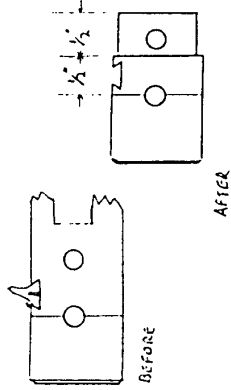
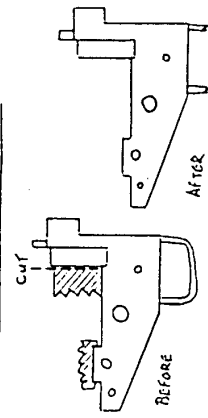


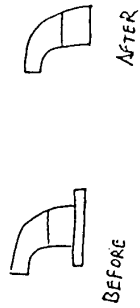
① BARREL SLEEVE



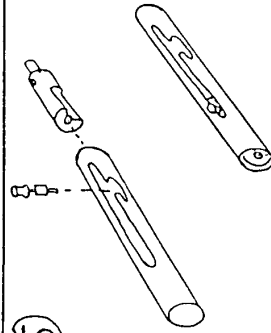
② TRIGGER HOUSING



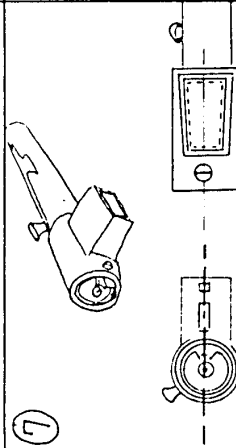
③ EJECTOR



⑥

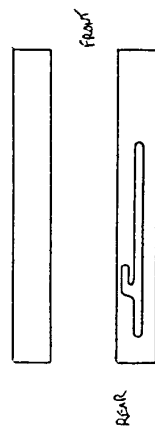


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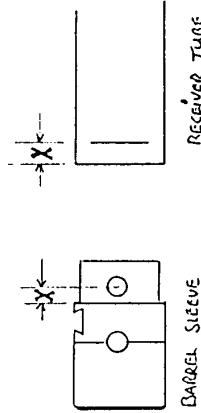


④

RECEIVER TUBE



⑤

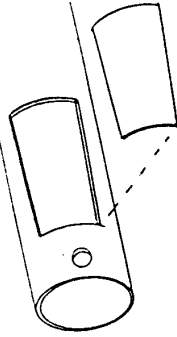


⑧

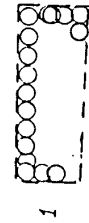


⑨

MAG PORT



⑪

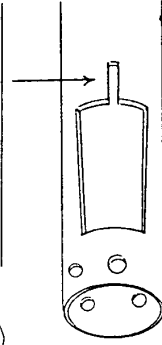


⑫



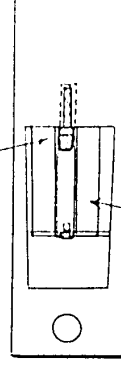
⑬

EJECTOR SLOT



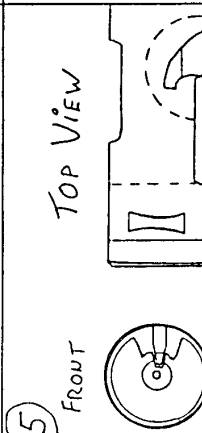
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EJECTOR

