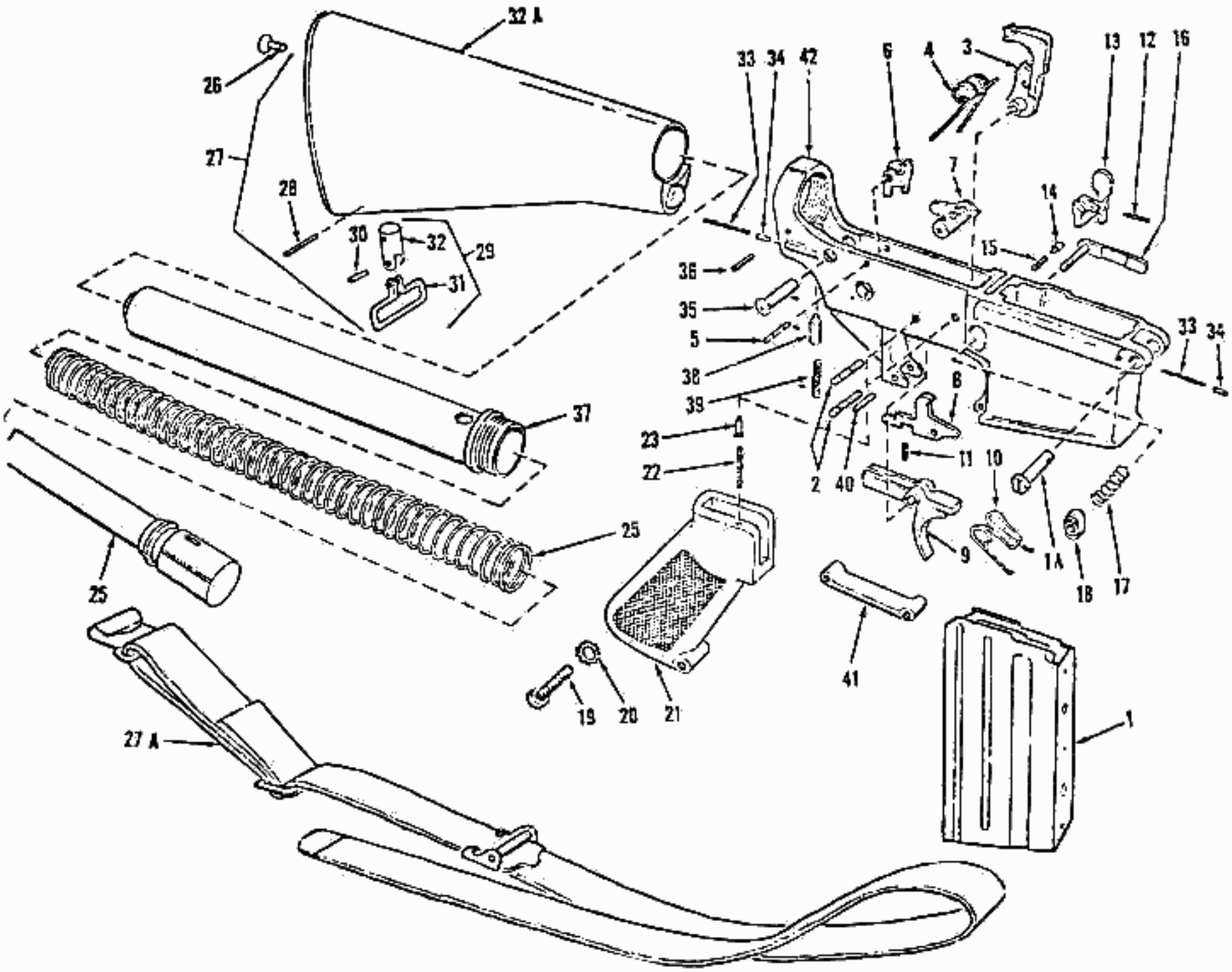


Instructions for Colt AR-15 converted to M16

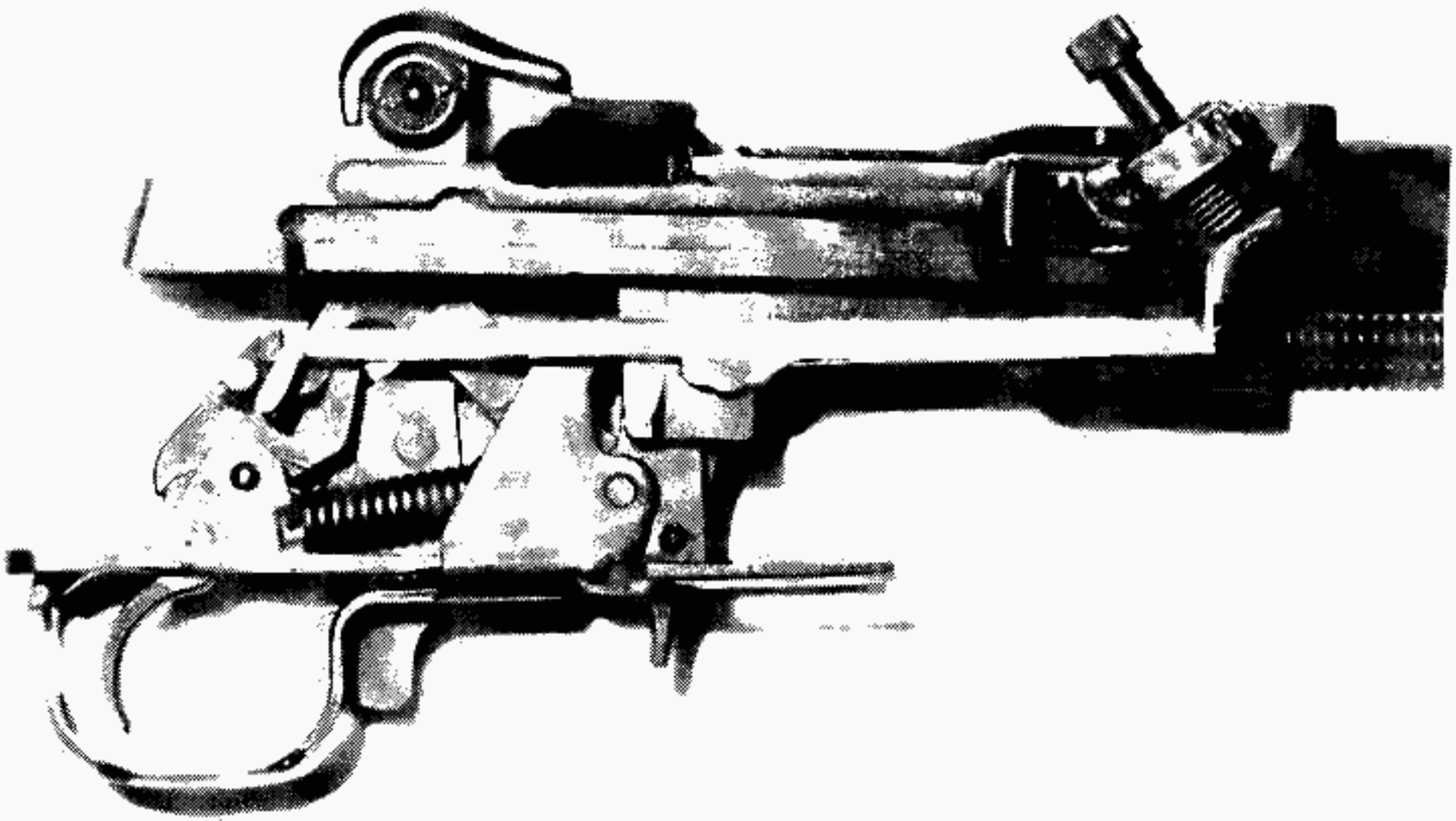


Instructions for Colt AR-15 converted to M16

REFER TO THIS DIAGRAM IF DIFFICULTY IS FOUND WHEN RE-ASSEMLEING THE RIFLE.



MINI-14 SELECTIVE FIRE CONVERSION



The main part of this conversion is the Secondary Sear Trip Lever. This part can be bent or filed to gain the exact fit you need. AT NO TIME ARE YOU TO FILE OFF ANY PART OF THE SEAR!

The average person can make this conversion using ordinary tools. With your weapon on full-auto mode, you can squeeze off single shots by using trigger control. The rate of fire is up to 750 rounds per minute.

In the normal firing cycle, the following actions occur: Starting in a locked and cocked position with a round in the chamber, the trigger is pulled. This causes the primary sear to move forward, disengaging the sear from the hammer. The hammer then moves forward and the weapon fires. Upon firing, the slide and the bolt move to the rear, carrying the hammer to the rear. Since the trigger is still in the rearward position, the primary sear is also in the disengaged position. The secondary sear has moved forward and engaged the hammer. (See figure 2).

When the trigger is released, the primary and secondary sears move to the rear. The secondary sear then disengages and the primary sear engages the hammer. The weapon is then ready to fire.

In full-auto condition the first round is fired normally. The trigger is held to the rear. When the slide and bolt move forward, chambering a round the slide contacts the Secondary Sear Trip Lever (figure 3) which cams the secondary sear to the rear, releasing the hammer. The weapon will continue to fire until the trigger is released and the primary sear engages the hammer.

Contrary to a popular belief, filing the sear is a mistake. It is a dangerous practice and may turn a fine piece of machinery into a booby trap.

