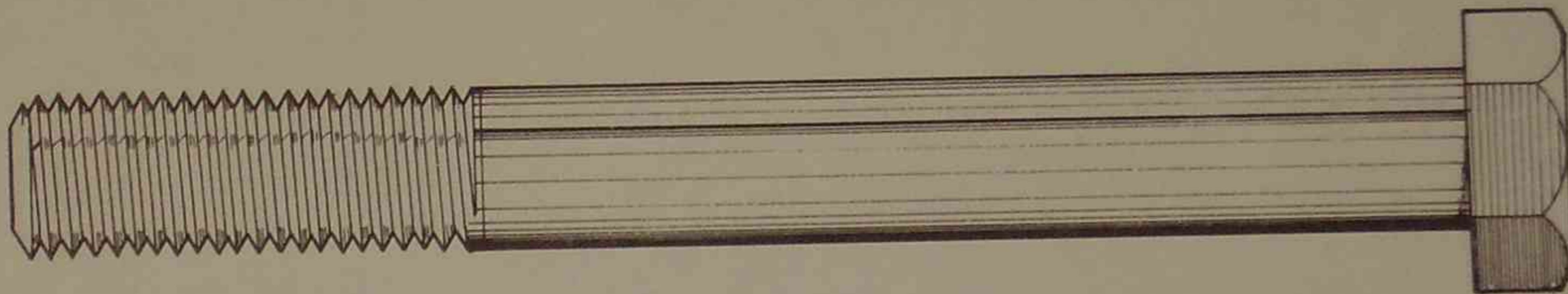


BOLT GUN



.22 L.R. CAL. DEFENSE WEAPON

DISCLAIMER: THE DRAWINGS HEREIN ARE SOLELY INTENDED FOR THE EDIFICATION AND ELUCIDATION OF THE READER. SARDAUKAR PRESS DISAVOWS ANY RESPONSIBILITY FOR APPLICATION OF THESE DRAWINGS TO ANY PURPOSE OTHER THAN THE USE STATED ABOVE.

WARNING: IT IS A VIOLATION OF FEDERAL LAW SUBJECT TO FINE AND / OR IMPRISONMENT TO MANUFACTURE THIS OR ANY FIREARM WITHOUT A LICENSE.

GENERAL NOTES

The BOLTGUN is a single shot, .22 long rifle caliber personal defense weapon disguised as a common 7/8" diameter, 8 inch long, galvanized bolt. Most of the components of the BOLTGUN are off the shelf items which can be found in any good hardware store. The only essential power tools are a drill press and Dremel hand grinder. The usual assortment of hand tools and a modicum of skill are also needed.

Undoubtedly, the hardest task is drilling the 29/64" hole down the center of part #5. V Blocks or a machinist's vise are helpful. Even so, it may take more than one try. Centering the hole is crucial to the effort. The 5/16" hole through part #2 is easier only because the piece is shorter. It is advisable to use the drill press chuck as the tap holder when cutting internal threads. If the tool is not perpendicular to the work, another piece of scrap is created.

The alternate design which eliminates one set of internal threads as well as part #12 is not recommended because of the difficulty of drilling the 29/64" hole entirely from one end. Although it is easier to drill the hole half way from either end, another threaded part is required.

Part #9 is turned down from 1/2" to 29/64" by chucking a piece of 1/2" bolt in the drill press and reducing the diameter with a file or grinder. Likewise, the 5/16" drill bit may be held in a machinist's vise while part #9 is chucked in the drill press to assure a centered hole. Part #9 may be fashioned entirely in the drill press and cut to length with a hacksaw while being turned to assure a square cut.

INSTRUCTIONS

1. Cut bolt into three sections: threads, shaft and head to use for parts #7, #8 and #13 respectively.
2. Drill 5/16" hole through #1. Drill 29/64" hole to indicated depth and cut threads with 1/2-20 tap.
3. Drill 29/64" hole through #8 (hint: drill hole half way from each end. Cut threads with 1/2-20 tap.
4. Drill hole in #13 and cut threads with 12-24 tap.
5. Cut 3" section from 1/2" bolt for #4. Cut 1/2-20 threads for 2". Drill 5/16" hole as shown. Cut #4 to length and square face. Drill 3/32" firing pin hole. Taper end to seat against bottom of hole in #2.
6. Grind #6 using Dremel hand grinder and #409 cutting wheel. Use #11 to locate 3/32" hole through side of #4 and drill same. Cut spring #5 and pin #7 to fit.
7. Cut 3" section from 1/2" bolt for #12. Cut 1/2-20 threads for 1". Drill 13/64" hole. Cut to length.
8. Drill 29/64" hole in scrap metal for gauge. Cut 3" section from 1/2" bolt for #9 and chuck in drill press. Reduce diameter of #9 until it will pass through gauge. Drill hole and tap 12-24 threads. Cut to length.
9. Cut #10 to length and tap both ends as shown.
10. Cut #1 to length. Drill chamber with #1 (wire size) bit using .22 l.r. round to gauge proper depth. Screw #4 tightly into #2. Place .22 round into #1 and insert into #2 (to set headspacing). Glue #1 into #2 using rear view mirror adhesive or Loctite and allow to set overnight. Grind end of #1 flush with #2.

11. After #1/#2 have set, screw #4/#5/#6/#7 into #2 with .22 round in chamber. Put drop of Loctite on exposed threads and screw on #8.
12. Assemble #9/#10/#11 and slide into #8. Adjust threads until #9 contacts #4 at the same time #11 contacts #8. Loctite #9 to #10.
13. Remove #13 from #10. Insert #9/#10/#11 into #8. Screw in #12 and screw on #13. The work is now finished.
14. To complete the camouflage, press a small piece of paraffin into the barrel and touch up with Testors #1146 gloss enamel silver paint.

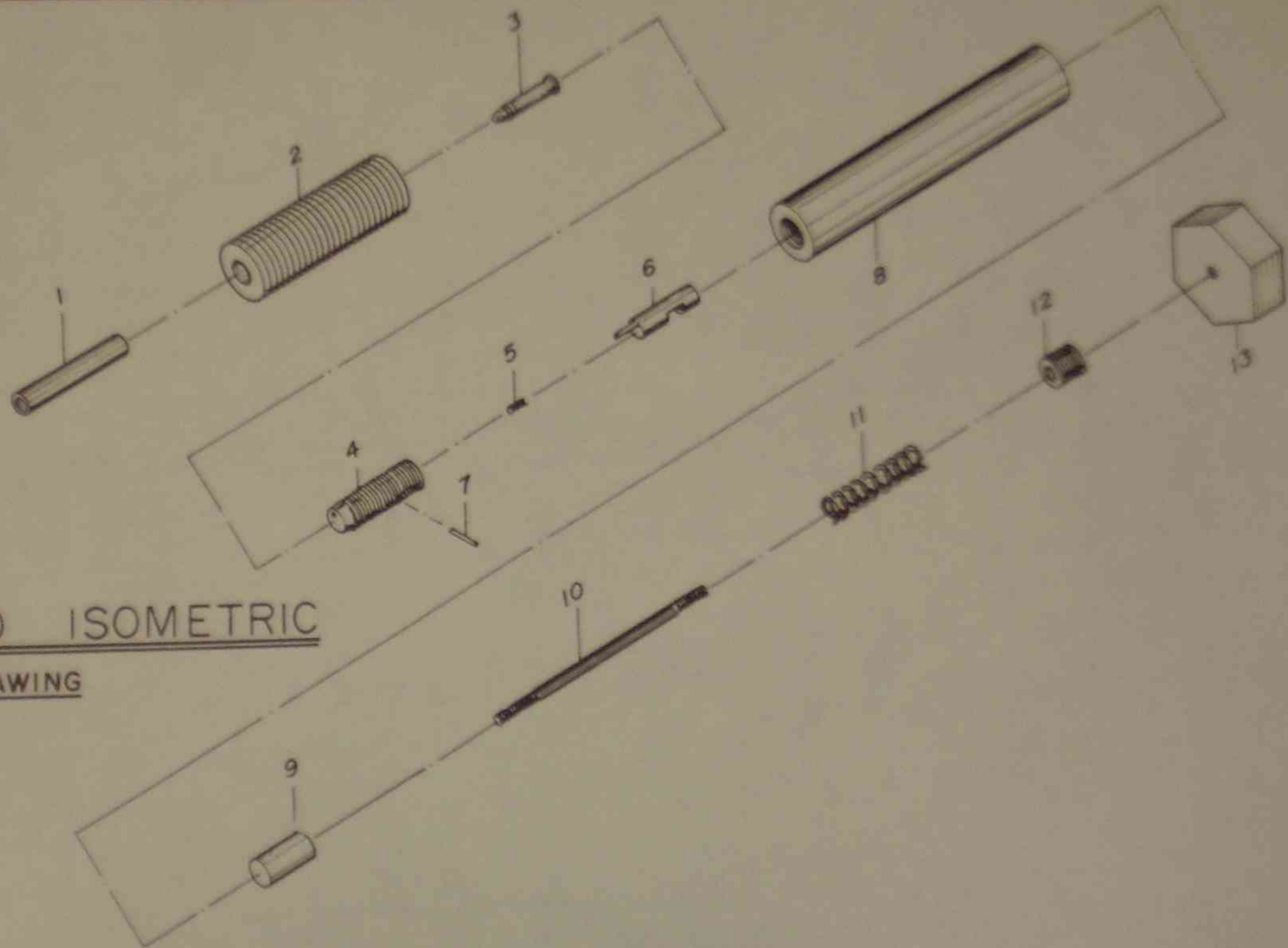
TOOLS AND EQUIPMENT NEEDED

Drill bits: #14, 29/64", 5/16", 13/64" & 3/32"
Machinist's vise and/or "V" blocks
Thread taps: 1/2-20 & 12-24
Dremel electric hand grinder
Dremel bits: #402 & #409
.22 l.r. bullets
Center punch
Drill press
Cutting oil
Hacksaw
Pencil
Hammer
Ruler

