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Author

Topic: MG-42 step by step build with BRP receiver (Read 891 times)

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Posts: 123



MG-42 step by step build with BRP receiver

« on: January 16, 2010, 09:02:36 AM »



Quote

I have this build posted on MG42.US and though this would be a great place to put it also. I decided show a step by step build of one of my BRP receiver.

I have built a few of these and this is how I do them. I am not saying it is the only way, but it's the way I do them and they all have worked without a flaw. I also don't use rivets. I have used them my whole life. From using them on a large farm in the Midwest when I was going up to aircraft in the military to gas turbines in the power industry. Rivets are hard to do correctly. I have done millions of them. Even if you get them tight, sometimes they become loose. This is a flaw I am not happy with. I weld everything. When my MG42's are done they have all the correct rivet heads in all the correct places, inside and out and it is quite easy to do. I will show every step for you first time builders. I will have this one completed in under a month. I measure everything in millimeters. All my tools are standard.

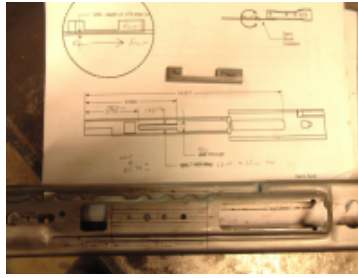
please ask questions here:

<http://www.prexis.com/sten/homebuilder/index.php?topic=8598.msg115836#msg115836>



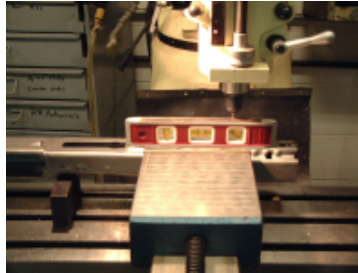
Pic 1.JPG (595.57 KB. 1280x960 - viewed 179 times.)

1: Lay out all your parts. I remove the bolts that hold the feed cover latch and barrel door latch. I then retap the holes and chase the threads of the screw. If there is a problem now is the time to catch it. You want do completely disassemble the Mg after you test fire so it can be sandblaster and blued.



 Pic 2.JPG (473.64 KB. 1280x960 - viewed 129 times.)

2: Lay out semi auto bolt block location on the bottom of the receiver. I also mark the block for the correct installation direction



 Pic 3.JPG (525.54 KB. 1280x960 - viewed 64 times.)

3: Proper set up before milling is key! Make sure you are level



 Pic 4.JPG (493.58 KB. 1280x960 - viewed 81 times.)

Mill notch.

« Last Edit: January 16, 2010, 01:51:08 PM by sdk1968 »

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 **Re: MG-42 step by step build with BRP receiver**

« Reply #1 on: January 16, 2010, 09:18:39 AM »

 **Quote**

5: Weld in the semi auto block. I use a Miller 210 mig welder with 0.023 wire.

Posts: 123



Pic 5.JPG (515.34 KB. 1280x960 - viewed 110 times.)

6: Grind welds flush.



Pic 6.JPG (532.97 KB. 1280x960 - viewed 68 times.)

7: Mill charging handle groove in ratchet plate. I use a 3/32 keyseat cutter to cut this in the middle of the dimples.



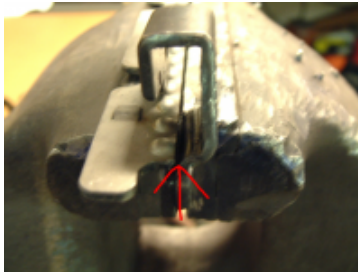
Pic 7.JPG (422.52 KB. 1280x960 - viewed 90 times.)

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 **Re: MG-42 step by step build with BRP receiver**« **Reply #2** on: January 16, 2010, 09:21:44 AM »**Quote**

8: Trial fit the charging handle in ratchet plate. You will have to mill the bottom of the ratchet plate for clearance.



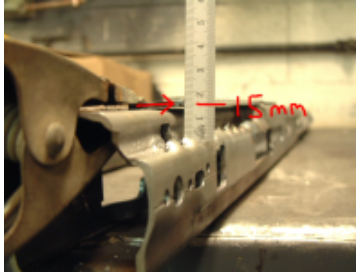
Pic 8.JPG (464.77 KB. 1280x960 - viewed 78 times.)




 Pic 11.JPG (468.24 KB. 1280x960 - viewed 54 times.)

 Pic 12.JPG (514.13 KB. 1280x960 - viewed 55 times.)

Page 4 of 18



Pic 13.JPG (467.79 KB. 1280x960 - viewed 57 times.)

12: Disassemble charging handle. If you are using a mill, remove the button on the end



Pic 14.JPG (443.69 KB. 1280x960 - viewed 42 times.)

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Re: MG-42 step by step build with BRP receiver

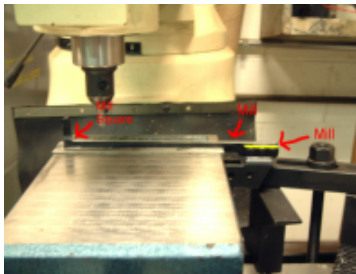
« **Reply #4** on: January 16, 2010, 09:31:23 AM »

 **Quote**

13: Machine charging handle using measurement 11A (step 11 measurement A) Mine is 16.5mm before milling. I removed 1.5mm from 2 locations. Also square the inside bend of the charging handle for the semi auto bolt.

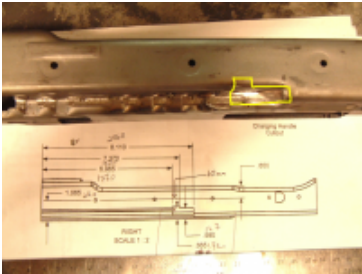


Pic 15.JPG (486.06 KB. 1280x960 - viewed 27 times.)



Pic 16.JPG (473.46 KB. 1280x960 - viewed 42 times.)

14: Lay out charging handle cut out.



Pic 17.JPG (483.56 KB. 1280x960 - viewed 57 times.)

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 Re: MG-42 step by step build with BRP receiver

« **Reply #5** on: January 16, 2010, 09:34:49 AM »



Quote

15: Mill charging handle cut out. You will need to rotate the receiver to complete the cut out.



Pic 18.JPG (507.58 KB. 1280x960 - viewed 33 times.)



Pic 19.JPG (444.97 KB. 1280x960 - viewed 31 times.)

16: Clean up the cut out and slot. Trial fit charging handle.



Pic 20.JPG (480.27 KB. 1280x960 - viewed 37 times.)

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 Re: MG-42 step by step build with BRP



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receiver

« Reply #6 on: January 16, 2010, 11:32:30 AM »



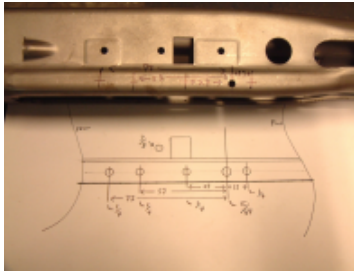
Quote

17: I sandblast all parts that are welded / riveted to the receiver. I then spray them with gun oil to prevent rusting



 Pic 21.JPG (455.17 KB. 1280x960 - viewed 33 times.)

