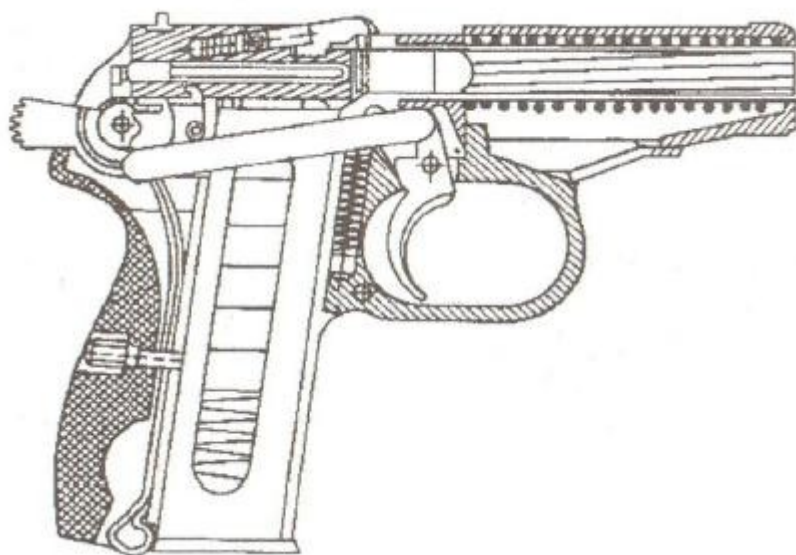




Installation of a New Barrel for the Makarov Pistol

Also covers complete disassembly of the pistols.



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Disassembly of the Makarov Pistol

Complete disassembly of the Makarov is helpful or even required for several operations. These include detail cleaning, barrel replacement, refitting of certain parts, and upgrading to the Simson-Suhl safety set.

Fortunately, the Makarov has only 27 parts. All of these, with the exception of the barrel, can be removed without specialized tools. The Makarov cleaning rod (available on the order form) with its claw tip and screwdriver tip near the loop is all you'll need. A flat-blade screwdriver, awl, and needle-nosed pliers will also suffice.

Lost or broke a part?

We carry all the replacement parts for the Makarov pistol here at Makarov.com, except the frame (considered "the gun" by the BATF and requires a class 1 FFL dealer) and the adjustable sight parts for Russian Makarovs so equipped. Pricing can be found on the on-line order form. An "emergency parts kit" is also available at a savings over individual parts.

Disassembly

Remove the magazine and clear the chamber

Let's start safely and remove the magazine and physically check the chamber for a live round. If you have the magazine in the pistol and it's empty, it should lock back. You can also lock the slide back by pushing up on the slide release and pulling the slide all the way back.



Remove the slide

Pull down the trigger guard and cock it to one side to keep it down. Cock the hammer, then pull the slide all the way back and pull up and off the rear. The recoil spring can then be pulled forward and off the barrel.

Remove the grip screw and grip

The Makarov grip, irrespective of which version or grip you have, is held in place by a single screw at the rear of the grip. Use the cleaning rod tool on the loop end or a screwdriver to unscrew and remove the grip screw. The grip can now be pulled off towards the rear of the gun. In some cases, it may be very tight, but it will come off backwards.

Remove the main spring retention clip

The clip that holds on the main spring should be pulled down towards the bottom of the frame. This is a bit easier if you decock the pistol and push the magazine release towards the front of the pistol to reduce tension on the spring.

Unhook the sear spring

The sear spring is hooked over the slide release. To release tension on the sear spring, which is wound around the sear, use your cleaning rod claw or a pair of needle nosed pliers to pull the spring over the slide release and release it.

Remove the sear

The sear can now be rotated forward and the right side is pulled out of the frame when the cam lines up with the hole. Some care should be taken not to scratch the slide release with the sear or sear spring since there is not much clearance.

Remove the slide release

Once the sear has been removed, the slide release is free to come out as well. Note its position for later reassembly and pull it out of the frame.

Remove the hammer

The hammer should now be rotated forward and off similar to the sear. It also has a cam on the right side that needs to properly align with the hole in the right side of the frame to be removed.

Remove the Trigger

With the Trigger Guard removed, the trigger and Transfer bar can be removed from the frame with little trouble. The Trigger will move forward and fall out the bottom of the frame, while the transfer Bar can be removed from the rear, pulling gently to the Right and up.