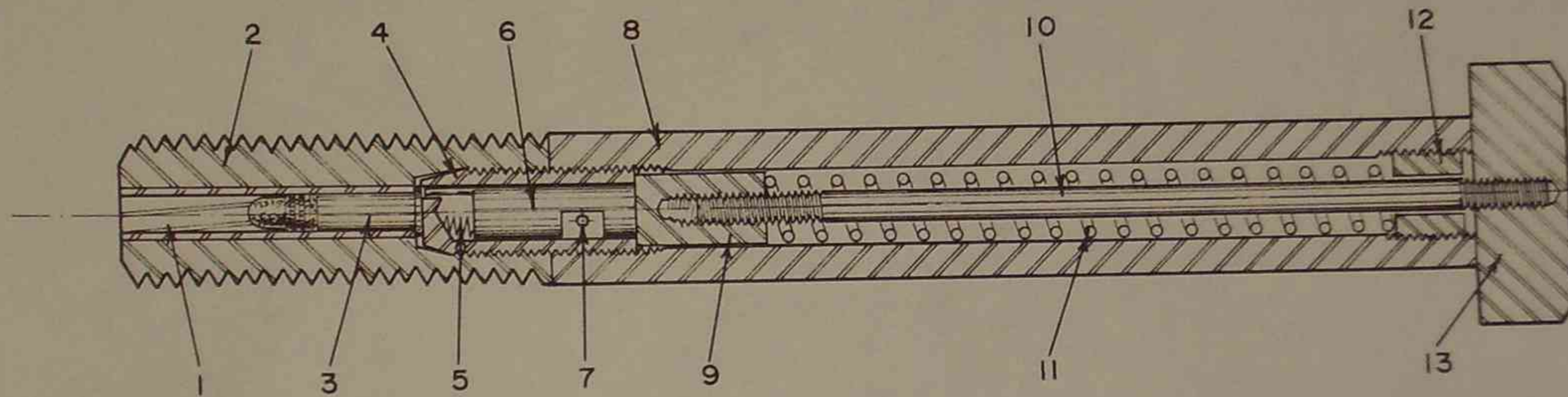
OTHER SARDAUKAR ORIGINALS

ZAPPER -Cigarette lighter gun
BUCKLER-DbI bbl belt buckle
BLITZER-High explosive bullets
TATTTLER-Trip wire sentry alarm
PENGUN -Writing/firing pen gun
ROCKER -AR7 full auto conversion
FOGGER -pen/smoke bomb
CANEGUN-Silenced walking stick gun

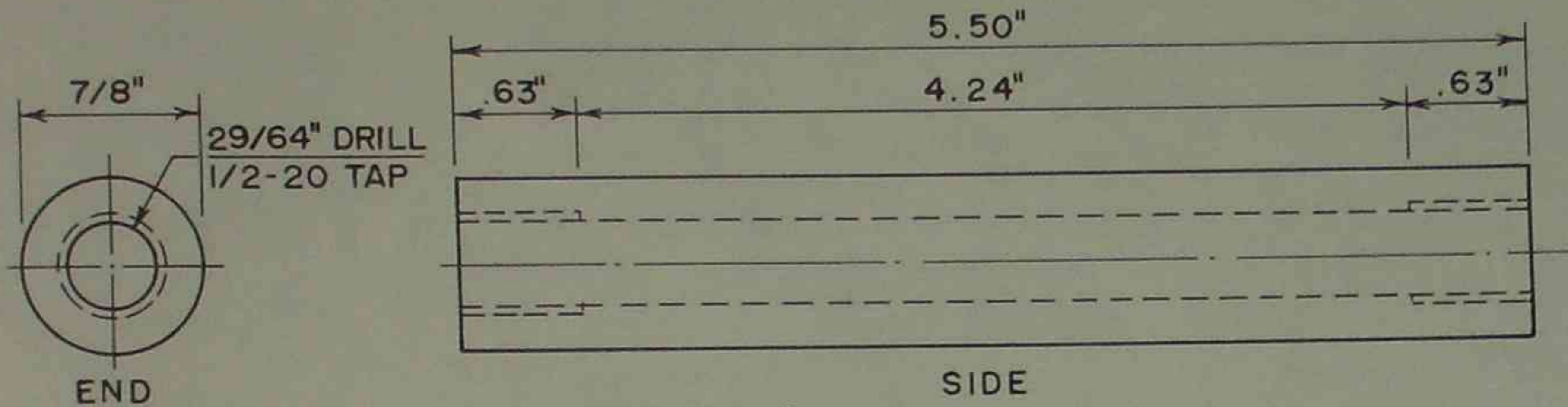
SARDAUKAR PRESS
P.O. Box 38531-D
Germantown, TN 38138



EXPLODED ISOMETRIC
HALF SIZE DRAWING

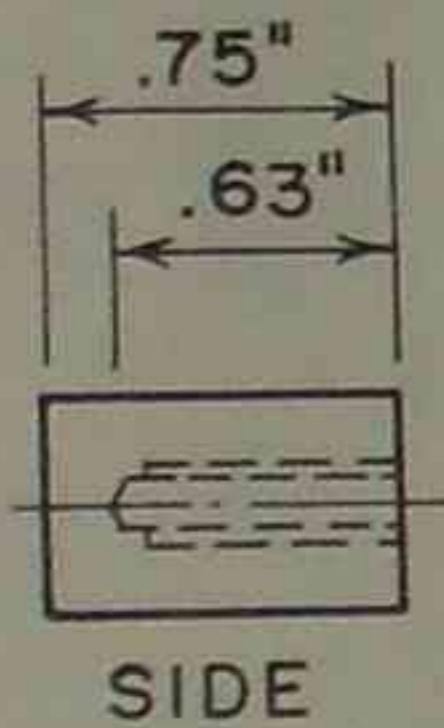
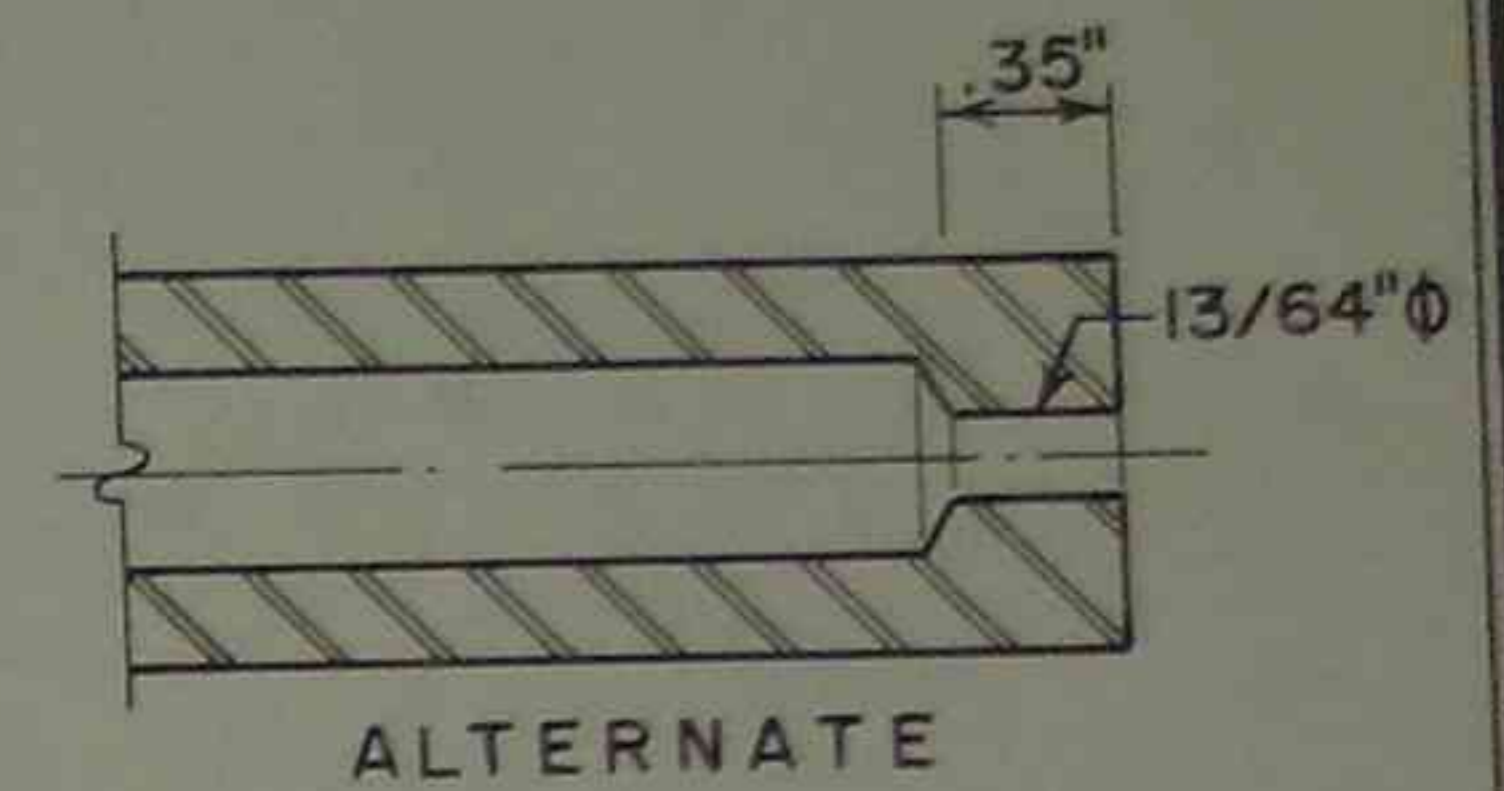