18: Lay out the holes for the rear barrel guide / barrel door bracket on both sides. Drill the 8 marked holes with a 1/4 drill bit. Drill the barrel door rivet holes with a 15/64 drill bit. Clean all burrs



 Pic 22.JPG (478.79 KB. 1280x960 - viewed 34 times.)

19: Clamp in your upper or lower bracket. The upper and lower brackets are not the same. The barrel door rivet holes are off set. Before you clamp in the bracket put a 15/64 drill bit threw the barrel door rivet holes to align the bracket.



 Pic 23.JPG (497.11 KB. 1280x960 - viewed 34 times.)

20: Weld the bracket to the receiver. Repeat steps 19 and 20 for the other bracket.



 Pic 24.JPG (481.05 KB. 1280x960 - viewed 41 times.)

21: Grind welds flush and smooth



 Pic 25.JPG (487.65 KB. 1280x960 - viewed 23 times.)

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Re: MG-42 step by step build with BRP receiver

« **Reply #7** on: January 16, 2010, 12:01:59 PM »



Quote

22: Cut 3 large rivets to the same thickness as the front barrel stop



 Pic 26.JPG (359.04 KB. 1280x960 - viewed 22 times.)

23: Drill out the 3 rivet holes in the receiver for the front barrel stop to a 3/8 hole. Clean and deburr holes.



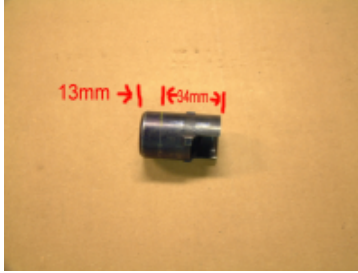
 Pic 27.JPG (438.95 KB. 1280x960 - viewed 28 times.)

24: Install front barrel stop into the receiver. If you have to hit anything with a hammer when building the MG-42 use a brass drift.



Pic 28.JPG (555.49 KB. 1280x960 - viewed 33 times.)

25: Mark a line on your barrel bearing. This is a very important setting for the correct location of the front barrel stop.



Pic 29.JPG (404.03 KB. 1280x960 - viewed 28 times.)

26: Install all 3 cut rivets on the inside of the front stop. Install the barrel bearing and barrel. Move the barrel forward until the line on the barrel bearing can be seen on the outside of the front receiver bushing. The line should be even with the front bushing. The barrel stop should be seated square on the barrel.



Pic 30.JPG (414.72 KB. 1280x960 - viewed 55 times.)

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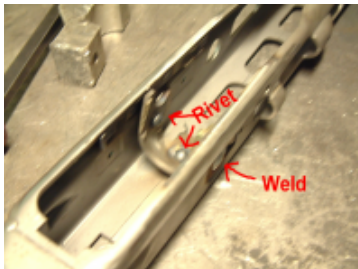
Re: MG-42 step by step build with BRP receiver

« **Reply #8 on:** January 16, 2010, 01:59:10 PM »



Quote

27: Weld the front barrel stop to the receiver and grind the welds down flush and smooth.



 Pic 31.JPG (516.93 KB. 1280x960 - viewed 42 times.)

28: You may need to make some adjustments to these tabs to get the barrel to fit.



 Pic 32.JPG (477.06 KB. 1280x960 - viewed 35 times.)

29: Extend a line from the front of the trunnion cut out to the top of the receiver. Measure from this line to the back of the trunnion stop 29C Mine is 19mm



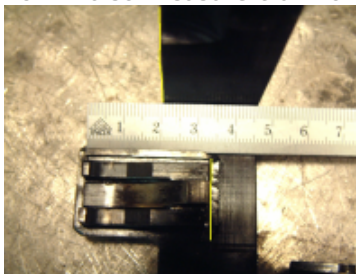
 Pic 33.JPG (495.1 KB. 1280x960 - viewed 28 times.)

30: Measure trunnion opening on the receiver. Mine is 20mm x 32mm



 Pic 34.JPG (513.32 KB. 1280x960 - viewed 35 times.)

31: Measure front of cam to front of trunnion 31D mine is 20mm also measure trunnion cam size. Mine is 20mm x 33mm



 Pic 35.JPG (529.99 KB. 1280x960 - viewed 34 times.)

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**Re: MG-42 step by step build with BRP receiver**

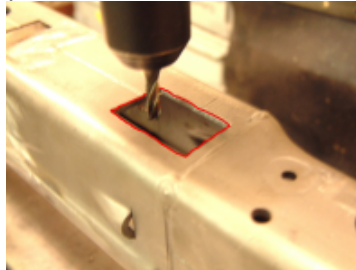
« Reply #9 on: January 23, 2010, 06:44:44 AM »

**Quote**

32: 31D - 29C = 32E Mark out the trunnion cut out. Remove 32E from the front of the trunnion . I have to remove 1mm

 Pic 36.JPG (456.93 KB. 1280x960 - viewed 11 times.)

33: Machine out you trunnion . My trunnion cam is 20mm x 33mm so I machined out my opening to 21mm x 34mm. Ensure you have .5mm clearance around your cam area.

 Pic 37.JPG (462.78 KB. 1280x960 - viewed 12 times.)

34: Install your trunnion . You may need to remove a small amount of material from these areas to get the trunnion fit.

 Pic 38.JPG (475.78 KB. 1280x960 - viewed 28 times.)

35: When the trunnion is installed, it should be up against the trunnion stops. I also cut the bolt. I leave 2 threads showing. They are needed later so don't cut it any shorter.



Pic 39.JPG (481.92 KB. 1280x960 - viewed 24 times.)

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Re: MG-42 step by step build with BRP receiver

« Reply #10 on: January 23, 2010, 06:48:57 AM »



Quote

36: To rivet the barrel door I use a C-clamp with two cut washers to lock the front foot.



Pic 40.JPG (612.27 KB. 1280x960 - viewed 23 times.)

37: Install barrel door and rivet. After riveting open and close the door a few times to loosen it up.



Pic 41.JPG (550.67 KB. 1280x960 - viewed 26 times.)

38: Install barrel door latch. Close door and ensure it latches.



Pic 42.JPG (470.41 KB. 1280x960 - viewed 21 times.)

39: Install the barrel bearing and barrel. Ensure the door

latches properly and the barrel moves freely back and forth. If the barrel is hard to move check these areas for interference. Also if the door is hard to latch when the barrel is properly seated all the way down and the barrel is hard to move back and forth you may need to also remove a small amount of material from the barrel pads on the barrel door latch. The best way to check this is to slightly unlatch the door. The barrel will then move freely. Be careful not to remove too much!



Pic 43.JPG (516.93 KB. 1280x960 - viewed 22 times.)

40: Stand receiver up and measure from the barrel bearing to the front receiver bushing with the barrel in the full back position. You should have around 8mm



Pic 44.JPG (440.13 KB. 1280x960 - viewed 24 times.)

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Posts: 123



Re: MG-42 step by step build with BRP receiver

« **Reply #11 on:** January 23, 2010, 07:06:00 AM »



Quote

41: The lower buffer tab is smaller than the upper tab.



Pic 45.JPG (460.11 KB. 1280x960 - viewed 13 times.)

42: The front of the tabs are going to be installed flush with the back of these machined grooves. This is very important!



