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-TRIGGER HOUSING-

CENTER HOLE IS .185 D AND IS DRILLED FIRST, ALL THE WAY THROUGH. SECOND HOLE IS .300 D, AND IS DRILLED ONLY THROUGH THE FIRST WALL.

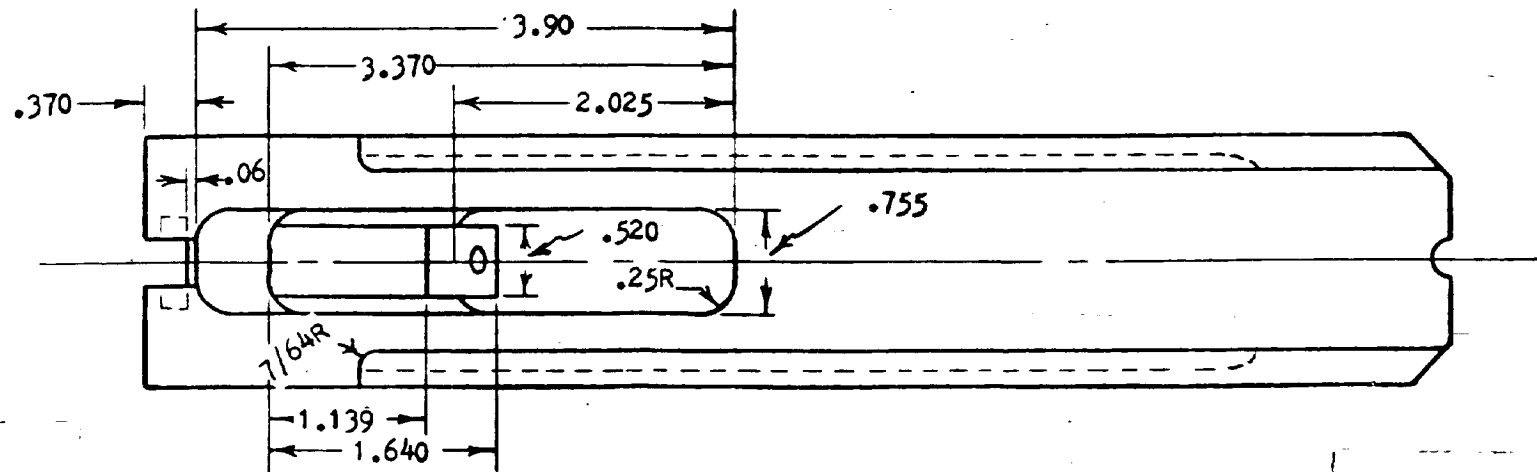
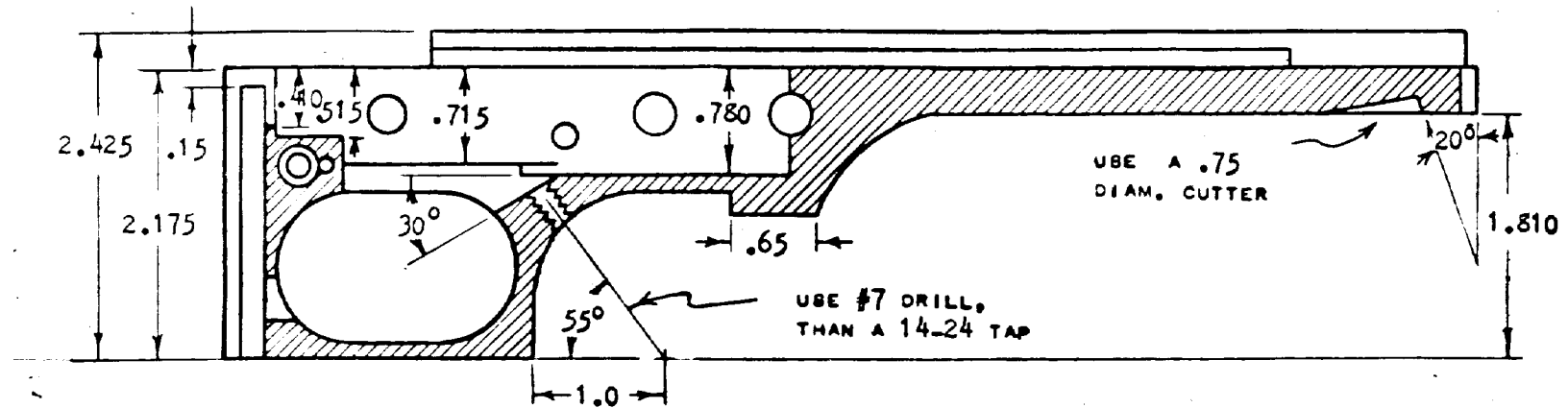
SLOT LENGTH IS 6.5" FROM START.
USE $\frac{1}{8}$.3R CUTTER.



