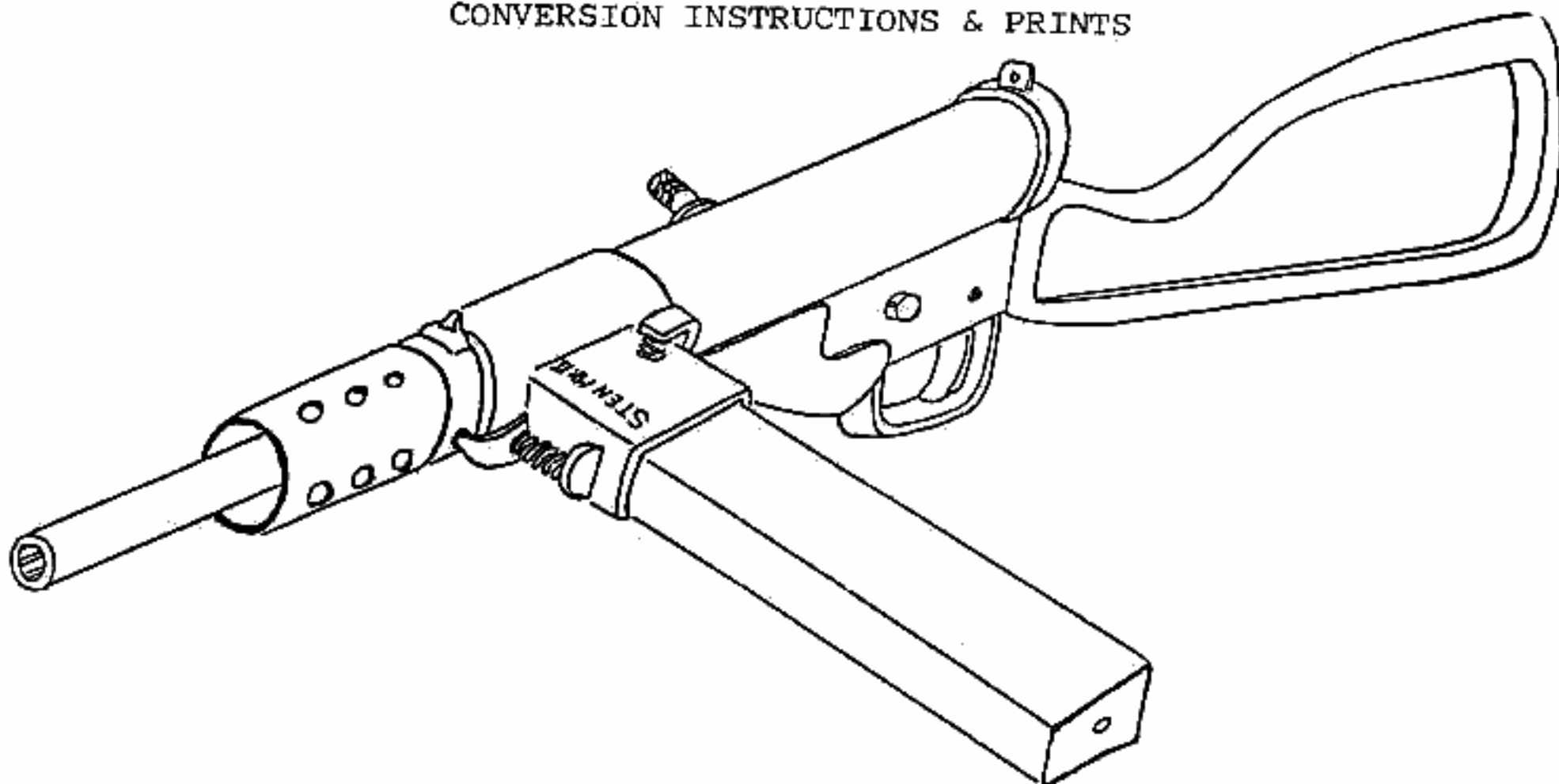
