

Triangle Sidefolding Stock Instructions



The stock comes assembled as shown above for fitting purposes. This is to ensure that all of the parts will fit together correctly. You will have to disassemble the locking mechanism to rivet the rear trunnion in your receiver.

Before disassembling the stock go ahead and fit it into your receiver to check the alignment of the latch window with the stock in the open position. Once you make sure it will be in the correct latch position take out the spring retaining pin, stock latch and spring.



Use two 8-32 x 3/8 screws and nuts to secure the trunnion in the receiver to lock it in position before riveting. I would also recommend checking the fit of the recoil assembly in the trunnion to make sure the angle won't put it in a bind.



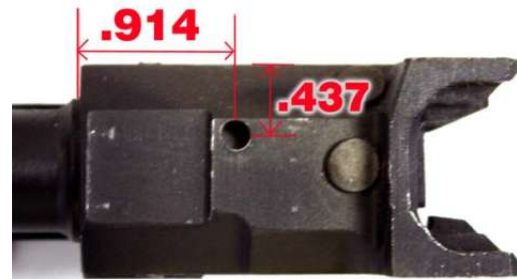
When checking the fit of the stock in the receiver you should also check to make sure stock in the open position is inline with the center of the receiver. The vertical pad on the hinge mount will set the stock angle in the open position.

Once you have the stock aligned and bolted in the receiver you can start installing the rear trunnion rivets. The long rear upper rivet will need to be flattened to clear the stock when it is in the open position. This can be done by sanding the rivet head flat or machining on a lathe. The upper long rear rivet is round on the opposite side that the stock folds to, but all of the short rivets have flat heads on the original demilled parts that I have seen.



The holes in the front trunnion and bottom of the front receiver are done with a #21 and a 6mm drill bit. The #21 hole in the trunnion is drilled perpendicular with the top rail of the receiver. After drilling the hole in the trunnion that is out of the receiver with no barrel you can put the trunnion into the receiver and drill back down through the hole into the receiver to make a pilot hole for the 6mm drill. If you are using a rifle/kit with the barrel still installed then you will need to use the measurements below to drill the holes without using the other as a guide.

From the front of the trunnion/receiver to the center of the pivot hole is .914" and .437" from the edge of the trunnion or .477" from the outside of the receiver.



The latch on the new stock sticks out on the right side of the receiver about the same as a Russian Tula Krink kit. Depending on if you need to

sand the pad down to get the alignment of the stock it may not stick out as far as the Russian one pictured. If you want it to stick out less you can either take a small amount of material off of the angled part of the latch or off of the window opening the latch contacts.



On trunnions with steps where the pin is drilled a clearance cut must be made. Machine the shelf so that you can drill the hole. You can check the level of the shelf by installing the trunnion in the receiver and look through the rectangle opening for the latch to see if it is even or slightly below the top of the opening. Below would be better to keep the latch from rubbing on the receiver each time it moves



This was milled flat with a 7/32 end mill then drilled with #21 drill.



Once the trunnion is riveted and all fitting has been done for the stock the trunnion needs to be "staked" to prevent the hinge pin from working out of the trunnion. Using a chisel or small punch displace the metal around the edge of the pin enough to keep it from coming out.



Once the pin is through the receiver and the spring the next trick is to get the pin into the latch. Once it is through the latch get the pin lined up with the hole in the trunnion and pushed flush with the bottom of the receiver



Here is an image showing a simplified view of how the latch assembly goes into the front trunnion/receiver. I modified a 1/8" long arm allen wrench into a tool to help install and remove the spring. Using a 1/16" cut off wheel I cut a notch into the allen wrench at an angle to hook over the spring. A dental pick would probably work, but I just used what I had here at my shop.

There is a notch in the pin that the spring locks into so the pin won't back out. The picture above shows the leg of the spring that will lock into the notch.



I would recommend cutting this at more at an angle to make a better hook to grab the spring.



What worked for me even though it was still tricky was to grab the spring with the allen wrench while it is under the latch. Pull the spring forward then get it lined up with the hole on the bottom of the receiver to start the pin through the spring.