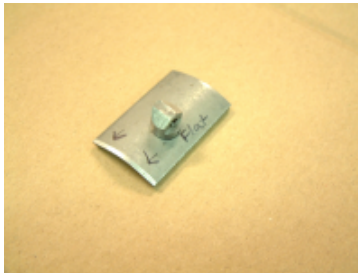
 Pic 46.JPG (454.86 KB. 1280x960 - viewed 35 times.)

43: Set the lower tab in its correct position and mark the location of the buffer latch stud along with an arrow pointing forward. The tabs are too long and will be cut to the correct size after they are welded in.



 Pic 47.JPG (539.63 KB. 1280x960 - viewed 18 times.)

44: Drill a $\frac{1}{4}$ hole for the latch stud. I also put a $\frac{3}{8}$ counter bore on the inside for a better weld. Also mark the tab to show that the flat side of the stud goes on the right side of the receiver.



 Pic 48.JPG (420.19 KB. 1280x960 - viewed 18 times.)

45: Weld the stud to the tab and grind the weld flush.



 Pic 49.JPG (423.4 KB. 1280x960 - viewed 11 times.)

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Re: MG-42 step by step build with BRP



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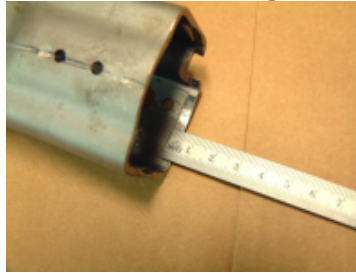
receiver

« Reply #12 on: January 23, 2010, 07:21:54 AM »



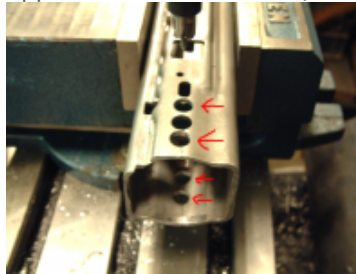
Quote

46: Measure distance from the outside of the receiver to the inside rear machined groove. 46E



 Pic 50.JPG (482.13 KB. 1280x960 - viewed 14 times.)

47: Drill out the two lower buffer tab rivet holes and the two upper ones also with a 3/8 drill bit.



 Pic 51.JPG (473.63 KB. 1280x960 - viewed 16 times.)

48: Clamp in the lower tab and weld. MAKE SURE you are flush with the machined groove.



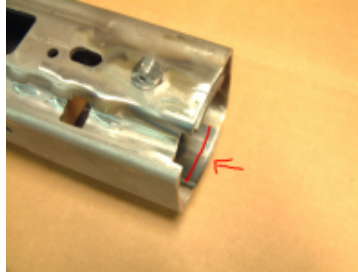
 Pic 52.JPG (368.67 KB. 1280x960 - viewed 16 times.)

49: Clamp in the upper tab and weld. Again make sure you are flush with the machined groove. Grind all welds flush.



 Pic 53.JPG (491.61 KB. 1280x960 - viewed 14 times.)

50: Measure in 46E from the outside of the receiver and mark the tabs to be cut.



Pic 54.JPG (402.73 KB. 1280x960 - viewed 20 times.)

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Re: MG-42 step by step build with BRP receiver

« Reply #13 on: January 23, 2010, 07:30:49 AM »



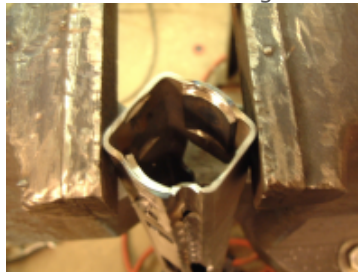
Quote

51: Cut tabs with a small cut off wheel.



Pic 55.JPG (330.91 KB. 1280x960 - viewed 18 times.)

52: Install the buffer assy. If it is hard to slide in, check to see if the walls are square. If not put receiver into a vice and adjust. The buffer should slide in easily. When you turn the buffer and it is hard to turn. Check to make sure the tabs are not in the machined groove area.



Pic 56.JPG (512.09 KB. 1280x960 - viewed 18 times.)

53: Mill a 3/16 hole 6 mm deep 10mm from the back of the receiver for the buffer latch spring.



Pic 57.JPG (457.37 KB. 1280x960 - viewed 15 times.)

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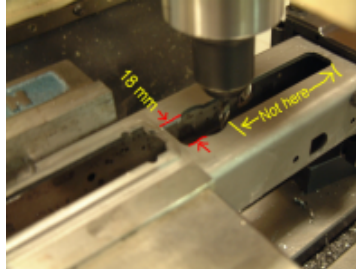


Re: MG-42 step by step build with BRP receiver

« Reply #14 on: January 23, 2010, 07:47:00 AM »

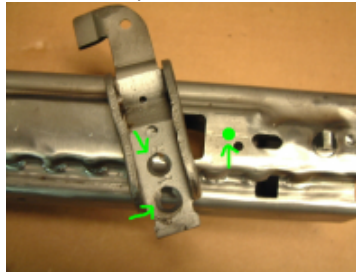
**Quote**

54: Machine this area only so the opening is 18mm wide for the trigger housing.



Pic 58.JPG (456.1 KB. 1280x960 - viewed 21 times.)

55: Drill 3/8 holes in these three areas.



Pic 59.JPG (482.8 KB. 1280x960 - viewed 23 times.)

56: Cut one large recessed rivet to the same thickness as the trigger bracket/recoup stop.



Pic 60.JPG (341.97 KB. 1280x960 - viewed 12 times.)

57: Cut your recoup to match the top one.



Pic 61.JPG (379.79 KB. 1280x960 - viewed 35 times.)

58: This is the correct orientation for the front recoup bolt.



 Pic 62.JPG (345.04 KB, 1280x960 - viewed 26 times.)

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Author

Topic: MG-42 step by step build with BRP receiver (Read 915 times)

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oakrodent
Guild Family
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Posts: 128



Re: MG-42 step by step build with BRP receiver

« Reply #15 on: January 23, 2010, 08:02:28 AM »



Quote

59: You need to drill out the front recoup hole with a 7/32 drill bit. Then install the recoup. Make sure the recoup is turned down so the tabs are down against the receiver.



Pic 63.JPG (369.11 KB. 1280x960 - viewed 24 times.)

60: Install trigger bracket/recoup stop



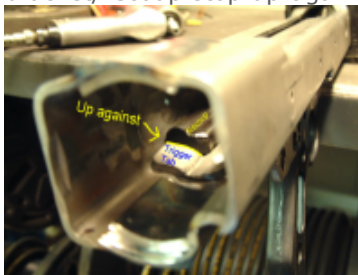
Pic 64.JPG (466.98 KB. 1280x960 - viewed 19 times.)

61: Install trigger housing.



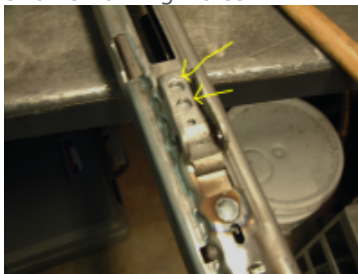
Pic 65.JPG (526.69 KB. 1280x960 - viewed 26 times.)

62: Pin the trigger housing to the bracket and push the trigger bracket/recoup stop up against the back of the recoup.



Pic 66.JPG (509.56 KB. 1280x960 - viewed 20 times.)