LONGITUDINAL SECTION
FULL SIZE DRAWING



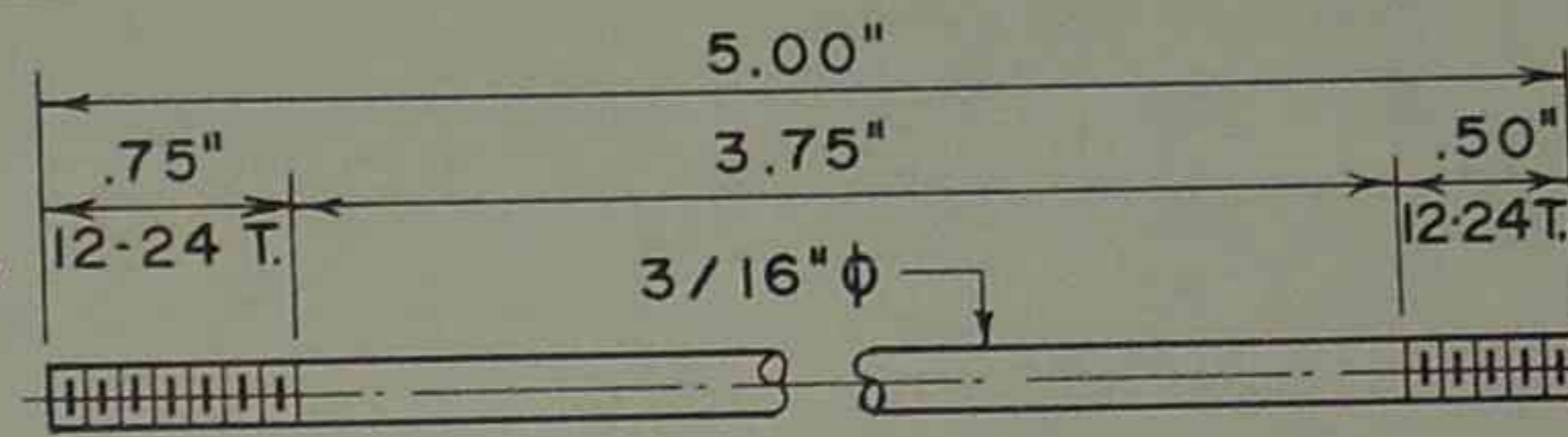
PART NO. 8

1" = 1"



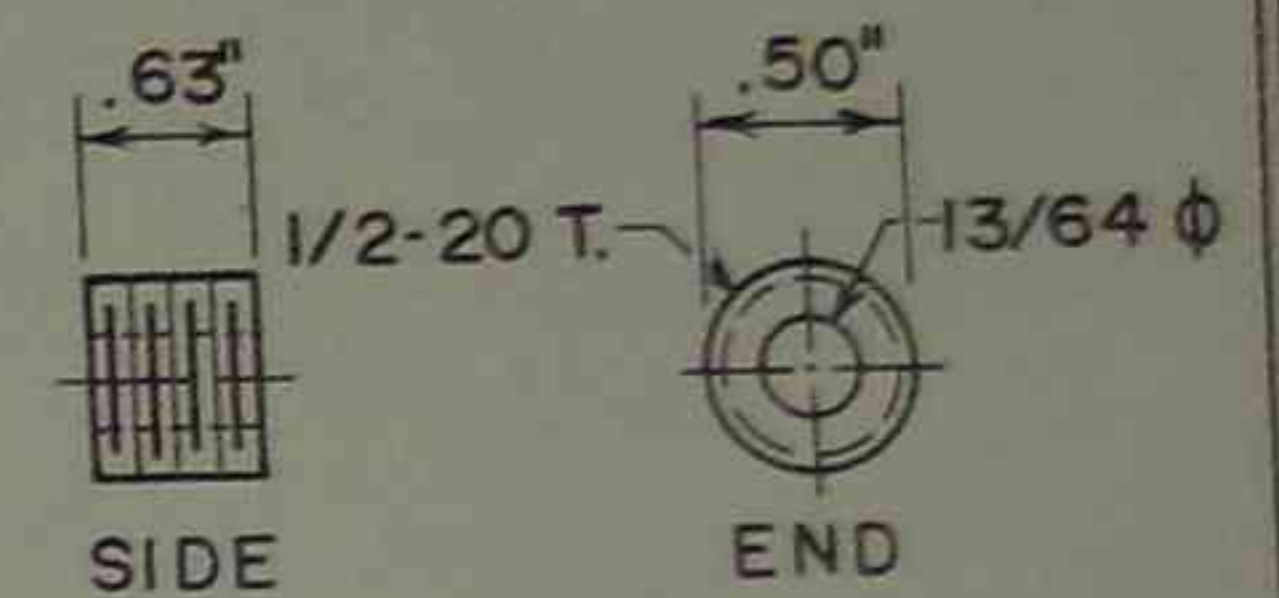
PART NO. 9

1" = 1"



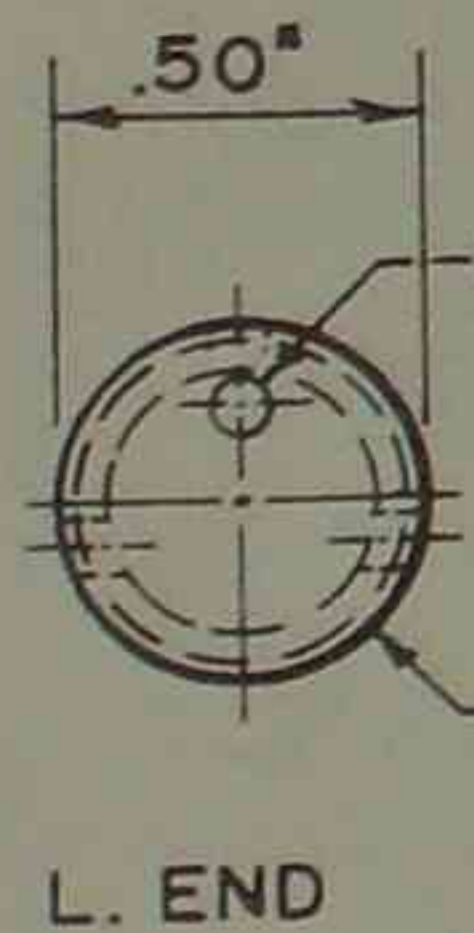
PART NO. 10

1" = 1"