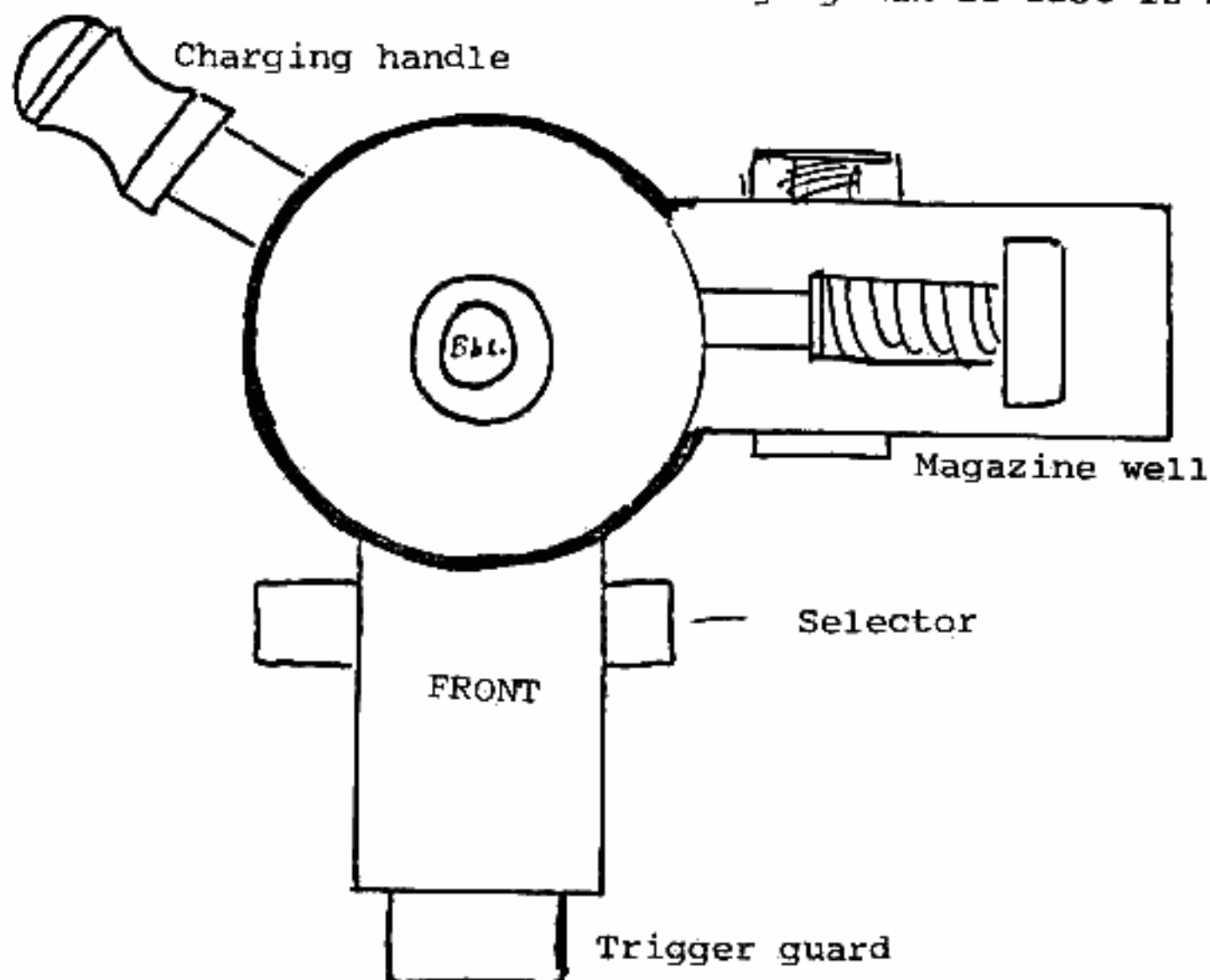


