

# AK-47/74 Barrel and Front Trunnion Rivet Removal

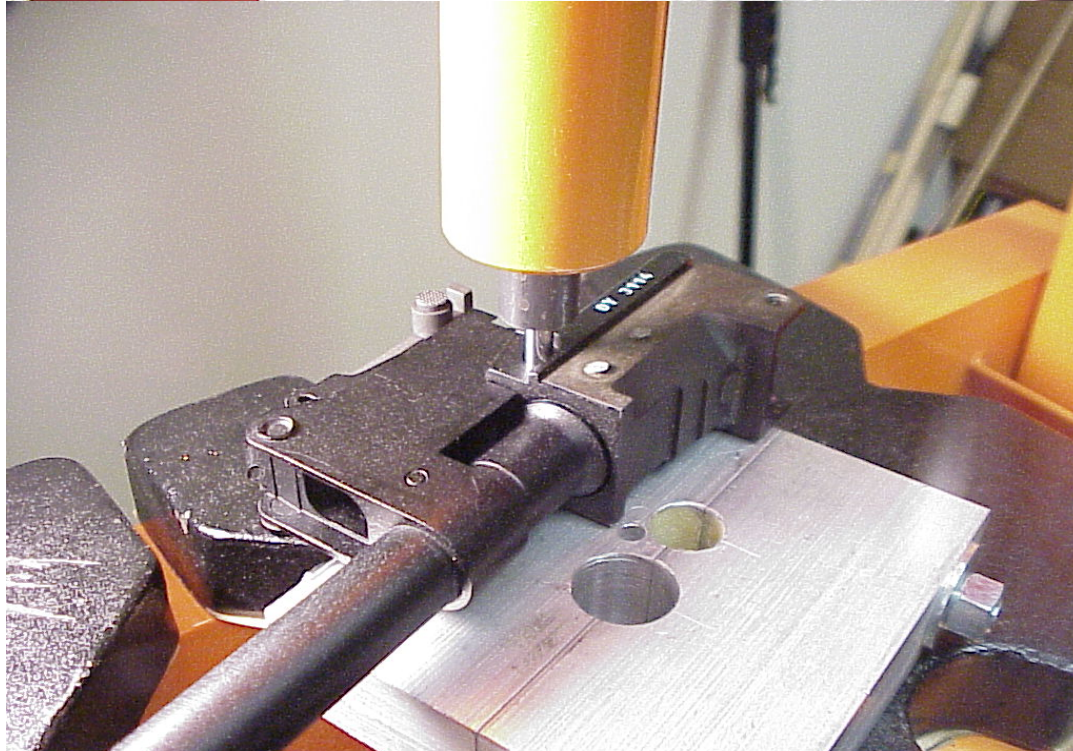
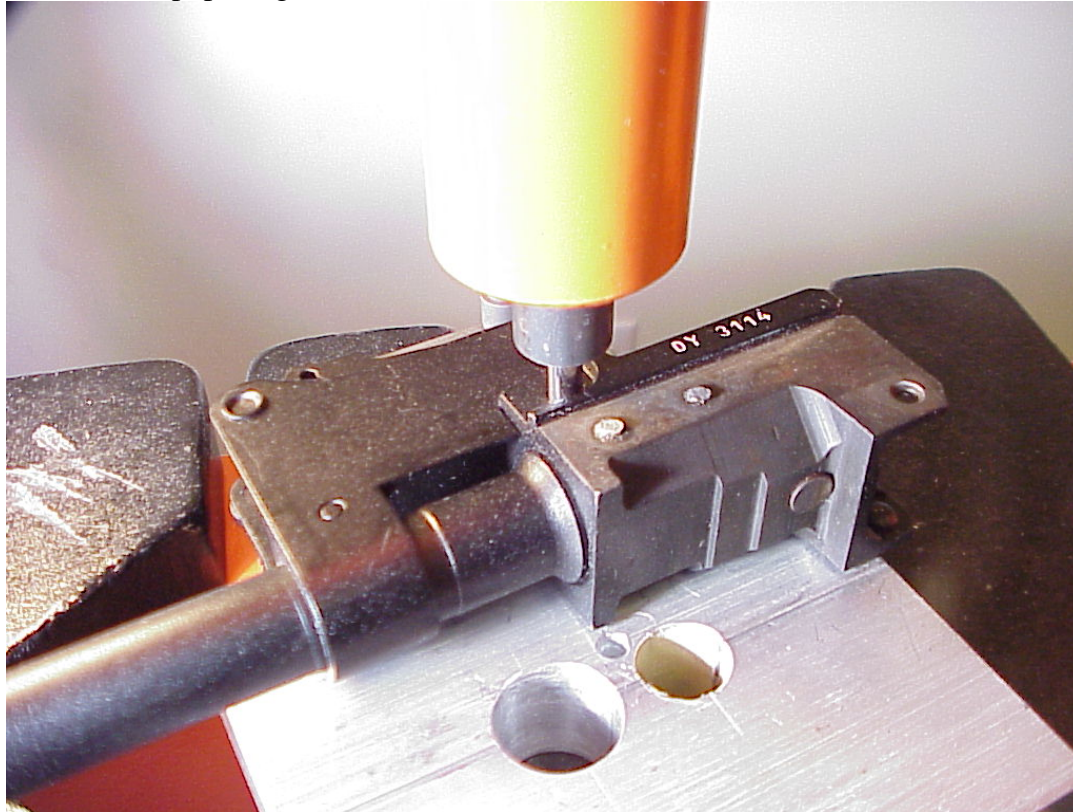
The following steps are used for barrel center pin, barrel and front trunnion rivet removal on AK-47/74 type rifles. Special jigs and fixtures were used but others have found ways around this. As with all shop operations the wearing of eye protection is strongly recommended. It must be noted that some of the pictures were created to provide a visual view of the task while other pictures are of the actual process.