63: Install the cut recessed rivet into the bracket and weld the bracket to the receiver. After you weld the rear bracket rivet hole, you will have to remove the trigger housing to weld the two remaining holes.



Pic 67.JPG (418.57 KB. 1280x960 - viewed 22 times.)

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oakrodent

Guild Family Member



Posts: 128



Re: MG-42 step by step build with BRP receiver

« Reply #16 on: January 23, 2010, 08:07:49 AM »



Quote

64: Grind down all the weld. Drill out the rear recoup bolt hole with a 7/32 drill bit. Install rear recoup bolt and tighten nut.



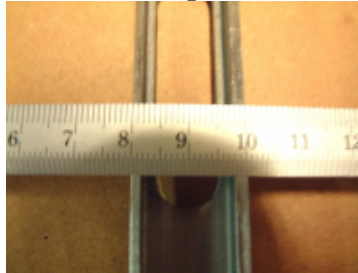
Pic 68.JPG (490.76 KB. 1280x960 - viewed 17 times.)

65: Cut 15 small rivets to the same thickness as the rail. I use an old piece of rail.



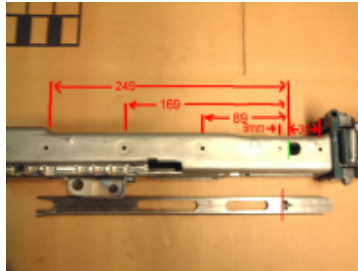
 Pic 69.JPG (418.52 KB. 1280x960 - viewed 21 times.)

66: Left and right rails are not the same. The left rail has one thinner rail. One is 2mm and the other is 3.5mm. Both rails on the right side are 3.5mm. You can use 2 left rails. Mark your rails left and right.



 Pic 70.JPG (487.4 KB. 1280x960 - viewed 15 times.)

67: Lay out your holes for your rails. They should be on the rails center line. When marking out your holes, you want the rails stops tight against the receiver. Use a 5/32 drill bit for the holes.



 Pic 71.JPG (493.73 KB. 1280x960 - viewed 31 times.)

68: I made a simple way to hold the rivets tight in the rails so the rails can be welded tight against the receiver. Make sure you cut it so it can push on the rivet and has clearance for the middle bolt tabs. I used two 3/8-16 x 3/4 bolts, one 3/8-16 nut, and one 3/8-16 coupler nut.



Pic 72.JPG (452.45 KB. 1280x960 - viewed 23 times.)

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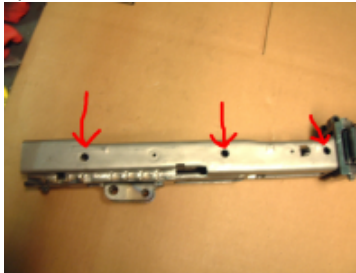
Re: MG-42 step by step build with BRP receiver

« **Reply #17** on: January 23, 2010, 08:12:30 AM »



Quote

69: Drill out these 3 holes on both sides of the receiver with a 3/8 drill bit.



Pic 73.JPG (431.69 KB. 1280x960 - viewed 23 times.)

70: Install rails using four 6-32 x 1" bolts with nuts. MAKE sure the rails are centered on the trunnion.



Pic 74.JPG (507.25 KB. 1280x960 - viewed 23 times.)

71: Install 1 set of rivets. Use the spreader to push them tight against the receiver.



Pic 75.JPG (445.77 KB. 1280x960 - viewed 18 times.)

72: Weld in the rails when you installed the rivets. Continue steps 71 and 72 until all 3 holes are done.



Pic 76.JPG (460.49 KB. 1280x960 - viewed 21 times.)

73: Remove the 4 bolts. Drill out the receiver with a 3/8 hole saw. Do not damage the rail. Use steps 71 and 72 to finish the rail rivet holes. Grind all weld flush when finished.



Pic 77.JPG (454.55 KB. 1280x960 - viewed 26 times.)

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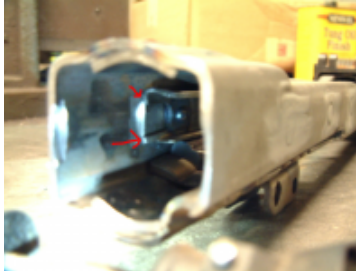


Re: MG-42 step by step build with BRP receiver

« **Reply #18 on:** January 23, 2010, 08:14:57 AM »

Quote

74: Check the rear of both rails to see if they extend into the front buffer lock groove. If they are, cut them back out of this area.



Pic 78.JPG (446.65 KB. 1280x960 - viewed 25 times.)

75: Test fit the bolt head in the rails. It should move freely back and forth. If it doesn't you have to correct this. I have a bolt head I accidently dropped awhile ago and broke off on of its tabs. I use this and a brass drift to adjust the rails. Hit the bolt more from the bottom and less from the top.



Pic 79.JPG (404.52 KB. 1280x960 - viewed 17 times.)

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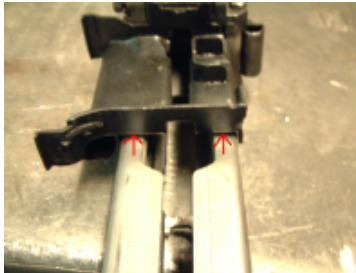
Re: MG-42 step by step build with BRP receiver

« Reply #19 on: January 23, 2010, 08:18:40 AM »



Quote

76: Pin on the feed tray. It has to sit flat on the top of the receiver.



Pic 80.JPG (437.5 KB. 1280x960 - viewed 18 times.)

77: This is the area that needs to be machined to get the feed tray down flat.



Pic 81.JPG (450.43 KB. 1280x960 - viewed 19 times.)

78: I use a mill for this task. You can also use a grinder or a sanding disk.



Pic 82.JPG (497.42 KB. 1280x960 - viewed 21 times.)

79: Install the feed cover latch and install the feed cover on the receiver. Feed cover should latch nicely.



 Pic 83.JPG (447.42 KB. 1280x960 - viewed 35 times.)

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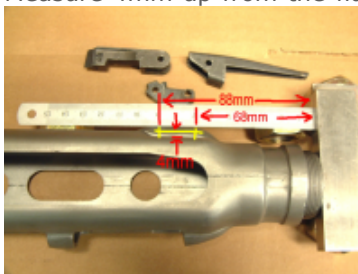
Re: MG-42 step by step build with BRP receiver

« **Reply #20 on:** January 26, 2010, 04:43:46 PM »



Quote

80: Lay out your holes for the front sight assy on both sides of the receiver. Measure from the front of the receiver bushing back. The flash hider lock hole is 68mm and the sight is 88mm. Measure 4mm up from the flat area.



 Pic 84.JPG (482.76 KB. 1280x960 - viewed 28 times.)

81: Use a 5/32 mill to drill these holes. A drill bit will walk too much to get things straight. Lay out and set up is very important for this step.



 Pic 85.JPG (481.04 KB. 1280x960 - viewed 17 times.)

82: Mark out the slot for the sight assy. It is 13mm wide. Mill out this area.



Pic 86.JPG (457.06 KB. 1280x960 - viewed 10 times.)

83: When milling out the slot, mill it even with these two areas. They are not on the same level. The flash hider lock is lower.



Pic 87.JPG (466.61 KB. 1280x960 - viewed 10 times.)

84: Make sure the slot is only slightly wider than the sight assy. Don't remove too much material.



