WARNING

Conversio

Ruger Mini-14

Full Auto
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Introduction
2. OPERATING SEQUENCE - FULL AUTOMATIC

1. Ensure magazine is loaded with cartridges.
2. Hammer cocked, engaged with trigger.
3. Sear engaged with trigger, ready for firing.
4. To fire, simply pull the trigger.
5. The trigger is depressed, releasing hammer.
6. The sear is engaged, transferring energy to the firing pin and discharging the bullet.
7. The sear is released, and the hammer returns to its original position.
8. The magazine is loaded, and the cycle begins again.

Blueprint Index
C. Pushing Triping Lever
B. Triping Lever
A. Screw-Pivot, Triping Lever

4. Parts To Be Manipulated
D. Sticker
C. Secondary Seater
B. Slide
A. Receiver

3. Parts To Manipulate
To depress the trigger to resume automatic fire.

2. The trigger is pressed allowing the hammer to drop.

1. The hammer is dropped to fire another cartridge.

- The bolt and breech are closed.
- The slide is moved forward to close the breech.
One of the contributing factors to its popularity is its reasonable cost. The M14 is attractive for special tactical and general application.

Beginning in 1972, many law enforcement agencies and some governments are choosing the M14. The M14 has become very popular since the early 1980s when cost-cutting measures were implemented.

The military M14 rifle.

Modern M14s have had a more minor changes from the M14 external. The internal parts of the M14 external were internal modifications. Some major changes from the M14. The M14 also took its basic mechanical.

The magazine is also available in 20, 30, 40, and 50-round magazines. A 7.62mm caliber is compatible with semi-automatic and automatic ammunition. The 7.62mm caliber is very popular semi-automatic rifles operated on the gas system.

Specifications

General Description and Mode of Operation — Semi-Automatic
3. With the trigger having been moved forward.

4. (See diagram #1)

5. $13,000 to $15,000 for the parts to convert $20,000 into $25,000 for the stainless and make it a high end piece. $25,000 for a total that is in the $50,000 to $75,000 range to the appendix for the stainless.
HAMMER COCKED, ENGAGED WITH TRIGGER SEAR.
SECONDARY SEAR IS NOT ENGAGED.
* NOTE: BOLT & SLIDE NOT SHOWN
TRIGGER IS DEPRESSED. HAMMER IS RELEASED AS TRIGGER SEAR AND SECONDARY SEAR ROTATE FORWARD SLIGHTLY.

TRIGGER STILL DEPRESSED: RECOILING BOLT FORCED HAMMER REARWARD TO ENGAGE SECONDARY SEAR. TRIGGER SEAR IS STILL FORWARD.
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2. TRIGGER HAS BEEN RELEASED, SECONDARY SEAR ENGAGES WITH TRIGGER SEAR AS SECONDARY SEAR DISENGAGES FROM HAMMER.

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ROTATION

2. TRIGGER HAS BEEN RELEASED, SECONDARY SEAR ENGAGES WITH TRIGGER SEAR AS SECONDARY SEAR DISENGAGES FROM HAMMER.

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1. TRIGGER IS DEPRESSED—TRIGGER SEAR DISENGAGES FROM HAMMER.
2. HAMMER ROTATES FORWARD TO STRIKE BOLT. (NOT SHOWN)
3. SLIDE IS STILL FORWARD, ENGAGED WITH TRIPPING LEVER. SECONDARY SEAR REMAINS REARWARD WHILE SLIDE IS FORWARD.

DRWG. NO. 2-B
OP. SEQ.—FULL AUTO

1. TRIGGER IS STILL DEPRESSED—TRIGGER SEAR STILL FORWARD.
2. SLIDE AND BOLT ARE IN FULL RECOIL. AS THE SLIDE MOVED REARWARD, THE CONTACT BETWEEN THE SLIDE & TRIPPING LEVER CEASED. SPRING PRESSURE ON THE SEC. SEAR MOVED IT FORWARD WHERE IT THEN ENGAGES & HOLDS THE HAMMER BACK. THE DISCONNECTOR ASS'Y MOVED FORWARD WITH THE SEC. SEAR, CAUSING THE TRIP. LEVER TO PIVOT ON PIVOT SCREW. TOP OF TRIP. LEVER MOVES REARWARD.