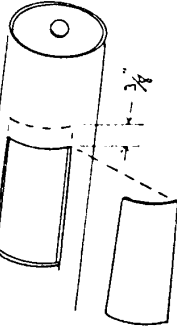


BOLT INSTALLED AS GUIDE

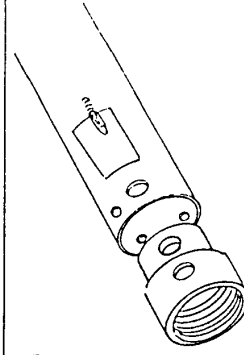
⑮



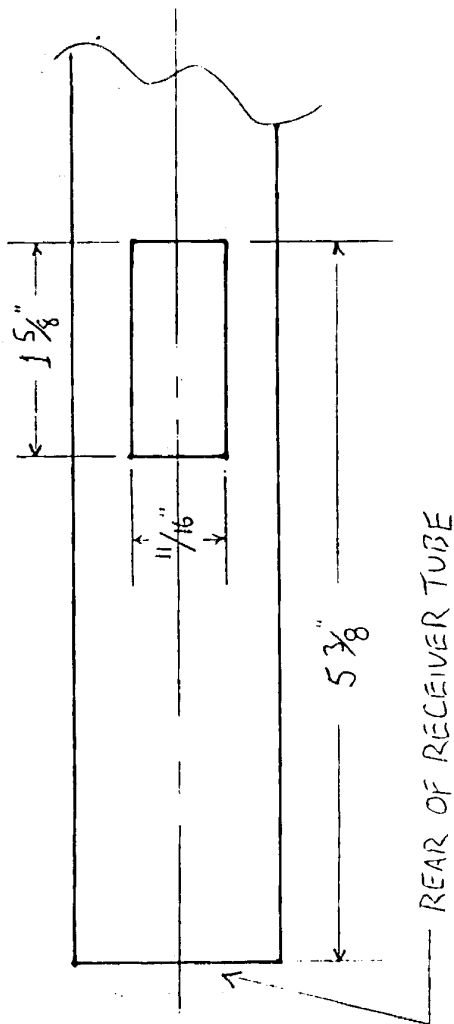
⑩ EJECTION PORT



⑯

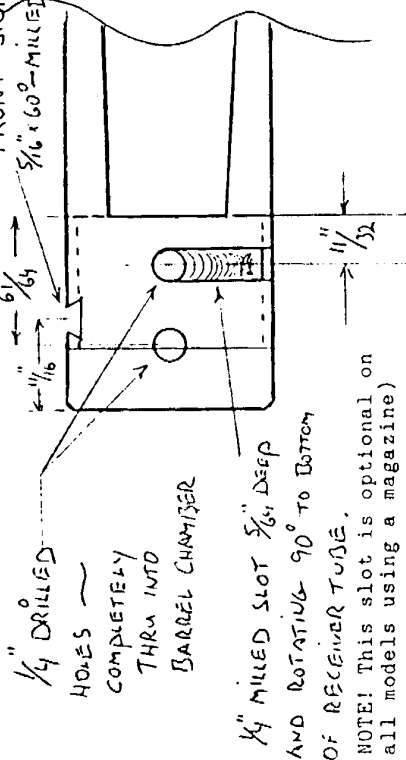


BOTTOM VIEW - SEAR SLOT



FRONT SIGHT SLOT ~ USE DOVETAIL MILL
RECEIVER .100" DEEP

(NOTE! Most all Sten guns had the front sight tack welded on as the small dovetail slot was not usually strong enough to hold sight securely. If the dovetail slot is still good on the kit barrel sleeve we suggest you use it rather than machine a new one. A small tack weld on the front of sight will hold it in place sufficiently.)



LEFT FRONT OF RECEIVER TUBE AFTER BARREL

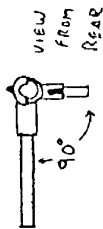
SLEEVE IS INSTALLED

NOTES:

INSTALLING BARREL SLEEVE - drill three 5/16" holes in front of receiver tube. Position the holes at points that will not interfere with 1/4" mag housing plunger & barrel ratchet holes, and front sight slot. Press sleeve in flush with front of tube, align and weld in place thru 5/16" holes.

INSTALLING EJECTOR - weld onto receiver tube thru 1/8" slot and make sure ejector reaches far enough up into bolt slot to catch shell. Insert bolt and cocking handle into receiver tube and use as a guide jig when welding in ejector. Grind welds flush to allow mag housing to slip over sleeve & ejector welds.

INSTALLING TRIGGER HOUSING - install mag housing and mag to insure it is at a 90° relation to trigger housing.



Install bolt in receiver tube behind area to be welded to act as a heat sink. This will help to eliminate burn thru when welding trigger housing to receiver tube. Use as little heat as possible on all welds to avoid warpage. All holes, ports, and slots should be deburred prior to welding. Check fit of parts to be assembled on receiver tube before, during and after welding.

REPLICA NOTES: weld 1/4" thick round disc to back of barrel sleeve before welding sleeve into tube. Do not cut mag port or slot for ejector. Do not install ejector. Grind off of bolt the firing pin and the feed lips (or weld bolt face solid). Drill a 3/8" hole into barrel chamber and weld barrel to barrel sleeve before welding on 1/4" thick disc (above mentioned). Cut magazine feed lips off and weld a plate on mag top. Do this so magazine can still be inserted into mag housing. Rotate cocking slot up or down about 1/4" before cutting ejection and sear ports.

see illustration #34, 35, 36

(read through all notes before cutting any metal or welding!)