STEN GUN MARK II
CONVERSION INSTRUCTIONS & PRINTS



Use a vertical mill or drill press if at all possible. Set up blank between centers and mill. Use a 1/4" end mill for all of the ports as they have a 1/8" radius on each corner. The charging handle slot is made



with a 3/8" end mill in all areas. Depending on your type of extractor, it gets a hole or slot in the area indicated in the magazine area. File to fit.

Due to the Sten being manufactured in many allied countries on various machinery, bolt diameters vary. Your bolt will most likely fit OK, but you may need to polish the tubes inside with an automobile brake cylinder hone and kerosene BEFORE cutting ports.

The end of the tube marked in yellow will get the barrel bushing.

After assembly of the weapon, locate and drill a 1/4" hole for the barrel retaining lock. Check how the bushing goes in before welding it into place.

The ejector may have to be filed for proper fit. The bolt should be able to slide freely over the ejector while still being high enough to work properly. Test with an empty case or dummy round.

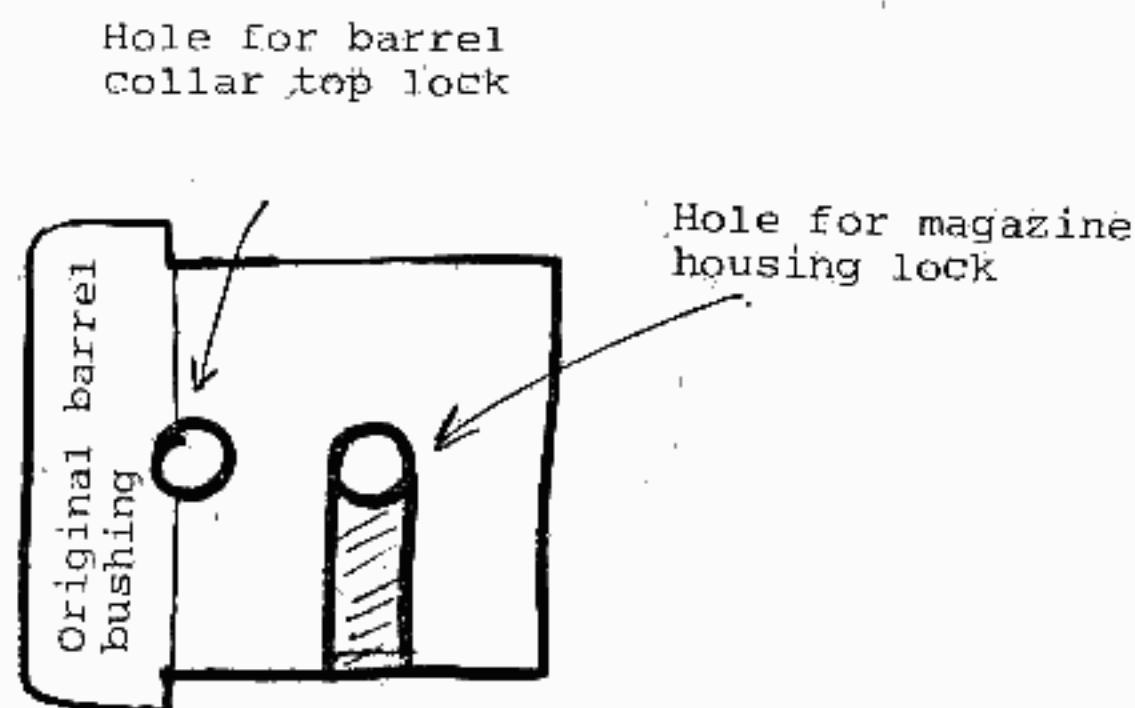
When welding the tube to the rear housing, place a snug fitting dowel through the housing into the tube to maintain the proper alignment of these two parts. The tabs on the trigger housing are welded to the tube. Weld the tube to the housing, THEN align the barrel bushing.

NOTE: It will probably be necessary to slightly enlarge the inside diameter of the magazine housing band where it slides over the tube. This is normal.

TIPS: .Test with dummy rounds.

.Ejector is fitted just behind magazine port (see ejector page).