DRWG. NO. 2-C
OP. SEQ.—FULL AUTO
1. Trigger is still depressed. Trigger sear still forward.
2. Forward movement of the slide pivoted top of trip. Lever forward as contact was made. This causes rearward travel of disconnector which moves sec. sear rearward also. This dis- engages the hammer to strike the bolt & fire the cartridge.

The slide and bolt are moving forward—feeding a live cartridge into the chamber. The trigger has been released, causing the trigger sear to engage & hold the hammer as the sec. sear dis- engages. Rearward pressure applied to the trigger will resume full auto fire.
To Weapon Modifications To Be Made

A. Receiver # Drawing # 32

B. A slot is mached into the upper fangue or assembly.

C. A # 6-32 threaded hole is machined into this frame.

D. This frame, the triggering lever, is extended through the triggering lever engages during the forward movement of the slide.

E. The receiver is extended to accommodate the back end of the triggering lever, and also establish the contact point which provides clearance for the top of the triggering lever.

F. A single cut is made into the slide as indicated.
The centerline can be located by measuring the vertical centerline, the mounting screws on the outside of the stock. The centerline can be transferred to the top of the frame, with the receiver in the hole of the #6-32 hole up onto the stock. The stock must be machined to provide clearance for the disconnector assembly.

4. Stock - Drawing # 30

Machine this part, use the fixture previously described when pin and seat from acceptor to coming apart. The small chamfer on the pin is important. The vertical centerline can then be transferred to the top of the frame. With the stock and receiver assembled, the center of the #6-32 hole on the receiver, the center of the #6-32 hole up onto the stock.

3. Secondary Seat - Drawing # 3C

Secondary seat until the small chamfer on the #6-32 hole in the frame. 4. Stock - Drawing # 30
OPERATION # 1 - MILL RIDGE (LOWER) OFF OF RECEIVER WALL UNTIL PLUSH WITH SURFACE 'A'

OPERATION # 2 - DRILL # 36 (.1065) THROUGH RECEIVER WALL AND THREAD # 6-32 N.C.

OPERATION # 3 - MILL 3/16" (.1875) SLOT THROUGH FLANGE, .450 LONG
New Parts To Be Manufactured
The plastic clip attaches to the small clamp. The plastic clip attaches to the small clamp.

2. (Clamping, Disconnector Pin – Drawing)

3. (Clamping, Disconnector, Secondary Screw – Drawing)

4. (Disconnector – Drawing # 40)

5. (Pin-Disconnector, Secondary Screw Engagement)

6. (Pin-Disconnector, Secondary Screw Engagement)

7. (Clamping, Disconnector, Pin – Drawing)

8. (Clamping, Disconnector, Secondary Screw – Drawing)

9. (Securing the Disconnector assembly)
3/16" RADIUS - BOTH ENDS

1.085
1.300
1.315

1/16" (0.0625)

5/16" (0.3125)

1/16" DRILL 1/2" (0.127) THROUGH

4. - DRILL 7/32" (0.222) THROUGH

HOLDS (ONE SIDE ONLY)

CHAMFER 0.020 x 45° BOTH

N.G. # G-24
2. Screw #8-32 x 1/2", used to hold secondary sear in fixture while machining holes & slot.

<table>
<thead>
<tr>
<th>Fixture - Sear</th>
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<tr>
<td>FULL SCALE</td>
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For construction of this part, the same material used for #2 can be used.

4. Disconnecter

This part can be made from almost any sheet metal. It would be very good.

3. Bushing, Tripping Lever

This part can be made from standard 1/16".

2. Tripping Lever

Since it measures well, and is easily obtained, drill for this application. This swivel can be either purchased or manufactured.

1. Screw-Fit, Tripping Lever

Material for Construction
5. Pin-Disconnector and Trippling Lever

6. Pin-Disconnector, Secondary Gear Engagement

7. Clip-Holding, Disconnecting Pin

8. Fixure-Secondary Gear Machining

Any type of steel or aluminum can be used for this application.

Position on the pin, #1.

So that it can clip onto and return this wire, it must not be flexible or pliable.

The only requirement for all types of secondary German plastic with this type of material used for this part can be almost any type of material.