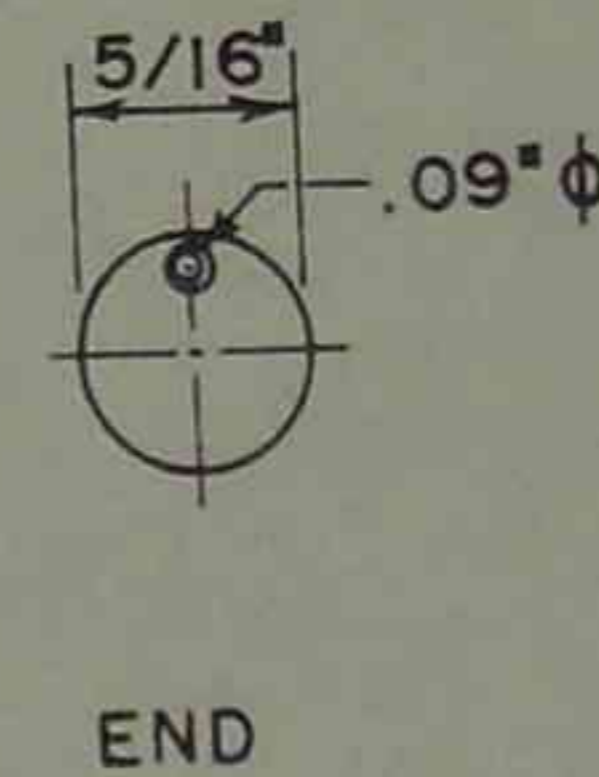
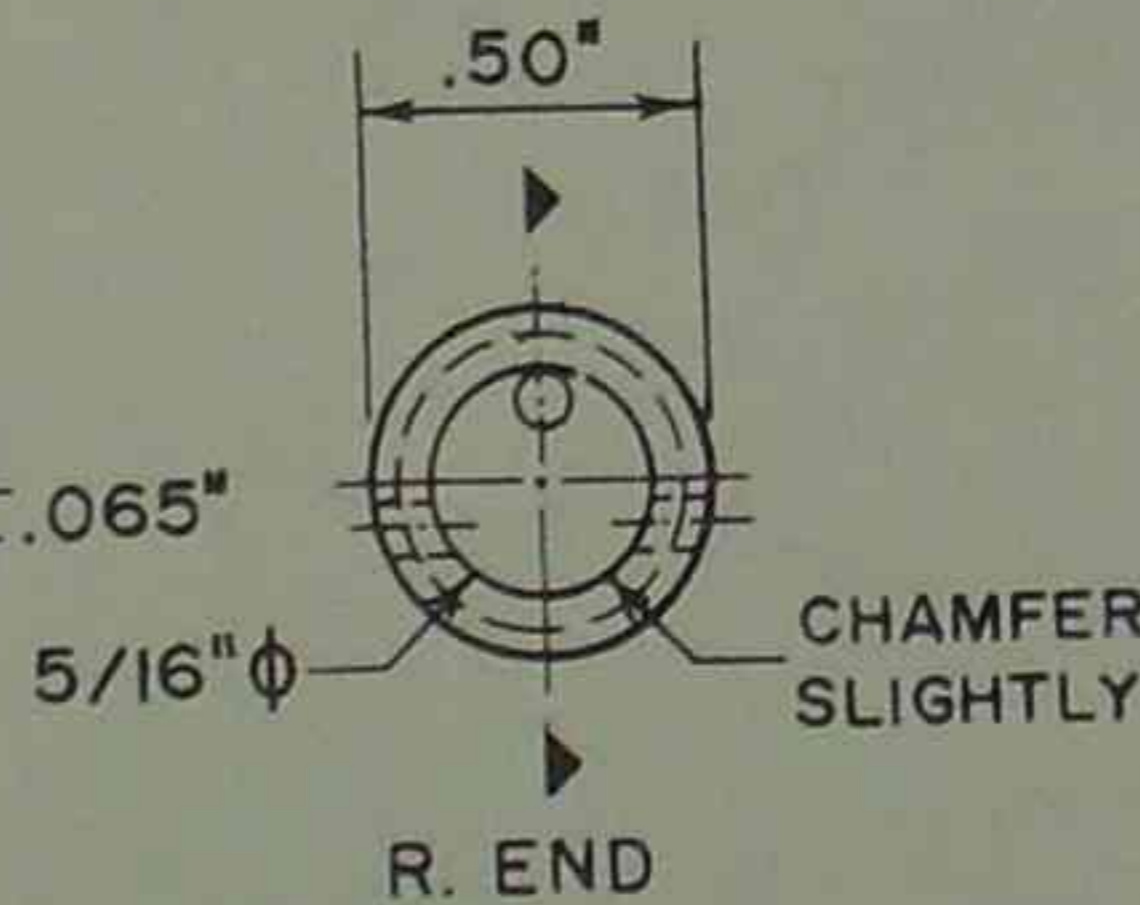
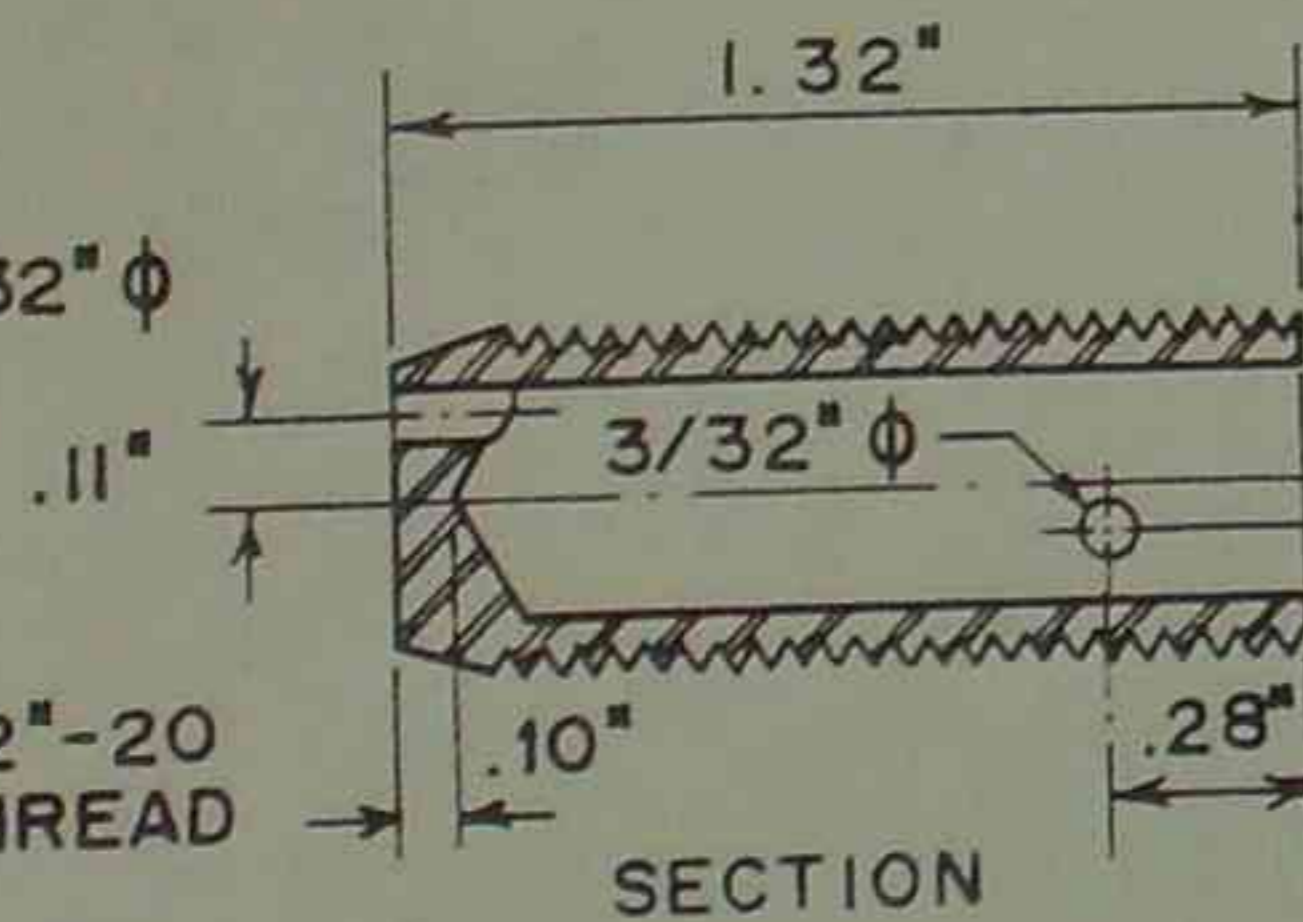
PART NO. 12

1" = 1"



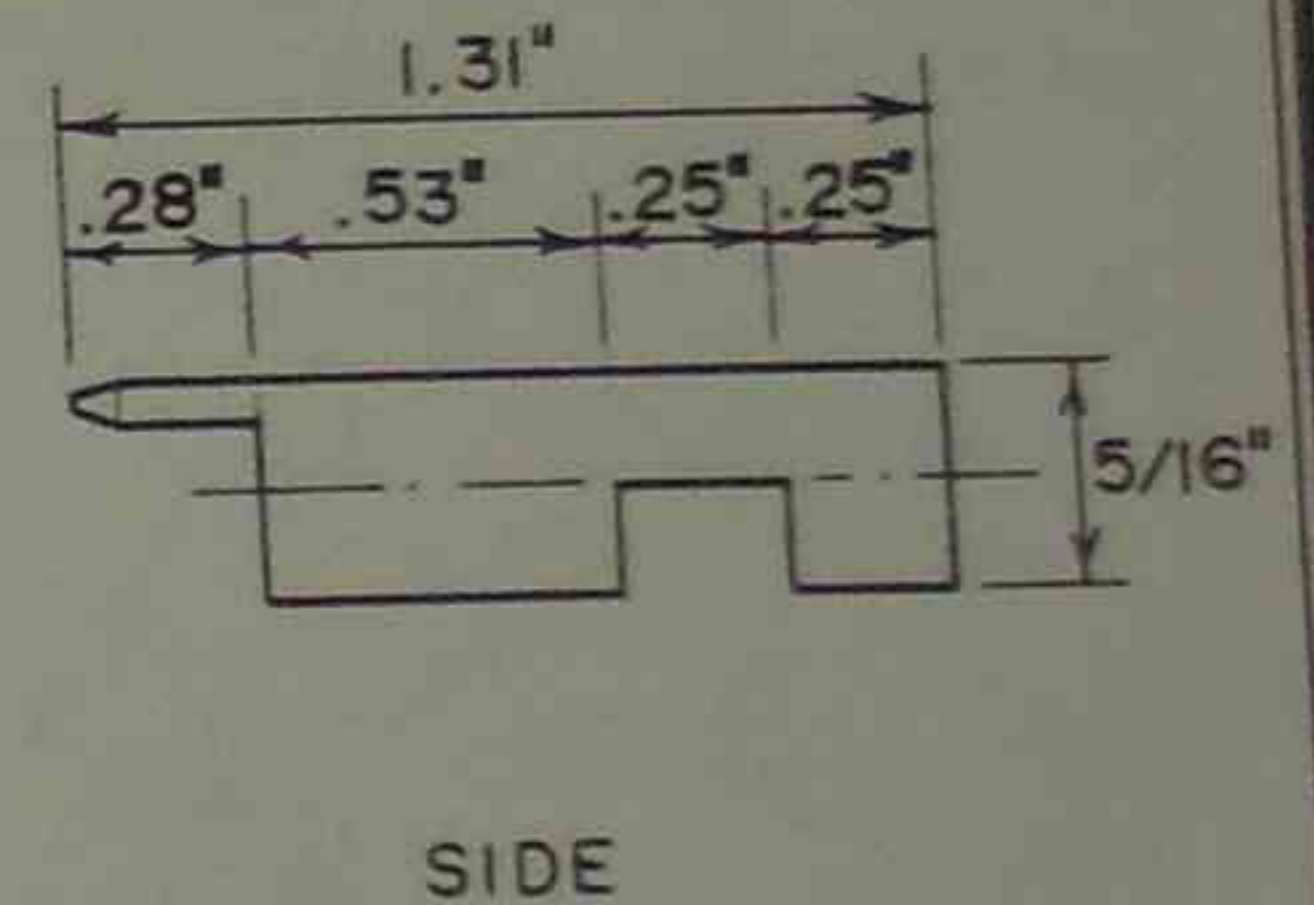
PART NO. 4

3" = 2"



PART NO. 6

3" = 2"