## REMOVAL OF THE BARREL CENTER PIN

1. Align the front trunnion so that the center pin will pass through the fixture when pressing. Use what is available to support the barrel and ensure the trunnion is level. If part of the receiver is present along with rivets, place the receiver/trunnion so that the rivets recess into the countersinks provided in the fixture.

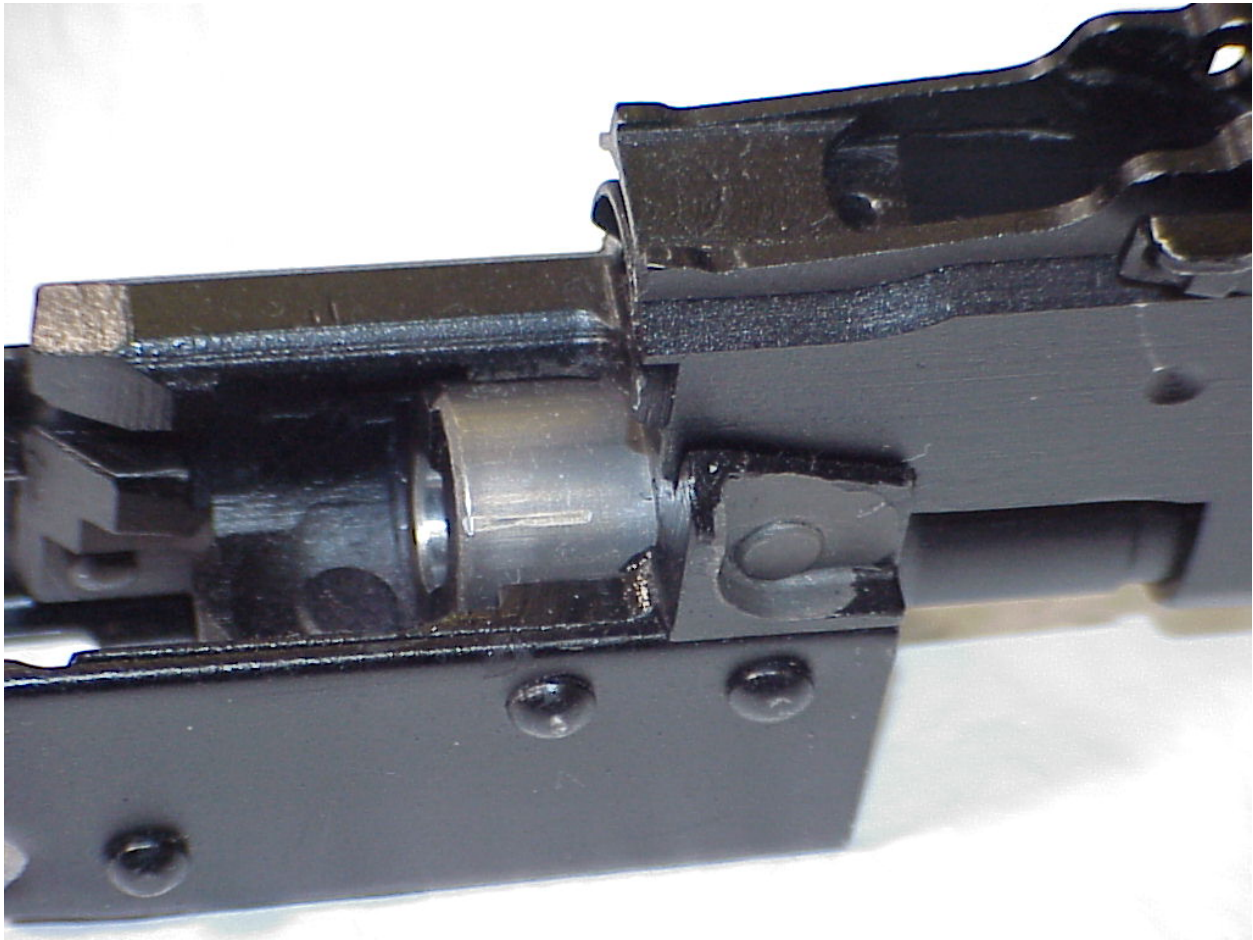


2. With the barrel supported and trunnion aligned; insert the short push rod (a hardened screwdriver hex bit may be used to start the removal) on the center barrel pin. Align press head with the push rod and begin to press out the barrel center pin. When the pin begins to move continue pressing until there is minimum clearance between the short push rod and the trunnion. At this time relieve pressure on the press head so that a longer push rod may be inserted. After the longer rod has been placed into position continue to push the center pin out until it drops free of the trunnion. NOTE: On some occasions the center pin is very tight and when pin starts to move a loud pop/bang will be heard.



