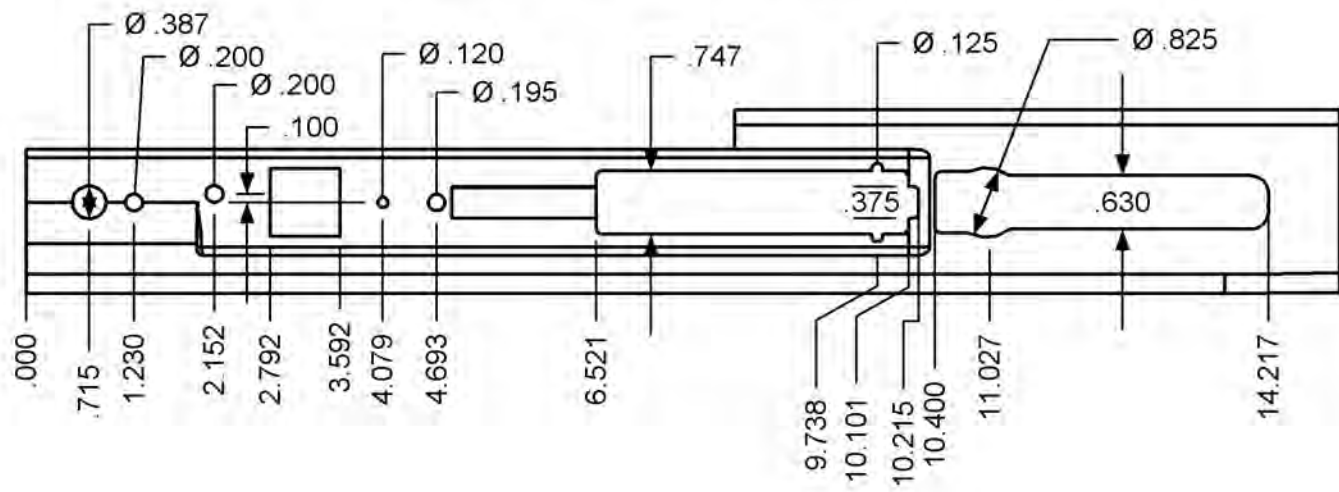
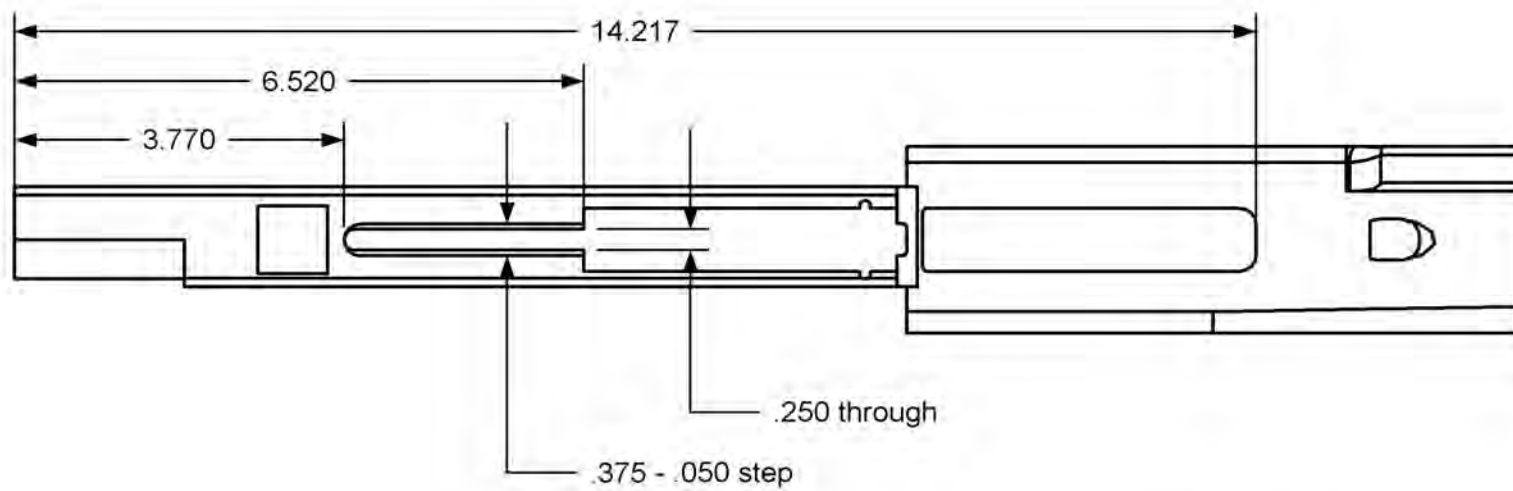
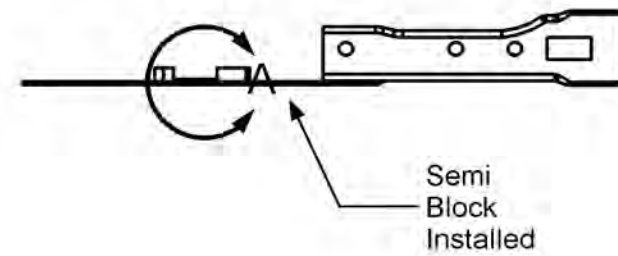
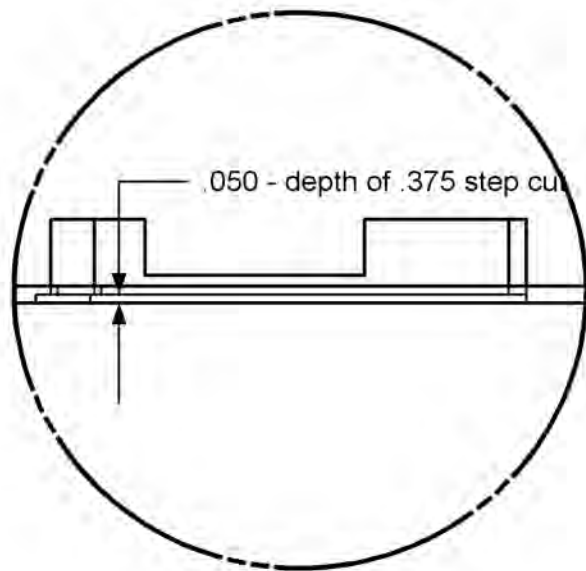
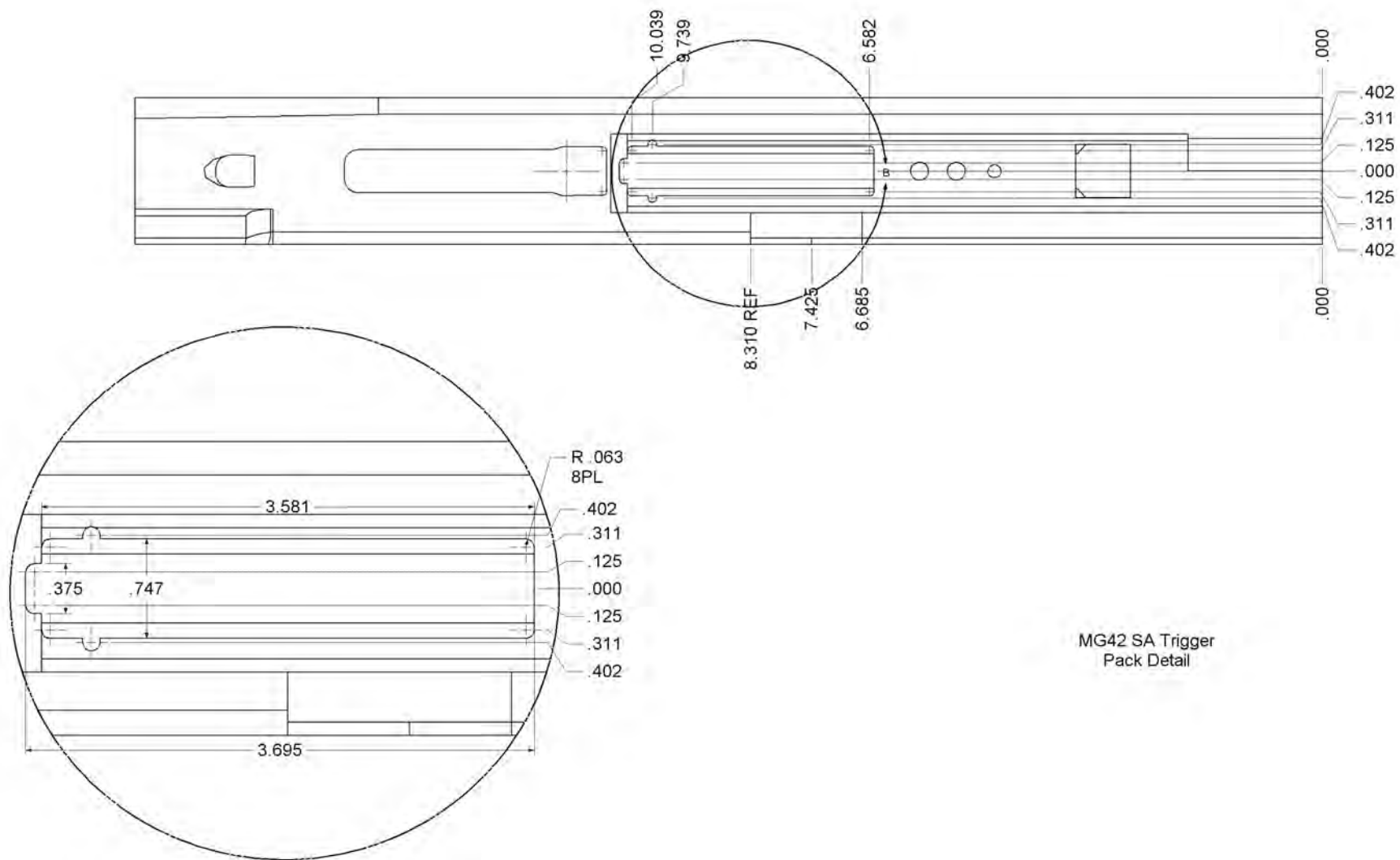




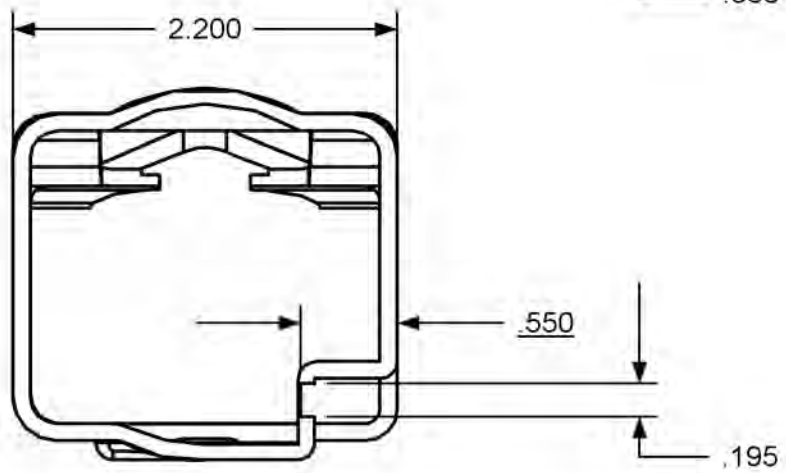
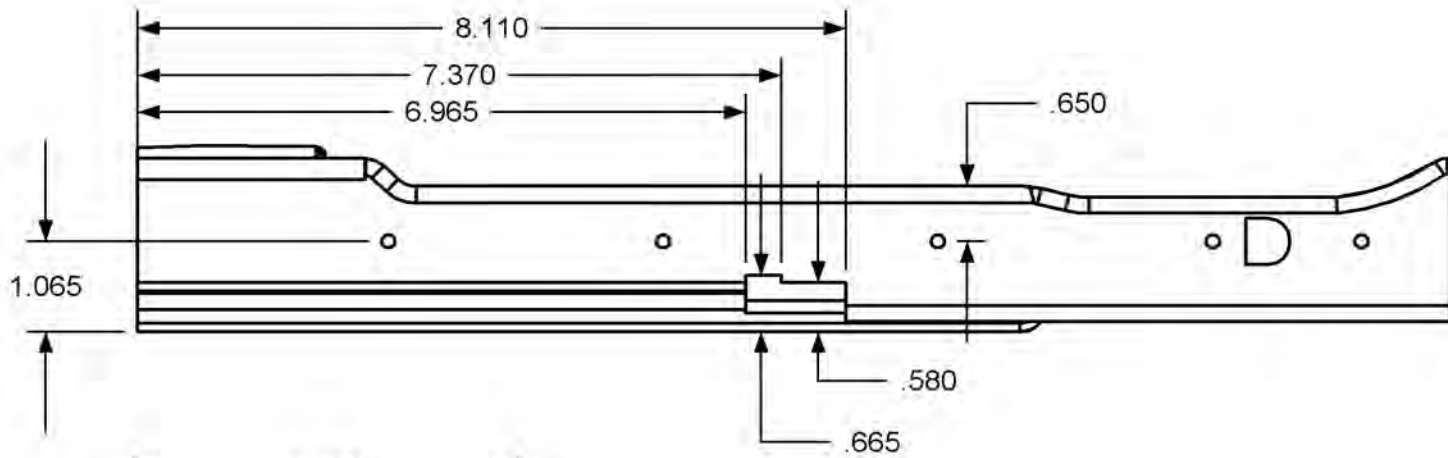
Semi Auto Bottom
(after blocker installation)