Pic 88.JPG (455.75 KB. 1280x960 - viewed 10 times.)

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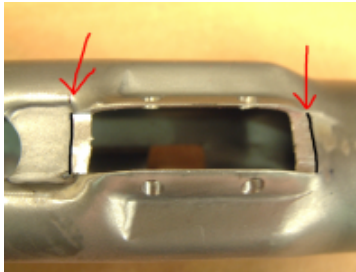


Re: MG-42 step by step build with BRP receiver

« **Reply #21 on:** January 26, 2010, 05:02:17 PM »

 **Quote**

85: Mark out the two mill lines.



Pic 89.JPG (448.66 KB. 1280x960 - viewed 9 times.)

86: Using a cut off wheel open up the slot to the lines you

marked.



 Pic 90.JPG (463.57 KB. 1280x960 - viewed 10 times.)

87: You want a nice bevel, not a flat edge.



 Pic 91.JPG (384.38 KB. 1280x960 - viewed 14 times.)

88: Test fit your flash hider lock bar. I use a 5/32 drill bit. Lift the bar up and measure to the front receiver bushing. You should have 20mm



 Pic 92.JPG (482.24 KB. 1280x960 - viewed 14 times.)

89: If your lock does not lift to the correct measurement. Remove some material from this area.



 Pic 93.JPG (432.45 KB. 1280x960 - viewed 11 times.)

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Re: MG-42 step by step build with BRP receiver

« **Reply #22 on:** January 26, 2010, 05:05:14 PM »



Quote



Posts: 128



90: Cut 2 old pins to 13mm for assembling the front sight assy.



 Pic 94.JPG (469.82 KB. 1280x960 - viewed 16 times.)

91: Assemble the sight assy using the short pins. First I clamp the block in a vice to install the front sight.



 Pic 95.JPG (518.12 KB. 1280x960 - viewed 15 times.)

92: Install the assembled sight assy into the receiver. Drive the short pins out with the correct long pins. Watch your alignment with your holes.



 Pic 96.JPG (466.41 KB. 1280x960 - viewed 15 times.)

93: Mushroom the ends of the pins. I use a lady finger up against a vice on one side while I hit the other. Don't go crazy. These pins will have to be removed to prep the MG for bluing after the test firing.



 Pic 97.JPG (480.27 KB. 1280x960 - viewed 15 times.)

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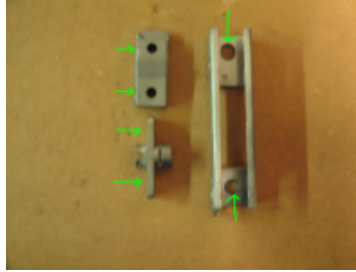
Posts: 128

**Re: MG-42 step by step build with BRP receiver**

« Reply #23 on: January 26, 2010, 05:08:58 PM »

**Quote**

94: Drill out these rivet holes with a 3/8 drill bit.



 Pic 98.JPG (500.76 KB. 1280x960 - viewed 10 times.)

95: Install the front AA sight bracket. Insert 2 of the small cut rivets from the inside. Weld the bracket on and grind flush.



 Pic 99.JPG (484.84 KB. 1280x960 - viewed 9 times.)

96: Cut the heads off of 8 large rivets and 12 small rivets. Grind the bottom of the heads smooth.



 Pic 99a.JPG (490 KB. 1280x960 - viewed 10 times.)

97: Now you will set up the receiver to mill the rivet tooling indents. You will need two different mills. A 3/8 mill and either a 7/16 or a 1/2 mill. I have seen both. I like the 1/2 .



 Pic 99b.JPG (459.15 KB. 1280x960 - viewed 26 times.)

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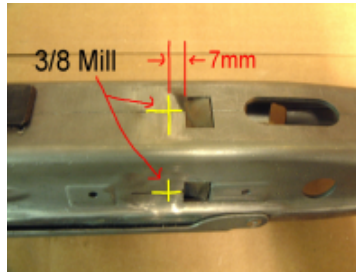
Posts: 128

**Re: MG-42 step by step build with BRP receiver**« **Reply #24 on:** January 26, 2010, 06:23:41 PM »**Quote**

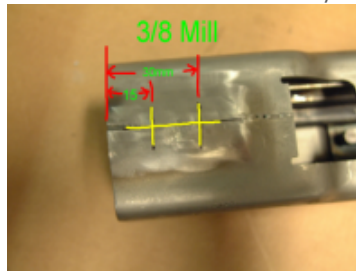
98: Start with the front AA bracket. The holes are 28mm apart. Use a 3/8 mill and only slightly mill it. Less than .5mm

 Pic 99c.JPG (449.72 KB. 1280x960 - viewed 13 times.)

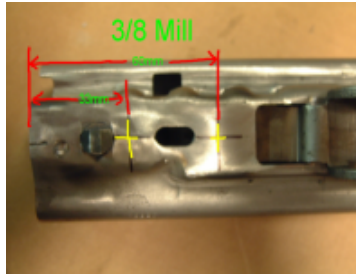
99: Next do only the top and left side of the front barrel stop. Measure back 7mm from the cut outs. Center it with the cut outs.

 Pic 99d.JPG (513.13 KB. 1280x960 - viewed 14 times.)

100: Next is the top buffer tabs. Measure 13mm and 30mm from the back of the receiver. Center the holes on the top of the receiver. Mill with a 3/8 mill.

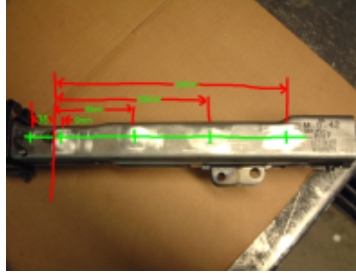
 Pic 100.JPG (378.49 KB. 1280x960 - viewed 10 times.)

101: Next is the lower buffer tab and recoup stop. Measure 33mm and 60mm from the back of the receiver. Center the holes on the bottom of the receiver. Mill with a 3/8 mill.



Pic 101.JPG (412.03 KB. 1280x960 - viewed 13 times.)

102: Measure out and mill the left and right rails. Use ether a 7/16 or 1/2 mill.



Pic 102.JPG (489.25 KB. 1280x960 - viewed 25 times.)

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Posts: 128



Re: MG-42 step by step build with BRP receiver

« **Reply #25 on:** February 09, 2010, 02:07:33 PM »



Quote

103 - I use a Magna-Spot stud welder for attaching the rivet heads. Any auto body shop will have one. Make sure the brass parts are clean so you have a good ground on your receiver and the rivet head.



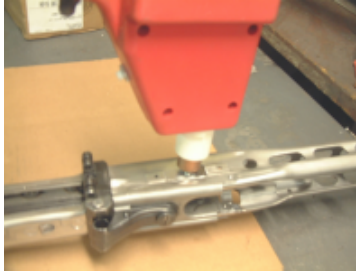
Pic 103.JPG (495.57 KB. 1280x960 - viewed 12 times.)

104 - Only install 3 rivet heads now. 1 large rivet head on the top of the receiver for the front barrel stop. 2 small rivet heads for the right rear rail.



 Pic 104.JPG (428.95 KB. 1280x960 - viewed 22 times.)