- 1) DRAWN TO 3/4 SCALE
- 2) DIMENSIONS IN INCHES
- 3) TOLERANCES:
- A- HOLE LOCATIONS $\pm .001$
- B- HOLE SIZES; ATTEMPT TO USE
DRILLS CORRESPONDING TO GIVEN
DIMENSIONS, OTHERWISE USE CLOSEST
SIZE LARGER.
- C- ALL OTHERS $\pm .002$
- D- SLOTS AND DOVETAILS MUST BE MILLED TO FIT.
- 4) FILLETS AND ROUNDS 1/8R UNLESS INDICATED.

THE THOMPSON SUBMACHINEGUN
MODEL M1A1
MACHINIST'S WORKING DRAWINGS
IN FOUR PLATES

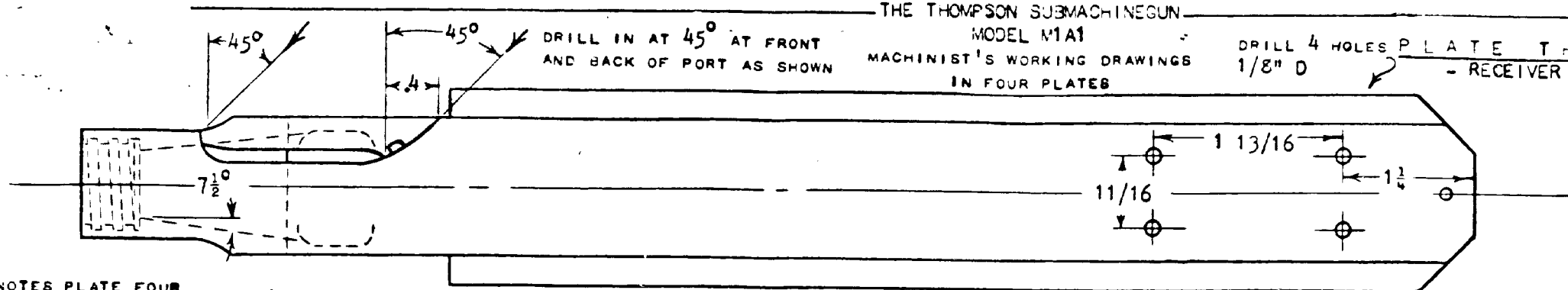
PLATE TWO
-TRIGGER HOUSING-
(ALTERED TO TAKE
M1928 BUTT-STOCK)



THE THOMPSON SUBMACHINEGUN
MODEL M1A1
MACHINIST'S WORKING DRAWINGS
IN FOUR PLATES

DRILL 4 HOLES PLATE THREE
1/8" D
- RECEIVER -

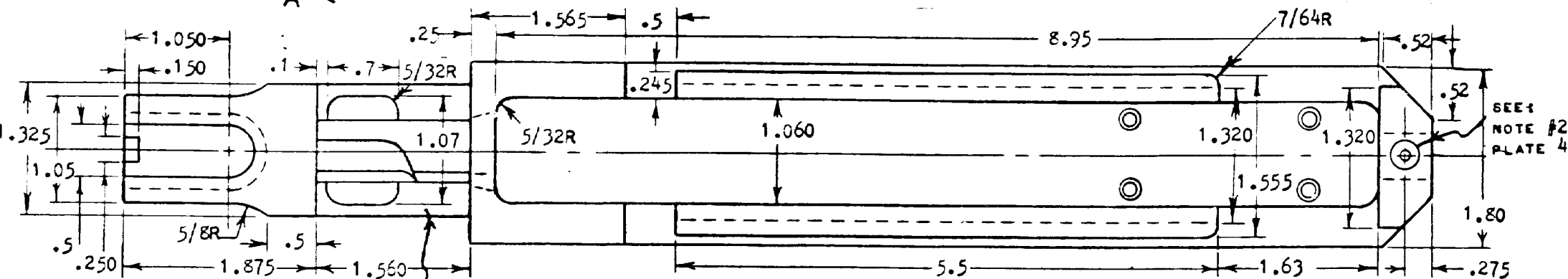
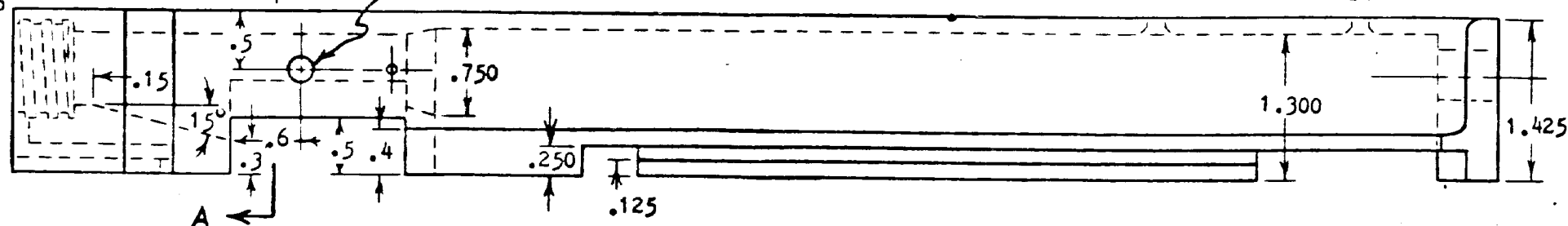
DRILL IN AT 45° AT FRONT
AND BACK OF PORT AS SHOWN



