

5.45X39mm

5 Round Magazine

To make a five (5) round magazine for the AK-74 rifle (5.45X39mm), you must first obtain a thirty (30) round magazine (typical plastic type). Do not use the orange bakelite magazines. Nothing special was used to make this magazine, just what was available at the time.

All dimensions are approximate.

1. Completely disassemble the thirty round magazine by removing the floorplate, floorplate locking plate, spring and follower. Remove the floorplate locking plate and follower from the spring.

1. Take the thirty (30) round magazine housing and cut it to 2.530" (forward) and 3.270" (aft) in length. Measuring from the front and back of the magazine housing. Ensure that the bottom of the cut magazine housing is as flat as possible. Clean all excess plastic shavings/sprag from bottom of magazine housing.

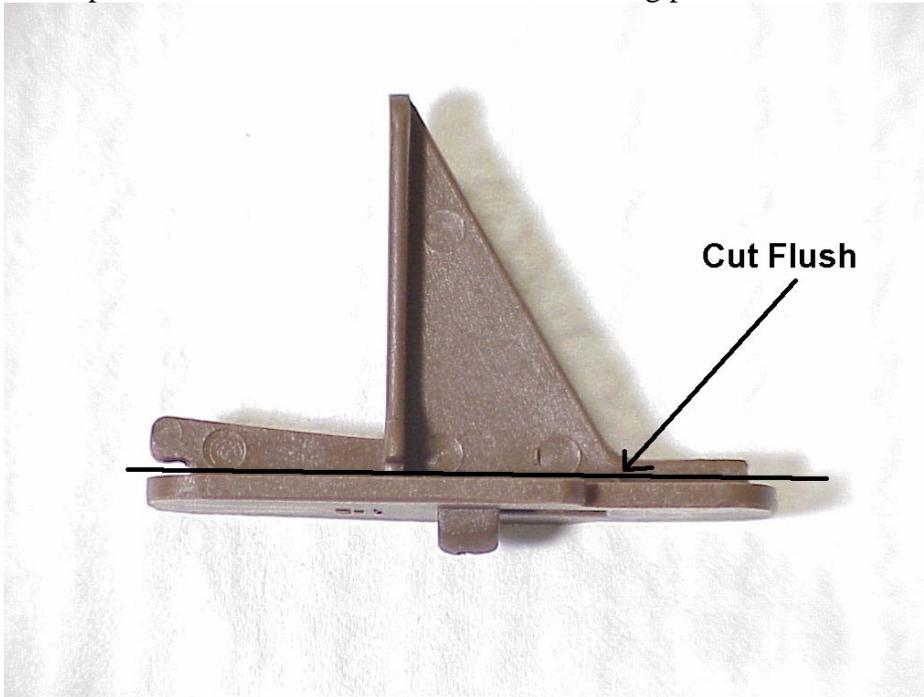


“Forward”



“Aft”

2. Take the floorplate locking plate and completely remove the guide portion. The guide portion is the long part that goes into the magazine housing. Try to make the surface as flat as possible. Do not touch the tab of the locking plate.



3. Use two (2) pieces of .042" metal, 1.250X" in length. Bend the metal at right angles (90 degrees).

4. Locate the bent metal and floorplate locking plate on the floorplate. Clamp all three (3) pieces together and place in a drill vise. Try to make sure that the floorplate is level on the "X" and "Y" axis. The spacing of the metal tabs is based on the inside dimension of the magazine well.



Prior to drilling, it must be determined what will be used to hold all three (3) pieces together. This will determine what drill size you will use. For this particular job, I used a small countersunk aluminum rivet, .096" in diameter. Many other items can be used for this application.

5. Using the drill selected, drill through all three (3) pieces. Remove the pieces from the vise. Using a countersink bit, countersink the hole on the outside portion of the floorplate so that the countersunk rivet head sits flush with the floorplate.



