

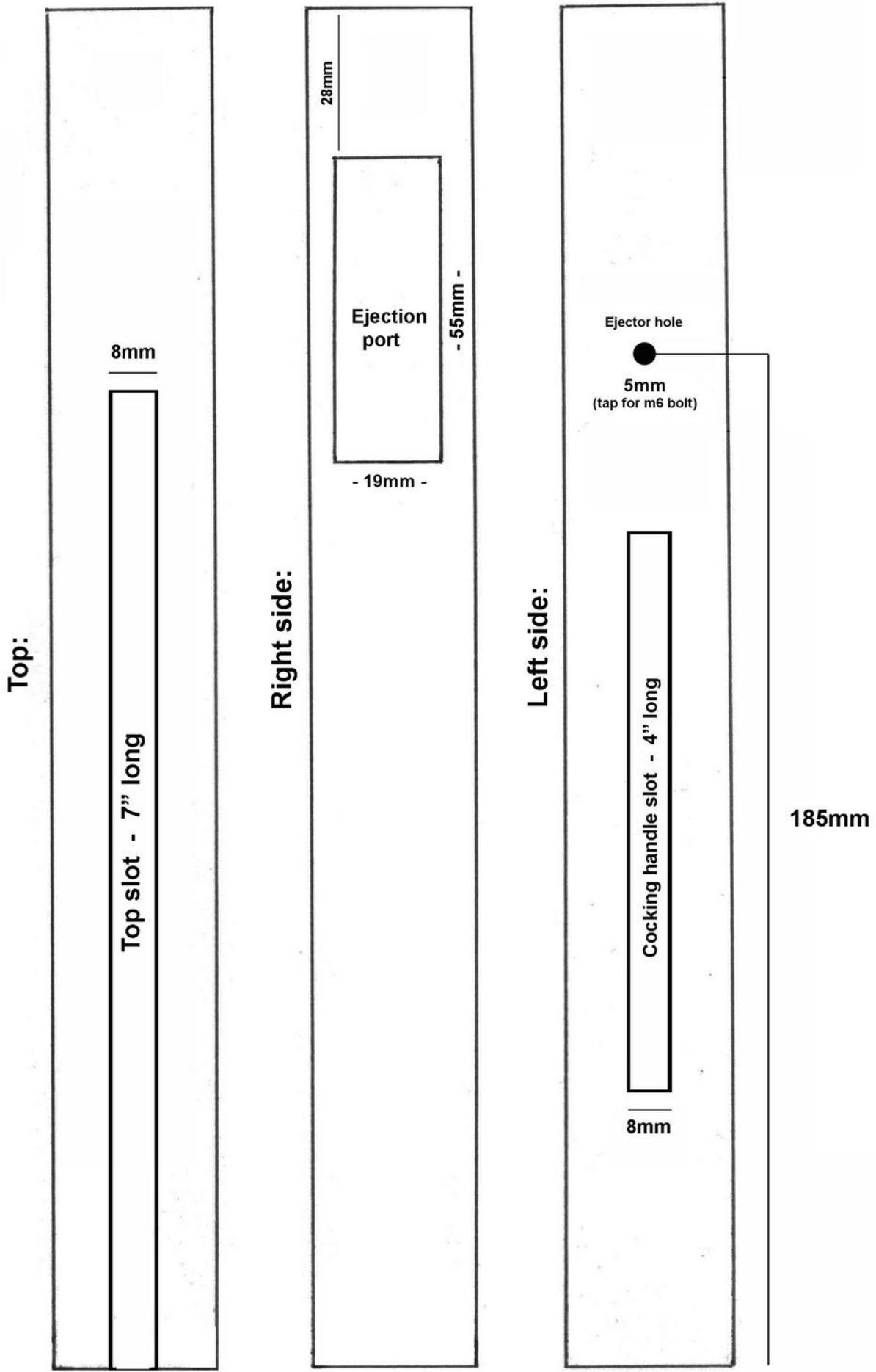
# 9mm semi automatic pistol

(Closed bolt striker fired operation)