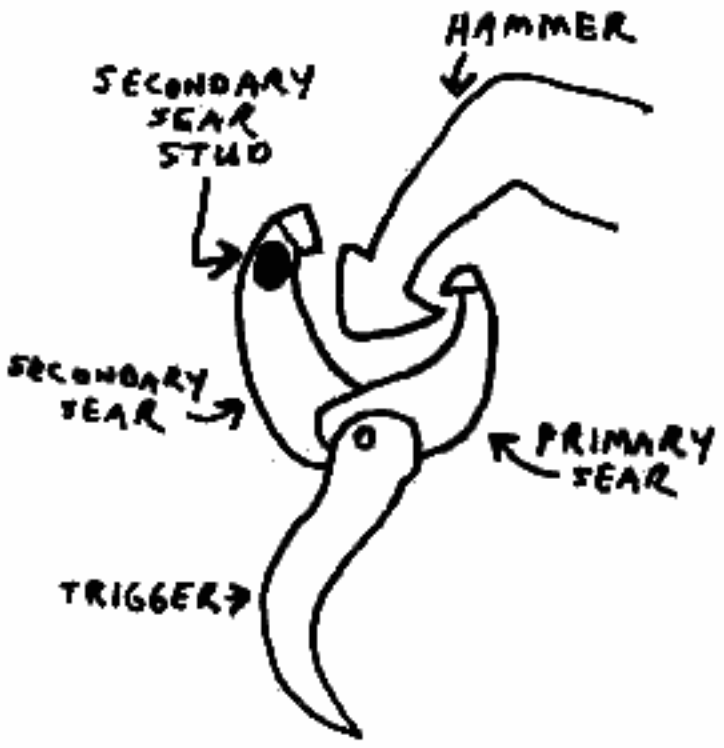


FIGURE ONE

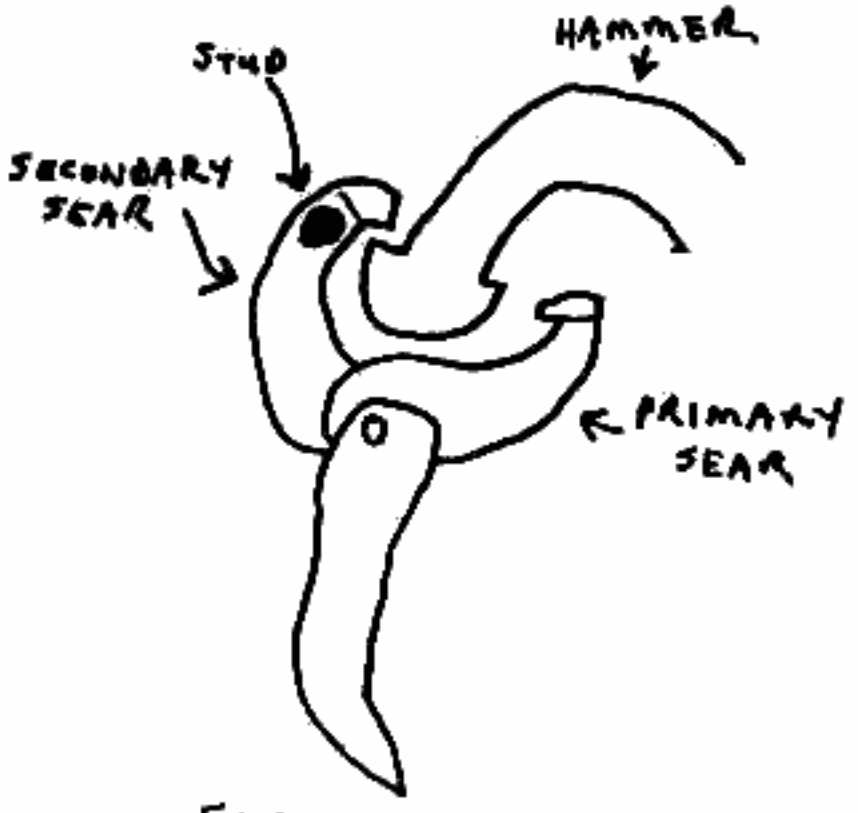