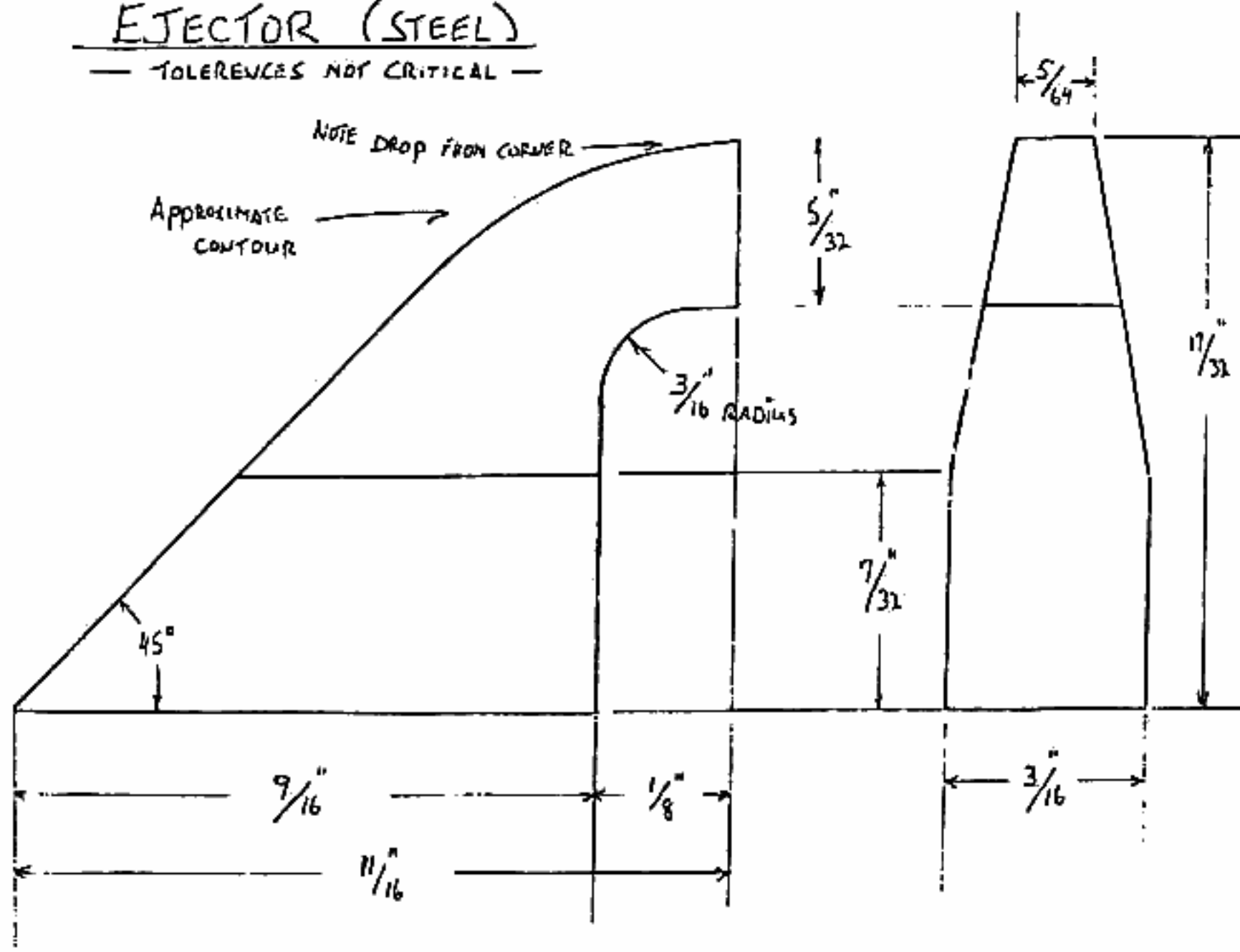
.Mount a front sight on the magazine housing. Otherwise, you won't be able to remove this housing if you have to.