6. Slide the rivet into the floorplate countersunk hole then place the locking plate and bent metal onto the rivet.

7. Place the countersunk rivet head on a suitable hard object and then a flat punch on the portion of the rivet that is protruding from the bent metal. Hit the punch with a hammer until the rivet forms a head and locks all three (3) pieces together.

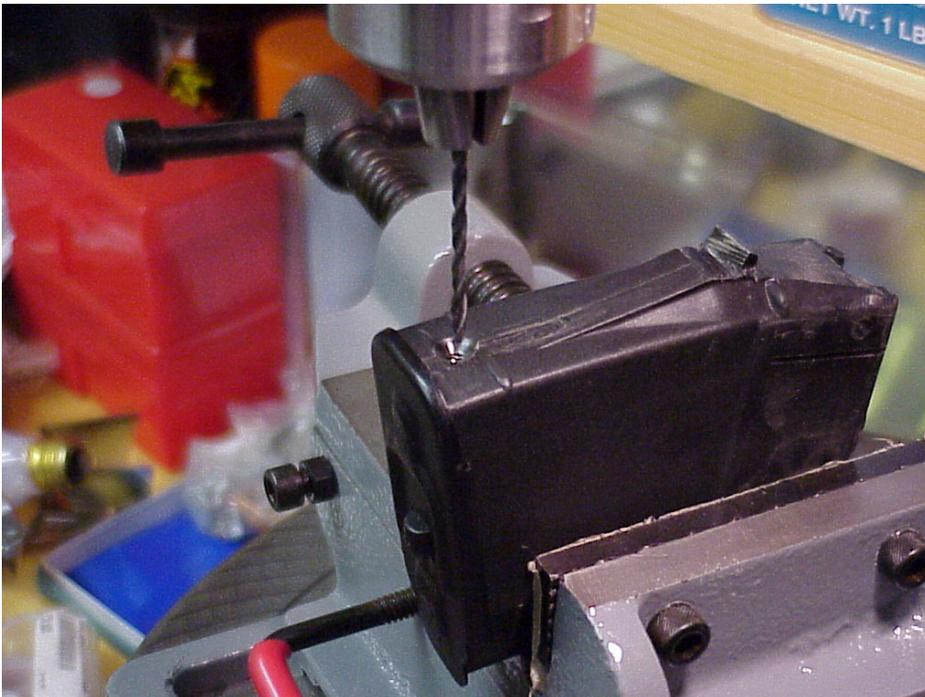


8. Accomplish the same operation on the opposite end of the floorplate.

9. With the two (2) tabs secured to the floorplate, slide the assembly into the magazine well until the floorplate sits flush with the magazine housing.



10. Locate the magazine housing with floorplate assembly into a drill vise. Determine where you want to install the retaining screws. For this application I choose 6-32 countersunk screws. Making sure that when drilling the holes, the tabs are drilled through.



11. Drill the first hole through the magazine housing and metal tab.

12. Use a 6-32 tap and tap through the magazine housing and metal tab. Insert the countersunk screw into position and tighten.



13. Then use a countersink bit to allow the screw head to sit flush with the outer magazine housing.



14. Accomplish the same operation in step # 12 to the opposite side.

15. Disassemble and clean the magazine housing and floorplate assembly of all metal and plastic chips.

16. Cut the magazine follower as follows; 1.400" (forward) and 1.560" (aft), measuring from the inside of the follower. Draw a line between the two (2) dimensions and cut. Repeat on the other side.