# Receiver

247mm long

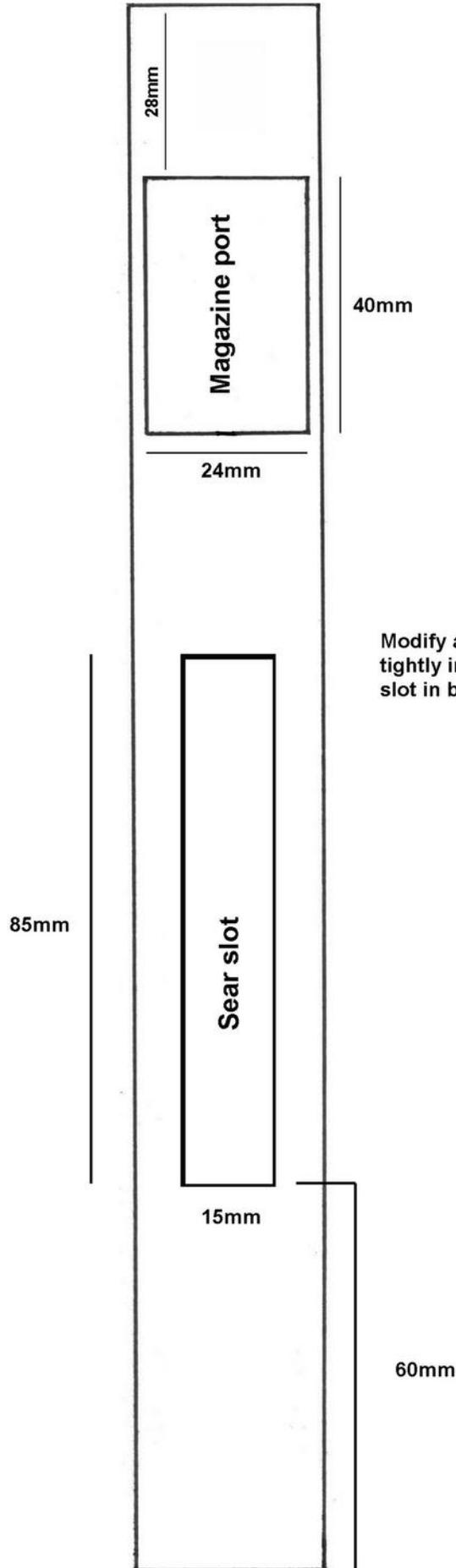


2 inches

Print on 8.5x11 US letter paper

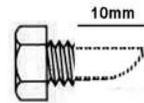
30mm dia mild steel round tube  
2mm thick wall