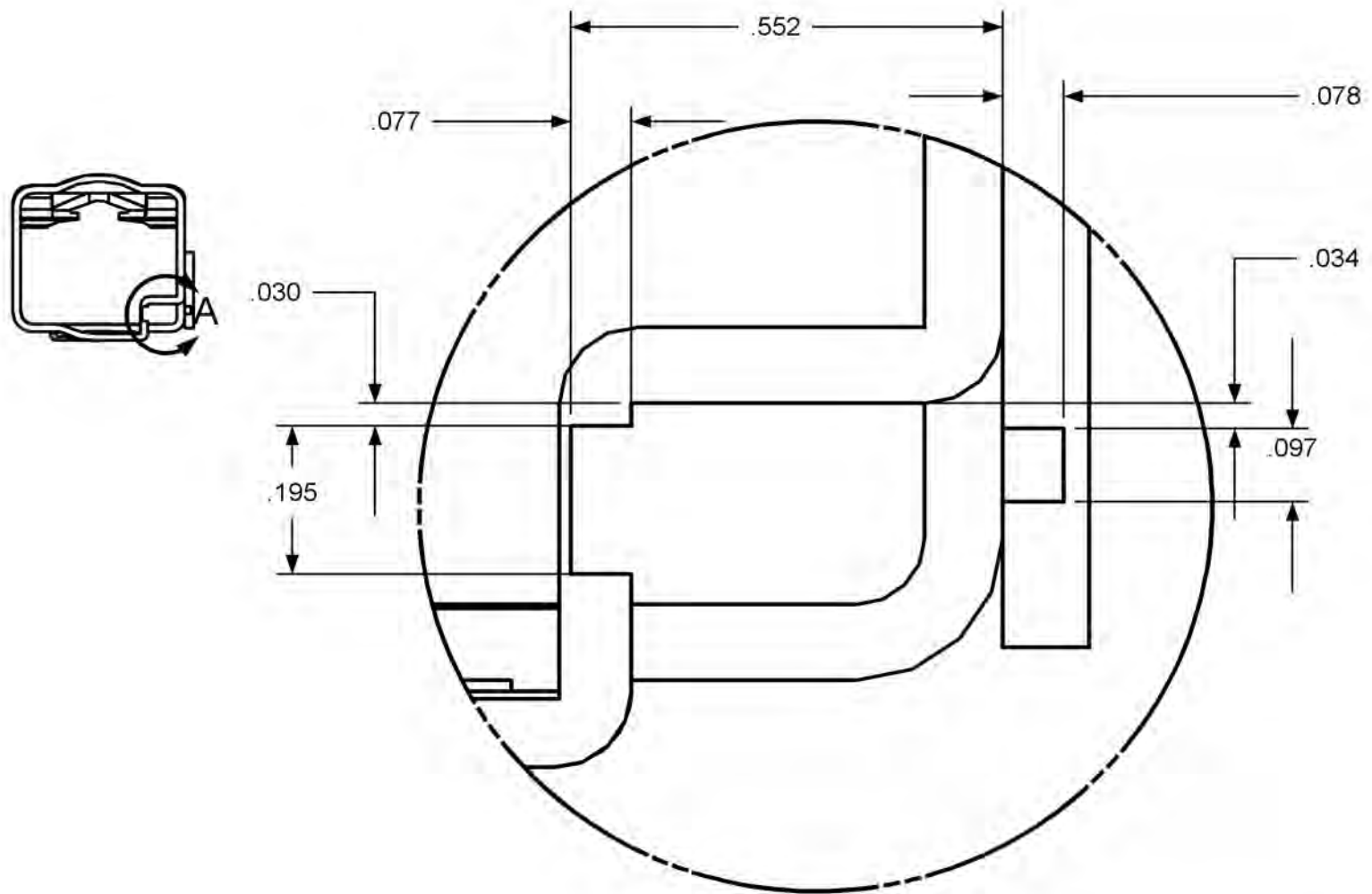
Semi Auto Blocker Installation



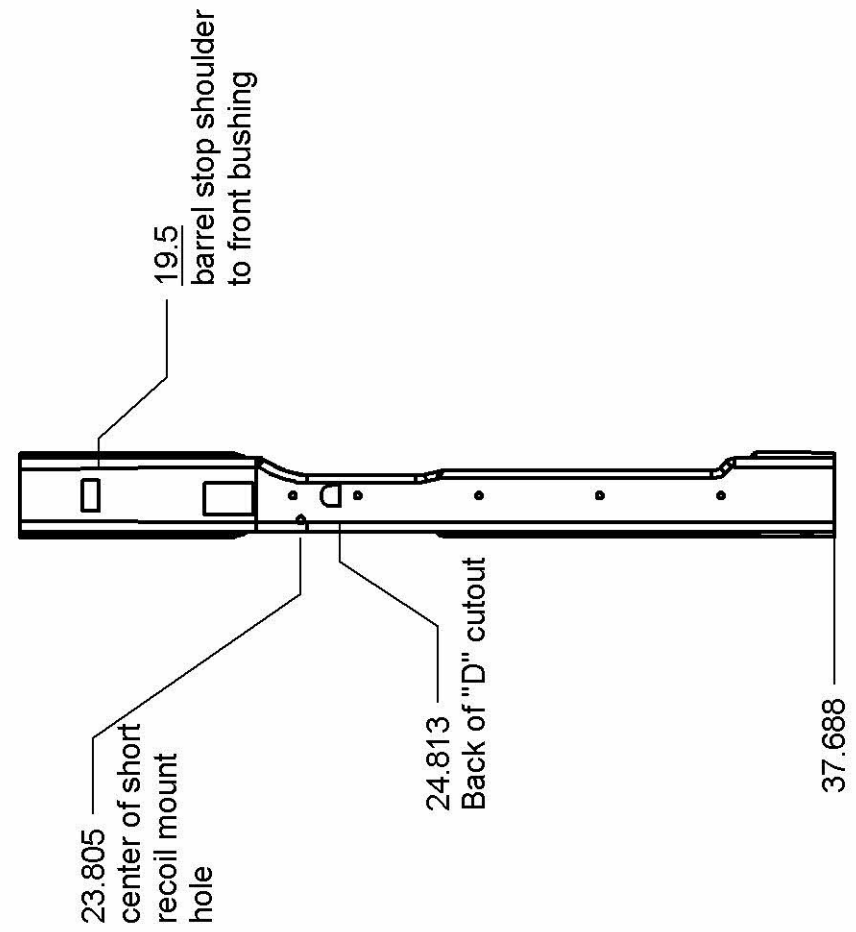
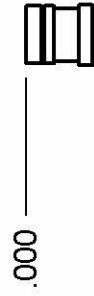
MG42 SA Trigger
Pack Detail