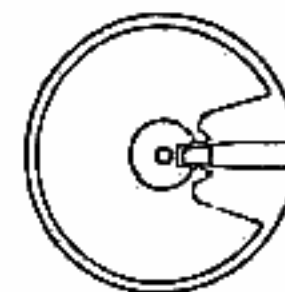
The two holes (1/4") in the barrel bushing shown here are to be drilled through the tubing and through the barrel bushing for the respective locking devices. Since the barrel bushings vary, it is best to measure yours. No measurement is given since they vary. The holes are best drilled after the bushing is welded in place. Ejectors vary also, but the ejector page should be of help.

EJECTOR (STEEL)

— TOLERANCES NOT CRITICAL —



FRONT VIEW
SHOWING EJECTORS RELATION
TO BOLT



TOP VIEW
CUT-A-WAY SHOWING POSITION
OF EJECTOR

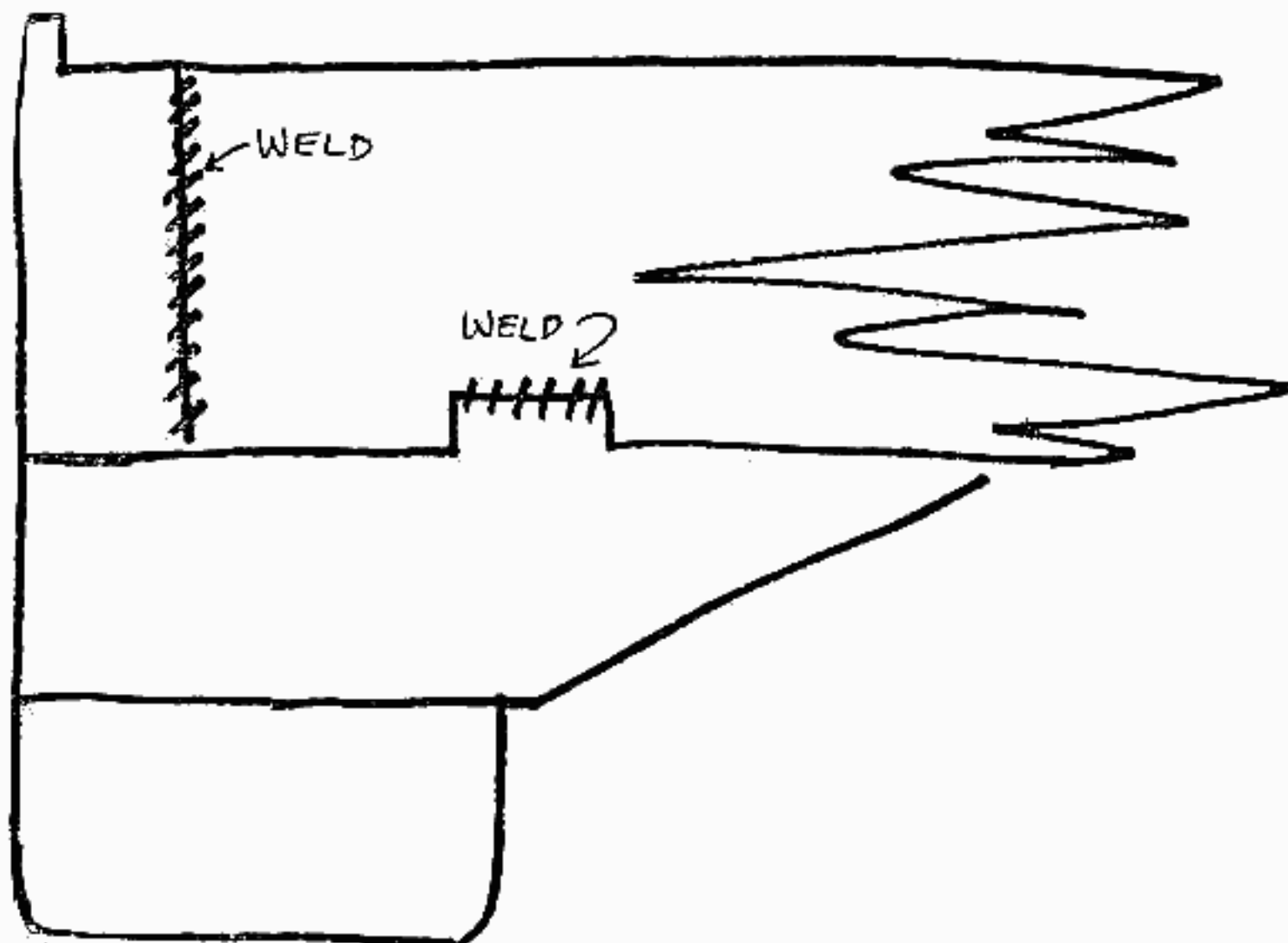


THE EJECTOR IS SHOWN HERE FOR THOSE WHO DON'T HAVE ONE. IT IS EASY TO MAKE.

This is your rear cut.

Locate the magazine port. (Left Side). Measure forward from the front edge of this port, 1.078". This is your front cut. Actually, the size of the ejection (right side) is arbitrary. You may wish to change the shape of this port to suit your taste.

Remember! The charging handle slot is rotated 25 degrees from horizontal.



