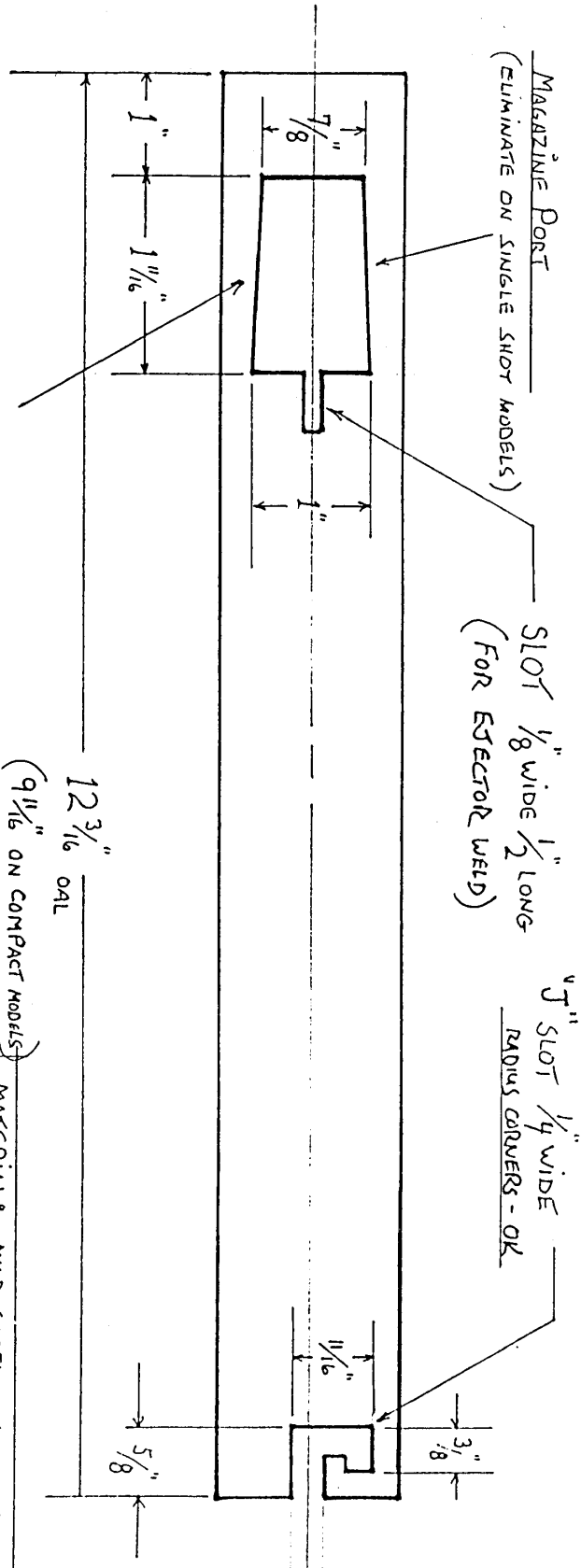


STEN GUN SMG. - LEFT SIDE VIEW

RECEIVER TUBE



RADIUS CORNERS ON PORT OPENING - OK

MAGAZINE PORT
(ELIMINATE ON SINGLE SHOT MODELS)

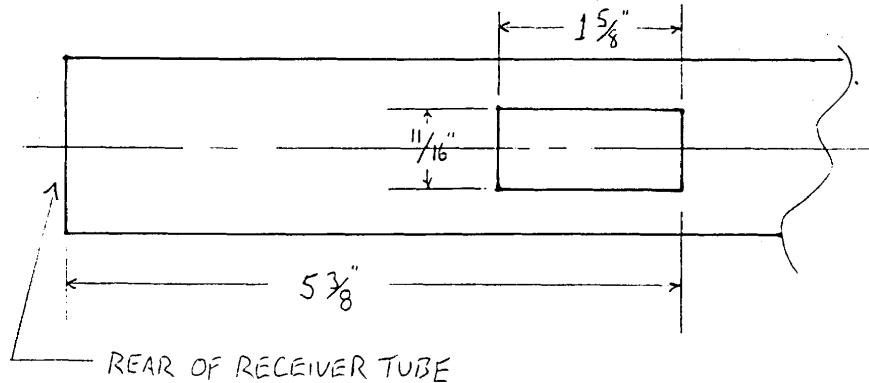
SLOT $1/8$ " wide $1/2$ " LONG
(FOR EJECTOR WELD)

$7/8$ " SLOT $1/4$ " WIDE
RADIUS CORNERS - OK

$12 3/16$ " OAL
($9 11/16$ " ON COMPACT MODELS)

MATERIAL: MILD STEEL - SEAMLESS OR
DRAWN OVER MANDREL - $1 1/2$ " O.D.
058-062 WALL ($13/8$ " ID.)
(FOR SEMI-AUTO - .083" WALL)

BOTTOM VIEW - SEAR SLOT



STEN GUN ASSEMBLY NOTES

all welding should be done with Heli-Arc (tig) welder. British also used arc & gas welding, but heli-arc gives the best looking weld and reduces heat warpage and burn thru possibilities.

TO BUILD GUN INTO A SEMI-AUTO CARBINE the following extra procedures are employed in addition to the procedures for building the gun into the original sub-machine gun configuration.