PARTS SCHEDULE

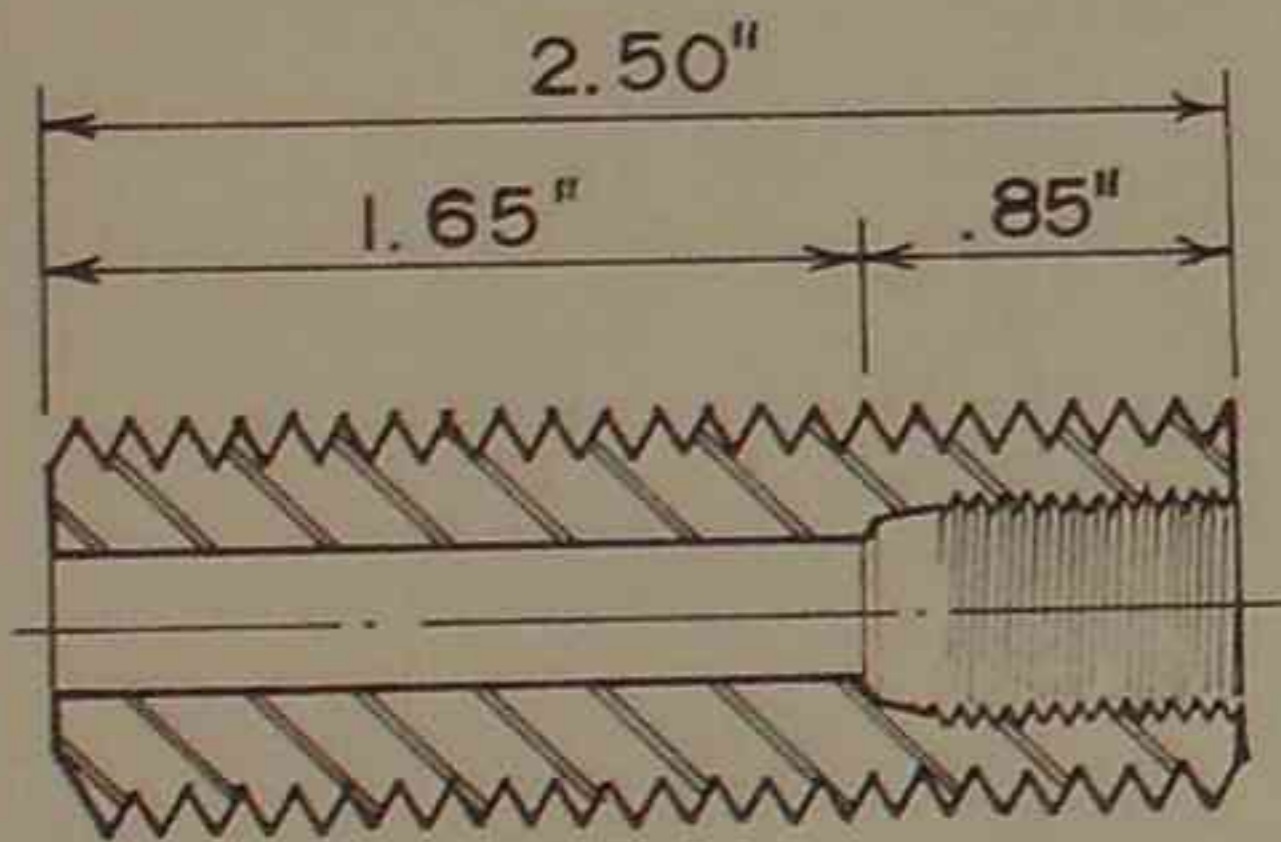
NO.	NOMENCLATURE	MATERIAL	SOURCE	MFGR	MFGR NO.	COMMENTS
1	BARREL (RIFLED)	STEEL	-	1	5L-12R46	MAIL ORDER ITEM
2	THREADS	STEEL	1	2	P2144-900B	7/8" X 8" GRADE 2 BOLT
3	.22 L.R. BULLET	COMPOSITE	2	-	-	
4	BREECH PLUG	STEEL	1	2	P2144-903B	1/2" X 10" GRADE 2 BOLT
5	FIRING PIN SPRING		3	-	-	FROM RETRACTABLE BALL POINT PEN
6	FIRING PIN		1	-	-	5/16" DRILL BIT
7	FIRING PIN RETAINING PIN			3	506	3/32" MUSIC WIRE
8	SHAFT			2	P2144-900B	7/8" X 8" GRADE 2 BOLT
9	HAMMER			2	P2144-903B	1/2" X 10" GRADE 2 BOLT
10	COCKING ROD			4	R36103	3/16" O X 36" GALV. ROD
11	MAINSRING			5	32	
12	SHAFT PLUG			2	P2144-903B	1/2" X 10" GRADE 2 BOLT
13	HEAD			2	P2144-900B	7/8" X 8" GRADE 2 BOLT

LOCAL SOURCE LISTING

1	HARDWARE STORE
2	SPORTING GOODS STORE
3	SUPERMARKET

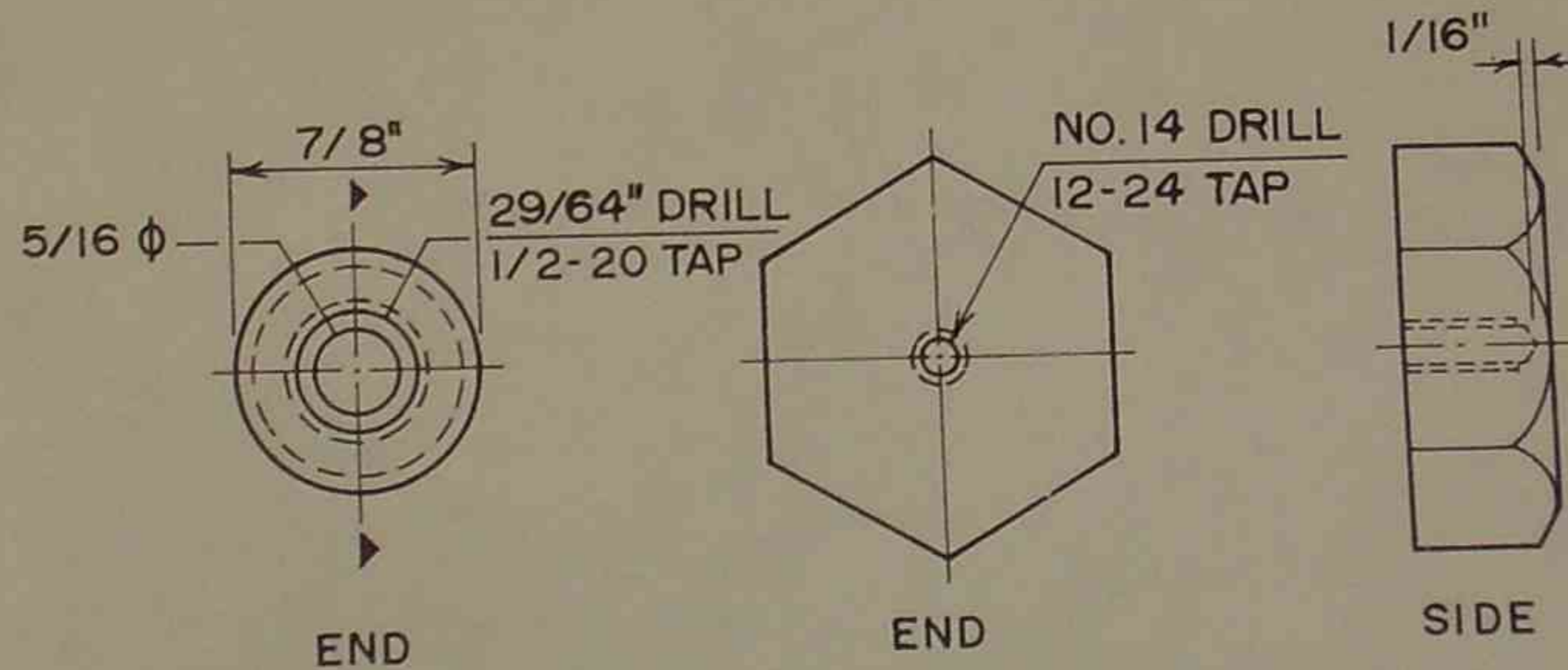
MANUFACTURERS LISTING

- BROWNELL'S INC.
ROUTE 2, BOX 1
MONTZUMA, IA 50171
- ROCKFORD PRODUCTS
P.O. BOX 6306
ROCKFORD, IL 61125-1306
- K & S ENGINEERING CO.
6917 WEST 59th ST.
CHICAGO, IL 60638
- MEDALIST
9375 WEST CHESTNUT
FRANKLIN PARK, IL 60131
- SERVALITE PRODUCTS
EAST MOLINE, IL 61244



SECTION

PART NO. 2
1" = 1"