FIGURE TWO

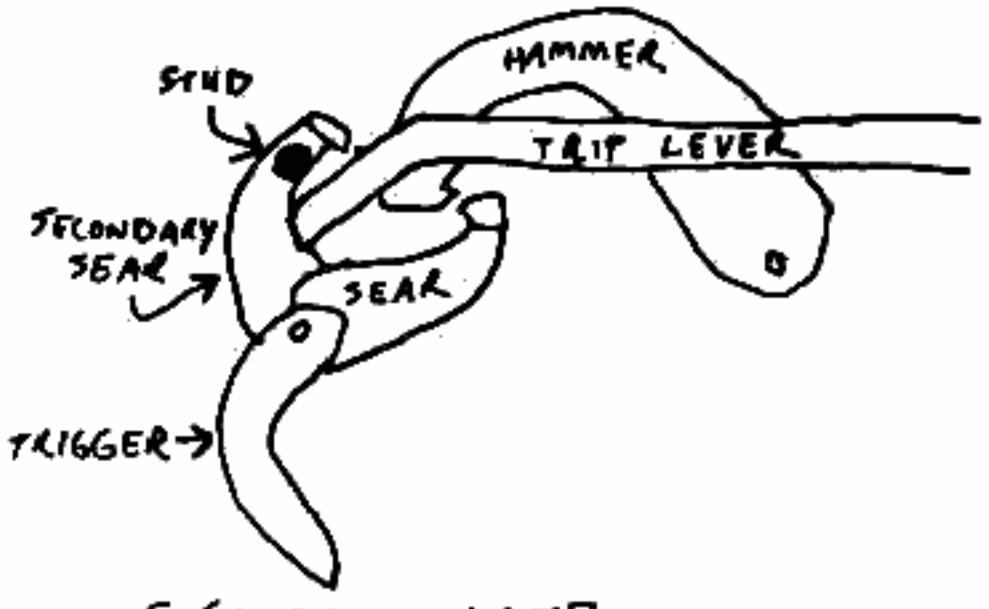
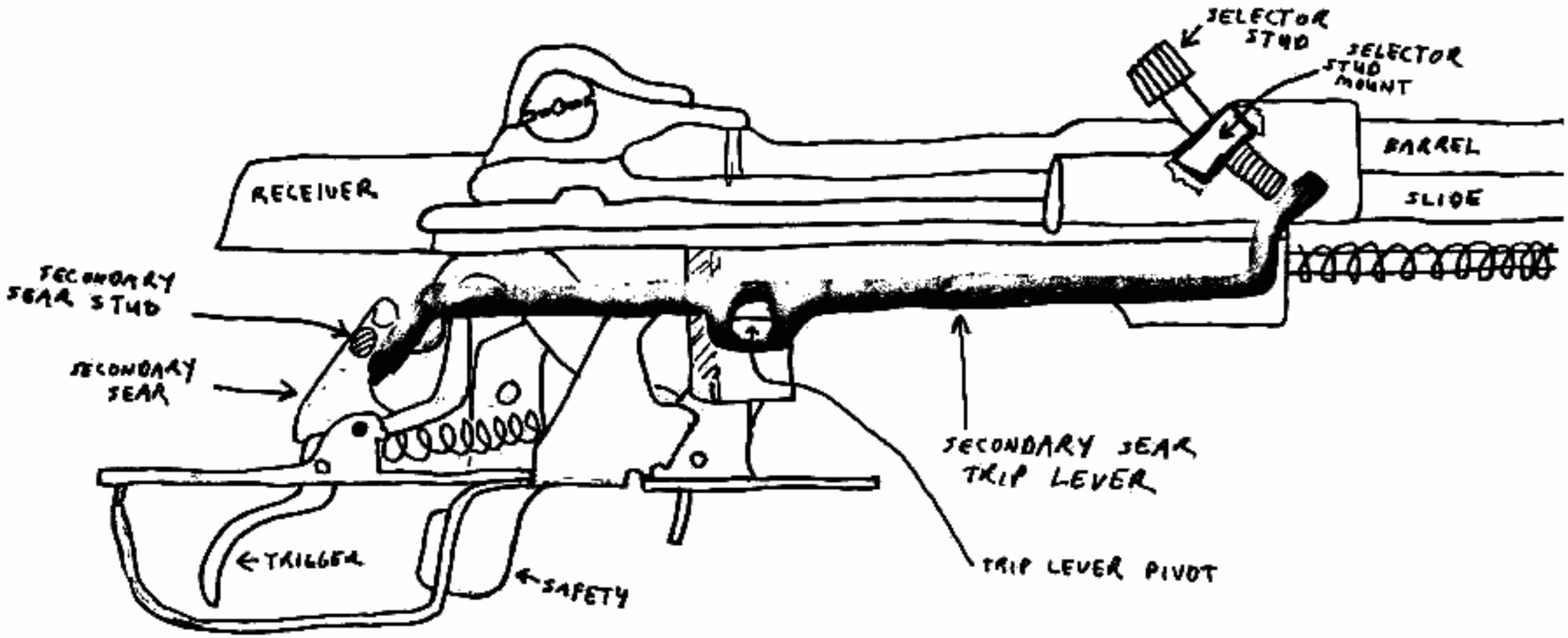