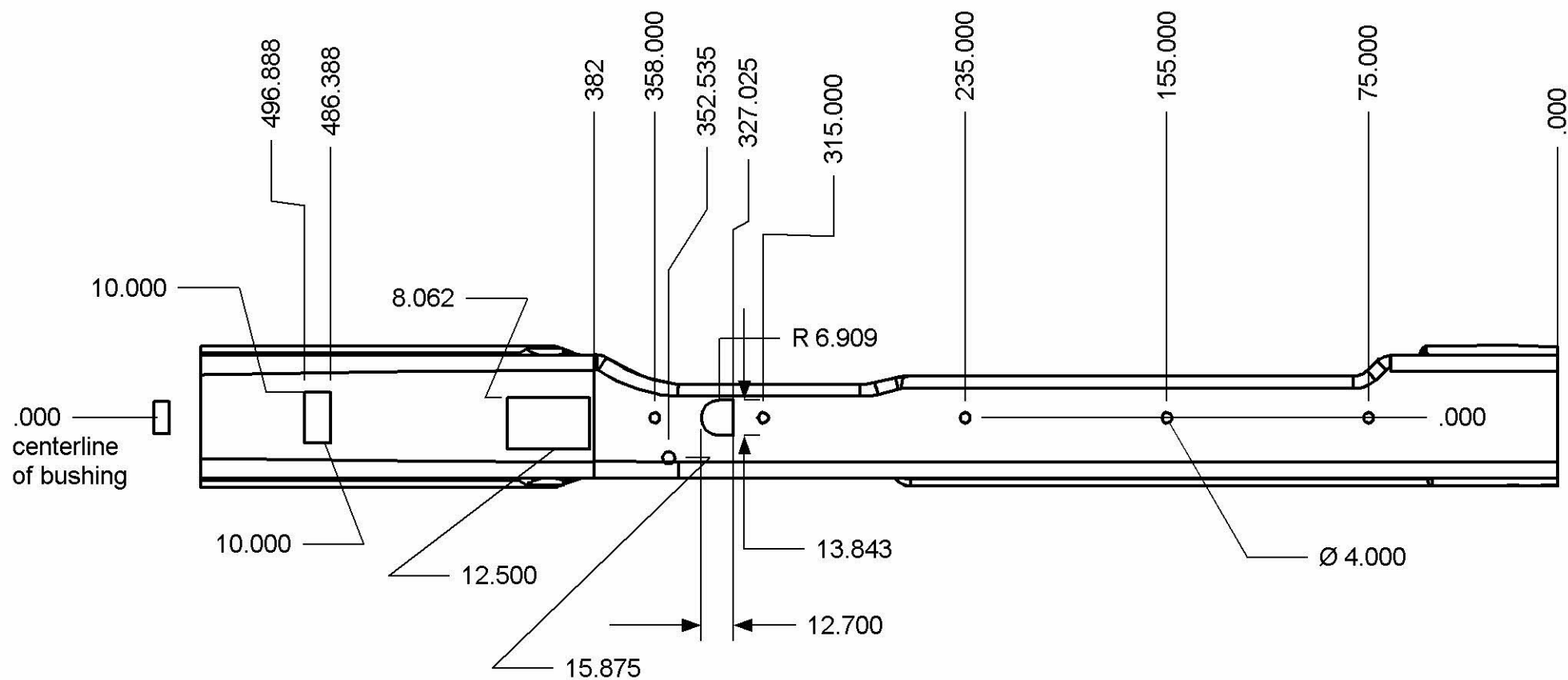
Charging Handle Cutout



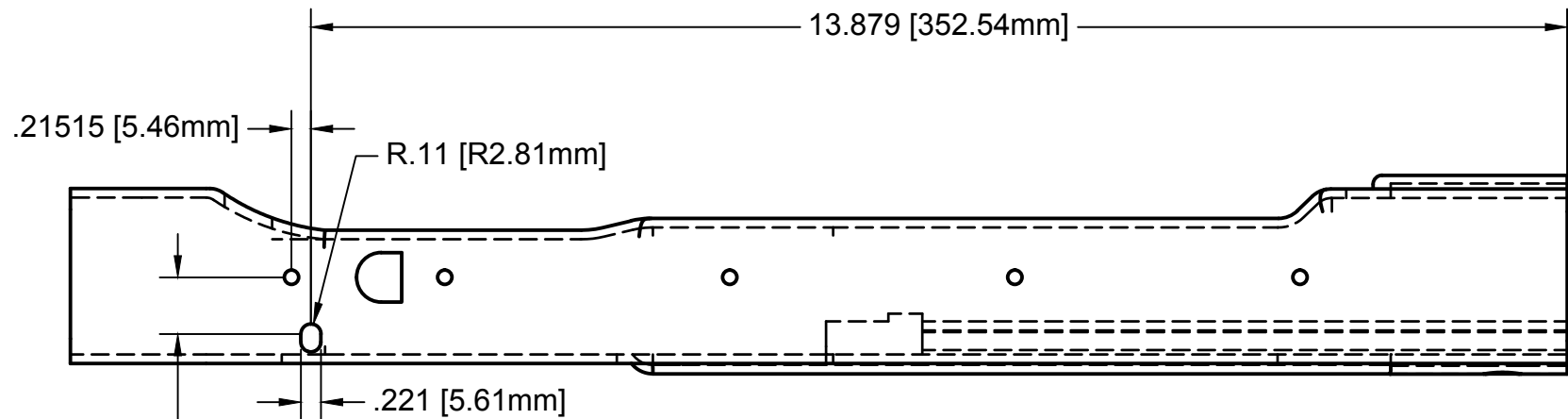
Charging Handle Cutout (dwg 2)
Track Detail



MG42 Semi Auto Reciever
Drawing 1: OAL Trim
BRP Rev 4
5-10-2011



MG42 Semi Auto Reciever
 Drawing 3: Left Detail
 BRP Rev 4
 5-10-2011



Current location of front recuperator mount hole relative to the front rail hole.

- Machine down as necessary, thereby creating a slot, to position the recuperator assembly tightly on the floor of the receiver under the left rail.