105 - Place rivet head in the middle of the tool mark. Put the stud gun over the top. Press down on the rivet gun until the outer ground is against the receiver. Push the button 3 times for 2 sec each time. After the rivet cools take a pair of pliers to make sure the head is securely welded. Install the other two rivets using this step.



 Pic 105.JPG (351.53 KB. 1280x960 - viewed 21 times.)

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Re: MG-42 step by step build with BRP receiver

« **Reply #26 on:** February 09, 2010, 02:09:47 PM »



Quote

106 - Place the lug on the bottom of the receiver over the front barrel stop. Place one cut rivet on the inside and weld the lug to the receiver. Grind welds flush.



 Pic 106.JPG (456.6 KB. 1280x960 - viewed 15 times.)

107 - Align the rear sight bracket on the receiver. Make sure the bracket is straight. Place 2 cut rivets on the inside and weld the sight bracket to the receiver. Mill the welds flush.



 Pic 107.JPG (478.25 KB. 1280x960 - viewed 12 times.)

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Re: MG-42 step by step build with BRP receiver



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receiver

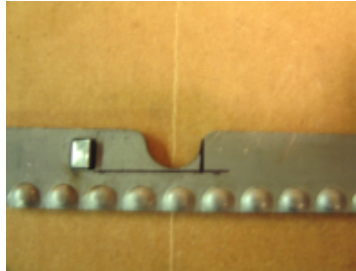
« Reply #27 on: February 09, 2010, 02:14:05 PM »



Quote

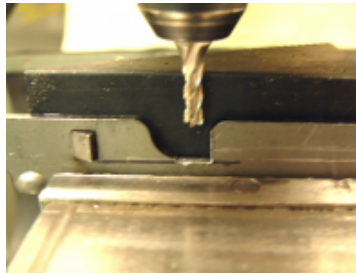
Steps 108 – 118 are for a bolt hold open lock. It is not original to the MG42. You can omit these steps if you like. I don't like to smash my fingers.

108 - Mark a line 12mm down. Then draw a vertical line to square up the round rivet cutout.



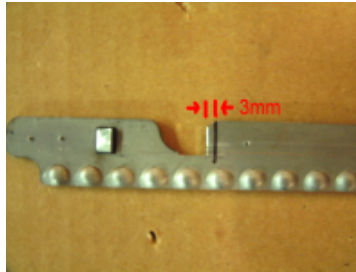
Pic 108.JPG (517.25 KB. 1280x960 - viewed 9 times.)

109 - Mill out the area.



Pic 109.JPG (484.36 KB. 1280x960 - viewed 10 times.)

110 - Mark a vertical line 3mm in from the cut.



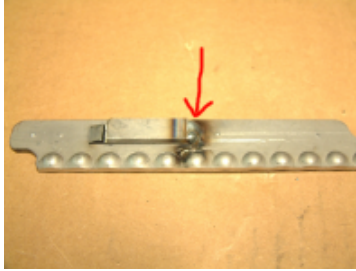
Pic 110.JPG (531.63 KB. 1280x960 - viewed 11 times.)

111 - Use a 1/8 x 3/8 key stock for steps 113 and 115



Pic 111.JPG (383.85 KB. 1280x960 - viewed 8 times.)

112 - Line up the key stock with the vertical line you marked on step 110 and with the horizontal line you machined out. Weld the front to the ratchet plate only.



 Pic 112.JPG (441.93 KB. 1280x960 - viewed 11 times.)

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Re: MG-42 step by step build with BRP receiver

« **Reply #28 on:** February 09, 2010, 03:38:36 PM »



Quote

113 - Cut the key stock flush with the notch you milled.



 Pic 113.JPG (434.07 KB. 1280x960 - viewed 12 times.)

114 - Grind the weld into a smooth ramp



 Pic 114.JPG (303.65 KB. 1280x960 - viewed 10 times.)

115 - Grind a bevel on one end of key stock.



 Pic 115.JPG (433.52 KB. 1280x960 - viewed 8 times.)

116 - Weld the beveled key stock onto the charging handle lock assy. Only weld the top and sides. Do not weld the bottom.



 Pic 116.JPG (433.09 KB. 1280x960 - viewed 9 times.)

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 **Re: MG-42 step by step build with BRP receiver**

« [Reply #29 on: February 09, 2010, 03:42:12 PM](#) »

 **Quote**

117 - Cut key stock flush with the bottom of the lock assy.



 Pic 117.JPG (410.26 KB. 1280x960 - viewed 12 times.)

118 - Grind Weld smooth.



 Pic 118.JPG (374.1 KB. 1280x960 - viewed 11 times.)

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December 10, 2010,
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Author

Topic: MG-42 step by step build with BRP receiver (Read 915 times)

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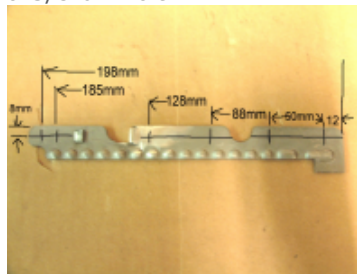
Re: MG-42 step by step build with BRP receiver

« Reply #30 on: February 09, 2010, 03:49:01 PM »



Quote

119 - Lay out the holes on the ratchet plate. Drill them out with a 3/8 drill bit.



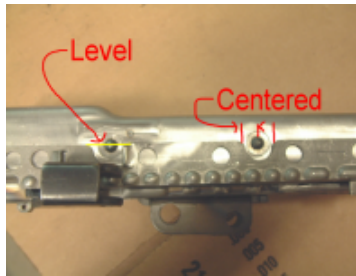
Pic 119.JPG (508.36 KB. 1280x960 - viewed 24 times.)

120 - 1-Bend the stop tab up until it looks like this. It can always be bend back down later if it is too far up.



Pic 120.JPG (292.89 KB. 1280x960 - viewed 13 times.)

121 - Install the disassembled charging handle into the receiver. Align the ratchet plate. The rivets should be centered in the cut outs and the center of the rivet should be almost level with the top of the ratchet plate.



Pic 121.JPG (369.41 KB. 1280x960 - viewed 22 times.)

122 - 1-Move the charging handle to the rear of the ratchet plate. Tack weld the ratchet plate to the receiver. Only put one tack weld in the second hole from the rear.



Pic 122.JPG (467.18 KB. 1280x960 - viewed 20 times.)

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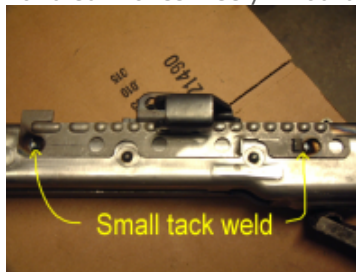
Re: MG-42 step by step build with BRP receiver

« Reply #31 on: February 09, 2010, 03:54:11 PM »



Quote

123 - Move the charging handle all the way forward. Weld a small tack in the first hole. After welding ensure charging handled moves freely. You don't want it to tight or too lose.



Pic 123.JPG (524.15 KB. 1280x960 - viewed 21 times.)

124 - Weld all the holes. You want to have nice welds. These welds do not get ground smooth. After welding check to make sure the charging handle still moves freely.