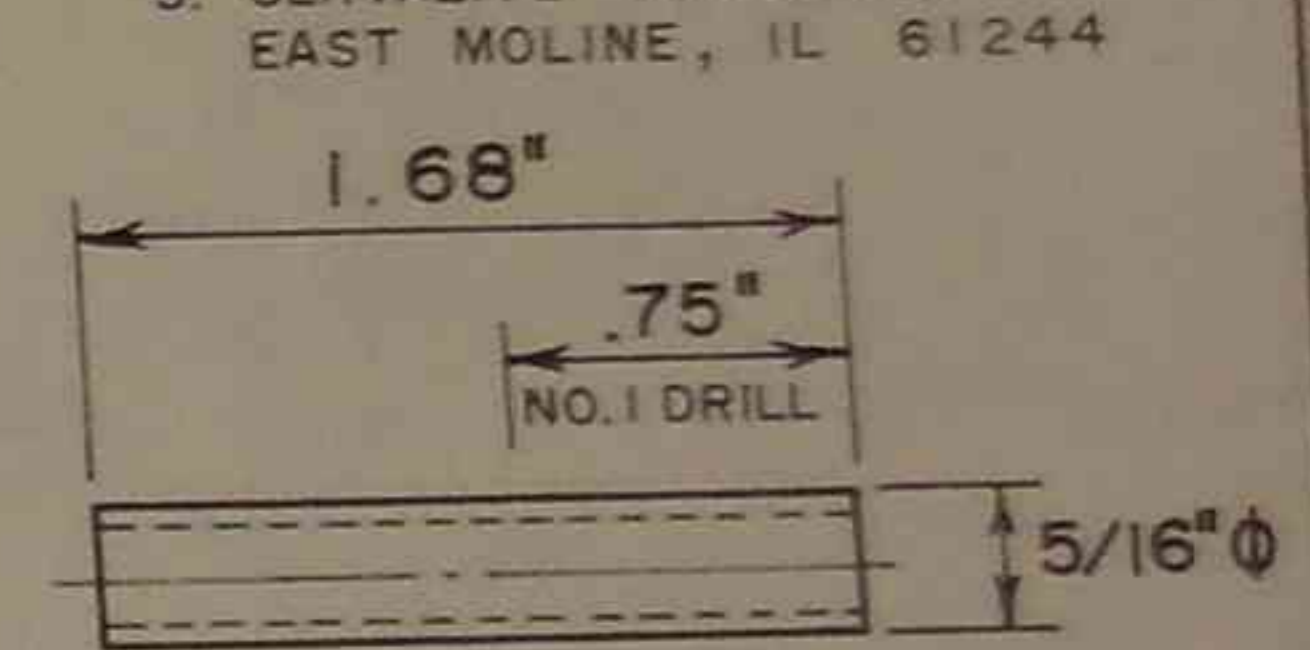


END

END

SIDE

PART NO. 13
1" = 1"

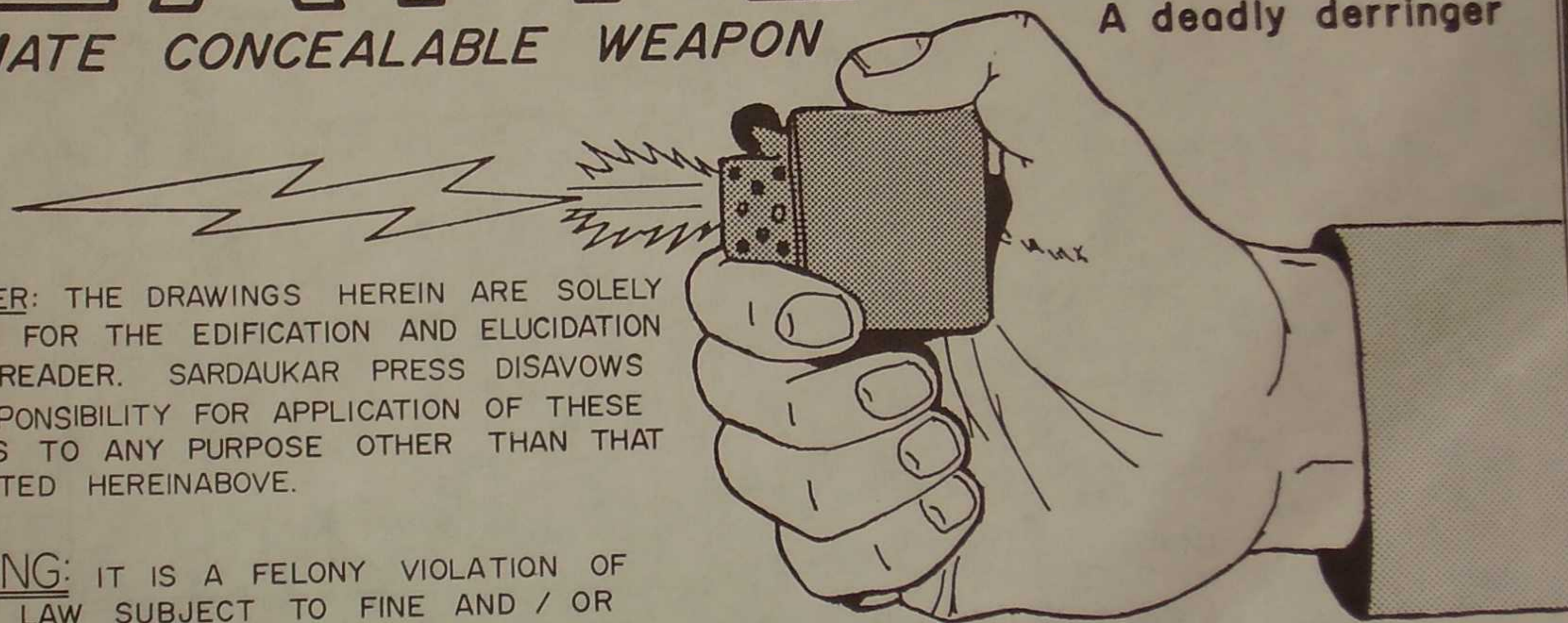


PART NO. 1
1" = 1"