IMPORTANT! As shown in the above diagram, the tube is butted up against the rear ring and welded. When stripping your parts kit, DO NOT REMOVE old piece of tube inside this ring. The tube part has two "Dog leg cuts" in it to retain the mainspring cap retainer. The tube measurements are generated from the front face of this ring forward.

SUPPLEMENTARY INSTRUCTIONS

Read all notes and instructions before proceeding.

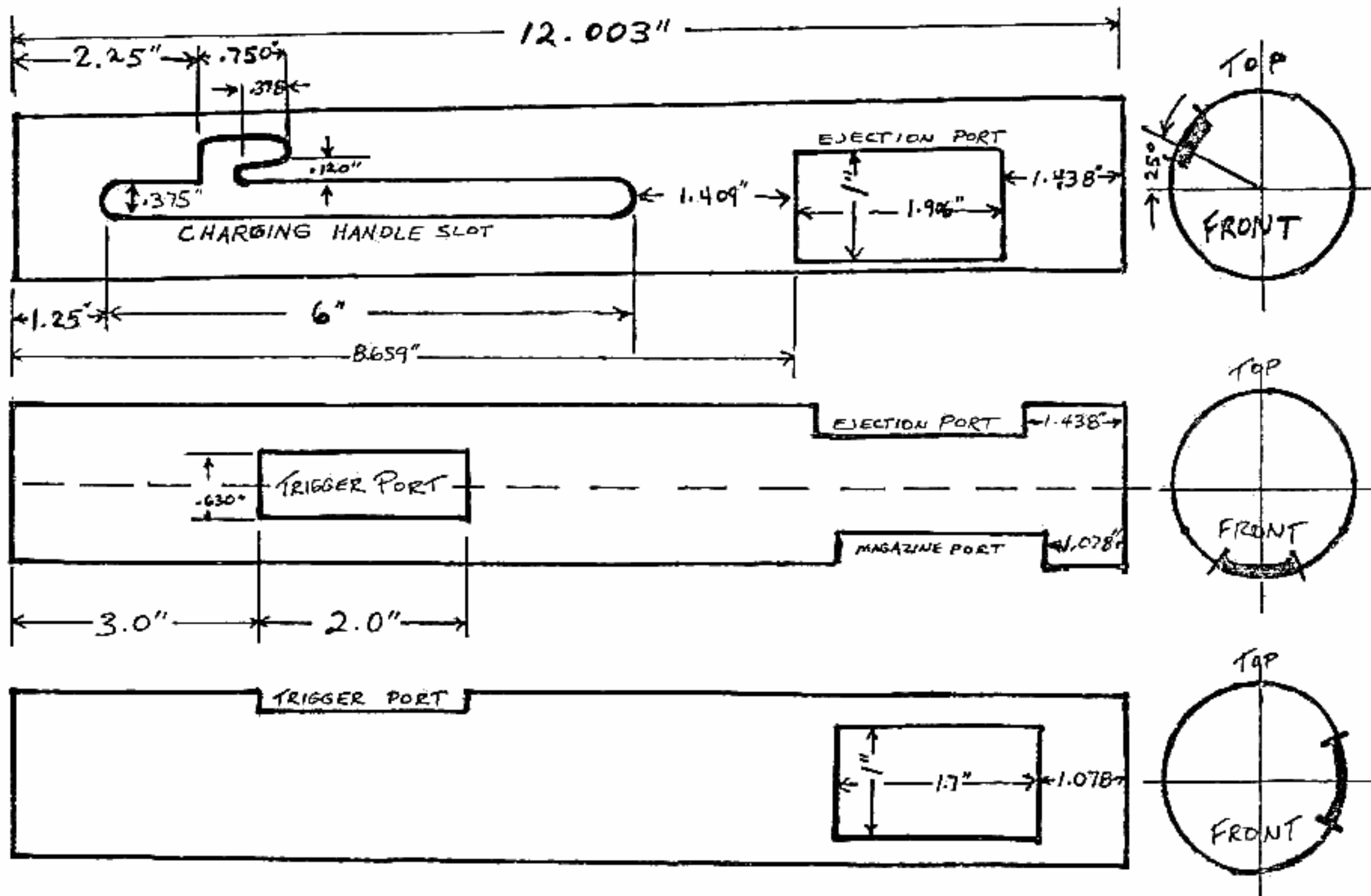
Method #1 If you have access to a vertical milling machine, this is the easiest and best. Set up the receiver blank between centers or in a good mill vise and mill (being careful not to crush the O.D.). The ejection port, magazine well and trigger port all have a 1/8" radius in each corner - so use a 1/4" end mill. The cocking handle slot is 3/8" wide in all areas - so use a 1/4" end mill. The small hole behind the magazine port is for the ejector. Drill the hole 5/32". The two larger holes in front of the magazine port are for the magazine housing lock. Drill these holes 1/4". (The furthest forward is for the barrel lock).