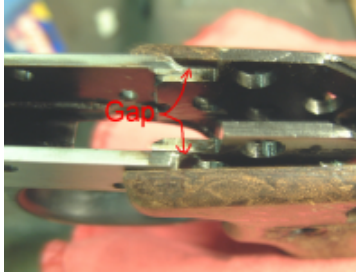
 Pic 124.JPG (344.79 KB. 1280x960 - viewed 23 times.)

125 - Lay out the trigger parts. If your trigger assy is still assembled you do not need to disassemble.



 Pic 125.JPG (460.97 KB. 1280x960 - viewed 23 times.)

126 - Hold the grips up against the trigger housing. Mark the grips where you need to mill them.



 Pic 126.JPG (434.75 KB. 1280x960 - viewed 20 times.)

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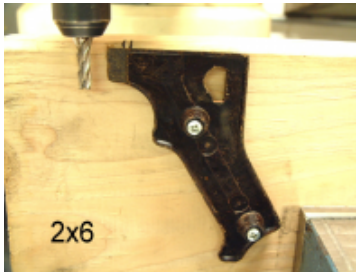
Re: MG-42 step by step build with BRP receiver

« **Reply #32 on:** February 09, 2010, 03:59:21 PM »



Quote

127 - I screw the grip s down to a 2x6 to mill them. Mill it very carefully. I trial fit the trigger housing to check the cut. Do not remove to much. I use a ¼ mill



 Pic 127.JPG (491.46 KB. 1280x960 - viewed 15 times.)

128 - You should have a nice fit when you are finished.



Pic 128.JPG (349.67 KB. 1280x960 - viewed 20 times.)

129 - Assemble the trigger pack



Pic 129.JPG (568.61 KB. 1280x960 - viewed 22 times.)

130 - Move the charging handle all the way forward and install the trigger pack. The hammer must be down.



Pic 130.JPG (370.44 KB. 1280x960 - viewed 25 times.)

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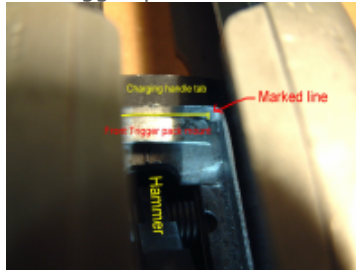
Re: MG-42 step by step build with BRP receiver

« **Reply #33 on:** February 10, 2010, 10:39:42 AM »



Quote

131 - Move the charging handle all the way forward and install the trigger pack. The hammer must be down.



Pic 131.JPG (462.4 KB. 1280x960 - viewed 19 times.)

132 - Carefully release the hammer. Don't let it slam. Hold you

finger on it. Mark where the hammer is on the charging handle.



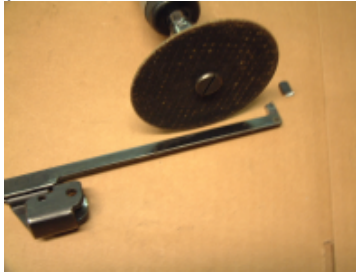
Pic 132.JPG (468.56 KB. 1280x960 - viewed 22 times.)

133 - Remove the trigger pack and charging handle. You must re cock the hammer to remove the trigger pack.



Pic 133.JPG (458.47 KB. 1280x960 - viewed 14 times.)

134 - Cut off the charging handle bolt tab at the hammer mark you made.



Pic 134.JPG (544.11 KB. 1280x960 - viewed 24 times.)

135 - Mill a notch in the charging handle bolt tab for the trigger pack mount clearance.



Pic 135.JPG (455.76 KB. 1280x960 - viewed 16 times.)

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Re: MG-42 step by step build with BRP receiver

« **Reply #34 on:** February 16, 2010, 03:58:09 PM »



Quote



Posts: 128



136 - Assemble the charging handle. Don't forget the button on the end if you removed it. This is the correct orientation of the spring in the lock bar.



Pic 136.JPG (310.57 KB. 1280x960 - viewed 15 times.)

137 - Install the charging handle then the trigger pack. Check the clearance between the charging handle tab and front trigger mount and also the hammer.



Pic 137.JPG (433.61 KB. 1280x960 - viewed 21 times.)

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Posts: 128



Re: MG-42 step by step build with BRP receiver

« **Reply #35 on:** February 16, 2010, 04:01:15 PM »



Quote

138 - Remove the trigger pack. Push the charging handle all the way forward. Measure the distance from the charging handle bolt tab to the front of the ejection port. (138F) Mine is 8mm



Pic 138.JPG (551.92 KB. 1280x960 - viewed 10 times.)

139 - Measure the distance between the front of the charging handle push off bar and the ratchet plate. (139G) Mine is 5mm. Subtract 138F - 139G = (139H) Mine is 8mm - 5mm = 3mm. This is the how much needs to be cut off of the ratchet plate. Measure in 139H on the ratchet plate and mark it. Now measure from that mark to the front of the ratchet plate. (139I) Mine is 17mm. Cut a piece of Key Stock to the length of 139I (same key stock that was used in step 111)



Pic 139.JPG (487.63 KB. 1280x960 - viewed 9 times.)

140 - Slide the charging handle back until it is 10mm from the back of the receiver.



Pic 140.JPG (457.32 KB. 1280x960 - viewed 8 times.)

141 - The end of the charging handle if exposed in the receiver cut out. A small piece of metal will be welded in to fill this area to prevent the charging handle from jumping out.



Pic 141.JPG (446.34 KB. 1280x960 - viewed 18 times.)

142 - Measure this distance (142J) Mine is 6mm



Pic 142.JPG (392.81 KB. 1280x960 - viewed 11 times.)

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Re: MG-42 step by step build with BRP receiver

« **Reply #36 on:** February 16, 2010, 04:03:38 PM »



Quote

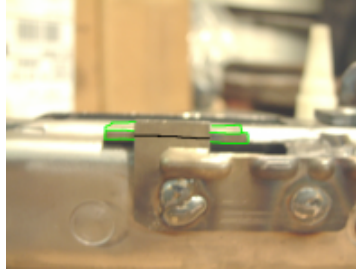


143 - Lay a short section of key stock on the bottom of the receiver next to the ratchet plate tab.



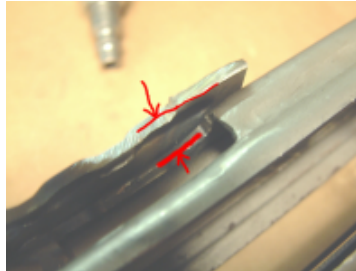
Pic 143.JPG (392.84 KB, 1280x960 - viewed 13 times.)

144 - Now mark the ratchet plate tab $\frac{1}{2}$ way between the thickness of the key stock you placed there. Cut the ratchet plate tab off at this mark and the one from step 139



Pic 144.JPG (376.31 KB, 1280x960 - viewed 11 times.)

145 - Measure this distance (145K) Mine is 11mm. Cut a piece of key stock to these measurements: 142J x 145K Mine will be 6mm x 11mm



Pic 145.JPG (389.36 KB, 1280x960 - viewed 10 times.)

146 - Take the piece of key stock from step 139 and mark out a notch 3mm x 142J



Pic 146.JPG (288.48 KB, 1280x960 - viewed 9 times.)