The **ZAPPER**

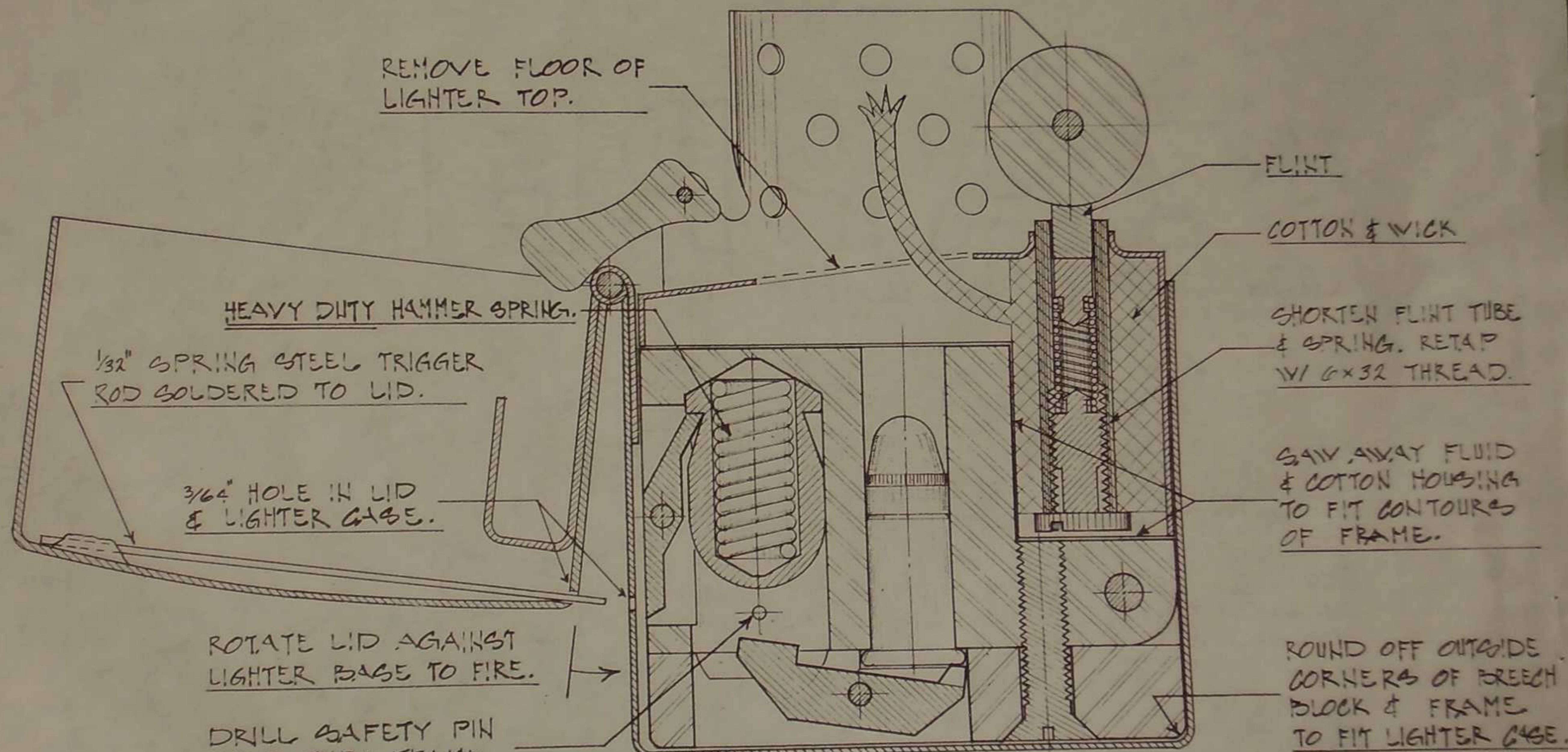
ULTIMATE CONCEALABLE WEAPON

**A functional lighter
A deadly derringer**



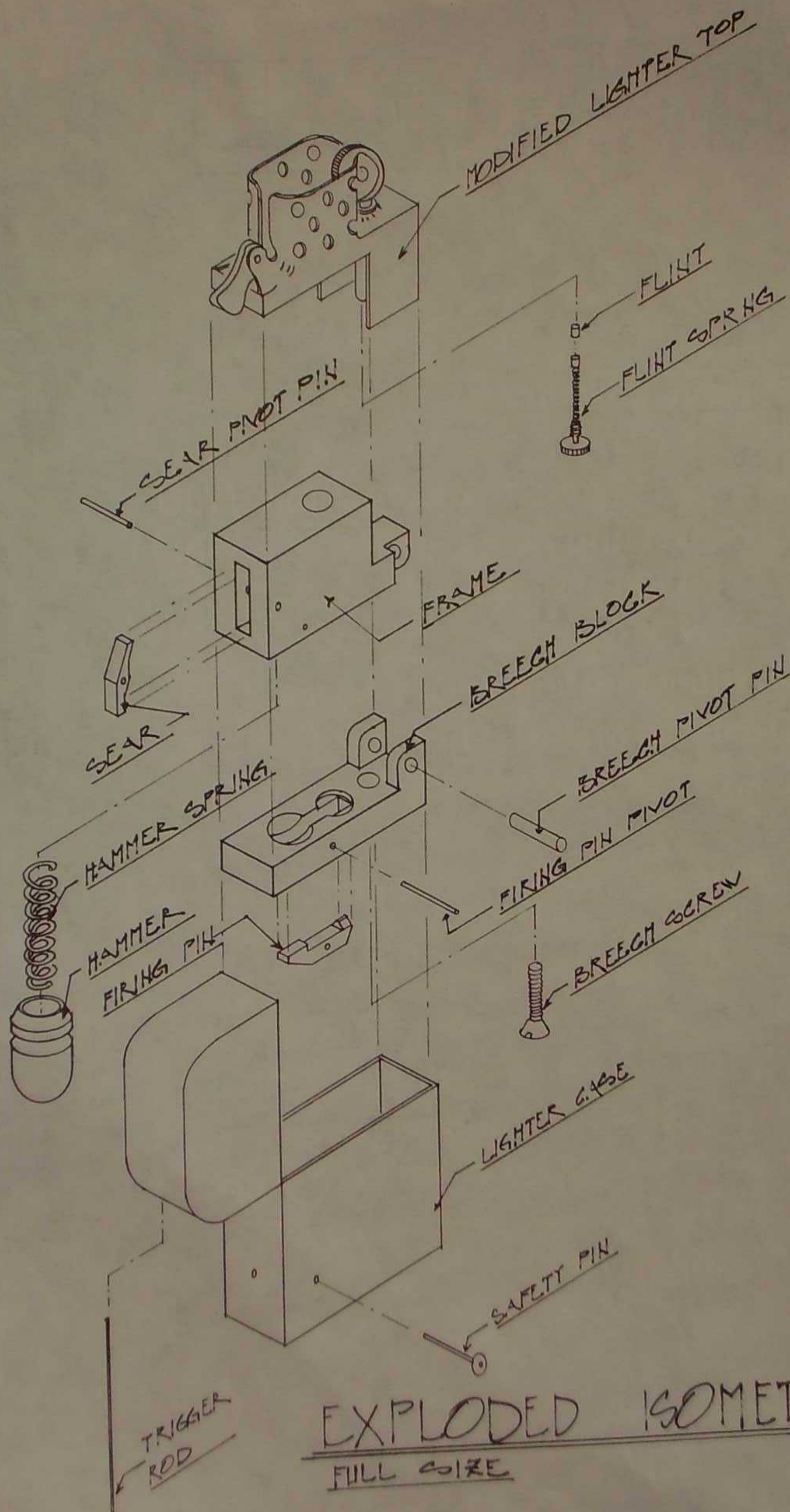
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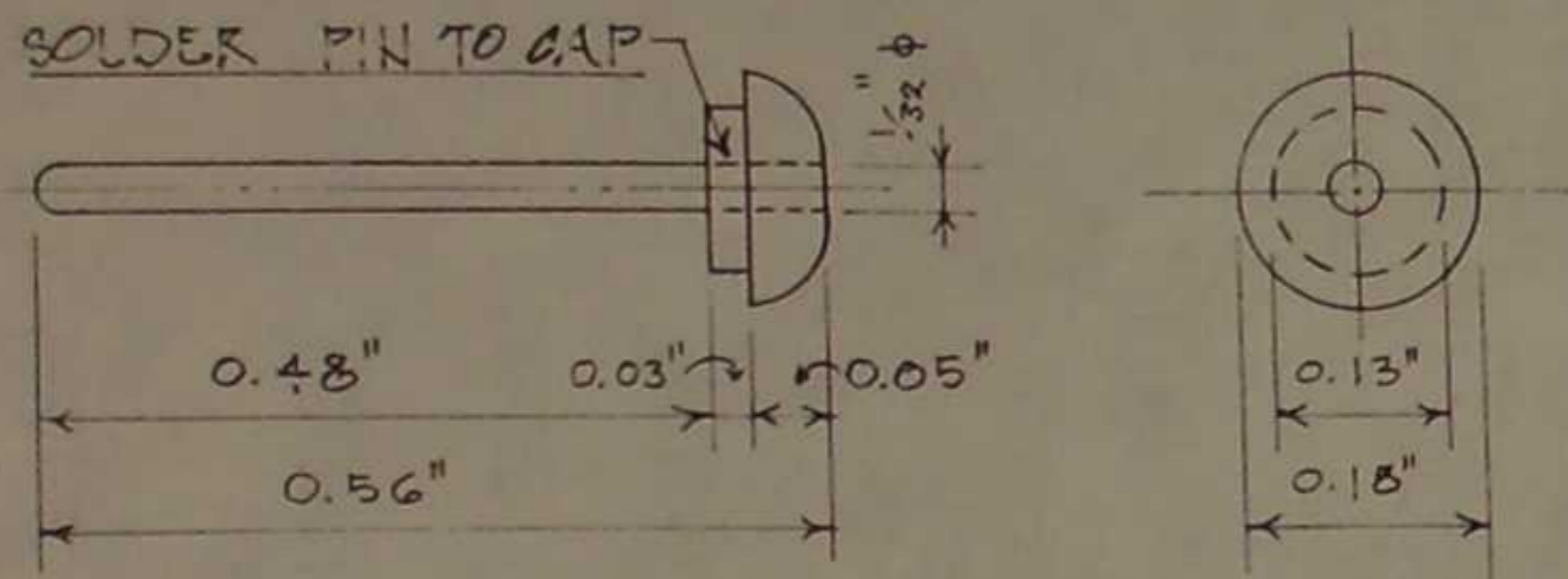


SECTION

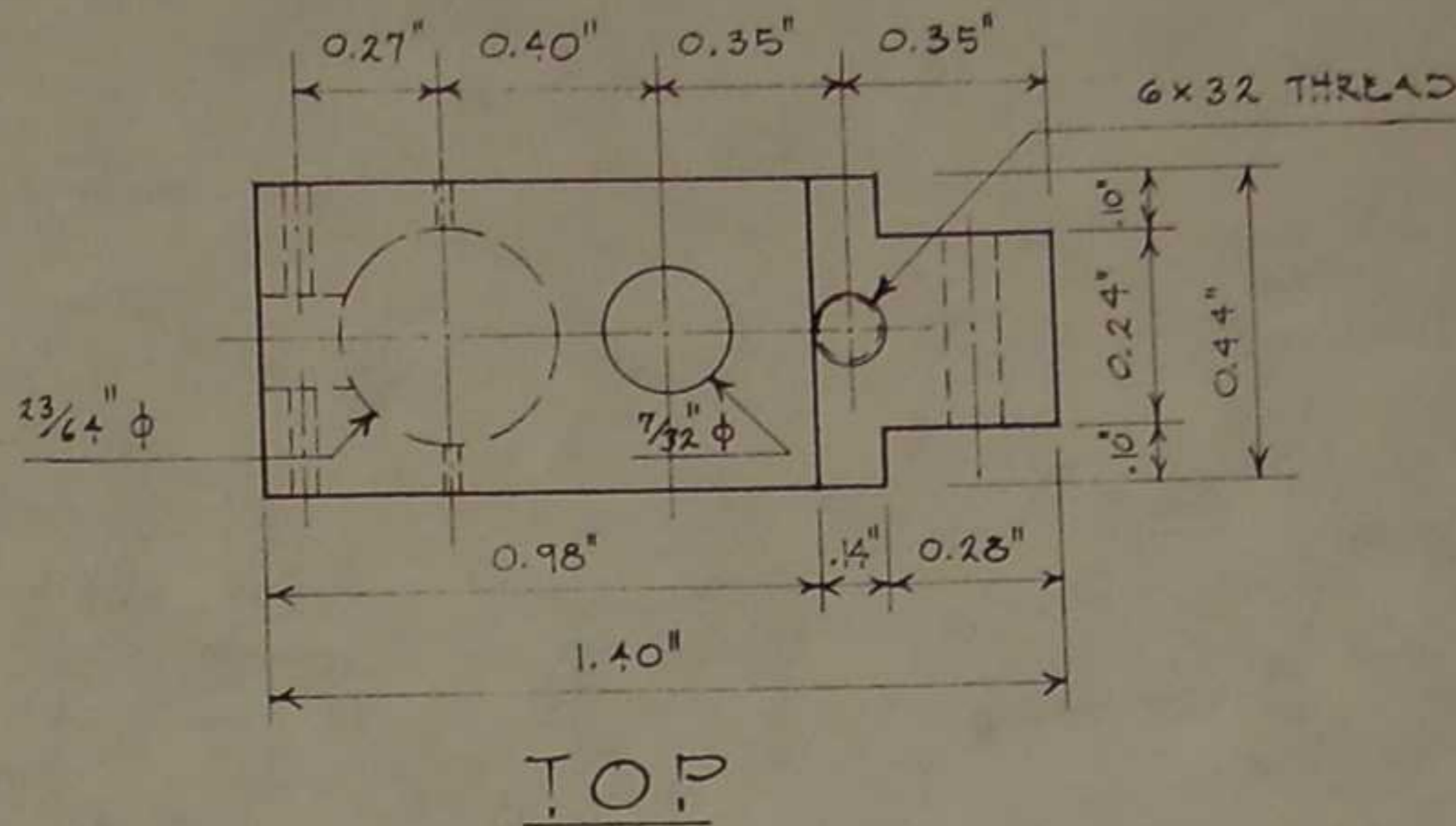
SCALE: 3" = 1"



