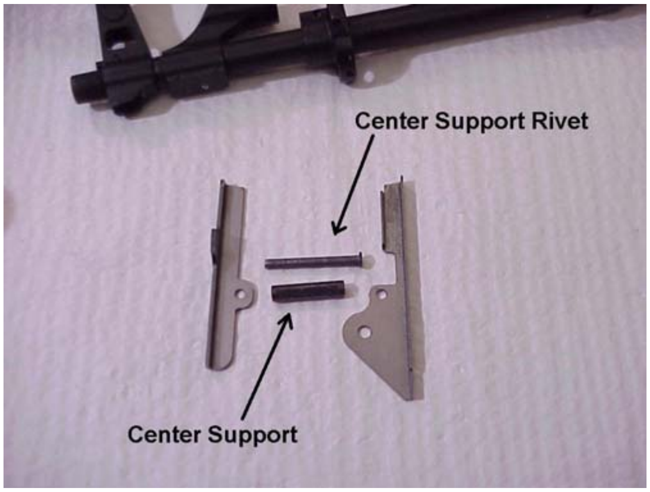
# Center Support Installation
# For
# AK-47 Type Rifles

This tutorial depicts the installation of the center support, which in my builds, is the last item to be accomplished prior to installing the triggerguard which completes the receiver.

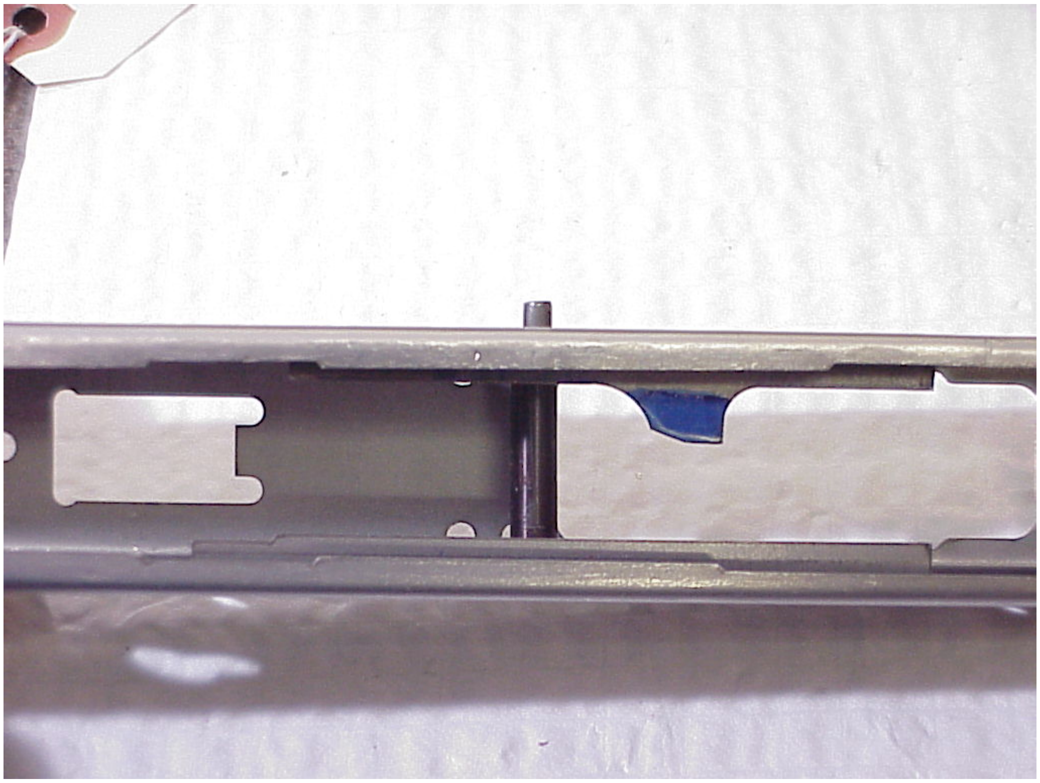
At this point the front trunnion and rear trunnion (tang) have been installed as well as the lower side rails, which have been discussed in previous posts. Prior to accomplishing this task, I have read various posts concerning the collapse of the center support while squeezing the center support rivet. To prevent this from happening ensure that the center support tube you use will withstand the compression of the rivet. I have used K-VAR center supports in all my builds and have had no problems what-so-ever.

Please note that some of the pictures have been staged because taking them during the process was not feasible.