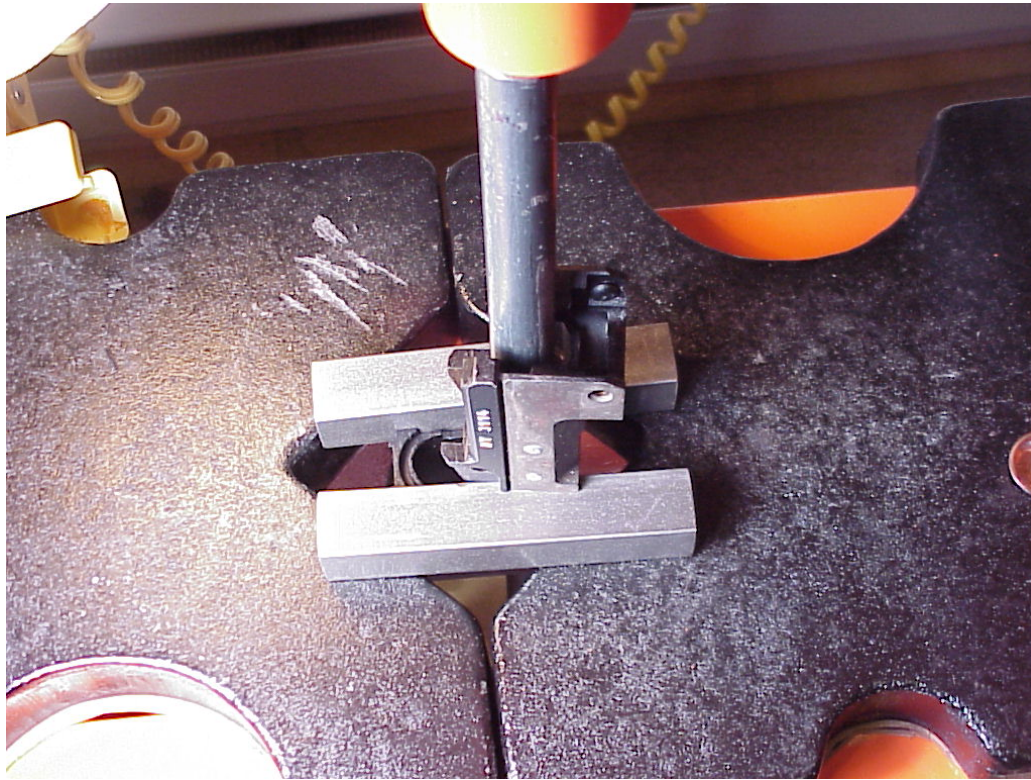
## REMOVAL OF THE BARREL

To make it things easier and also to help prevent galling during barrel removal, you may apply paint remover to the top of the barrel where it is exposed in the front trunnion. This removes the paint and will allow the barrel to slide easier through the front trunnion without marring it as much as not removing the paint. Taping off the rest of the trunnion is recommended to preserve the paint.