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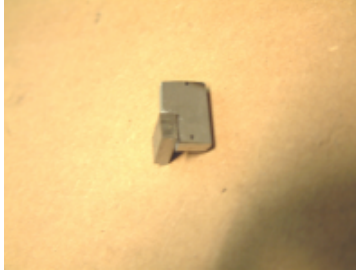
Posts: 128

**Re: MG-42 step by step build with BRP receiver**

« Reply #37 on: February 16, 2010, 04:06:48 PM »

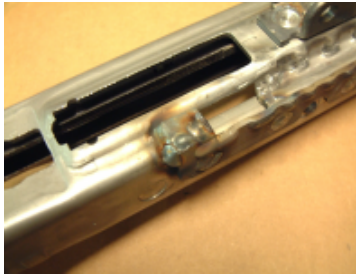
**Quote**

147 - This is the way they get put together.



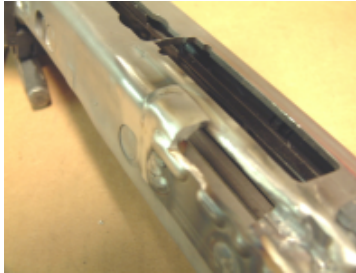
Pic 147.JPG (343.62 KB. 1280x960 - viewed 10 times.)

148 - Install these 2 pieces into the receiver and weld. Do not weld the side closest to the trigger pack cutout.



Pic 148.JPG (472.54 KB. 1280x960 - viewed 17 times.)

149 - Grind welds smooth. Don't grind the weld on the front.



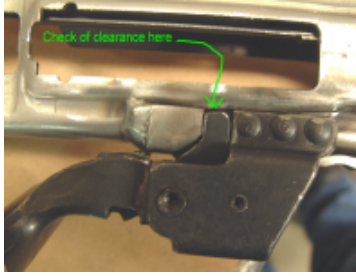
Pic 149.JPG (402.33 KB. 1280x960 - viewed 13 times.)

150 - Install charging handle and push it all the way forward. Mark the area where the push bar hits the new receiver/ratchet plate area.



Pic 150.JPG (423.32 KB. 1280x960 - viewed 12 times.)

151 - Grind out the marked out area. Reinstall the charging handle.



Pic 151.JPG (488.8 KB. 1280x960 - viewed 16 times.)

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oakrodent
Guild Family
Member



Posts: 128



Re: MG-42 step by step build with BRP receiver

« **Reply #38 on:** February 16, 2010, 04:10:07 PM »



Quote

152 - Check the charging handle stow lock. You may need to mill the front of the ratchet plate back to get it to lock properly. Check the clearance between the charging handle push off bar and the receiver. You may need to cut the push off bar down.



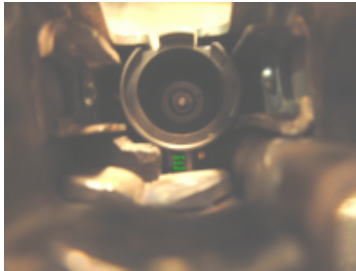
Pic 152.JPG (442.03 KB. 1280x960 - viewed 12 times.)

153 - Assemble the bolt assy. Install the bolt in the receiver.



Pic 153.JPG (321.03 KB. 1280x960 - viewed 19 times.)

154 - Mark the semi auto receiver block where the rear of the bolt hits it.



Pic 154.JPG (441.49 KB. 1280x960 - viewed 18 times.)

155 - Mill the semi auto receiver block. Remove as little as possible.



 Pic 155.JPG (454.29 KB. 1280x960 - viewed 18 times.)

156 - Reinstall the bolt and check the fit of the charging handle tab on the bolt tab



 Pic 156.JPG (321.74 KB. 1280x960 - viewed 13 times.)

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oakrodent
Guild Family
Member



Posts: 128



 **Re: MG-42 step by step build with BRP receiver**

« **Reply #39 on:** February 16, 2010, 04:27:39 PM »

 **Quote**

157 - Install the barrel, trigger pack, recoil spring, and buffer assy.



 Pic 157.JPG (379.49 KB. 1280x960 - viewed 23 times.)

158 - Watch the rear of the bolt as you pull the trigger. Either you should see the bolt move back or the hammer will hang up.



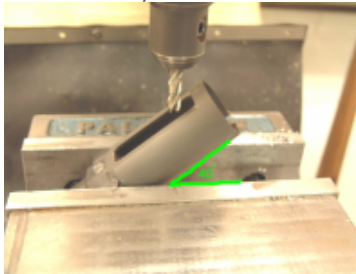
 Pic 158.JPG (410.64 KB. 1280x960 - viewed 18 times.)

159 - Remove the bolt and disassemble it. This is the area that needs to be milled. Mark a line 40mm from the back of the bolt.



 Pic 159.JPG (314.21 KB. 1280x960 - viewed 23 times.)

160 - Set up the bolt in the mill at a 40 angle. Mill the bolt up to the line you marked.



 Pic 160.JPG (414.5 KB. 1280x960 - viewed 12 times.)

161 - Your bolt should look like this. Reassemble the bolt and install the bolt, recoil spring, and buffer assy. You will need to depress the hammer to slide the bolt head over it. Check the clearance of the hammer and the back of the bolt by pulling the trigger.



 Pic 161.JPG (346.41 KB. 1280x960 - viewed 31 times.)

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oakrodent
Guild Family
Member



 **Re: MG-42 step by step build with BRP receiver**

« **Reply #40 on:** February 16, 2010, 04:30:47 PM »

 **Quote**

162 - Remove all major parts

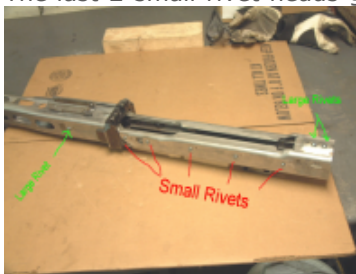


Posts: 128



Pic 162.JPG (428.07 KB. 1280x960 - viewed 19 times.)

163 - Attach all the remaining rivet heads using the stud gun. 3 large rivet heads go on the buffer tabs. 1 large rivet head goes on the recoup stop/ trigger bracket. 1 large rivet head goes on the left front barrel stop. 8 small rivet heads go on the rails. The last 2 small rivet heads go on the front AA sight mount.



Pic 163.JPG (409.43 KB. 1280x960 - viewed 20 times.)

164 - Clean all parts and the receiver. Wipe everything down with an oily rag. The gun is now ready for reassembly and test firing.



Pic 164.JPG (422.18 KB. 1280x960 - viewed 28 times.)

THE END

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oakrodent
Guild Family
Member



Posts: 128



Re: MG-42 step by step build with BRP receiver

« Reply #41 on: April 30, 2010, 03:51:50 AM »

Quote

Can one of you all powerful Moderators make this a sticky and delete this reply.

P.S. there is no butt kissing smilies

Report to moderator Logged

sdk1968Administrator
Senior Guild
Member

Posts: 11235

SDK1968 aka
DUTIGAF**Re: MG-42 step by step build with BRP receiver**

« Reply #42 on: April 30, 2010, 06:26:21 AM »

**Quote**

yes we can... im not "powerful" but my sticky button works.
LMAO

oh and the BIG CHEESE made me do away with the butt kissing
smiley.... we did have that one. 🙄

PS: and congrats on that build instructor badge!

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**SAY WHAT YOU MEAN. MEAN WHAT YOU
SAY!!**

**NO politics or religion = less
problems**

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