

ASSEMBLING THE MACHINE GUN

Both the upper and lower receivers are now complete and ready to be bolted together (Figure GG). The three socket screws are unscrewed from the underside of the upper receiver, but the screw removed from the middle collar is discarded, since it is not required.

Both receivers are positioned together (Photo 54), and then the remaining two screws are screwed in to hold the two halves of the machine gun together. A certain amount of hand fitting may be necessary before the two receivers will fit together. The front tip of the feed ramps may need to be filed back slightly so there is sufficient clearance between the front of the ramp and the breech face of the barrel. The contour of the ramp may also require adjustment to allow the block to slide over it.

With the receivers bolted together, the

weapon should be dry-fired to make sure all internal parts are functioning smoothly. The breech block (bolt) should be pulled all the way back to check that the sear snaps up to hold the block in the cocked position. When the trigger is pulled, the block should release cleanly and fly forward smoothly. The magazine lips and feed ramp must not interfere with the block's forward travel or slow it down in any way. The correct adjustment of the lips and feed ramp will ensure that this does not occur. Providing no further adjustments are required, we can get down to the fun stuff of test-firing the machine gun.

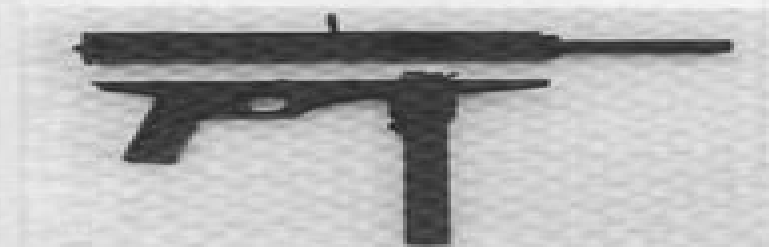


PHOTO 54: The two receivers ready to be bolted together.

Expedient Homemade Firearms The Mm Submachine Gun

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