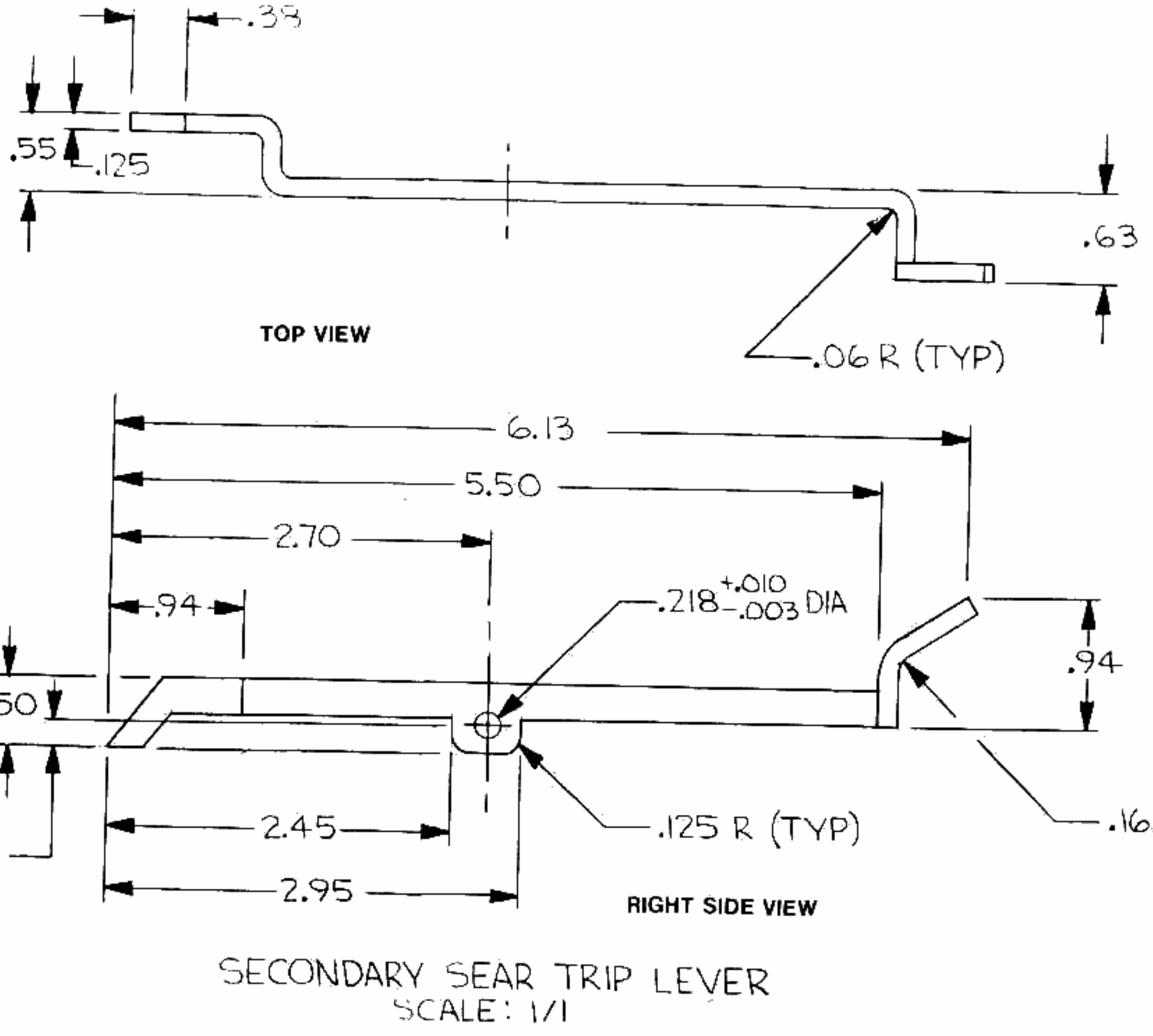
FIGURE THREE

PARTS LIST

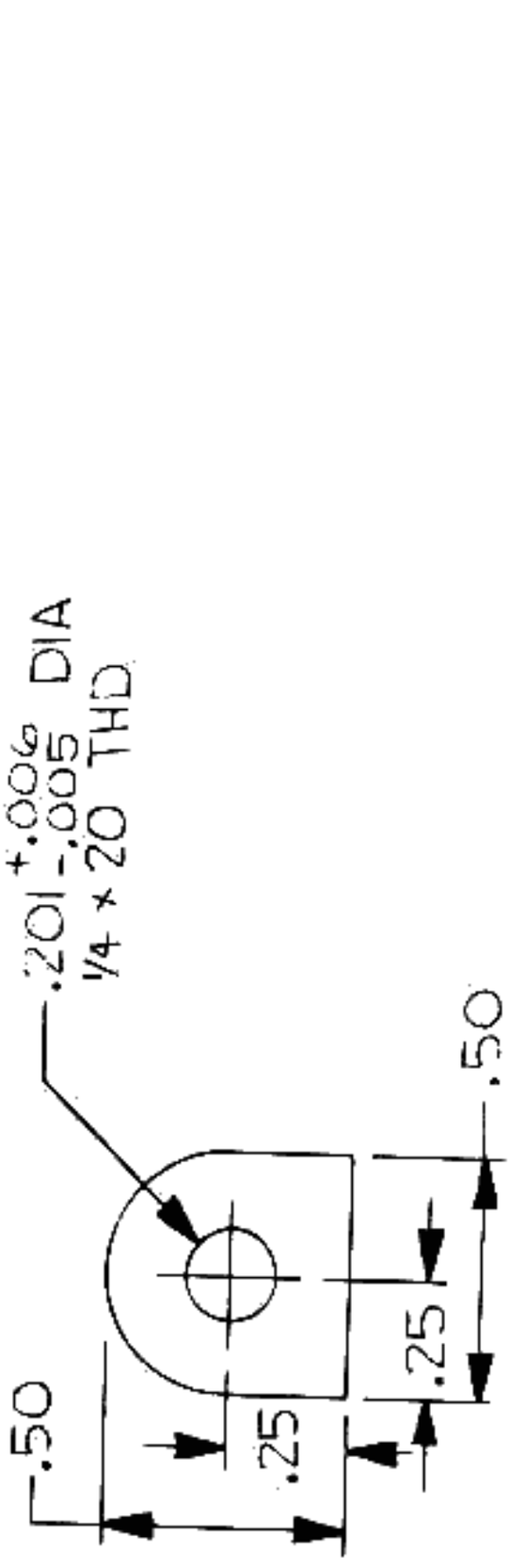
1) Drill Rod, 11/64 or 3/16" diameter, 1/4" long (Secondary Sear Stud).
2) Key Stock or Soft Iron Flat Bar, 1/8" or 3/16" diameter respectively (Secondary Sear Trip Lever).
3) Machine Screw #10-24, 1/2" long, (Secondary Sear Trip Lever Pivot).
4) Set Screw, 1¼ long x 1/4" diameter with #20 thread (Selector Stud).
5) Steel Nut, #20 thread, commercial or hand made (Selector Stud Mount).

---------- PARTS NOMENCLATURE ----------





SECONDARY SEAR TRIP LEVER
SCALE: 1/1



SCALE: 2/1

SELECTOR STUD MOUNT
STEEL

The first step is to basically field strip your weapon, the next page offers some additional guidance.