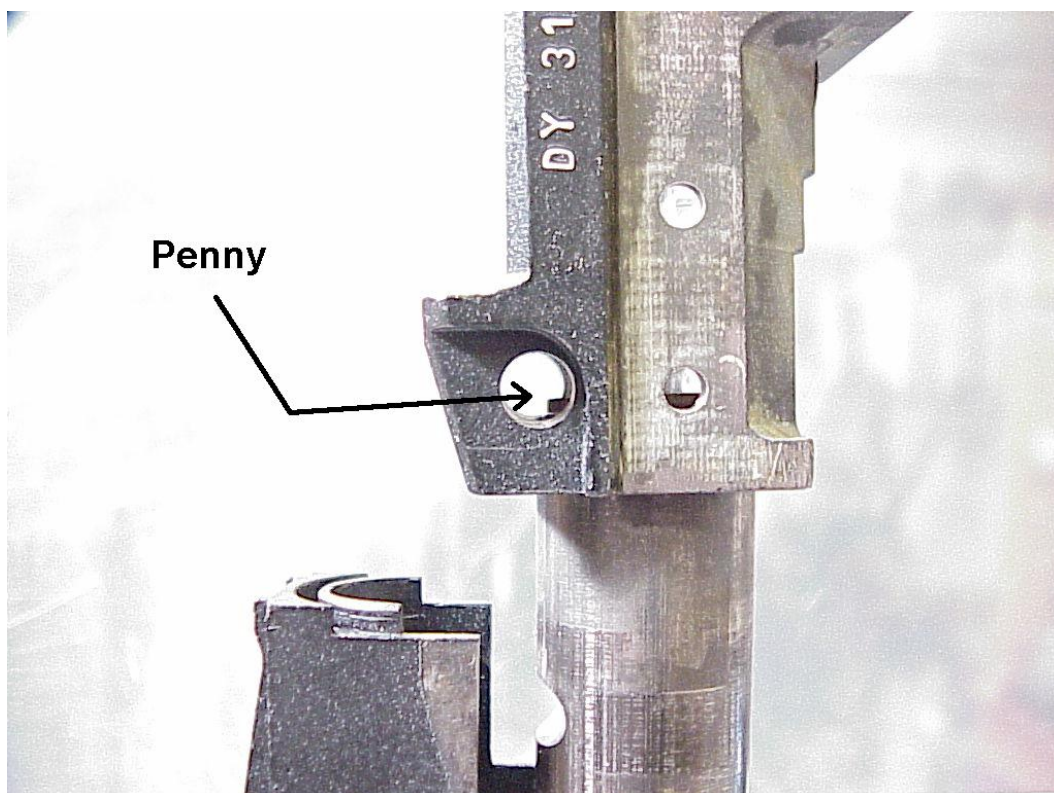


1. Setup the press so that there is enough room to press out the barrel.
2. Slide the barrel through the press arbors making sure that the gas tube lock-down lever and the rear sight will not be damaged. Often the rear sight will need to be removed to prevent damage. Place the trunnion on the two (2) support blocks again making sure that there is clearance for barrel removal. Insert a “penny” or other flat soft material (this will protect the barrel when removing) on top of the chamber area.