Method #2 To complete with a hand drill and file or Dremel style Moto-Tool (using cut-off disks). Place receiver blank in a vise, being careful not to crush the tube. Then, take a center punch and mark it for a 1/4" drill in each corner of the ports and ends of the slot.

Drill out the corners of the blacked in areas first, then drill more holes inside the blacked in areas to remove the metal along the straight edges (being careful to stay inside the black areas). Drill all the small holes as in method #1.

NOTES:

1. The barrel bushing must be turned down by lathe to an outside diameter of 1.398" - 1.400" (slip fit into tube). The best method is to turn the barrel bushing between centers for a concentric cut. DO NOT REMOVE ANY PART OF THE OLD TUBING THAT MAY BE ATTACHED TO THE BARREL BUSHING EXCEPT BY TURNING IT DOWN IN A LATHE OR IT MAY BE UNDERSIZE. THE INSIDE DIAMETER OF THE NEW TUBING IS A FEW THOUSANTHS OF AN INCH LARGER THAN THE ORIGINALS (modern stock sizes). The barrel bushing should be 1.5" long. Slide the barrel bushing into the front of the receiver tubing until flush and silver-braze, spot-weld or button-weld into place.
 2. The ejector fits into the hole behind the magazine port. It should be silver-brazed in place. Filing the top of the ejector may be required to get a proper fit. The bolt must be able to just slide freely over the top of the ejector. Test with an empty cartridge case. When the action is worked rapidly, the case should be thrown clear of the action.
 3. The trigger group and rear housing should be welded onto the receiver tubing.
 4. The magazine housing may require some material removed from the interior diameter to allow it to slide freely over the receiver when assembling the gun.
 5. After the barrel bushing is welded in place, the furthest forward hole should be drilled completely through on one side to allow the barrel lock to contact the serrations on the barrel. The hole drilled previously in the receiver tubing acts as a guide for this step.
- CAUTION: This gun fires from an open bolt. Never close the bolt on a live round or the gun will fire.



This diagram is intended for use with ORIGINAL barrel bushing. It is pressed in the front and heliarc-welded. This diagram was prepared from an actual uncut Sten and also Austen.