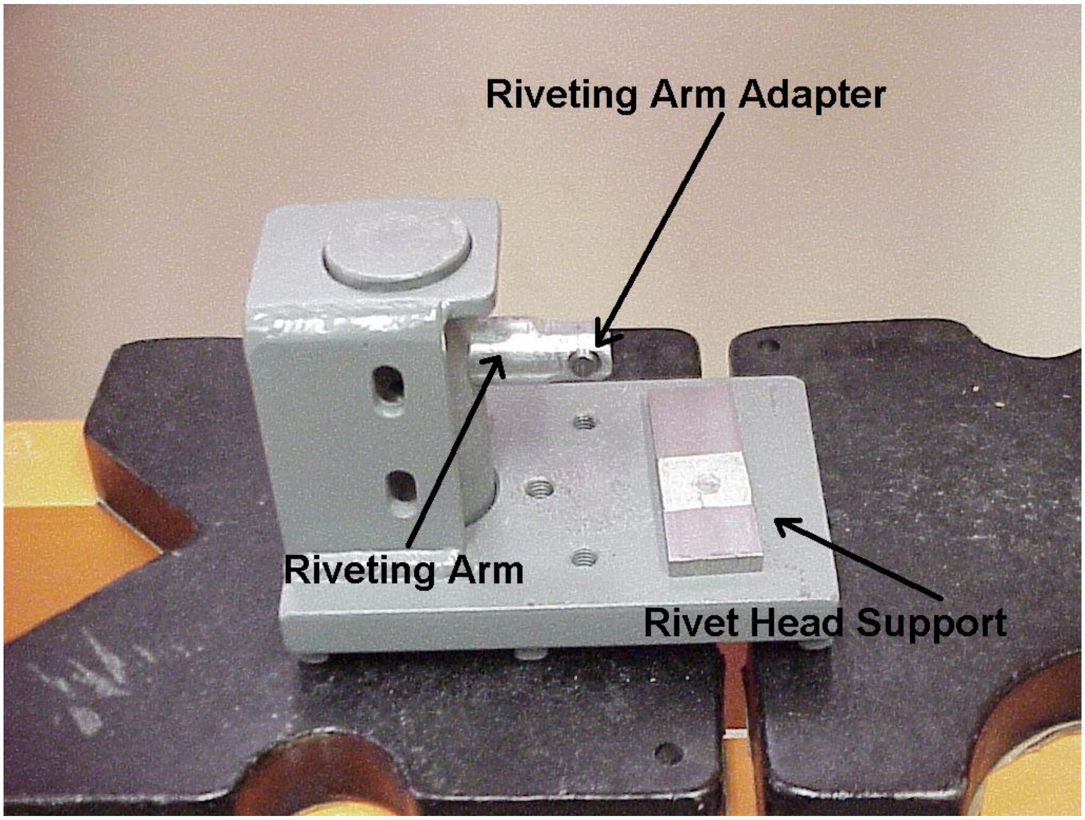
1. The center support is placed between the lower rails to provide rigidity to the center of the receiver and is comprised of the center support tube and rivet.



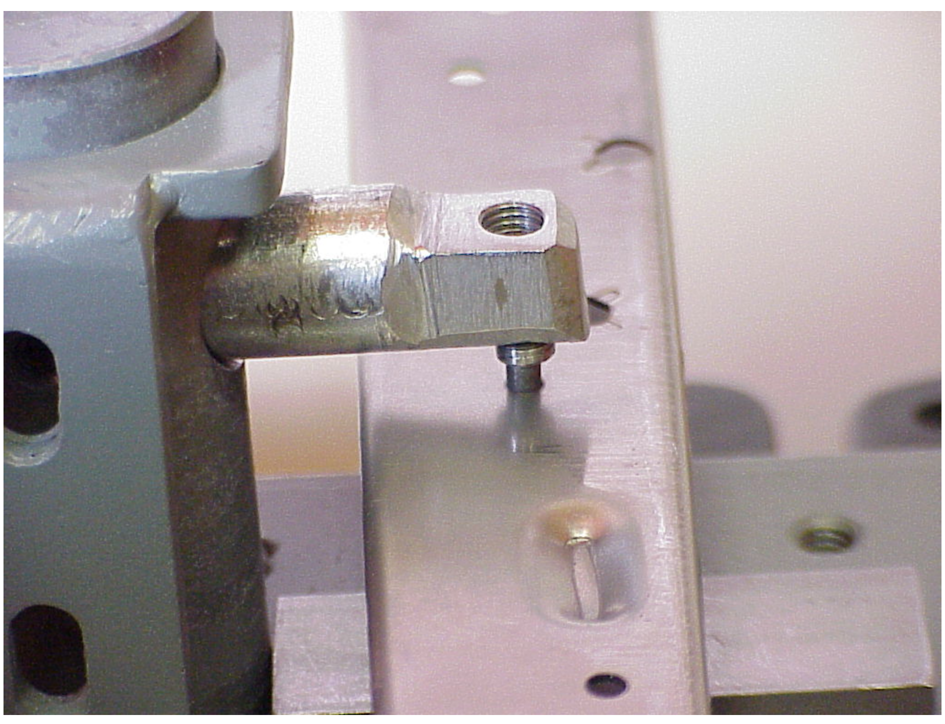

2.  Slide the center support into the receiver and align with the holes in the receiver.  Slide the rivet through the holes in the receiver capturing the center support.  To provide clearance for the selector lever make sure that the factory made semi-flat head is located on the RH side of the receiver.