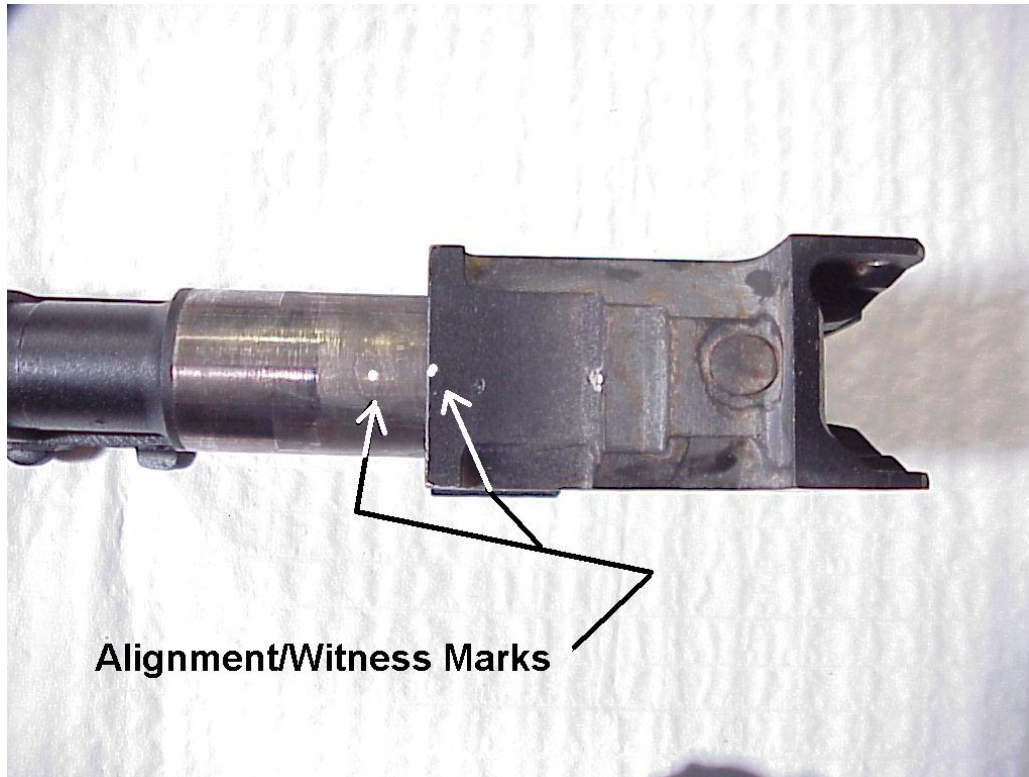
3. Insert a large push bar on top of the penny and move the press head down until it contacts the bar. Check that all areas that could be damaged are clear. Slowly apply pressure to the large push rod ensuring alignment of the rod with the press head.



4. As additional pressure is applied the barrel will start to move. When you can see the penny through the barrel center pin hole stop barrel removal.