PROJECT

MG42 Recevier

TITLE

Front Recuperator Mount Hole/Slot

SIZE

A

CODE

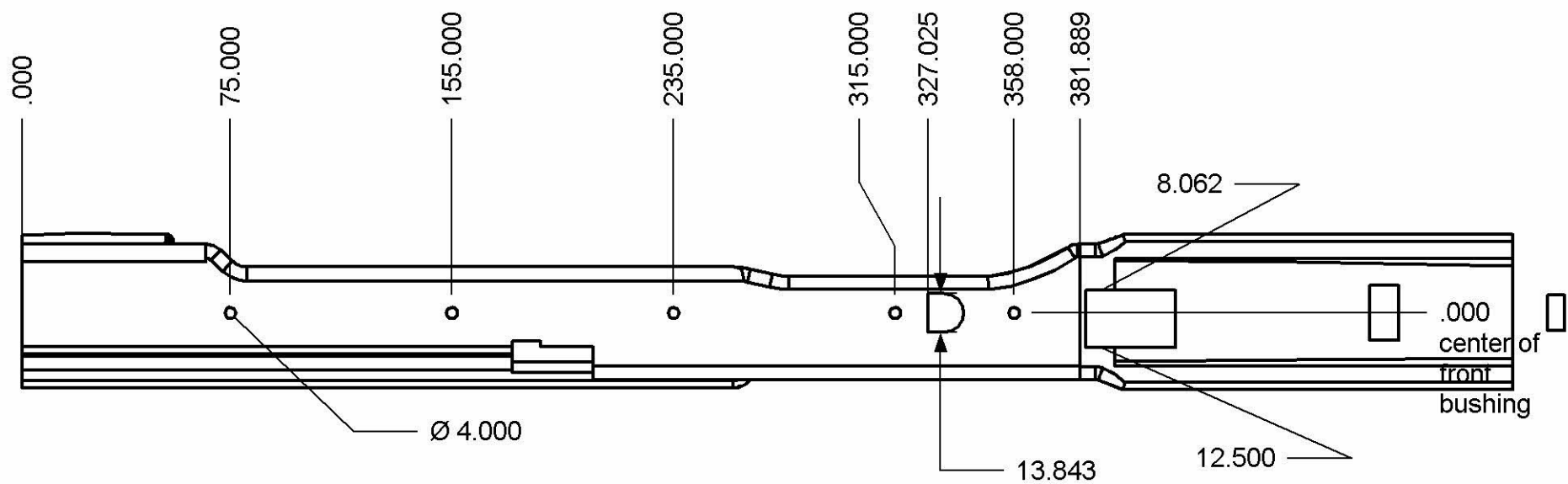
DWG NO

REV

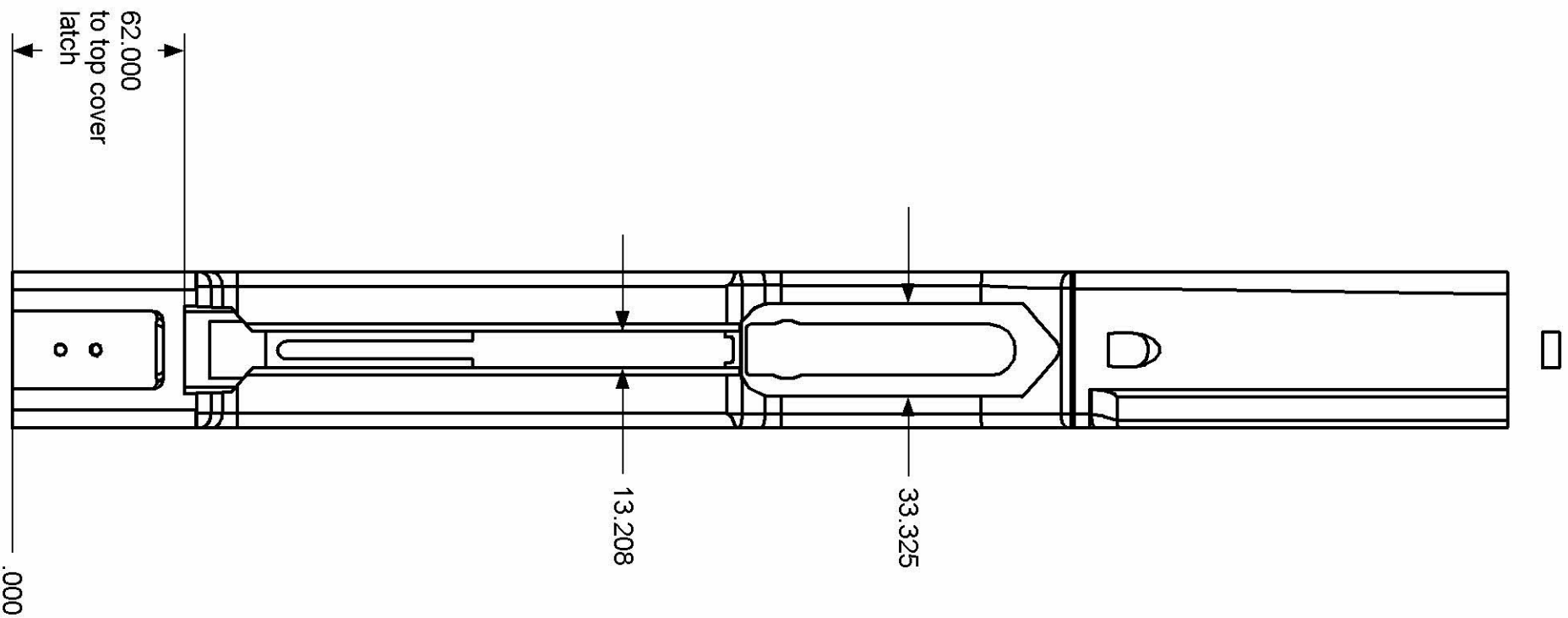
SCALE 1:2

WEIGHT

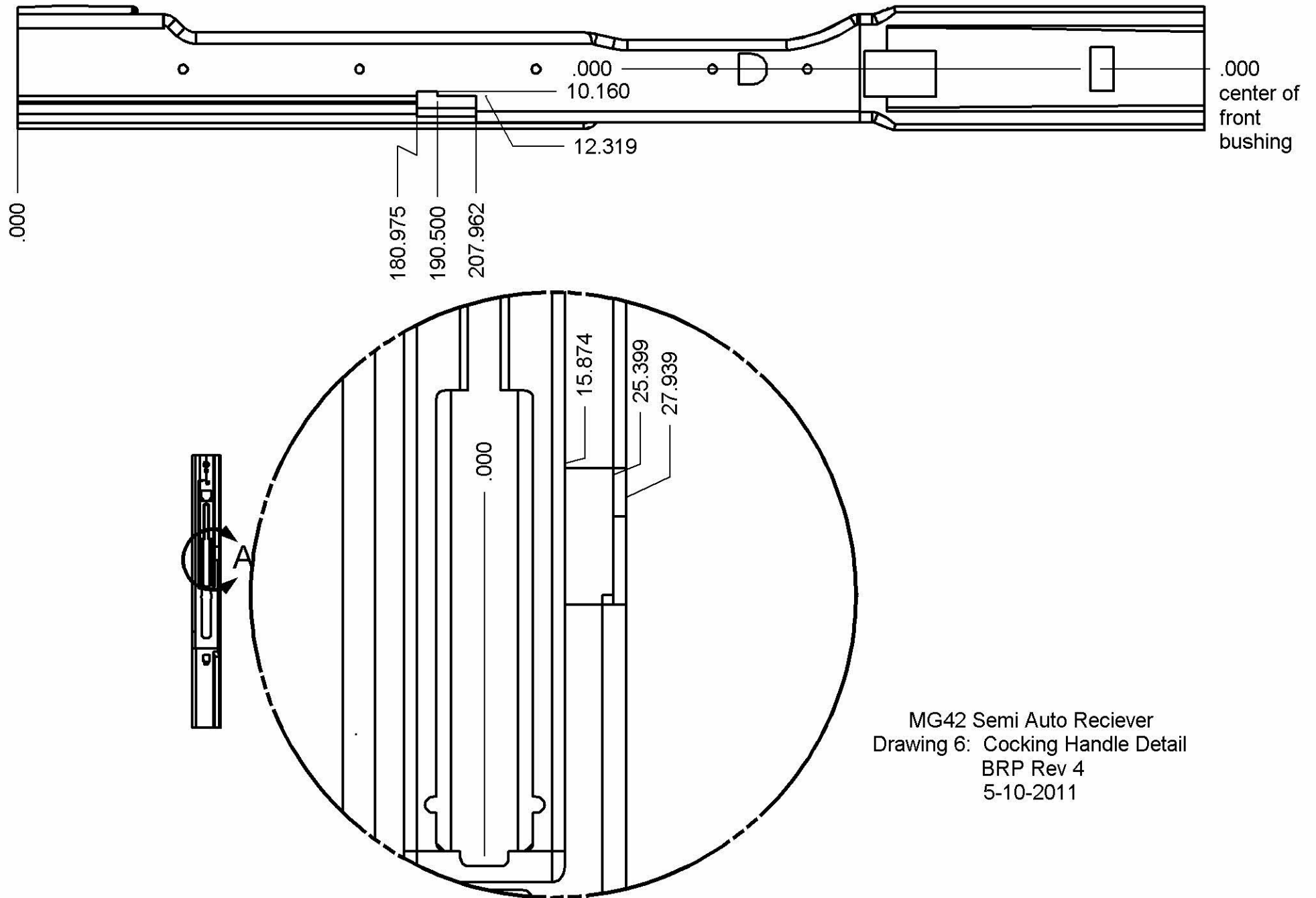
SHEET 1/1



MG42 Semi Auto Reciever
 Drawing 4: Right Detail
 BRP Rev 4
 5-10-2011



MG42 Semi Auto Receiver
Drawing 5: Top Detail
BRP Rev 4
5-10-2011



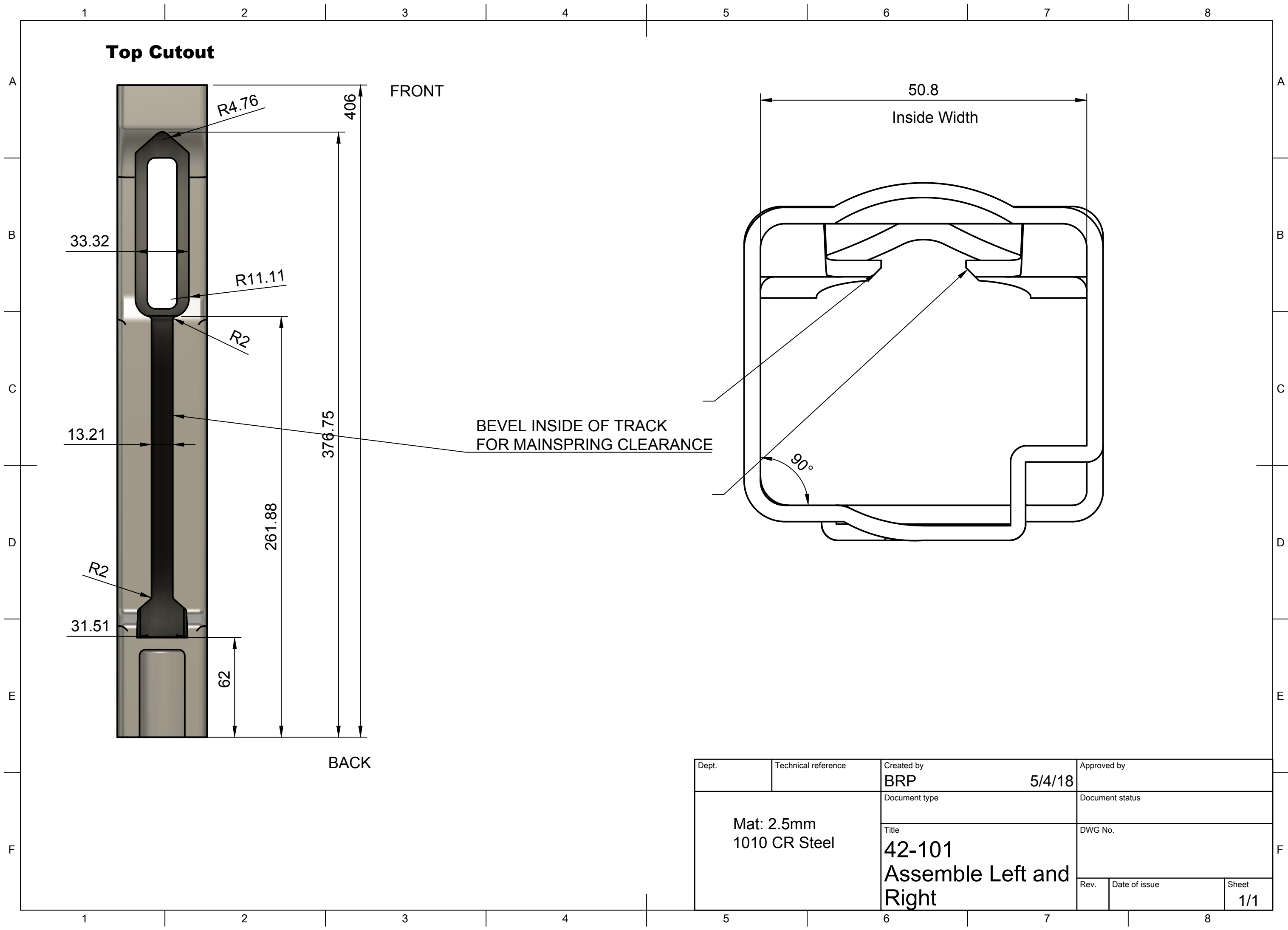
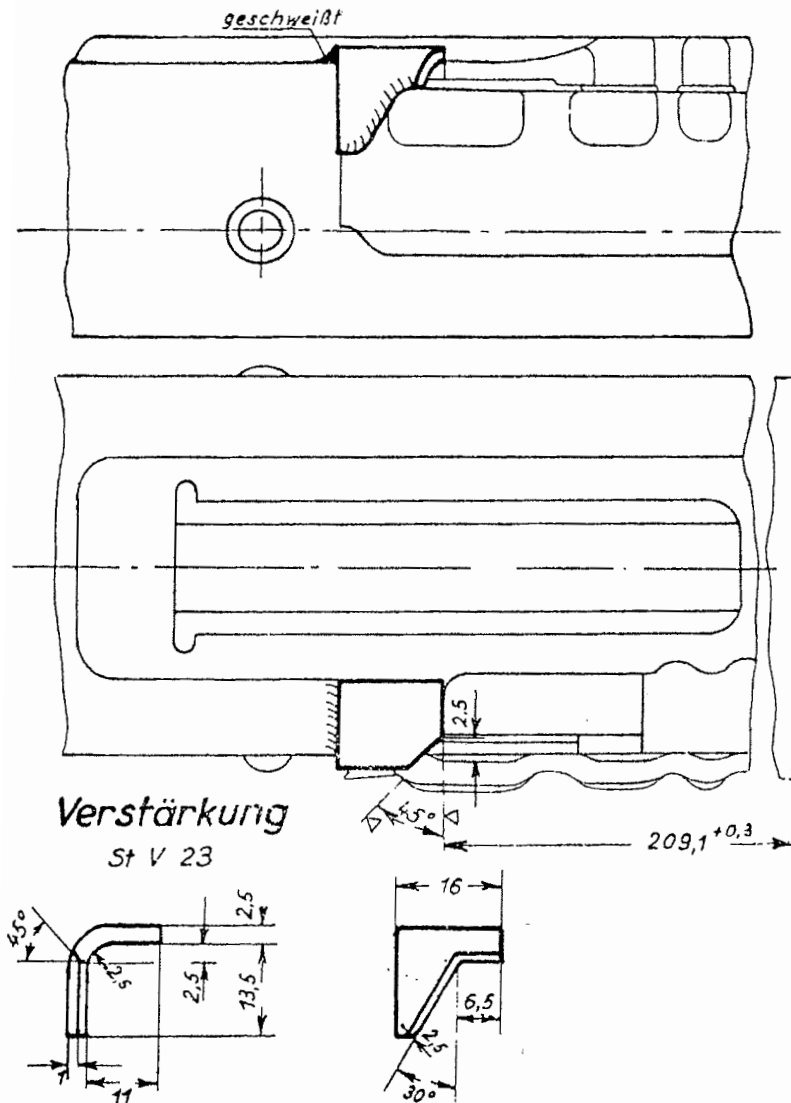


Bild 6

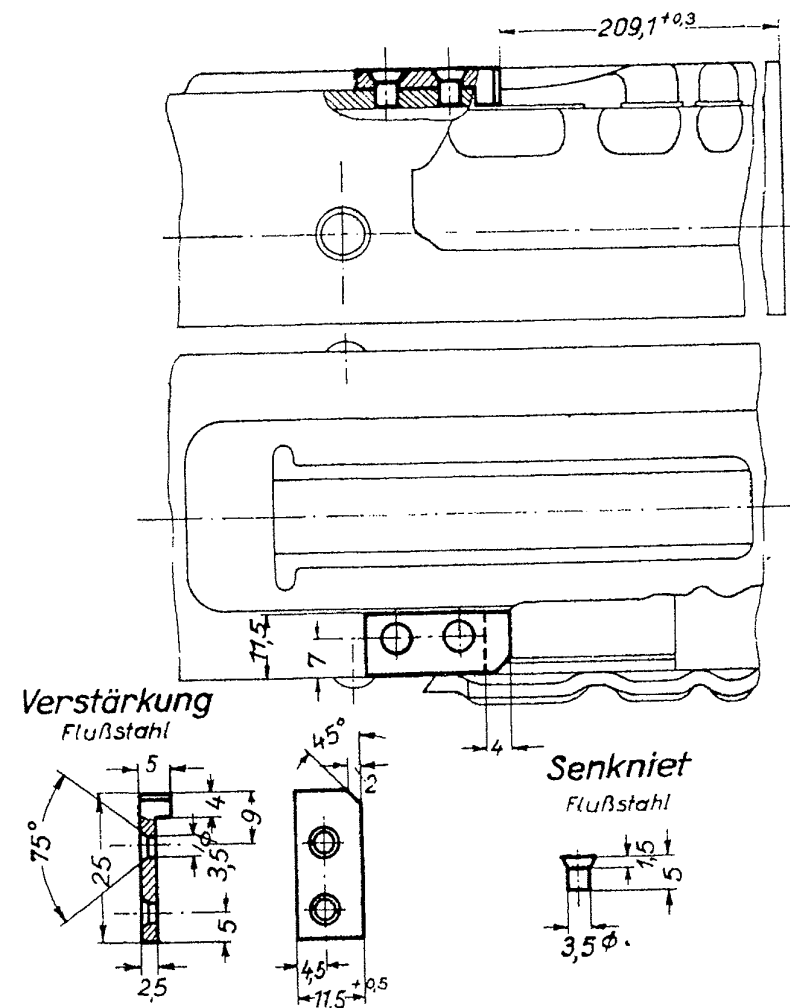


Anleitung zum Anbringen einer Verstärkung am Anschlag für den Hebel zum Spannschieber am Gehäuse

Befestigen der Verstärkung durch Schweißen

Ausführung: Verstärkung nach Skizze anfertigen, anpassen, durch Schweißen befestigen und nacharbeiten