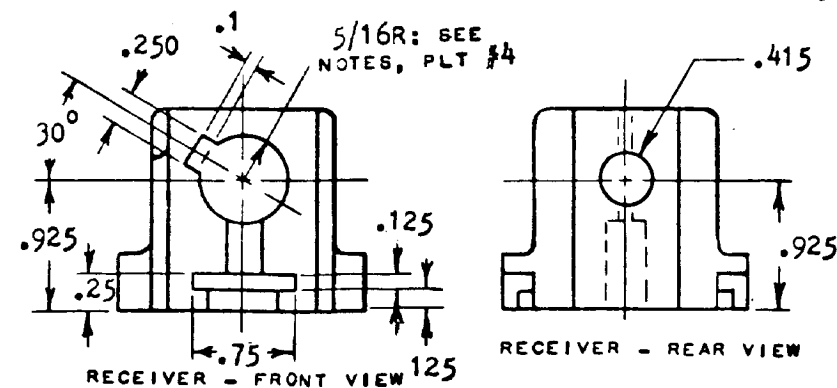
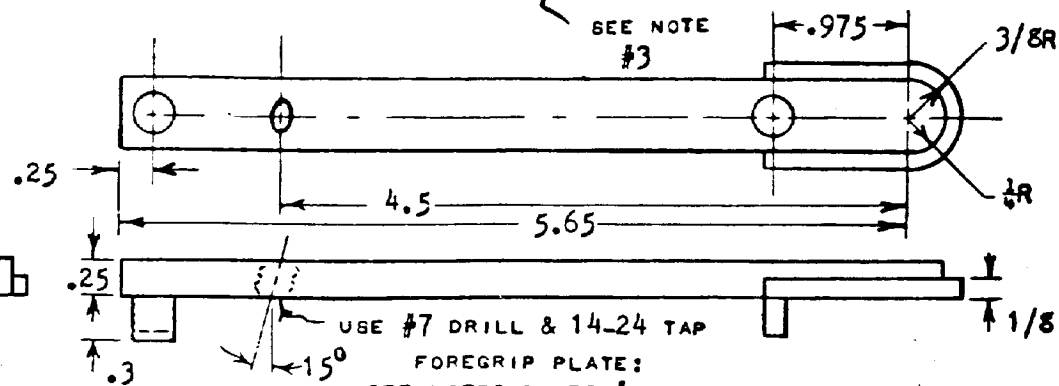
SEE NOTES PLATE FOUR
CONCERNING
THREADS AND
ANGLES OF
FEED RAMP

A

LARGE HOLE IS .20 & GOES INTO CHAMBER--SMALL HOLE IS .10; LOCATED .8 FROM OTHER



SEE NOTE
#3



RECEIVER - REAR VIEW

RECEIVER - FRONT VIEW

THE THOMPSON SUBMACHINEGUN
MODEL M1A1
MACHINIST'S WORKING DRAWINGS
IN FOUR PLATES



PLATE FOUR

1. ON ALL PLATES: MANY HIDDEN LINES HAVE BEEN ELIMINATED TO SIMPLIFY VIEWS - ONLY NECESSARY HIDDEN LINES ARE SHOWN.
2. DRILL $3/23$ LOCATING HOLE FROM TOP, THEN DRILL $.300$ HOLE FROM BOTTOM TO A DEPTH OF $.620$ (SEE REAR VIEW).

NOTES:

3. THESE TWO SURFACES ARE CUT AT 45° (SEE SEC. "A-A")
4. TWO $.3$ DIAM. ROUND BARS ARE HEAT-FITTED INTO PLATE AND THEN CUT AS SHOWN, THE FRONT ONE CUT TO FIT BARREL - THE REAR ONE CUT TO FIT SLOT IN FRONT OF RECEIVER.
5. A $5/8$ DIAM. HOLE AND SLOT ARE CUT INTO THE RECEIVER BEFORE THREADS ARE CUT (SEE FRONT VIEW), BOTH GO TO DEPTH OF 3.685 .

6. RECEIVER THREADS ARE SQUARE THREADS, 10 TPI, $.850$ MD AND $.750$ MIN D, DEPTH TO $.55$.

7. THE FLOOR OF THE FEED RAMP IS INCLINED 15° AND STARTS $.15$ INCHES FROM CHAMBER. THE SIDES OF THE RAMP SWING 7.5° TO EITHER SIDE AND START FROM THE EDGE OF THE CHAMBER WHILE STILL AT 15° FROM THE HORIZONTAL. USE A $1/2$ " DIAMETER CUTTER.

8. BARREL AND RECEIVER MUST BE HEAT-FITTED.

9. USE 4130 CHROME¹ STEEL FOR RECEIVER