Remove the Barrel Pin

The Barrel pin can now be drifted out of the frame, with the Proper size punch. In some cases it maybe necessary to apply a few drops of Penetrating Oil and allow it to soak for a few hours. If your Pin is REALLY stuck, than start the pin with a Hardened center punch, and than drift out the pin the rest of the way with your drift Punch. Please note however that this will deform the Pin, and a replacement will be needed to install the new barrel.

Remove the safety

Remove the slide from the frame if it has not already been done. Rotate the safety to the "safe" position (up), and then push the bottom of the safety lever to continue rotating clockwise until the safety detent spring clears the detent under the "safe" setting. On some pistols, this may take considerable force. Once it has cleared, the safety should easily rotate such that it makes an approximately 120° angle with the muzzle. It can now be removed from the slide. Note the position of the peg on the end of the inside of the safety and how it inserts into the frame.

Reassembly

Much of the reassembly can be summed up by the statement "refitting is the reverse of removal," but there are some tricks.

Replace the firing pin and safety

Before inserting the firing pin; take a look into the firing pin hole with a light to make sure it's not obstructed with crud. If it is, try using a cotton swab with one head broken off to push stuff out. Resist temptation to squirt too much lubricant into the hole since gobs of oil

will attract and trap dirt. Similarly, clean and *lightly* lubricate the firing pin.

Insert the firing pin with the sharp tip first and such that the quarter-circle cutout at the rear is on the lower left if you hold the slide as if to look at the sights while aiming. Insert until the pin is flush with the firing pin hole.

Taking care not to tip the firing pin back out, insert the safety back into the frame. It only goes in one way, but make sure that the rotating pin that's part of the safety is properly inserted back into the hole in the frame. Now rotate the safety counterclockwise and back into the "safe" position. Considerable force might be required to get the safety rotated back into place and the detent spring will most likely mar the slide slightly. This is normal and typically cannot be helped.

Refit the hammer

Hold the hammer as shown and insert it into its holes near the rear of the frame. Then rotate backwards to the cocked position.

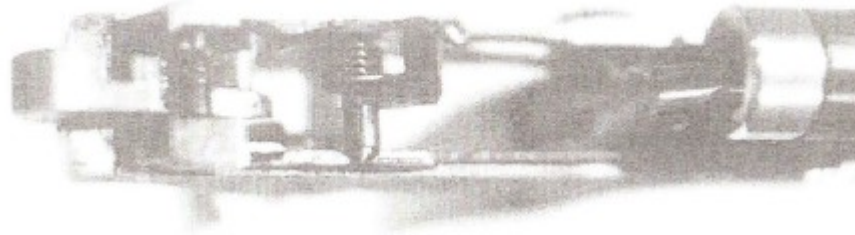
Refit the slide release

This just drops right into place. Note that the hole in the slide release needs to line up with the hole on the side of the frame. The sear will insert through both of these in the next step and hold the slide release in place.

Refit the sear

Position the sear such that the "sharp" contact surface that goes against the hammer face is pointing up or slightly forward. Insert the left pin (the side with the sear spring hook) through the slide release and into the frame hole. Insert the right pin, which is cammed, into the hole on the right. Some jiggling and repositioning may be required to get the sear to insert properly.

While holding the slide release to keep it from rotating, rotate the sear backwards into position. Take care to minimize scraping damage to the slide release.



Hook the sear spring

The sear spring must be hooked over the slide release. Use the cleaning rod claw tool or a pair of needle-nosed pliers to place the hook end of the sear spring over the slide release. The sear should now be properly tensioned against the hammer.

Refit the main spring

Decock the hammer to reduce tension on the spring when installing. This may require manually lifting the sear. Insert the main spring such that the sharp end goes up under the hammer. Align the hole in the main spring with the grip screw hole in the back of the frame. The spring will already be under tension at this point and will require force to keep it there.

Refit the main spring retention clip

While holding the main spring as shown above, slip the main spring clip back onto the frame. Make sure the hole in the clip aligns with the holes in the main spring and the grip screw hole in the frame.

At this point, test the single and double-action functions of the pistol to make sure that all parts have been replaced correctly. If the pistol does not function correctly, the most likely culprits are the disconnecter/trigger bar placement and main spring placement.