# Receiver (Bottom)



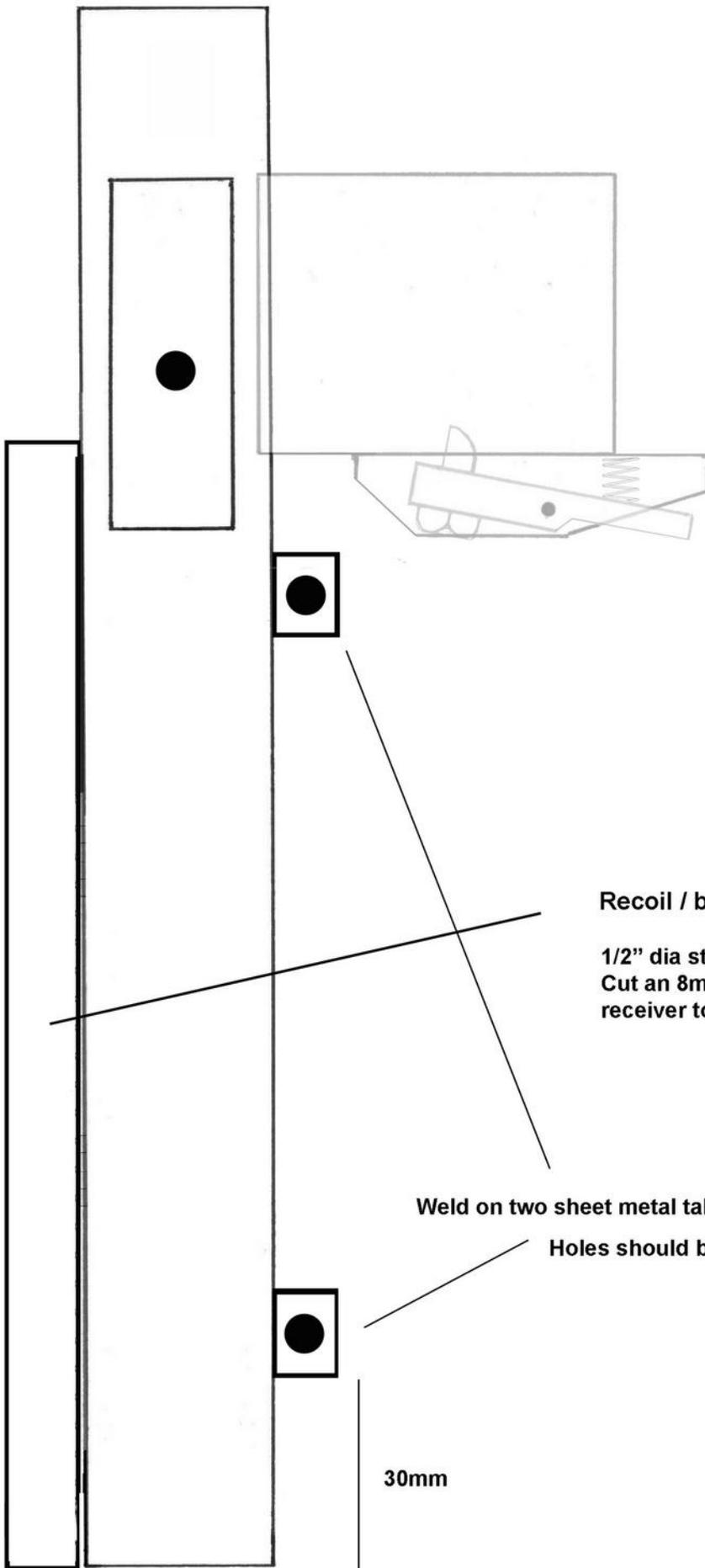
## Ejector

Modify a 1/2" long m6 bolt into a blade profile. Screw tightly into the ejector hole until aligned with slot in bolt. Apply loctite to fully secure.



2 inches

# Complete upper receiver



**Recoil / bolt return spring housing tube**

**1/2" dia steel tube, 7" long  
Cut an 8mm wide slot along bottom to match receiver top slot. Weld in place.**

**Weld on two sheet metal tabs, 14mm wide with a 6mm hole**

**Holes should be spaced 117mm apart.**

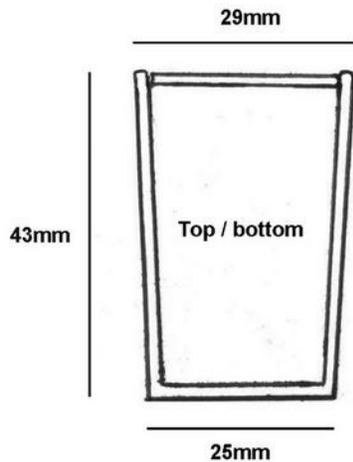
**30mm**

**2 inches**

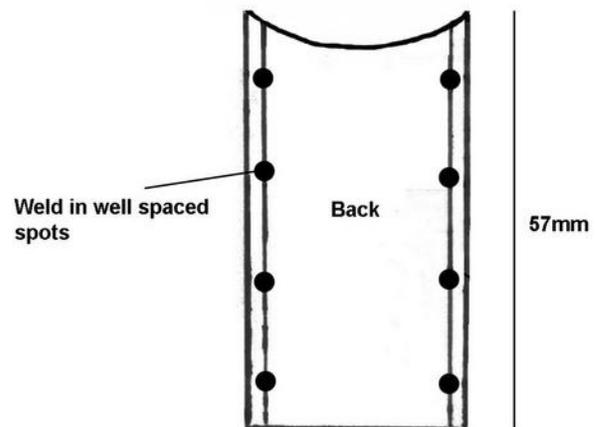
**Print on 8.5x11 US letter paper**

# Magazine-well (for 9mm STEN magazines)

A 57mm length of 1" x 2" (25mm x 50mm x 2mm wall) steel rectangular tube is modified by removing a single 1" side to enable both 2" sides to be flared out slightly in order to accept a STEN magazine. A section of 1" steel bar can be hammered down through the opened side to achieve this. The removed side is then welded back into place forming the correct inner dimensions. Use a STEN magazine for reference throughout.