1) remove the magazine
2) pull the cocking lever to the rear and release, put safety on
3) open trigger guard latch
4) remove trigger group
5) remove barrel and receiver group from stock
6) remove recoil spring and guide
7) remove slide
8) remove stock reinforcement from stock

Take the stock reinforcement and cut off two pieces with a hack saw as shown below from the right side:

STOCK REINFORCEMENT RIGHT SIDE

The above procedure will allow clearance for the Trip Lever.

Replace the Stock Reinforcement

FIELD STRIPPING

1. Remove magazine (Fig. C).

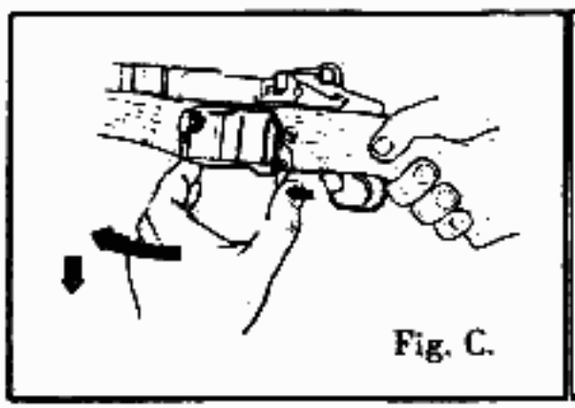


Fig. C.

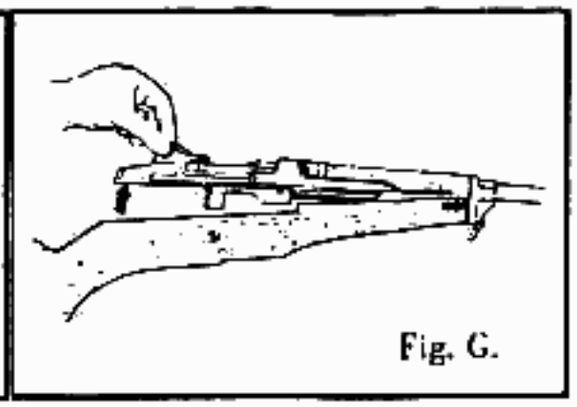


Fig. G.

5. Remove Barrel/receiver assembly from stock (Fig. C).

2. Pull cocking handle entirely to rear and release. Put Safety "On", (Fig.D). (Note: Hammer must be cocked and Safety must be "On" to accomplish disassembly and reassembly).

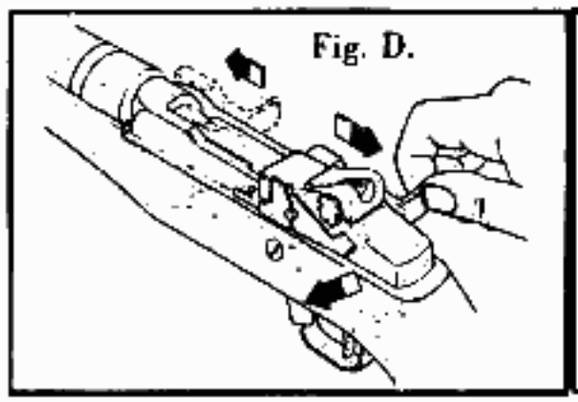


Fig. D.

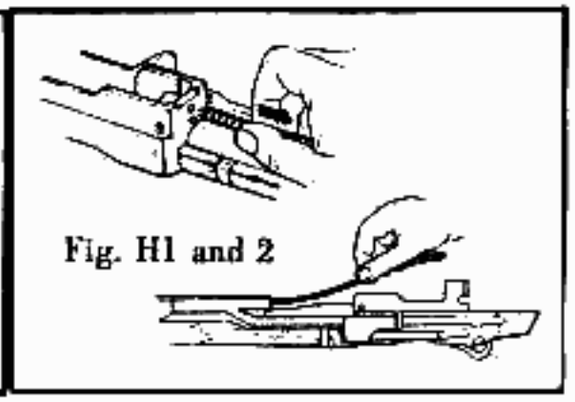


Fig. H1 and 2

6. Remove Recoil spring guide and recoil spring (Fig. H1 and 2). Caution· Mainspring is heavily compressed — Use care while disassembling or reassembling to prevent mainspring assembly from escaping and possibly causing injury.

3. Using a cartridge or other suitable tool, spring open trigger guard latch (Fig. E).

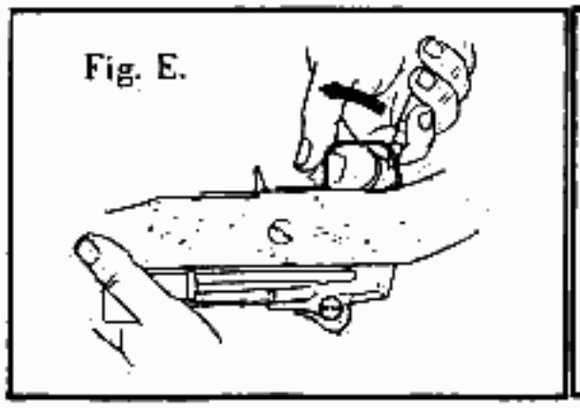


Fig. E.