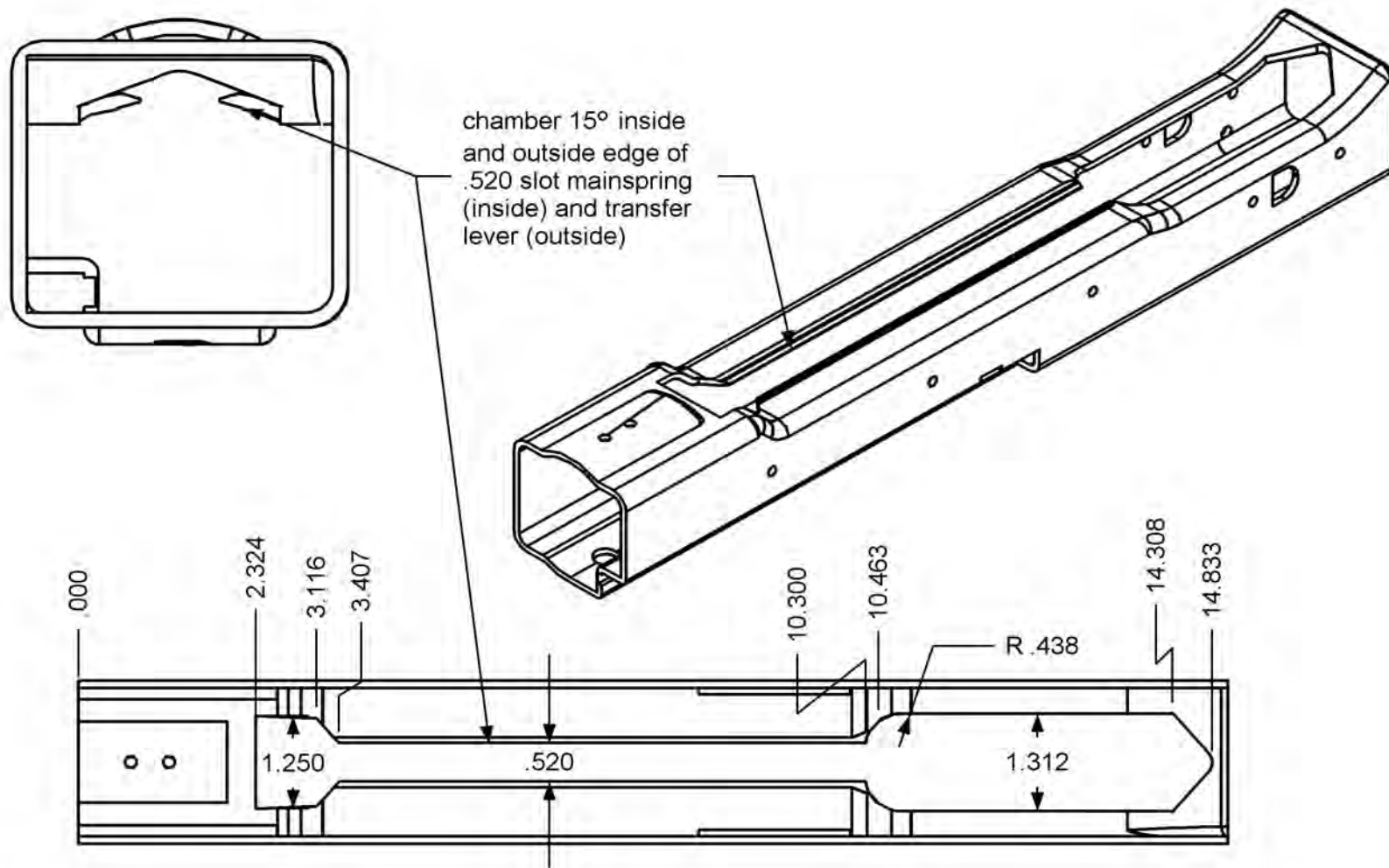
Bild 7



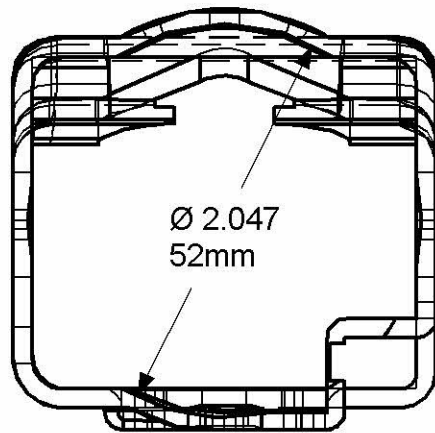
Befestigen eines Verstärkungswinkels durch 2 Zapfen (Senkniete) u. Weichlöten

Ausführung:

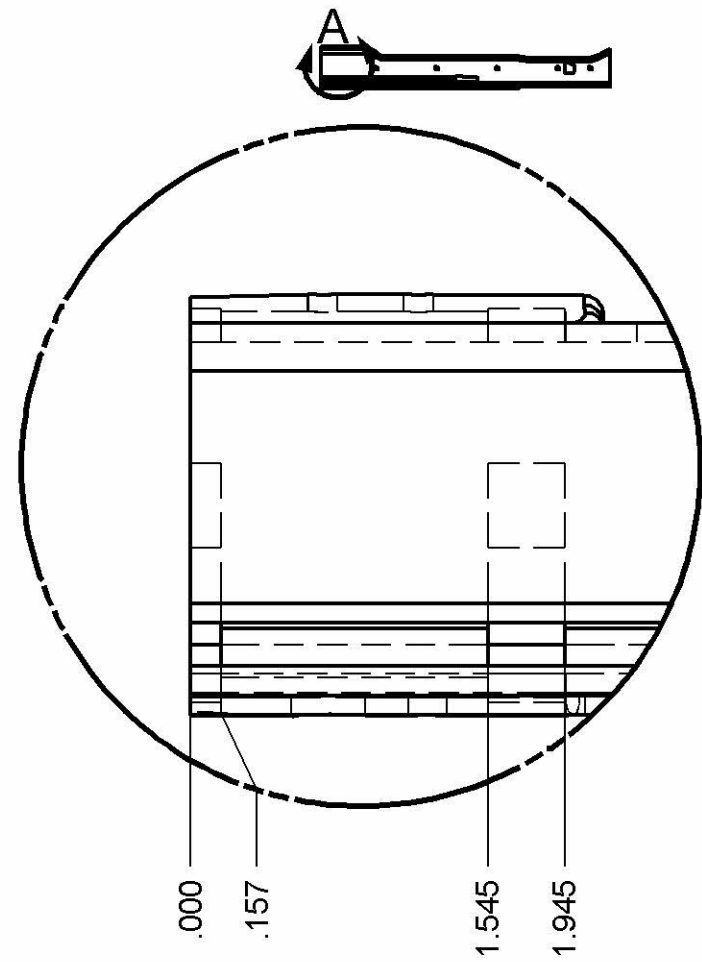
1. Verstärkungswinkel und Zapfen (Senkniet) nach Skizze anfertigen.
2. Anschlag am Gehäuse 4 mm nacharbeiten (Material am Radius stehen lassen).
3. Winkel zum Weichlöten an das Gehäuse anpassen.
4. Löcher anreißen und bohren.
5. Lötflächen verzinnen.
6. Winkel mit Zapfen am Gehäuse befestigen.
7. Löten und Nacharbeiten

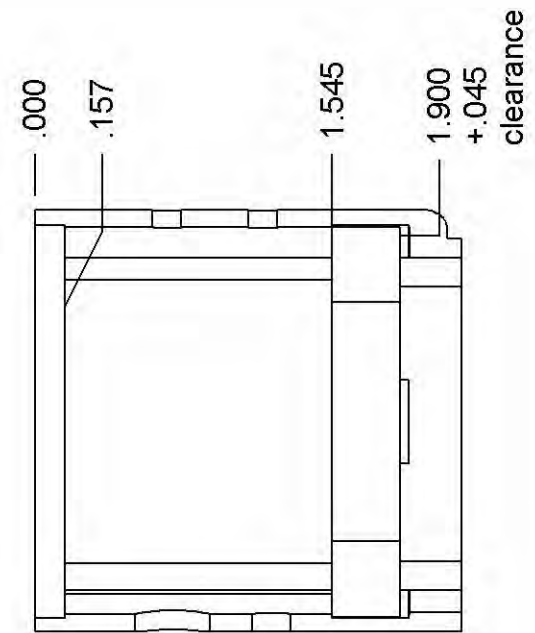
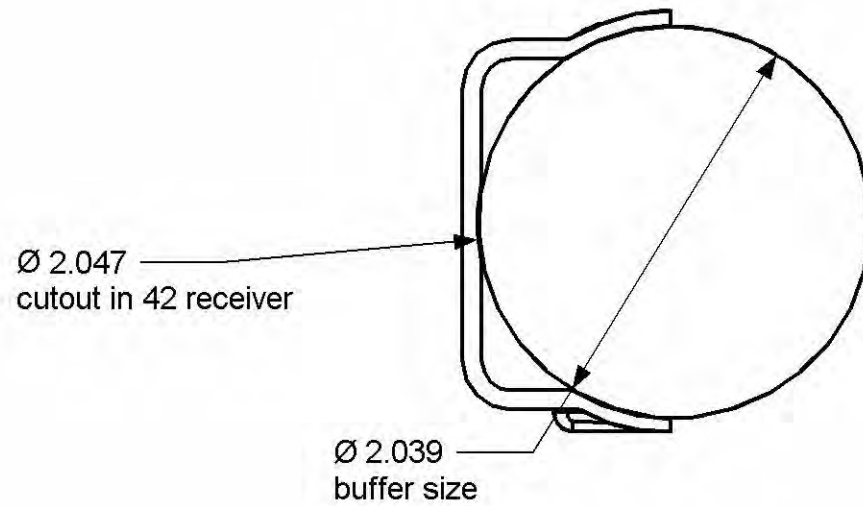
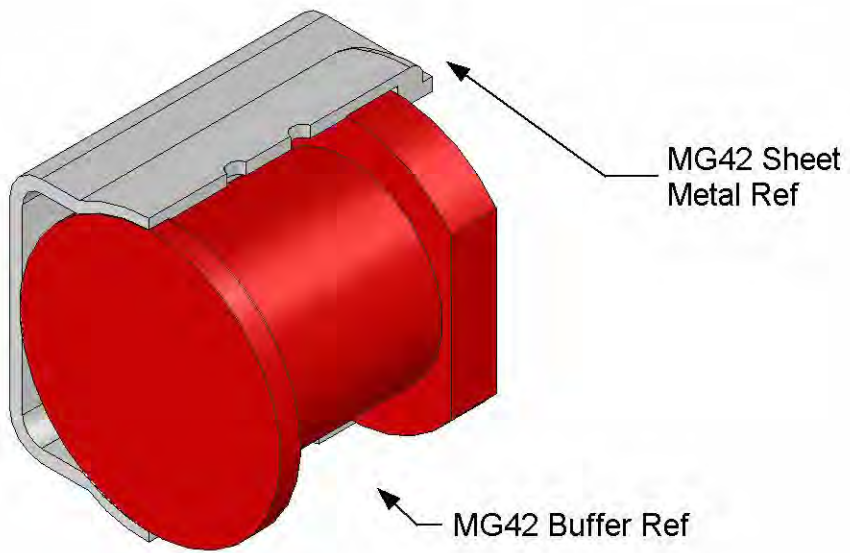


Semi Auto Top

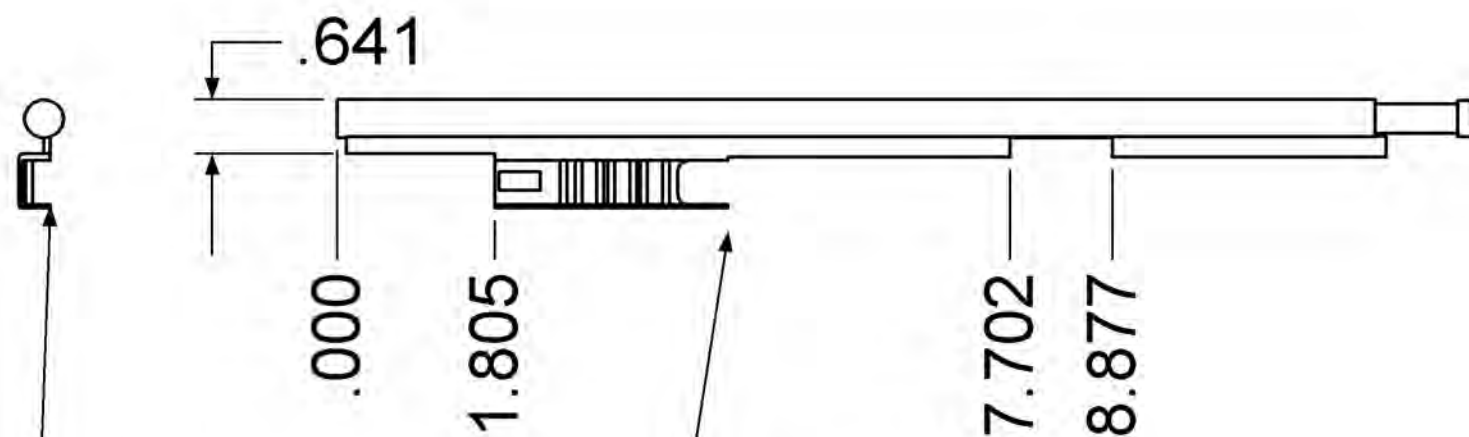
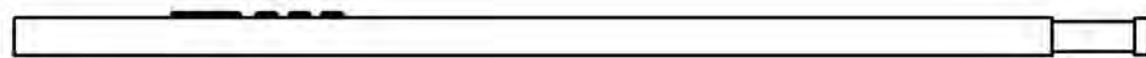