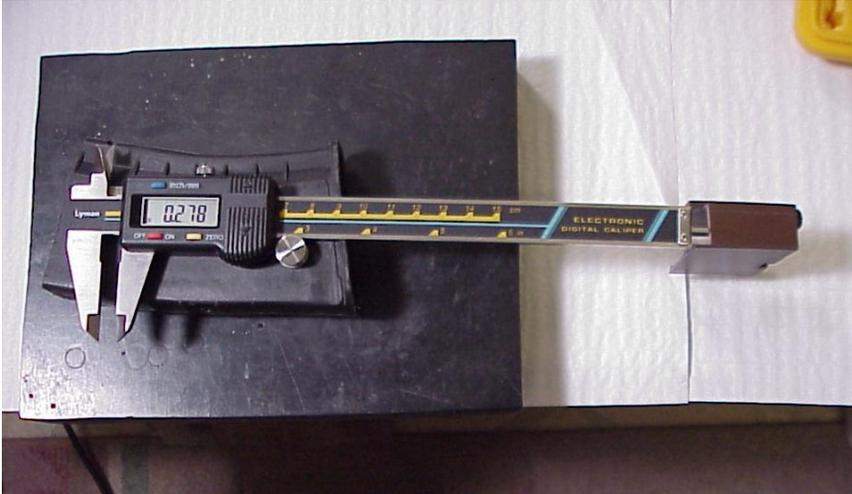


“Forward”

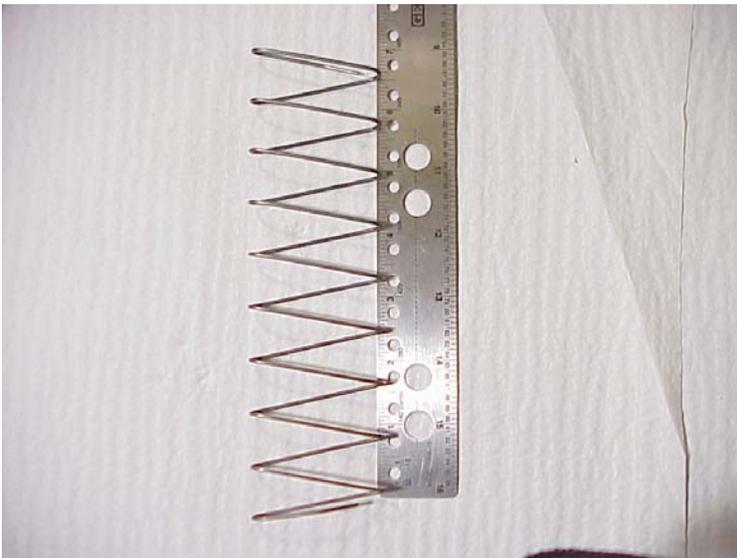


“AFT”

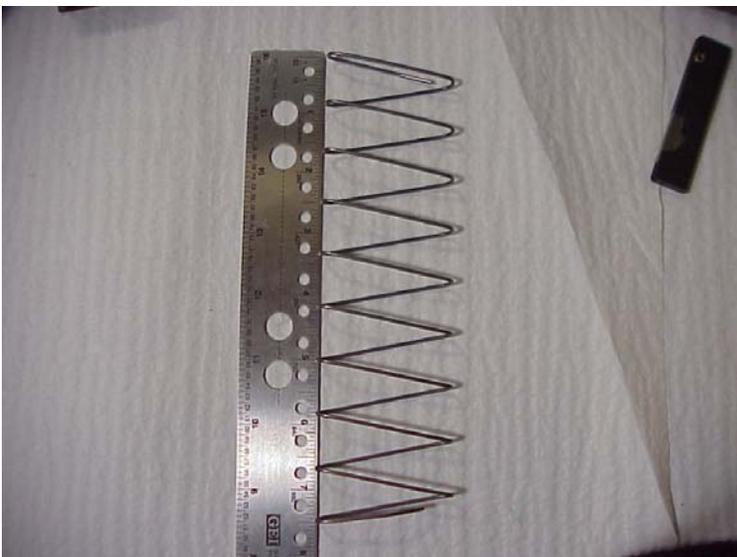
17. After removing the sides of the follower, cut the back of the follower to a length of .275" measuring from the inside of the follower.



18. Cut the magazine spring (measurement is without tension) as follows; 6.500" (forward) and 7.500" (aft). On the cut end, bend to make flat and inward.



“Forward”



“AFT”

19. Assemble the spring to the follower, and insert the spring into the magazine housing.

20. Slide the floorplate assembly into the magazine housing compressing the spring. Insert the 6-32 screws into their respective holes and tighten.



21. Function check the magazine.