

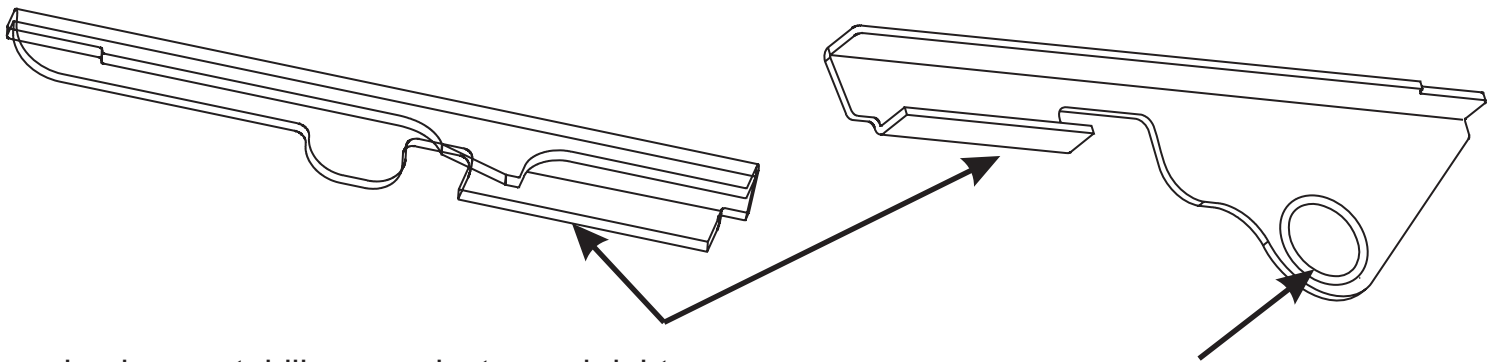
# AK-Builder Standard Flats

Material 4130 Chromemoly Annealed Steel on rails and flat

These flats were designed to be bent and assembled like a manufacturer was trying to make a receiver. With that in mind the problems associated with pre-drilled holes in rails and holes too close to a bend had to be addressed.

This is why I made the holes undersized to have them drilled or reamed afterwards. The trigger pin hole stretches because the hole is too close to the bend. I made the hole a little smaller, but it still slightly bends outward and will need to be tapped on to bend it down. After bending that down then it's ready to ream and will turn out better than any flat with the hole that was drilled to full size before bending.

To install the rails you slide them all the way up against the front trunnion. Make them parallel with the top rail and lined up with the front trunnion so the bolt slides in and out without jumping. Some people say to use a certain size drill bit, which is a good idea if you test fit to get the right size.



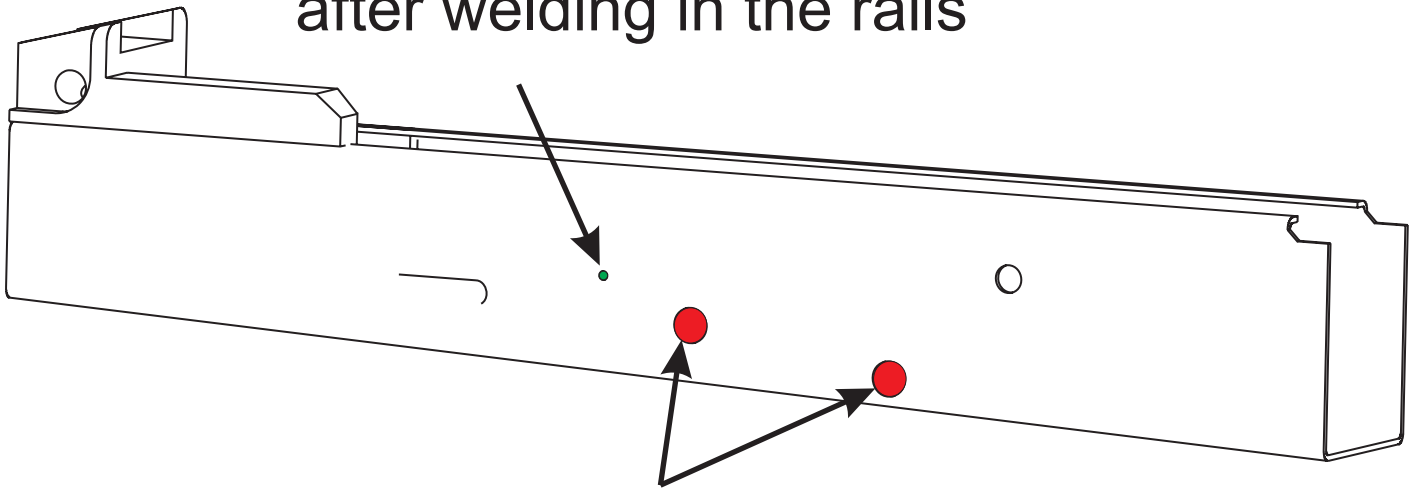
Oversized mag stabilizer on ejector and right side rails will need to be trimmed. It's easier to do this before welding the rails in. The best way would be to get them close to the right size and final fit them after welding. That way if the mag opening is off center it can be accounted for.