5. Remove the barrel/trunnion from the press area. The reason for removal prior to complete barrel removal is to provide alignment/witness marks on the barrel and trunnion for re-installation purposes. In some way (a chisel or center punch can be used) mark the barrel and trunnion so that the marks are in alignment. The closer the marks are in alignment the easier it will be to install the barrel.

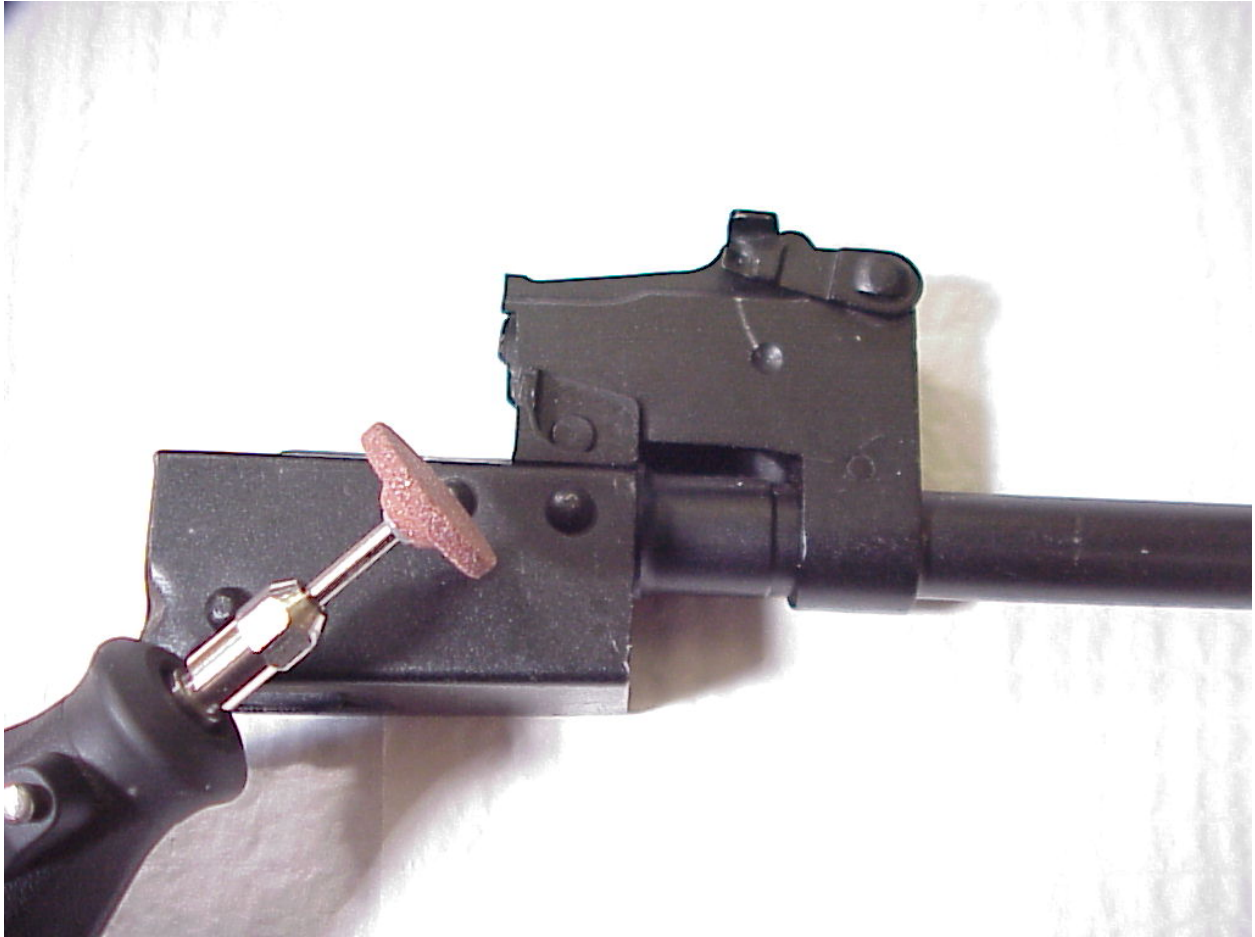


6. After making the witness marks on the barrel and trunnion, place back in the press and continue to push the barrel out (make sure you reinstalled the “penny”). Have someone catch the barrel or have something to cushion the fall as the barrel drops free from the trunnion.