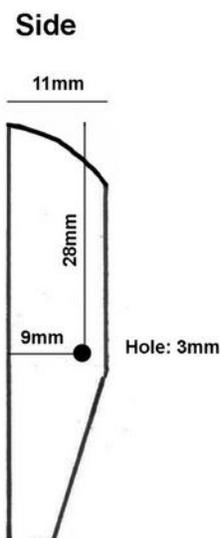
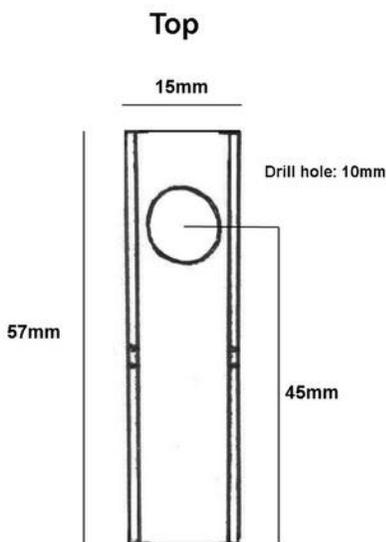


Curve top to match receiver profile



## Magazine catch housing

Make using a length of 15mm steel square box section or bend from sheet.



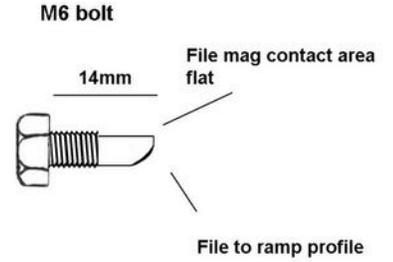
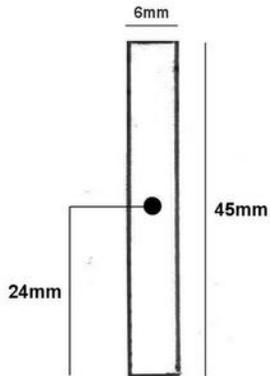
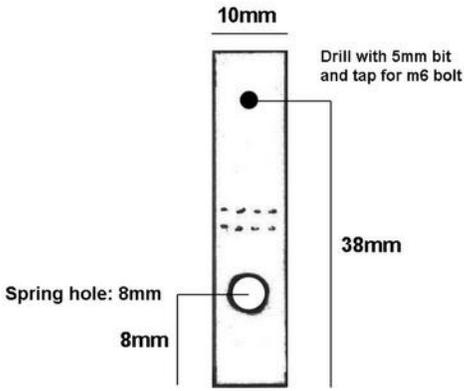
Front



2 inches

# Magazine latch

Assemble from a strip of 6mm (1/4") thick aluminum or plastic plate + M6 bolt

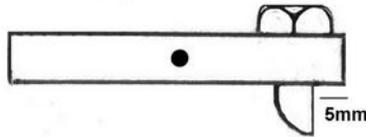


Tightly screw into plate and modify as above while in place.

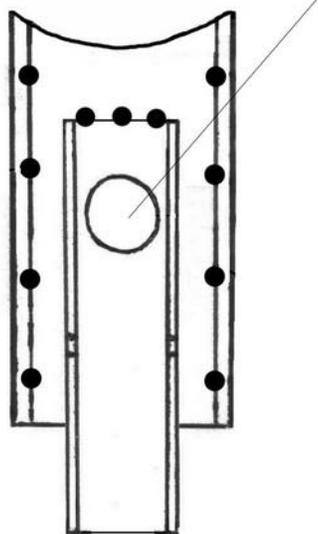
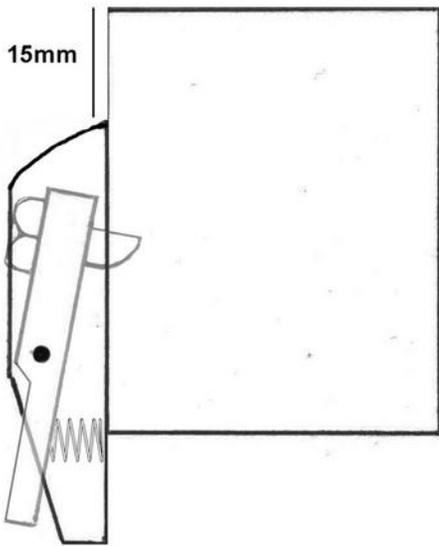
8mm x 15mm compression spring