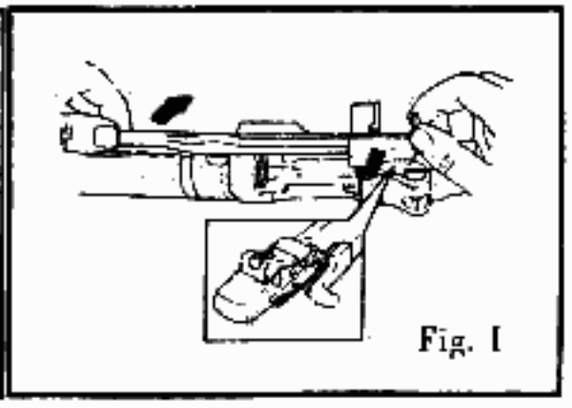


Fig. I

7. Pull slide handle to the rear. Align locking projections on slide with disassembly notch on receiver. Remove slide (Fig. I).

8. Pull the bolt forward until it pivots out of the receiver. Align firing pin projection with slot in lower receiver bridge. Remove bolt (Fig. J).

4. Remove trigger group (Fig. F).

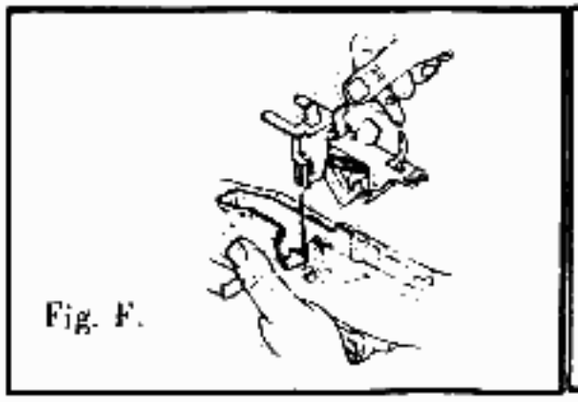


Fig. F.

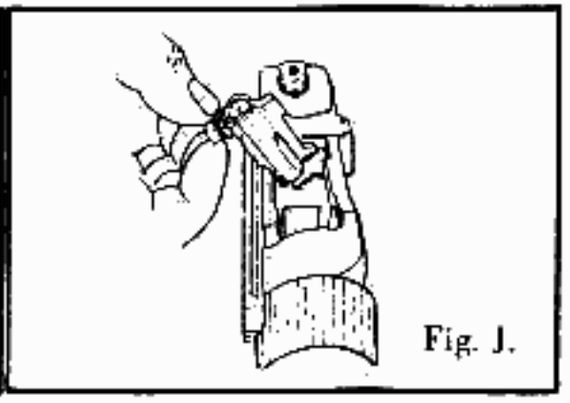
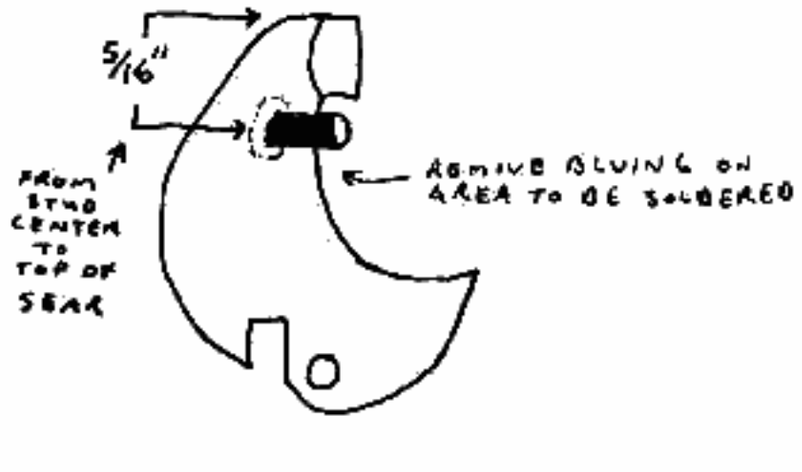


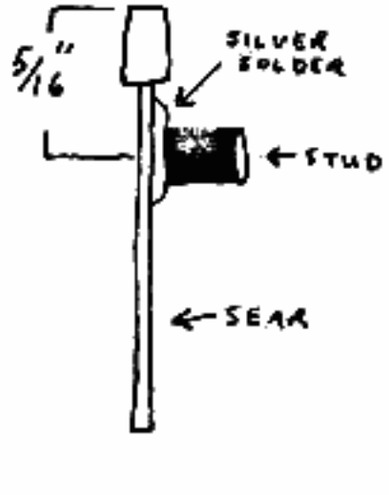
Fig. J.

Further disassembly should not be required and is not recommended unless performed by competent persons experienced in gunsmithing.