The embossed dimple on the right rail will help center the hammer in the center of the receiver. It is easier to install the trigger guard if it is done before welding in the rails.

Most builders only heat treat the ejector, hammer holes and trigger holes with a torch. If you will be spot heat treating the receiver try to do the ejector without the rail welded in. Heat the trigger/hammer holes after they are reamed to save wear on the reamers.

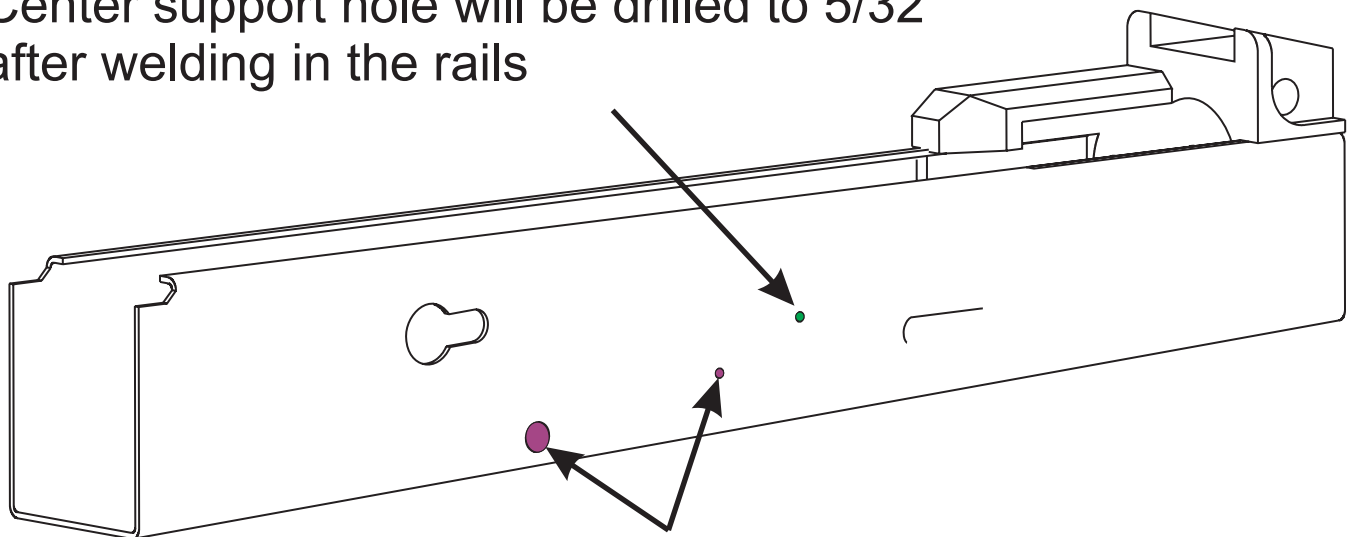
If you have a local heat treat facility it's worth a look into having them commercially heat treated. Be sure to follow all laws if you pursue this avenue.

Center support hole will be drilled to  $5/32$ " after welding in the rails



The Hammer/Trigger pins will need to be reamed out to 7mm after bending.

Center support hole will be drilled to  $5/32$ " after welding in the rails



The Hammer/Trigger pins on the Operator side will need to be reamed to 5mm. The hole for the hammer pin should be drilled at  $.177$  first then reamed to 5mm