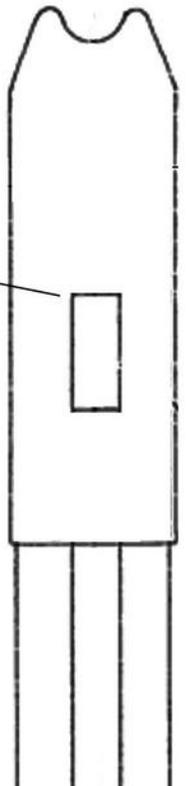
Finished:



Drill through both pieces with 10mm bit



Latch should contact this point on a 9mm STEN magazine

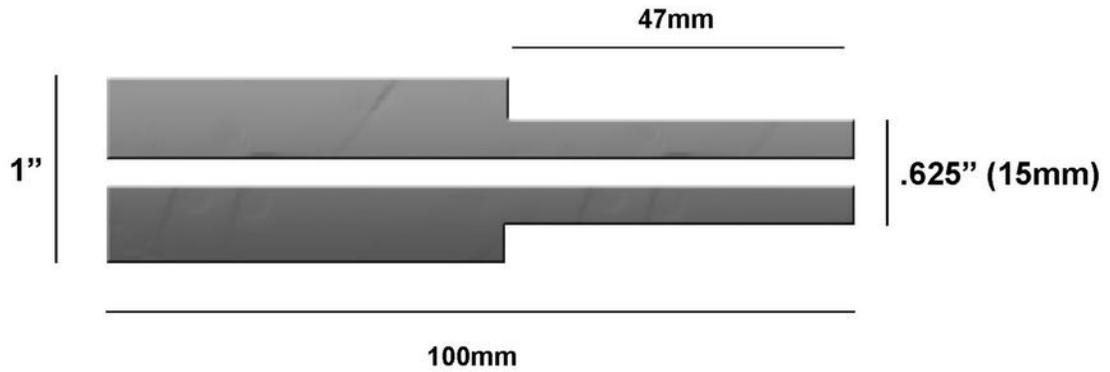


- Weld latch housing to mag-well
- Secure latch with M3 bolt + nut

2 inches

# Bolt

Turn on a lathe from 1" mild steel round bar



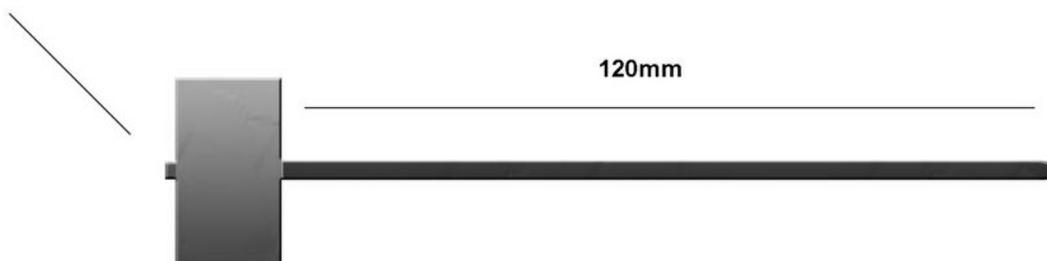
Bore a 3mm dia hole through center

*Harden bolt face using Kasenit*

## Striker assembly

Firing pin: 3mm silver steel rod - round off tip

Either weld at rear or retain in a blind hole

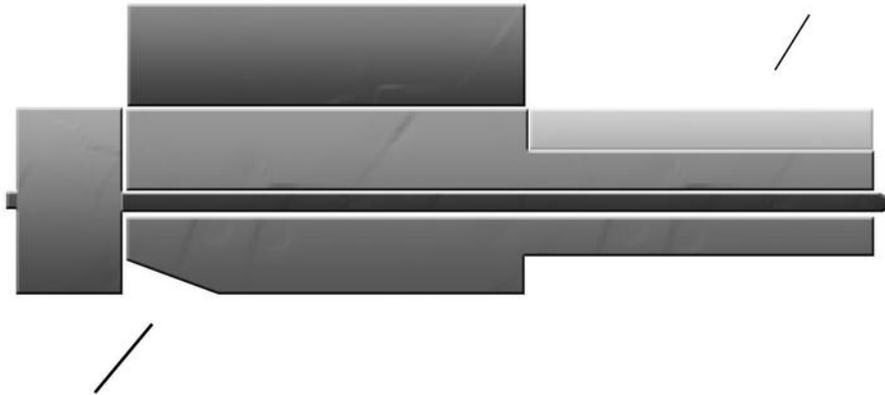


1" mild steel round bar, 15mm long

- Firing pin can be of a larger OD and necked down through a smaller ID hole in breech face end.

