9mm semi automatic pistol

(Closed bolt striker fired operation)
**Receiver**

247mm long

**Top:**
- Top slot - 7" long

**Right Side:**
- Ejection port
- 28mm
- 19mm
- 56mm

**Left Side:**
- Ejector hole
- 5mm (tap for M6 bolt)
- Cocking handle slot - 4" long
- 8mm

185mm

2 inches

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30mm dia mild steel round tube
2mm thick wall
Receiver (Bottom)

28mm

40mm

24mm

Magazine port

85mm

Sear slot

15mm

60mm

2 inches

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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.
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
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.

Magazine catch housing

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

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

Spring hole: 8mm

8mm x 15mm compression spring

Drill through both pieces with 10mm bit

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

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

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Bolt

Turn on a lathe from 1” mild steel round bar

100mm

Bore a 3mm dia hole through center

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.

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
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)

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