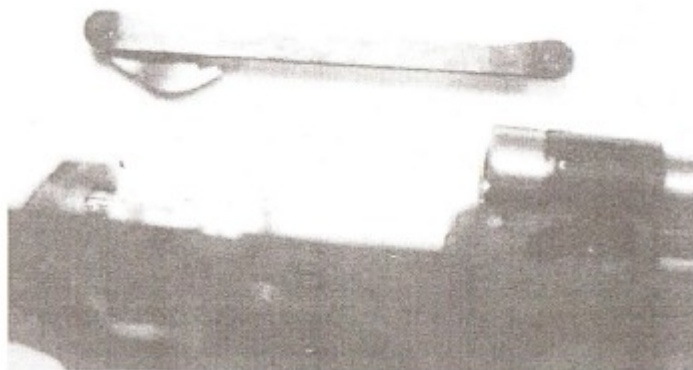
Refit the grip and screw

Slide your grip back on from the rear and make sure the grip screw hole aligns with the threaded hole in the frame. The Makawrap grip works slightly differently, of course, but the holes must still align.



Remove the Trigger Guard

At the bottom rear of the Trigger Guard is a small Pin, this pin can be drifted out with the proper size punch, which will allow the Trigger Guard, Trigger Guard Plunger and Trigger Guard Spring to be removed from the bottom. Please note, these parts are under tension from the spring, and care should be taken to control these parts as they are removed.



Removing the Barrel On a Makarov Using the Twin Rod Type Barrel Press.

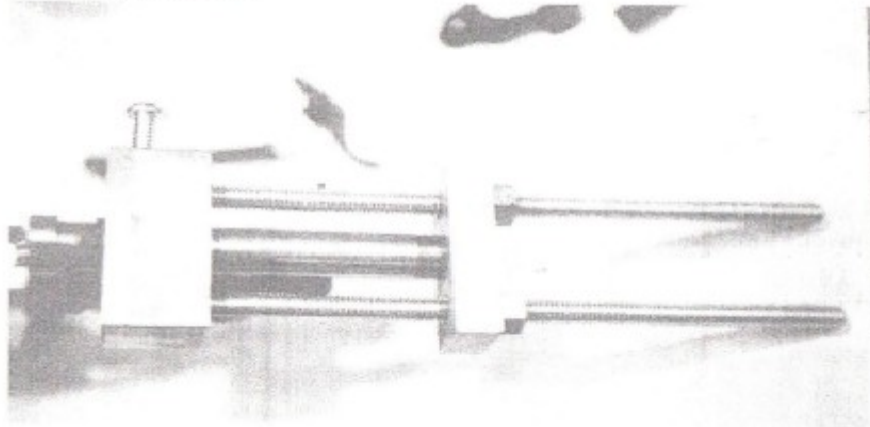
The Twin Rod Type barrel press, uses a Frame Block, the muzzle block, two Threaded rods and a pair of Washers and Nuts, along with a Short rod to remove the barrel from the Makarov.

After the Frame is stripped of all parts, insert the barrel of the Makarov into the frame block, with the opening facing the rear. The Steel pin should slide into the hole in the left side of the Frame block, and thru the frame of the pistol.

Insert one threaded rod thru each of the two holes to the left and right of the Center hole of the frame block. Each rod should be secured front and rear with a washer and Nut. On some versions of this type of press, the Block is threaded for the rods, and the Extra Nuts and washers will not be used.

Slide the Muzzle block over the threaded rods, with the depression in the center aligned with the Muzzle of the barrel.

Use a Washer and nut to push the muzzle block firmly against the muzzle of the barrel.



Secure the Frame Block in a bench vise making sure the rear of the frame is clear and unobstructed.

Begin applying pressure to the barrel by tightening the nuts nearest the muzzle, evenly, giving each about one half turn and than the other.

After several turns of both nuts, the barrel should begin to back out of the frame. After about 1 inch has cleared the barrel sleeve, the barrel should be able to be withdrawn from the frame by hand.



Installing the new Barrel

Remove the Press from the frame, and remove one of the threaded rods.

Clean the Barrel channel Very well, and apply thin coat of oil to the inside of the barrel channel.



Insert the new barrel, making sure the feed ramp is at the bottom, and aligned with the cutout in the frame for the barrels feed ramp.

Put One washer and one nut on the end of a threaded rod, and insert it from the chamber end of the barrel.

Slide the Tube supplied over the barrel, and attach another washer and Nut to the Muzzle end.

(Note: As shown in the Picture above, you can also use the Frame Block in place of the second nut and washer, but this does not allow much adjustment to the barrel during installation.)

Begin to turn the nuts in Opposite directions, working slowly and making sure the feed ramp stays aligned.