# Bolt assembled

47mm long steel plate or 1" dia (5mm wall) steel tube cut in half and welded in place to reduce wear on bolt face



Cut sear relief ramp on underside of bolt

## Recoil / return spring contact plate

53mm



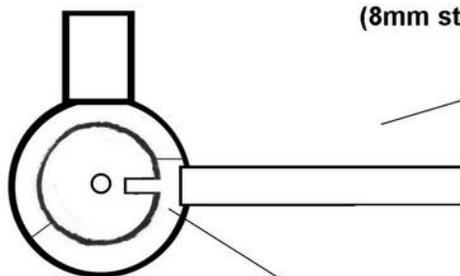
13mm

1/4" mild steel plate - weld in place

Front

Cocking handle

(8mm steel bar, 45mm long. Tap into a blind hole)

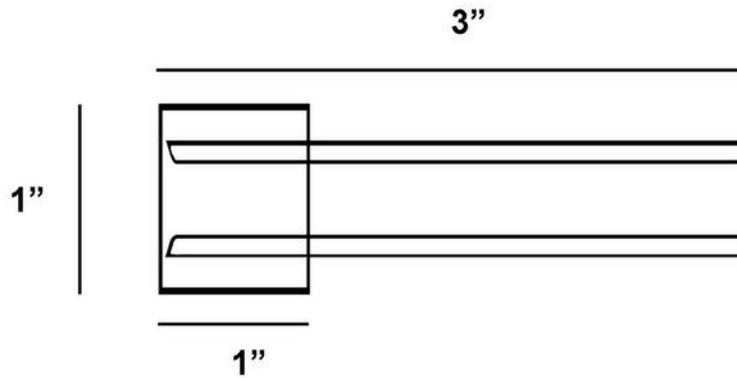


Cut a 5mm deep slot on right side of smaller dia section for ejector

## Barrel & collar



STEN feed cone



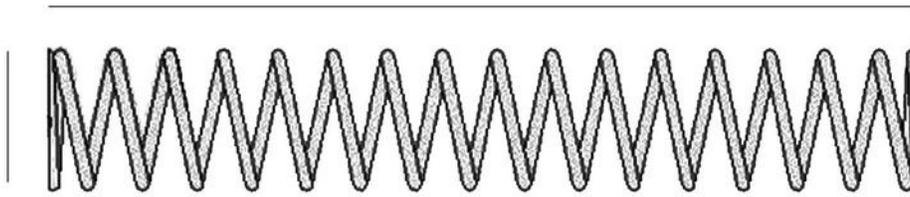
Cut a feed cone / bevel into the front of chamber using a 16mm+ bit

## Striker spring

4 3/4" (120mm)

*Unmodified purchased compression spring*

19mm / 3/4"