MG42 Buffer Cutout for Rotation

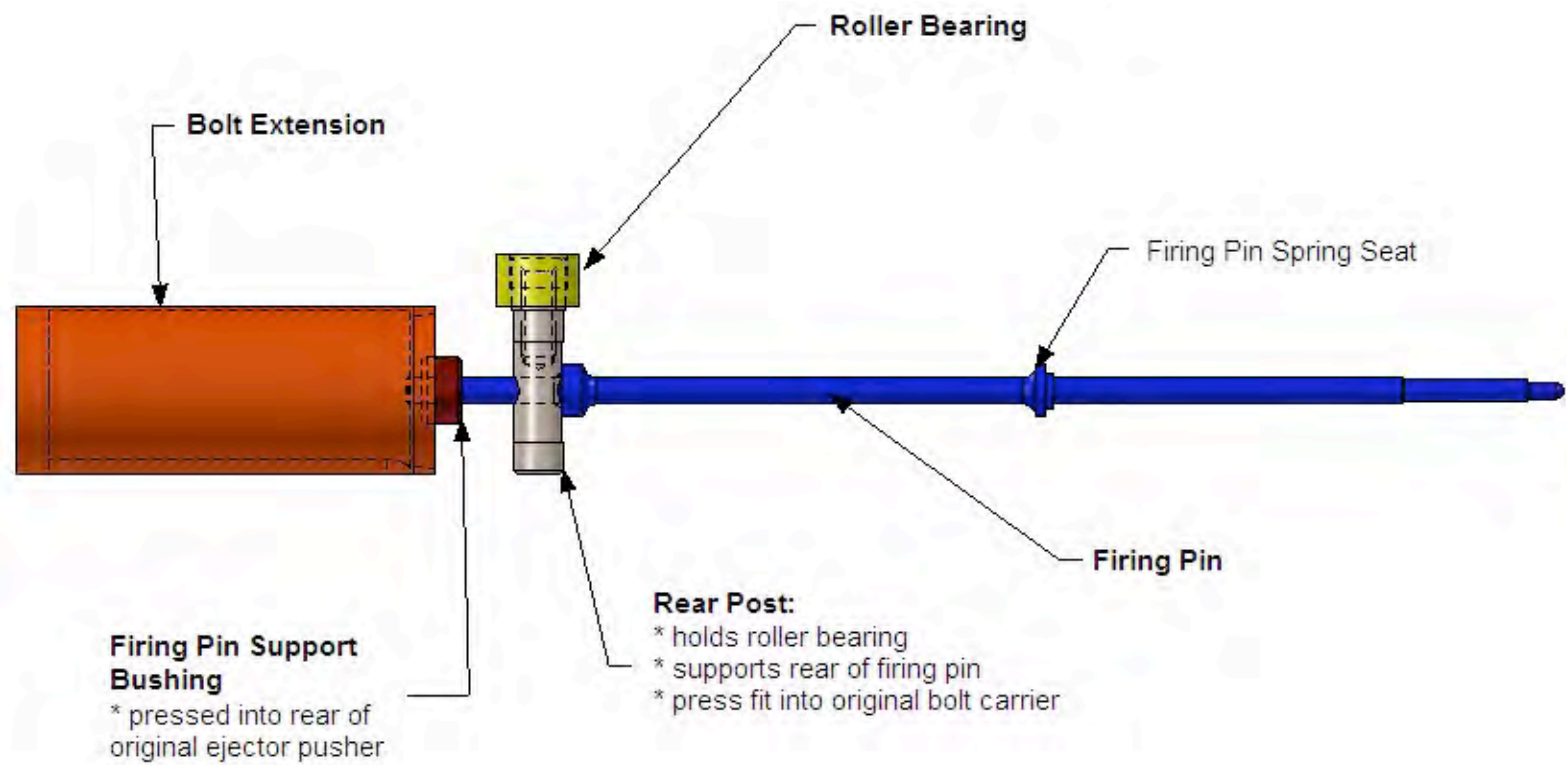


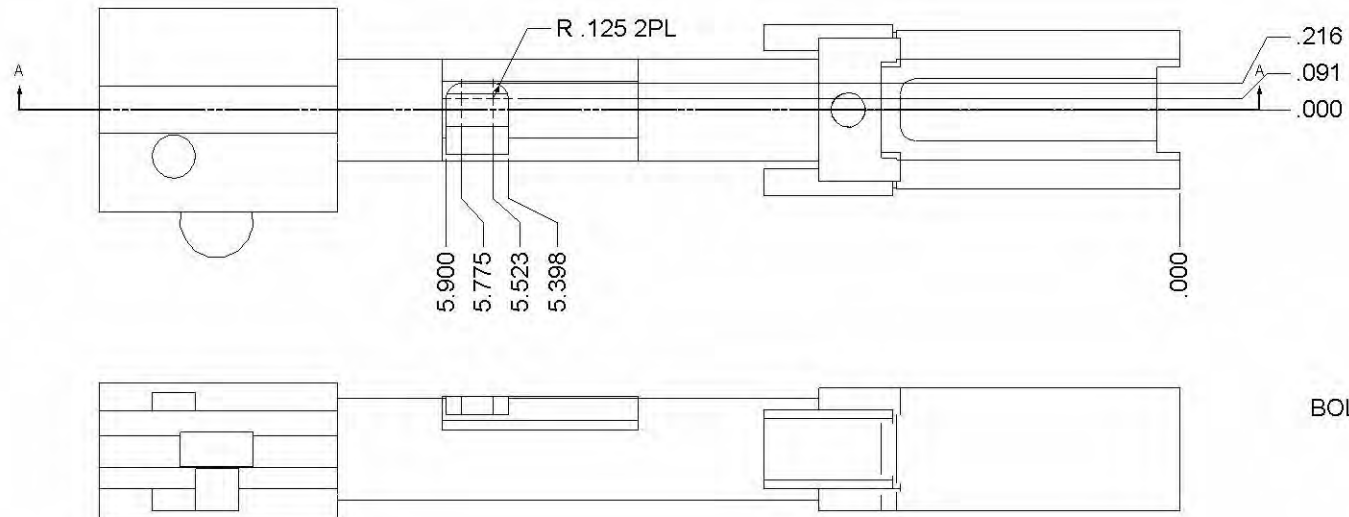
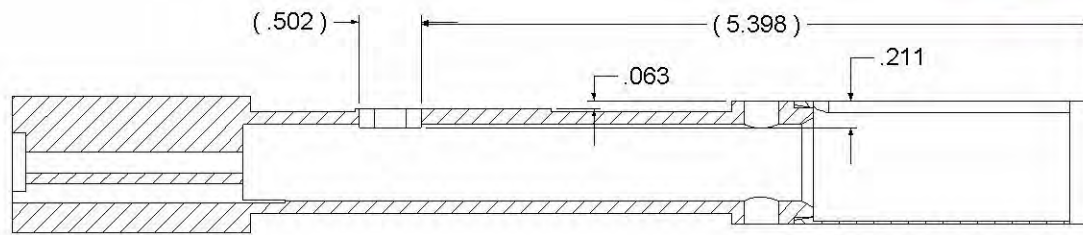
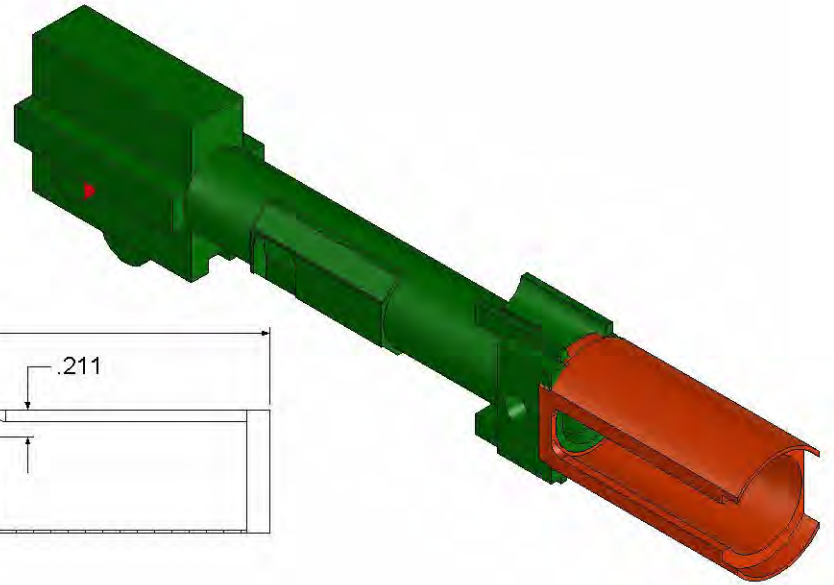


Buffer/Receiver Fit

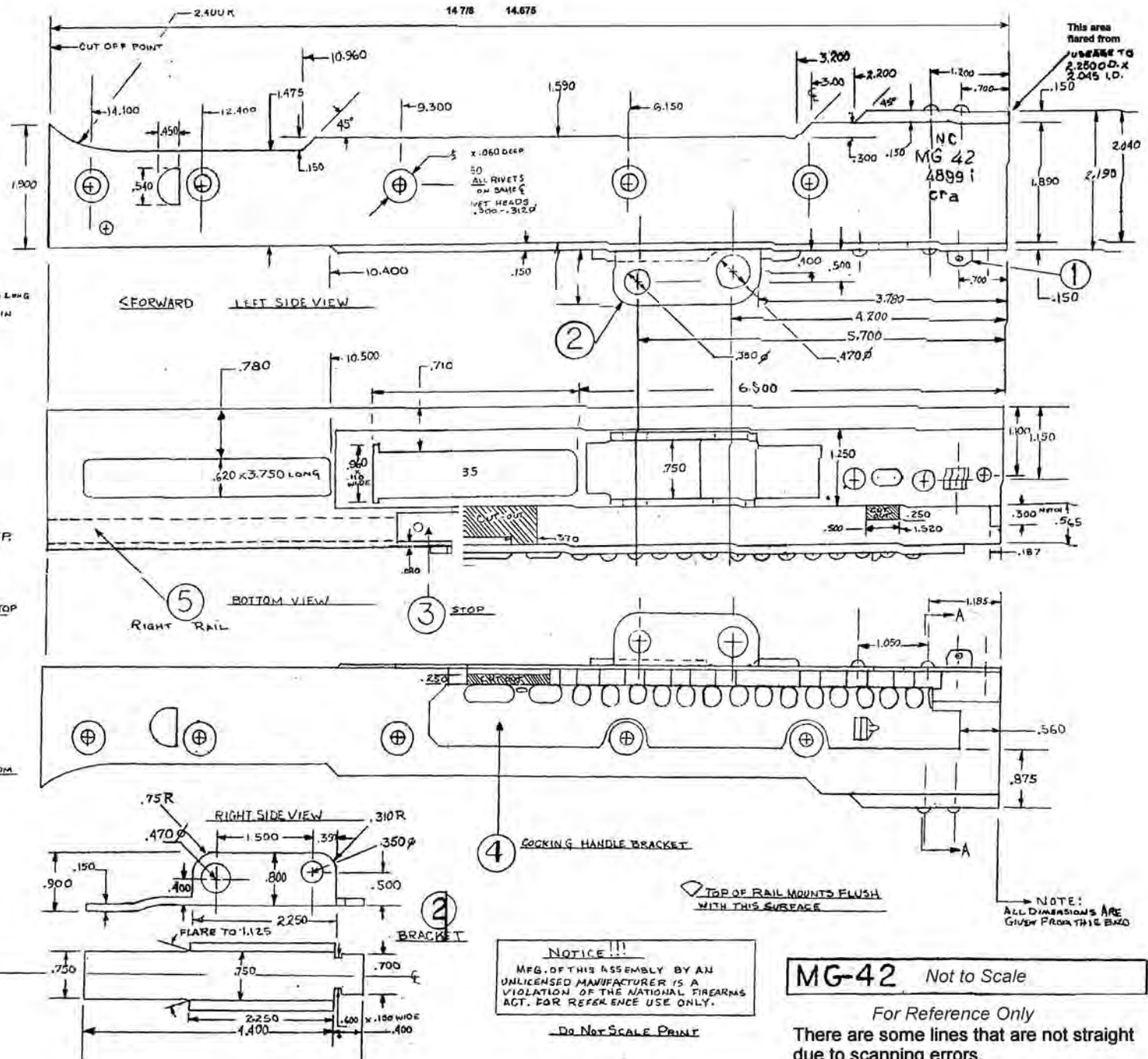
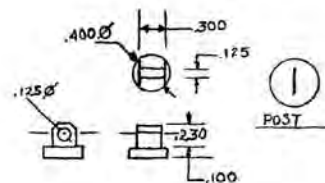
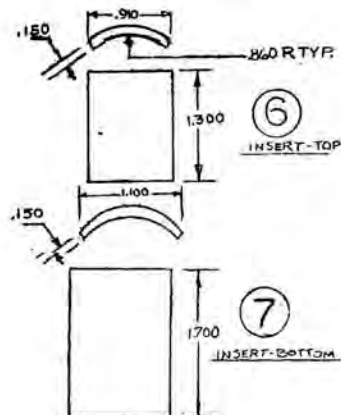
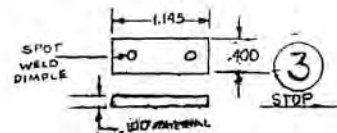
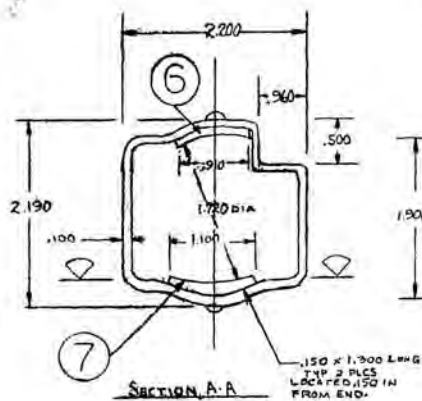