Remove Secondary Sear



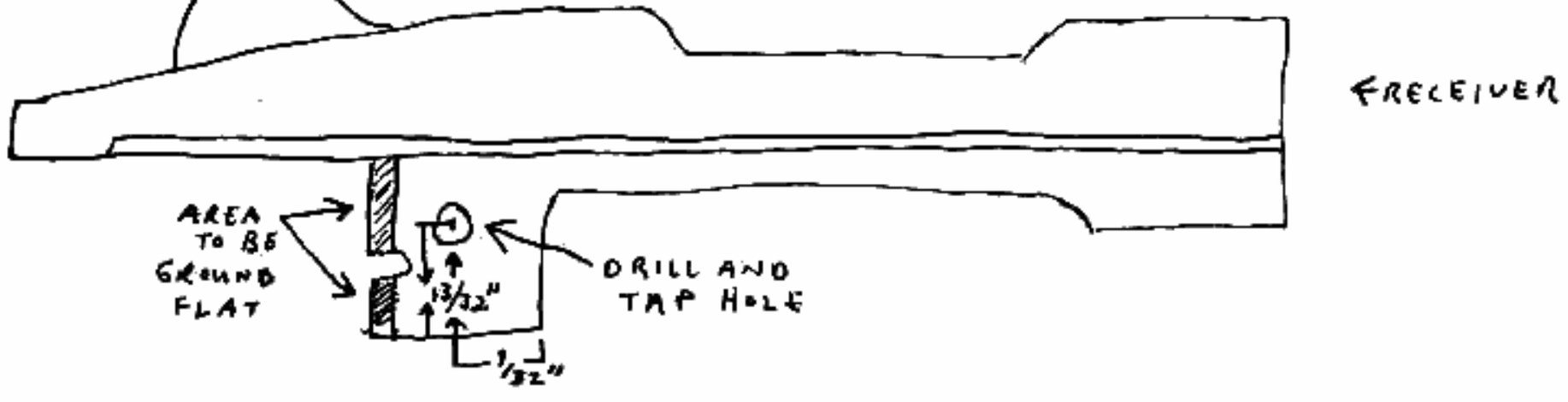
very carefully silver solder Stud to sear as shown



When soldering, follow directions on the Flux container and properly apply flux to sear, place Sear Stud on flux and then solder using a good propane or acetylene torch.

Replace Secondary Sear

Taking the Receiver, drill and tap #10-24 hole for Trip Lever Pivot. You might mark your drilling spot with a center punch. Use a 1/8 or #9 drill bit. Use a #10-24 starter tap.



Grind metal from receiver to provide clearance for Trip Lever. A disk grinder or a file will do this well. Once the hole is drilled, use a #10-24 starter tap to thread the hole with.

Now using the Trip Lever Pivot, install the Trip Lever. Once the Pivot Screw is tight, you will want to cut off and file flush any exposed threads from the inner side as to not interfere with the magazine track. Also it is advisable to use Loc-Tight to insure the Pivot stays in place in a FIRE FIGHT.

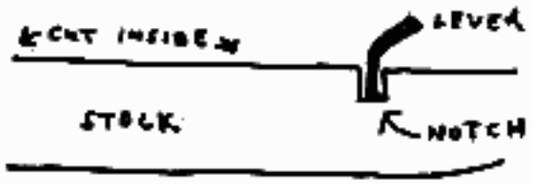
Using the Parts Nomenclature diagram as a guideline, silver solder the Selector Stud Mount to the Slide.

The Trip Lever must be in place. When aligning the Mount, insert the Stud to get accurate alignment. Remove the Stud before actually soldering the Mount to the Slide.

Install the Trigger Group onto the receiver, when you do this be sure the Trip Lever stays in proper configuration with the Sear Stud as shown below.

Install Recoil Spring and Operating Slide.

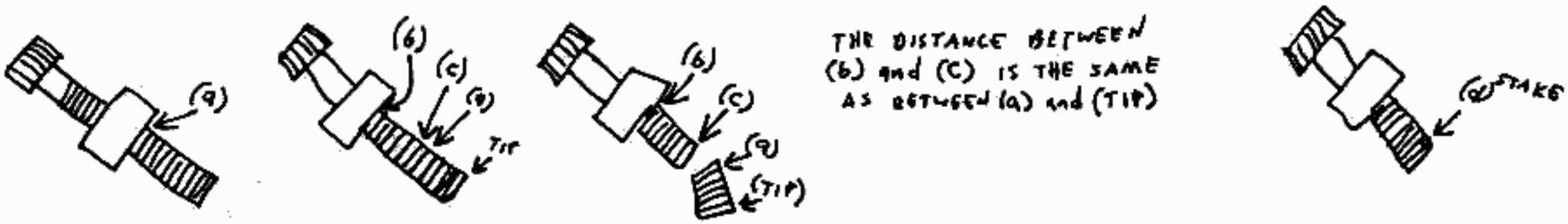
Now inlet the stock for clearance of the Trip Lever. Do this by aligning the stock and barrel/receiver assembly, then using a chisel or similar wood working tool, make the proper cuts. In addition to the obvious cut-out on the outside, it is necessary to cut-out an area on the inside on the right side to allow clearance for the Trip Lever.



Now assemble the weapon

Partially screw in the Selector Stud. You are now ready to make the final adjustment. Place the safety in the Fire position, depress the trigger and leave it depressed until I tell you to let it up. Pull the slide to the rear and release it, screw down the Selector Stud until the Secondary Sear is disengaged and the hammer falls, at this point the weapon is on AUTOMATIC. NOW YOU CAN LET UP ON THE TRIGGER.

A) Now at this point, measure the amount of thread between the Stud Mount and the Trip Lever (a) and mark it, then tighten the Stud all the way down, take measurement (a) and measure from point (b) toward the tip, you will be at point (c), cut off the excess from point (c) toward the tip. Now when the Stud is tight, the weapon will be on AUTO and when it is backed off it will be on SEMI. You could stake the end of the Stud with a center punch or chisel, this will provide a stop for the Selector Stud when it is backed out in the SEMI position, see (d).



You are now ready to test fire your weapon.