STEPS

(refer to corresponding illustration number)

1. Drift out front sight (most sights were tack welded or brazed on so some file work is needed to remove). Trim receiver tube off of barrel sleeve. Leave $\frac{1}{8}$ " of receiver tube on sleeve (the part with front sight dove tail slot). Leaving this $\frac{1}{8}$ " piece on sleeve eliminates necessity of having to recut a sight dove tail.
2. Cut off residue of old receiver tube at head casing leaving portion with "J" slots intact in head casing. Also trim off residue piece of tube on two front tabs leaving as much of tab as possible.
3. Trim residue piece of tube off of ejector. If a new blank ejector is supplied with kit grind it to shape as per drawings.
4. Cut cocking slot in blank tube as per drawings.
5. Measure dimension X on barrel sleeve as per illustration and transfer this measurement to front of receiver tube. Scribe a mark on side of tube opposite of cocking handle. This will be reference for the mag housing plunger pin hole.
6. Slide bolt into receiver tube and insert cocking handle. Slide assembly forward.
7. Slip on mag housing and align with bolt as per illustration. Align mark from step 5 in center of plunger pin hole. While holding mag housing in position as a temp plate mark on tube the locations for plunger hole, mag port, and ejection port.
8. Strip receiver tube and drill a $\frac{1}{8}$ " mag housing plunger pin hole. Insert barrel sleeve to check alignment.
9. Machine out the mag port. (omit this step on single shot & replicas)
10. Machine out ejection port (note that front of ejection port in tube is $\frac{3}{8}$ " back from mark of mag housing port.)
11. The machining of steps 9/10 can best be done on a mill, but also can be done using a $\frac{1}{4}$ " drill. Drill holes all the way around the port to be cut out. Carefully punch out port and hand file or grind rough edges smooth.
12. Drill three $\frac{1}{8}$ " holes at points illustrated. These should be about $\frac{3}{16}$ " back from front edge of tube.
13. Cut ejector slot ($\frac{1}{8}$ " wide x $\frac{1}{2}$ " long) on back middle of mag port as per illustration. (omit this step on replica)
14. Insert bolt with cocking handle into tube and position bolt about half way open to use as a guide in welding ejector in place. Ejector will be welded from outside through slot. Use long needle nose pliers to hold ejector while welding in place.

15. Immediately after welding ejector check bolt to ejector clearance. If ejector sits too close to bolt it will hang up during firing. If ejector sits too far out from bolt it will not eject the brass. To correct any spacing problems, while weld is still hot, tap with small hammer on hot weld to move ejector in, or tap on bolt through ejection port to drive ejector out. Remove bolt assembly.
16. Insert barrel sleeve and align mag housing plunger pin holes. While firmly holding tube to barrel sleeve weld the two pieces together through the three $\frac{1}{8}$ " holes of step 12. Dress welds so mag housing is a tight slip fit over tube.
(If you have access to a mill and a rotating fixture you can now cut mag housing plunger pin slot as per dimension drawings. This is an optional procedure).
17. Make sure the length of receiver tube is correct*. If not trim off the proper amount from the rear of tube. Install all trigger parts into trigger housing. Hold receiver tube against trigger housing in position in which it is to be welded. Installing mag housing and a mag will help in making sure trigger housing is 90° to mag housing. While firmly holding assembly together note position of rear through space at tabs on trigger housing. Mark on tube just behind rear (RM). This will be mark indicating rear edge of rear port. Holding trigger all the way back, note forward position of trip lever (disconnector). Mark in front of trip lever about $\frac{1}{8}$ " (RM). This will be mark indicating front edge of rear port.
18. Strip trigger housing and reinstall on receiver tube. When aligned as before scribe along the inside of both sides of trigger housing near tabs. This will be right and left of rear port. Cut out rear port as per dimension drawings.
19. Reinstall trigger parts and check fit and operation of rear port. Rear tang of rear should catch on back of rear port to limit upward travel of rear. Trip lever in complete forward position should just miss front of rear port when pulled down. Rear should clear sides of rear port. Hand file to correct any errors.
19. Assemble bolt, mag housing/mag assembly, and stripped trigger housing to receiver tube assembly. Align trigger housing 90° to mag housing and holding (or clamping) complete assembly together tack weld together. After checking for alignment finish welding.
- After welding check travel of bolt. Assemble completely and check weapon manually. Test fire gun. If all is well gun is ready for final finish.
20. On compact models remove $\frac{1}{8}$ " from bolt and weld back together as shown. On Son of Sten compact also cut all of spring guide off of back of bolt except for $\frac{1}{8}$ " as illustrated. On models that feed from the right or top or bottom - you will need to cut the bolt and rotate to the proper position and weld. Also rotate the mag port and the ejection port to the proper position on the receiver tube before cutting them out.

* Over-All-Length of standard SMG tube when ready to be welded to barrel sleeve and trigger housing is about 11". Compact models are 8 $\frac{1}{2}$ ". Single shot & semi auto are same as SMG. Replica is also same as SMG.