### **FRONT TRUNNION RIVET REMOVAL**

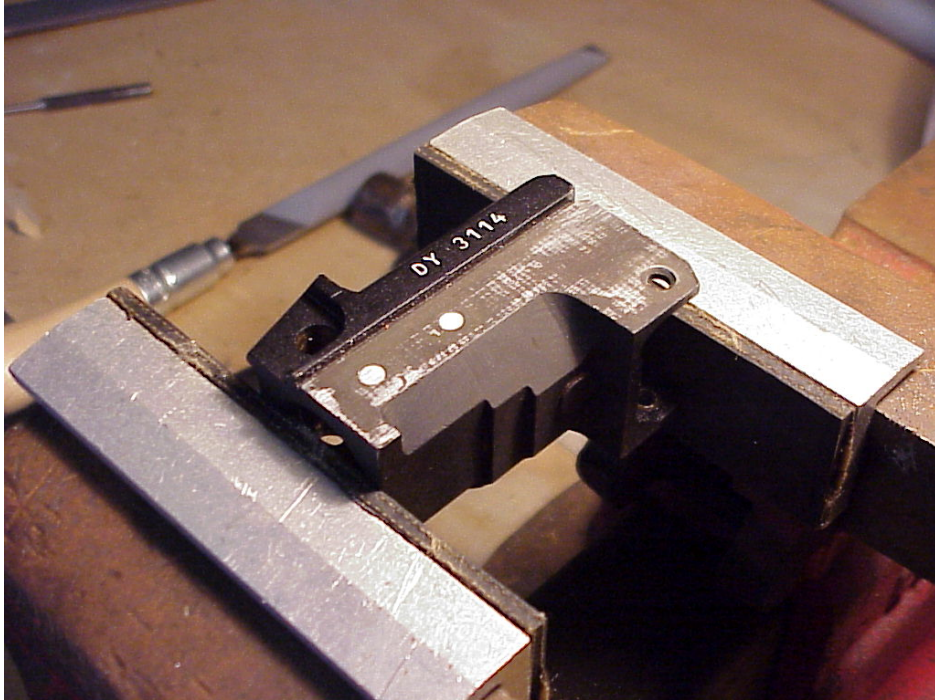
Now that the barrel has been removed from the front trunnion you will need to remove the rivets. If a portion of the receiver is still attached to the front trunnion and the factory rivets are present, begin with step # 1. If the factory rivet heads have been removed, begin with step # 3. There are different ways to remove the factory rivet heads, you can grind the heads off, file flats on the exposed heads, then drill the heads off.

1. Grinding the heads off is perhaps the easiest method. If you are not experienced in grinding, protect the trunnion area that is near the rivets. Using a dremel tool or other type tool with either a stone grinding disc or a carbide bit begin to remove the rivet head. Once the rivet head is flat or flush with the receiver stop and continue to the next rivet head. Perform this operation on all six (6) rivets.



2. When all six (6) rivets are flush, pry the receiver away from the front trunnion.

3. Chuck the trunnion in a vise and file the remainder of the rivet material flat with the trunnion. Take your time and try not to damage the trunnion.



4. With all the rivets flush with the trunnion, use a punch to tap the remaining portion of the rivet out. They will knock out easily.

After completing the tasks listed above, you will have removed the *Barrel Center Pin*, removed the *Barrel* from the front trunnion and finally, removed the *Front Trunnion Rivets*.. Clean all parts as necessary for re-installation.