1.5mm wire

## Recoil / bolt return spring

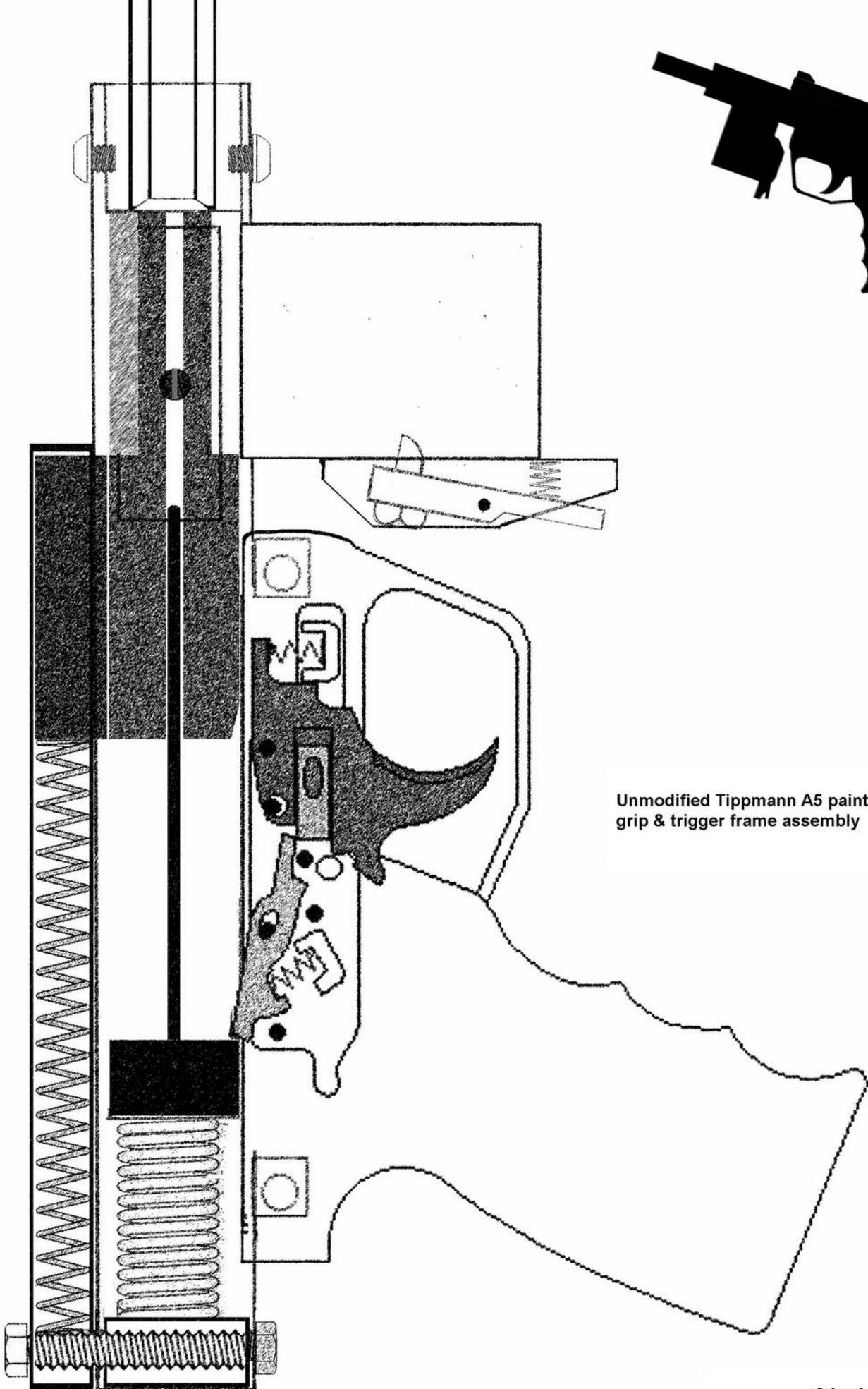
6"

10mm



1.5mm wire

Fabricate a rear plug from a 1/2" length of 1" bar. Retain spring assembly via a 45mm long M8 bolt + nut inserted through a hole drilled vertically through spring holder, plug and receiver.



Unmodified Tippmann A5 paintball marker  
grip & trigger frame assembly

2 inches

Print on 8.5x11 US letter paper