The Barrel will be drawn into the Barrel channel on the frame, and it will take a bit of effort to get the final 1/16" or so seated.



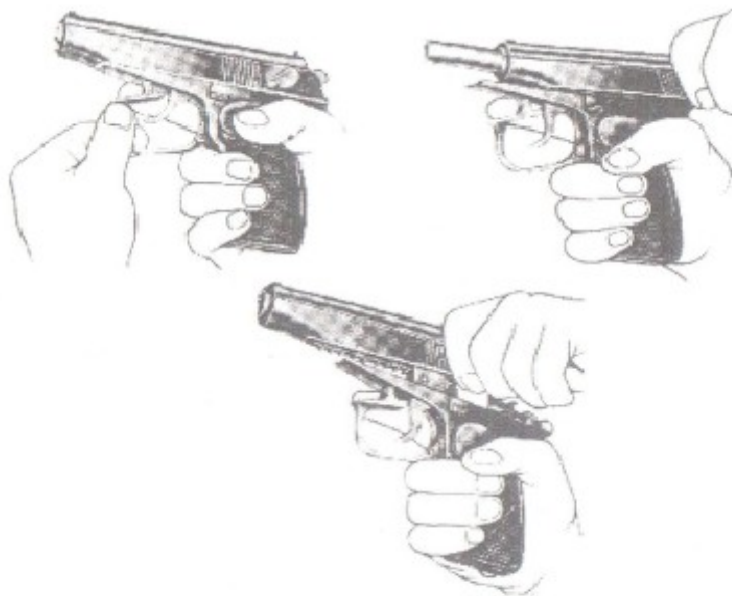
Remove the Threaded Rod and Tube. If your new barrel is pre-Drilled for the Barrel pin, you can now tap this pin into place.

If your New barrel is not Pre-Drilled, than use the holes in the frame as a guide, and using a Number 31 Drill bit, drill thru the barrels feed ramp. Than the barrel pin can be Tapped into place.

Tighten the grip screw, taking care that it does not protrude into the magazine well. Do not over torque the screw, particularly with wooden grips.

Refit the slide onto the frame

Assuming you have not removed the recoil spring, refit the slide just you would after field stripping: Pull down the trigger guard and offset to one side such that it rests against the frame and doesn't rebound back into its normal position. Pull the hammer back to its cocked position. Push the barrel through the muzzle opening in the slide, then pull the slide all the way back and down onto its rail on the frame while compressing the recoil spring with the slide. The recoil spring should now push the slide forward into battery. Push the trigger guard back into its normal position.



If you have any problems or questions please call our Tech Support Line at 1-304-760-2136 or Email us at joe@bca-industries.com

Helpful Hints and tricks for Barrel Removal

-If your barrel is very tight, and does not seem to want to come out, apply a few drops of a good Penetrating oil and allow to sit for a few days.

-If the barrels still does not want to come out, Assemble the Barrel press onto the frame, and place the entire unit into the freezer for 8 hrs or so. Remove the unit from the freezer, and clamp it into your vise. Using a small propane torch, apply heat to the Barrel Channel, but try not to allow the heat to get to the barrel. After "Sweat" has appeared on the barrel Channel, begin turning the Nuts at the muzzle end. This should allow the bond between the barrel and barrel channel to separate.

-When you first start the barrel moving, you will hear a sharp Crack, this is normal, and it means the rust or other bond between the two parts has separated.

-If the supplied frame block rod tends to bend, or in some cases breaks, a hex wrench of the proper size will work in its place, and in most cases, holds better than the Original rod.

-Allow several hours the first time you remove a barrel, after that it gets much easier, and can normally be done in about 30 mins. From start to finish.

-In extreme cases, it maybe necessary to use a hammer to hit the front of the Muzzle block to start the barrel moving. Use a block of wood between the hammer and the muzzle block, and Hit it ONCE and than try to turn the nuts. Repeat if needed.

-If your barrel is bent, bulged, cracked, or otherwise damaged, use a hacksaw to cut off the barrel behind the damaged area, before you attempt to remove the barrel.

-The Makarov barrels are Pre Adjusted for Headspace, so you will not have to adjust this in anyway if your barrel is properly seated into the Frame.

DO NOT ATTEMPT TO FIRE THE MAKAROV WITHOUT A
BARREL PIN IN PLACE !



New Barrel installed, and parts returned to the Pistol.



The Completed Re-barrel Job. Ready to Test fire.