1. 14" barrel sleeve is slipped over and welded onto standard Sten S.M.G. barrel - giving an overall barrel length of 16"+.
2. Heat treated steel bolt extension is slipped over rear of bolt and welded in place - bolt sear & front of extension is then ground off flush with flat of bolt. This moves bolt sear to rear of bolt extension and places bolt face just behind magazine when in cocked position. It also eliminates the full auto relief in bolt sear.
3. A safety block is welded into trigger housing prior to assembly to receiver tube. This block converts selector switch to a fire and safe switch.
4. Trip/sear lever has a $\frac{1}{4} \times \frac{1}{4}$ " roller bearing brazed onto it's end. This makes the lever disconnect no matter the position of selector switch.
5. After trigger and sear pivot pins are installed they are welded to the outside of the trigger housing to insure guns trigger mechanism is kept in a permanent semi-auto mode.
6. The receiver tube is thicker wall tubing (.083") than for the full auto gun (.062"). This gives an I.D. of 1.334" compared to 1.375". It requires the bolt's O.D. to be turned to 1.310". The use of this size I.D. tubing completely distinguishes the semi-auto receiver from the original Sten sub-machine gun receiver.
7. Weld trigger dust cover to receiver. (this shows your intent not to convert gun to selective fire by modification of safeguards)

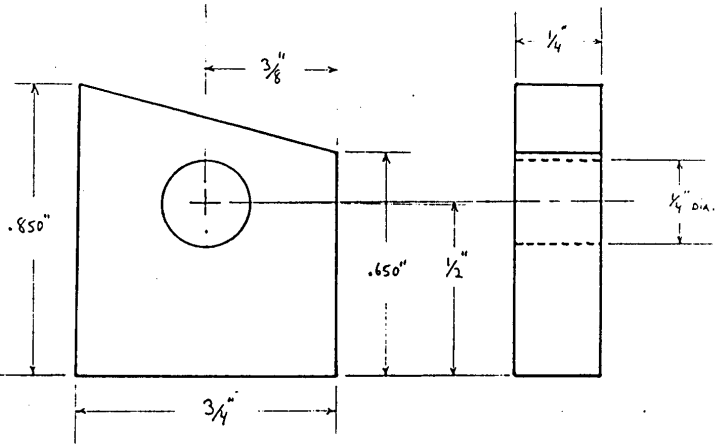
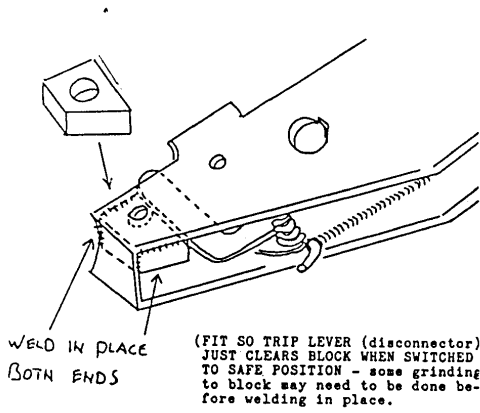
TO BUILD GUN INTO A SEMI-AUTO PISTOL follow #2 thru #7 above.

8. A simple pistol grip is constructed and installed in place of butt stock. The standard length Sten S.M.G. barrel can then be used without the necessity of having a barrel sleeve installed.

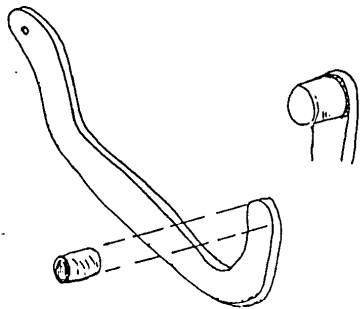
CAUTION: THE USE OF A RIFLE BUTT STOCK ON THE STEN SEMI-AUTO PISTOL MIGHT BE IN VIOLATION OF FEDERAL OR STATE LAW IF PRIOR PERMISSION IS NOT OBTAINED. CHECK WITH A KNOWLEDGEABLE ATTORNEY ON THIS ASPECT!

SAFETY BLOCK (MILD STEEL)

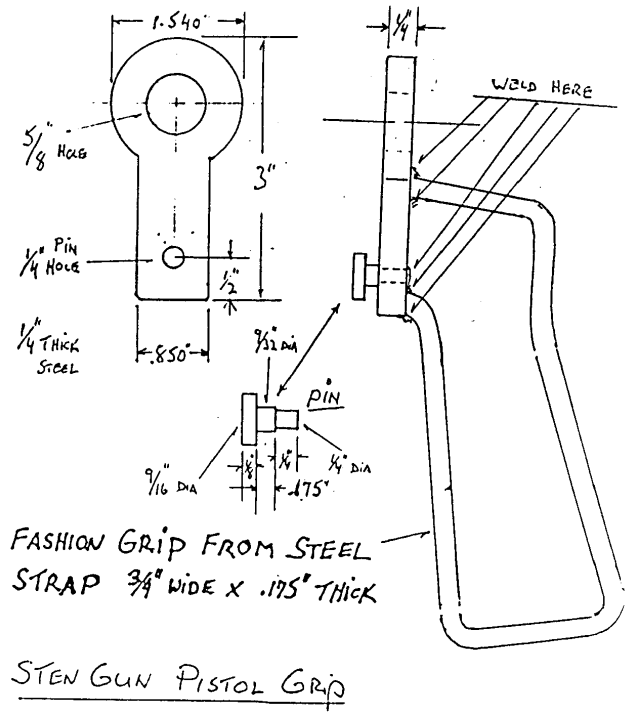
(USED ONLY ON SINGLE SHOT & SEMI-AUTO MODELS) TOLERANCES NOT CRITI



1/4" x 1/4" ROLLER BEARING INSTALLATION ON TRIP LEVER



SILVER SOLDER OR BRAZE ON
FOR SEMI-AUTO MODEL ONLY



These plans given for entertainment and educational purposes only. All NFA laws apply!