MG42
SHORT RECOIL
MOD





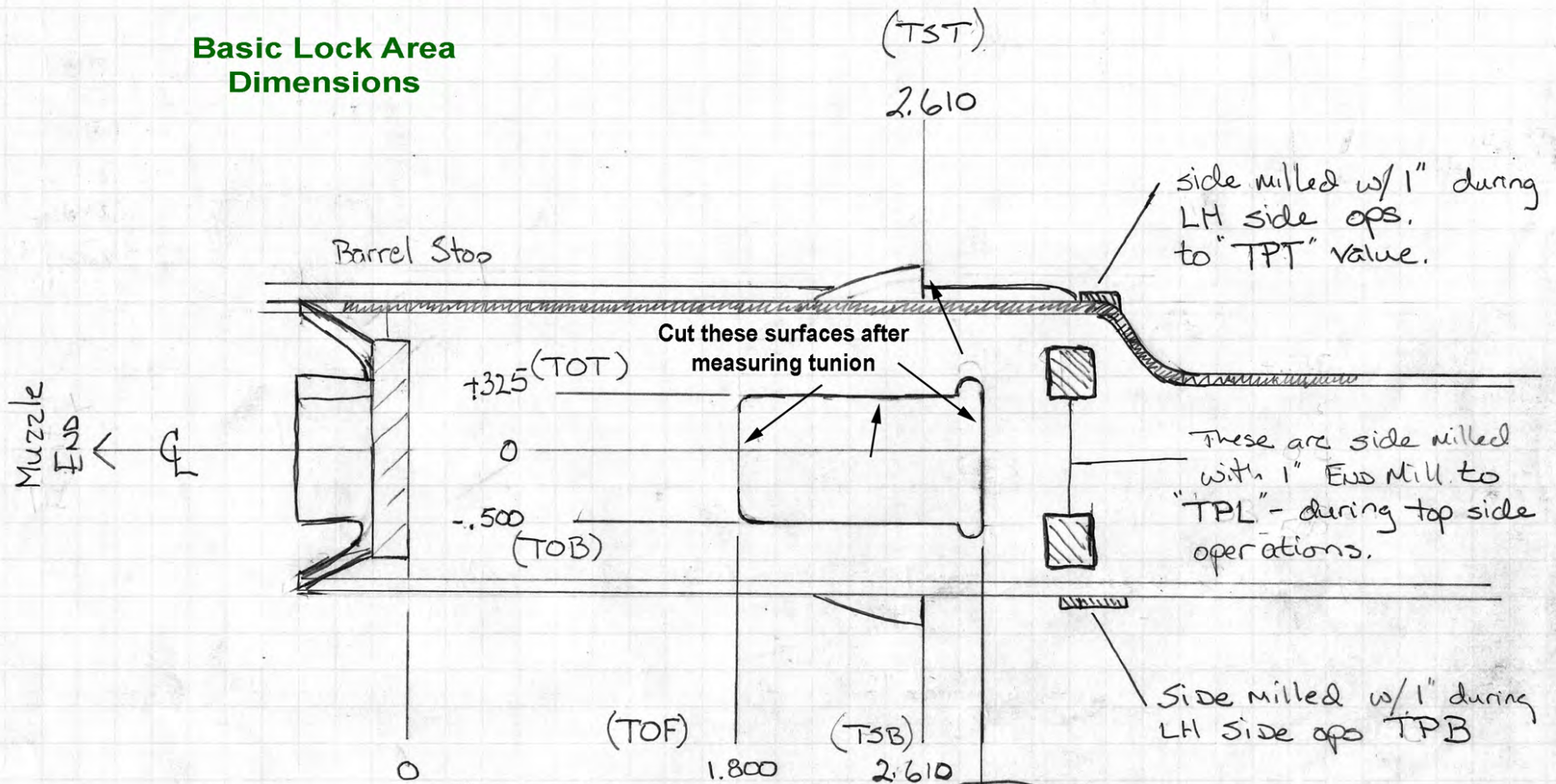
MG42
BOLT MODIFICATION
10-16-02



MG-42 Not to Scale

For Reference Only
There are some lines that are not straight
due to scanning errors.

Basic Lock Area Dimensions



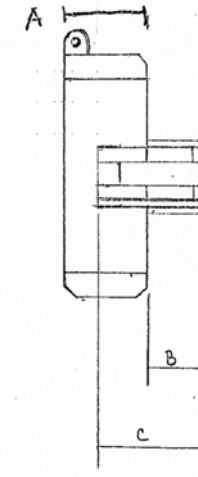
- All values are actual Tool Offsets
must be calculated

Notes: "TO" and TS values from Barrel Stop "Zero"

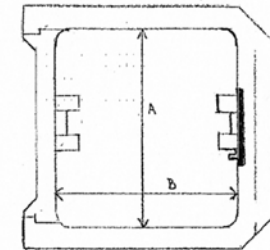
- Trunnion Pad Values From "Zero" (TPL, TPR, TPT, TPB)

Sample Chart

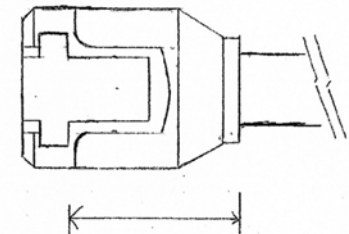
	Trunion Opening Rear	Trunion Pad Left	Trunion Pad Right	Trunion Pad Top	Trunion Pad Bottom
Trunion Number	TOR	TPL (+)(2)	TPR (-)(1)	TPT (+)(2)	TPB (-)(2)
Kls n627	3.095	1.100	-1.101	.9655	-.9655
Kls U-202	3.102	1.100	-1.101	.967	-.967
Kls O-550	3.103	1.100	-1.100	.967	-.967
Kls P-628	3.096	1.101	-1.102	.964	-.964
CRA 1072c	3.096	1.100	-1.100	.965	-.965
Kls G976	3.098	1.100	1.100	.965	-.965
Kls 2848	3.099	1.100	1.101	.967	.966
ar 5245	3.095	1.099	1.100	.964	.963
ar 7547	3.100	1.100	1.101	.967	.966
CRA 8225	3.096	1.100	1.101	.965	.964
Kls H518	3.110	1.100	1.100	.965	.965
Kls A145	3.098	1.100	1.100	.965	.965
Kls F161	3.101	1.100	1.101	.964	.964
Kls W-55	3.100	1.101	1.101	.964	.964
Kls I-89	3.104	1.101	1.101	.964	.964
Kls N960	3.091	1.102	1.103	.964	.963
Kls J978	3.098	1.103	1.103	.965	.965

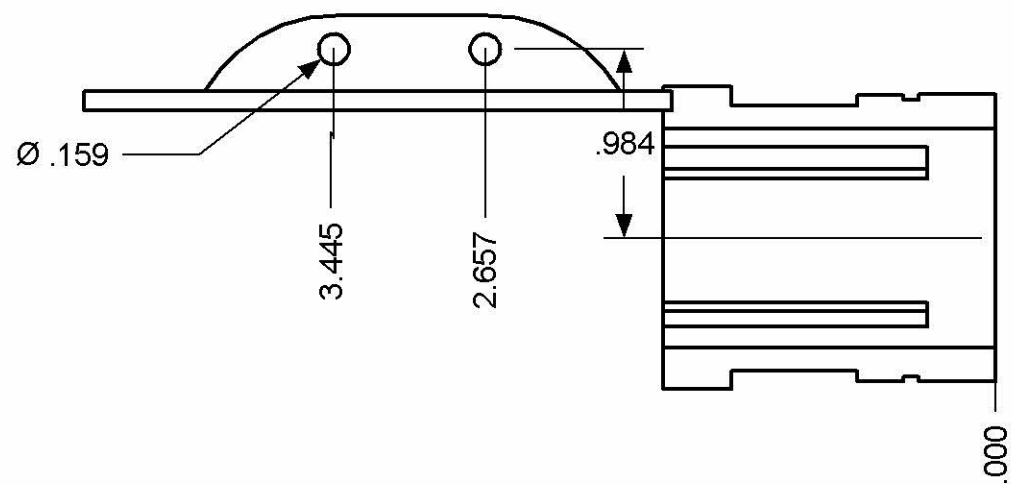
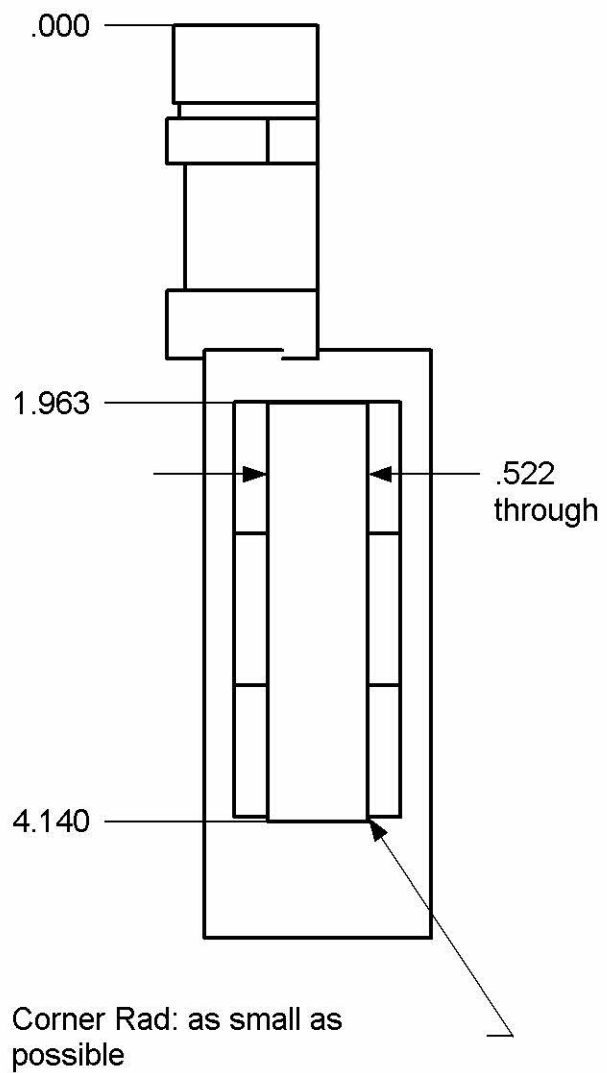