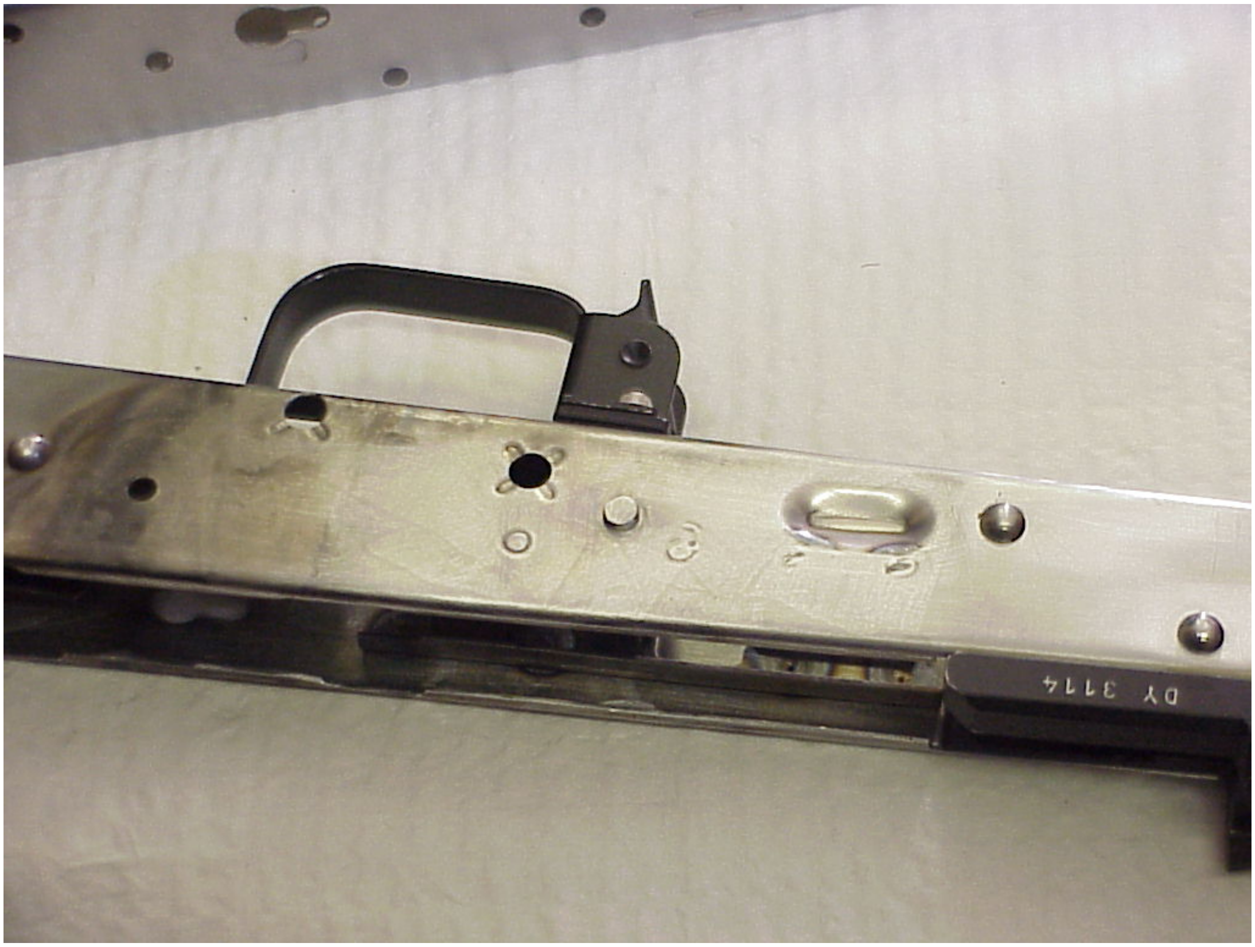
3.  Set-up the riveting jig so that the riveting arm holds a flat riveting adapter.  I made a rivet support to hold the rivet which is a piece of flat stock with a recess cut into it.  Unlike the trunnion rivets the center support is semi-flat which requires the rivet head support to be made accordingly.




4.  To aid in the forming of the rivet, I use a hammer to start the rivet head.  Carefully shaping the rivet until it approximately 1/8" larger.  Some builder's have had success by just using the jig to complete the operation but I have found that the hammer forming makes the job a little easier.  With the rivet inserted as shown in step # 2, place the receiver in position so that the riveting adapter is centered on the rivet shank (the part that will be squeezed).



5.  Apply pressure to the rivet until the rivet head is approximately 7/32” in diameter.  Note that the size of the squeezed head is really up to the builder just as long as the center support is properly held by the rivet.



6.  After obtaining the correct squeeze on the rivet, it may be necessary the dress-up the squeezed rivet head. This can be accomplished by using a small flat file that has a safety edge (which is a file that has a cutting surface on the file flat, not the sides) to remove any blemishes made during the squeezing process.

7.  As a final check, insert the bolt and bolt carrier to ensure that this riveting process has not compressed the receiver and that the carrier assembly moves freely on the upper rails.  If by chance the receiver has been compressed, removal of the rivet and center support may be necessary and this task re-accomplished.  I have found that at times, you can eliminate this problem by sanding the upper rails until smooth movement of the carrier is obtained.