A _____
B _____
C _____

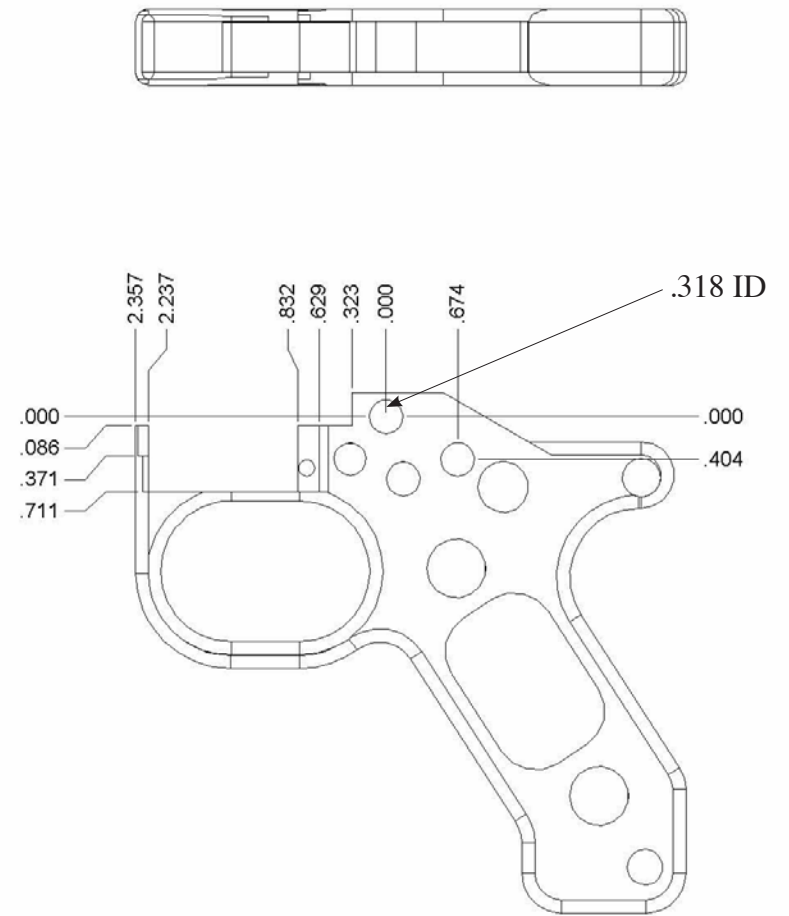


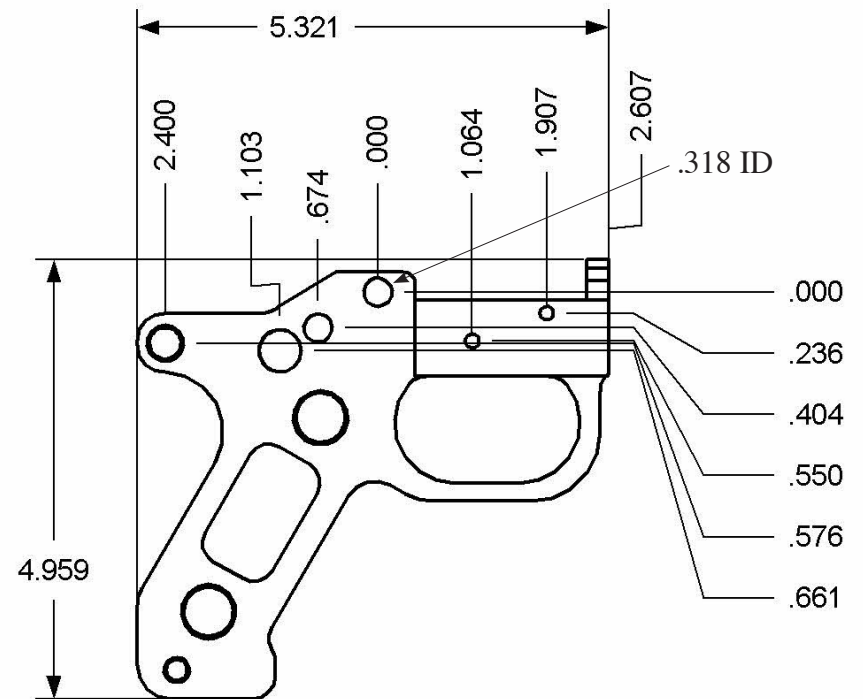
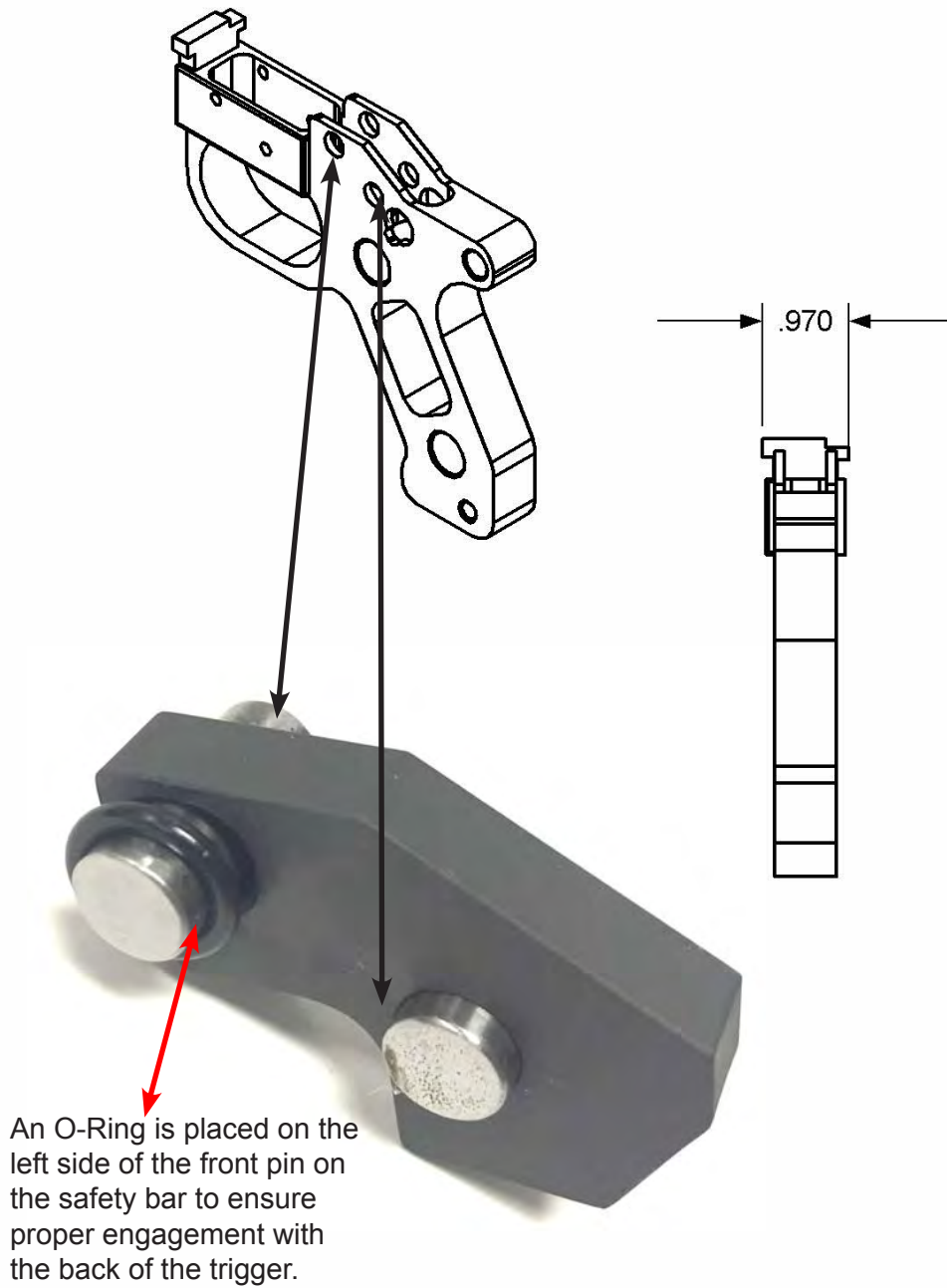
A _____
B _____



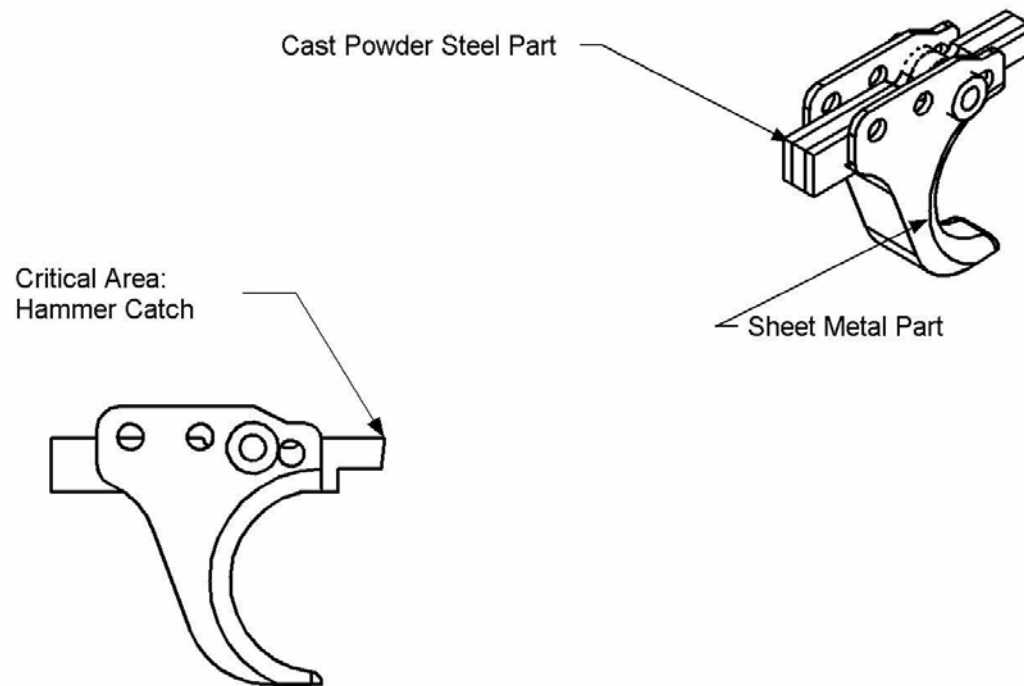


MG42 Semi Auto Reciever
 Drawing 7: Front Sight Ref
 BRP Rev 4
 5-10-2011

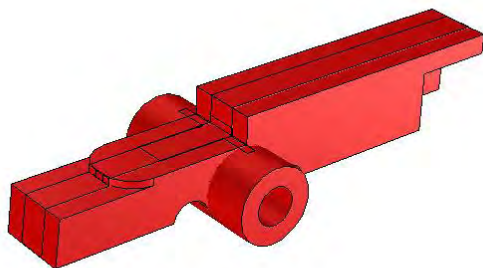




Part Name: 42SATP
 Part #: 4216
 Mat: 7075 alum



SCALE 1 : 1



MG42
Trigger Assembly
MAT'L: AR15 Trigger
Cast Powder Steel
Case Hardened
Welded to Sheet Metal Trigger