EXPLODED ISOMETRIC
FULL SIZE



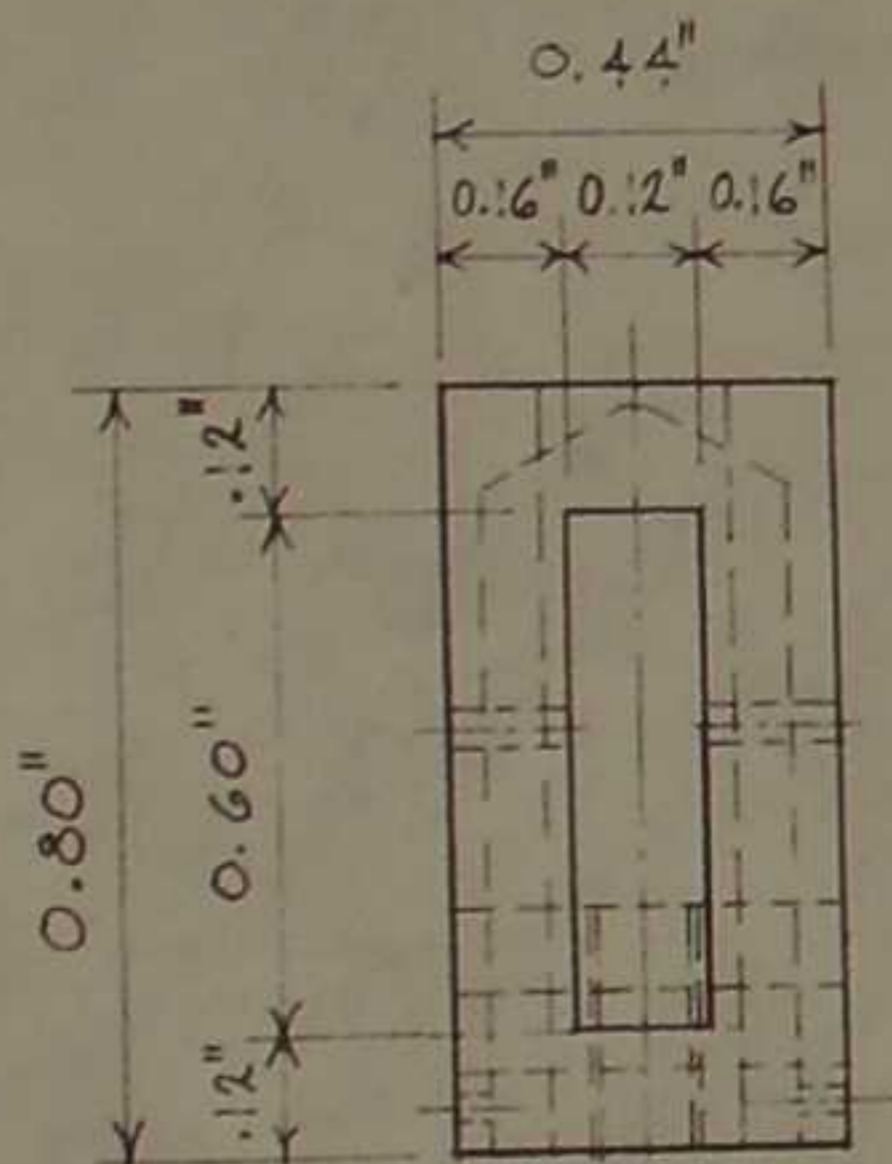
S. SAFETY PIN
SCALE: 4" = 1"



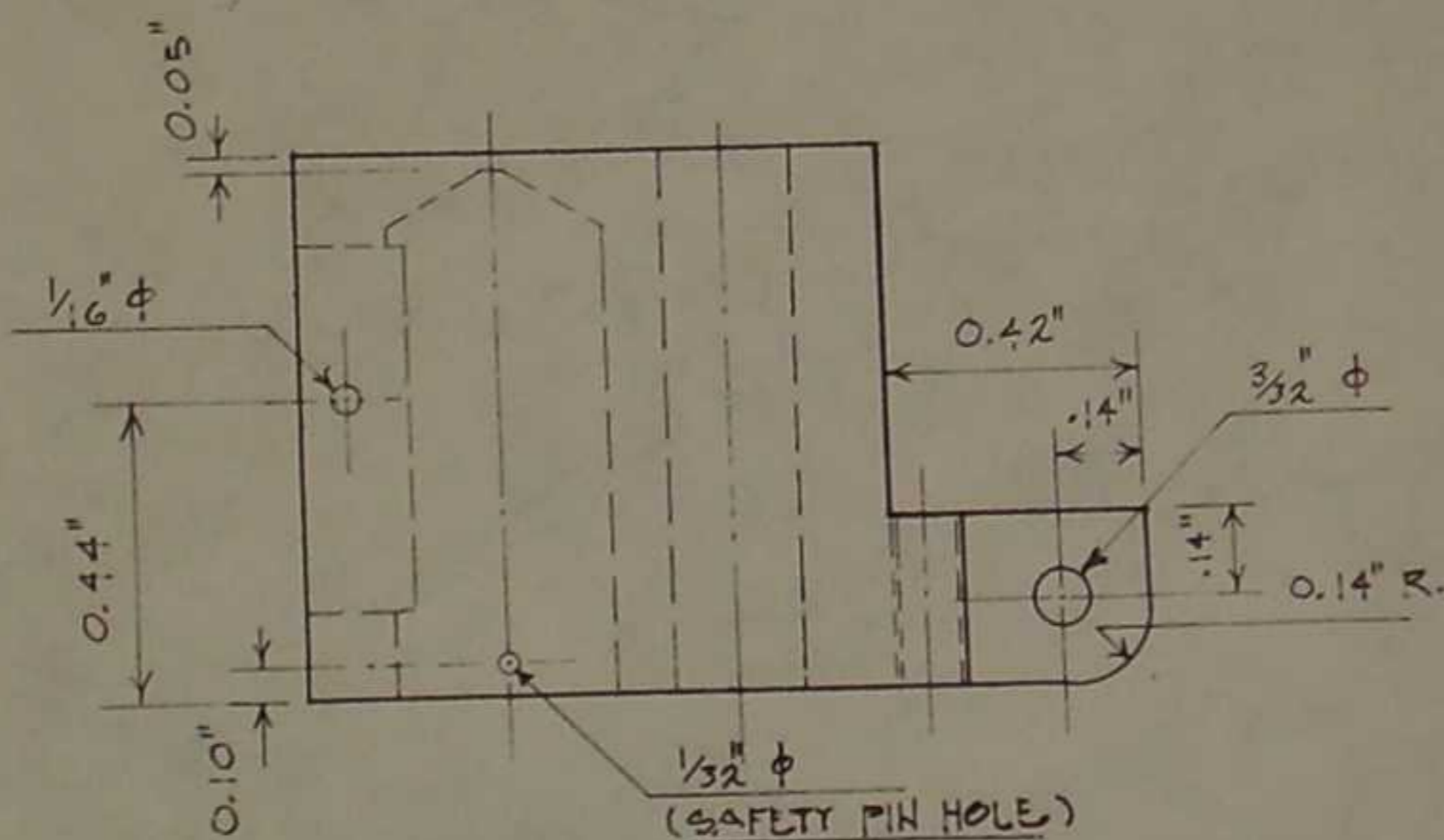
TOP

NOTES:

1. ALL PARTS TO BE MADE OF STEEL.
2. ENLARGE CHAMBER W/ EMEORY CLOTH ON SLOTTED MANDREL USING DRILL.
3. GEAR & FIRING PIN BEST MADE BY GRINDING SHAPES FROM STD. HALF MOON KEYS.

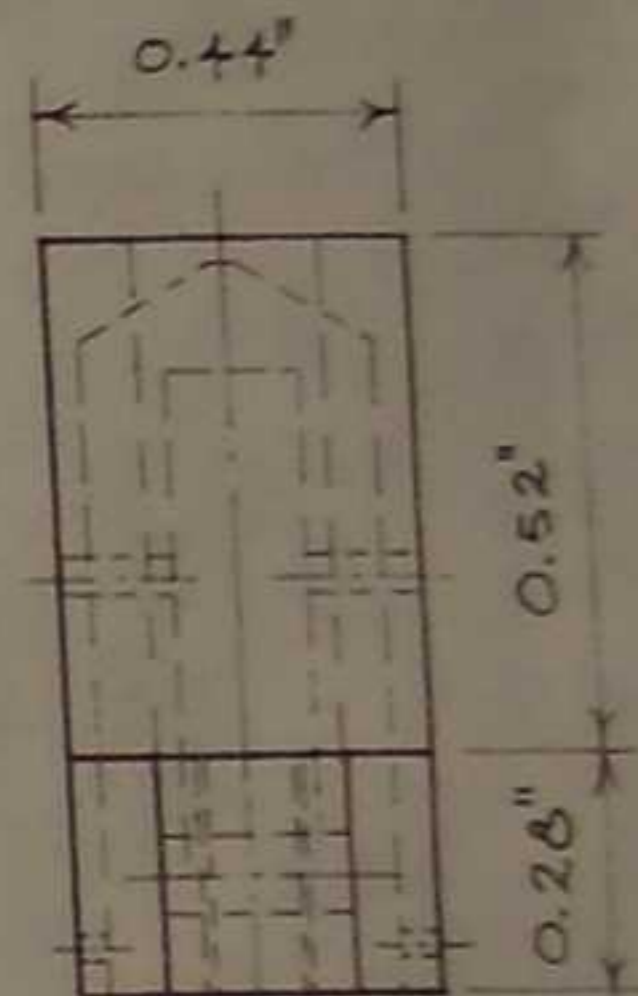


SIDE



FRONT

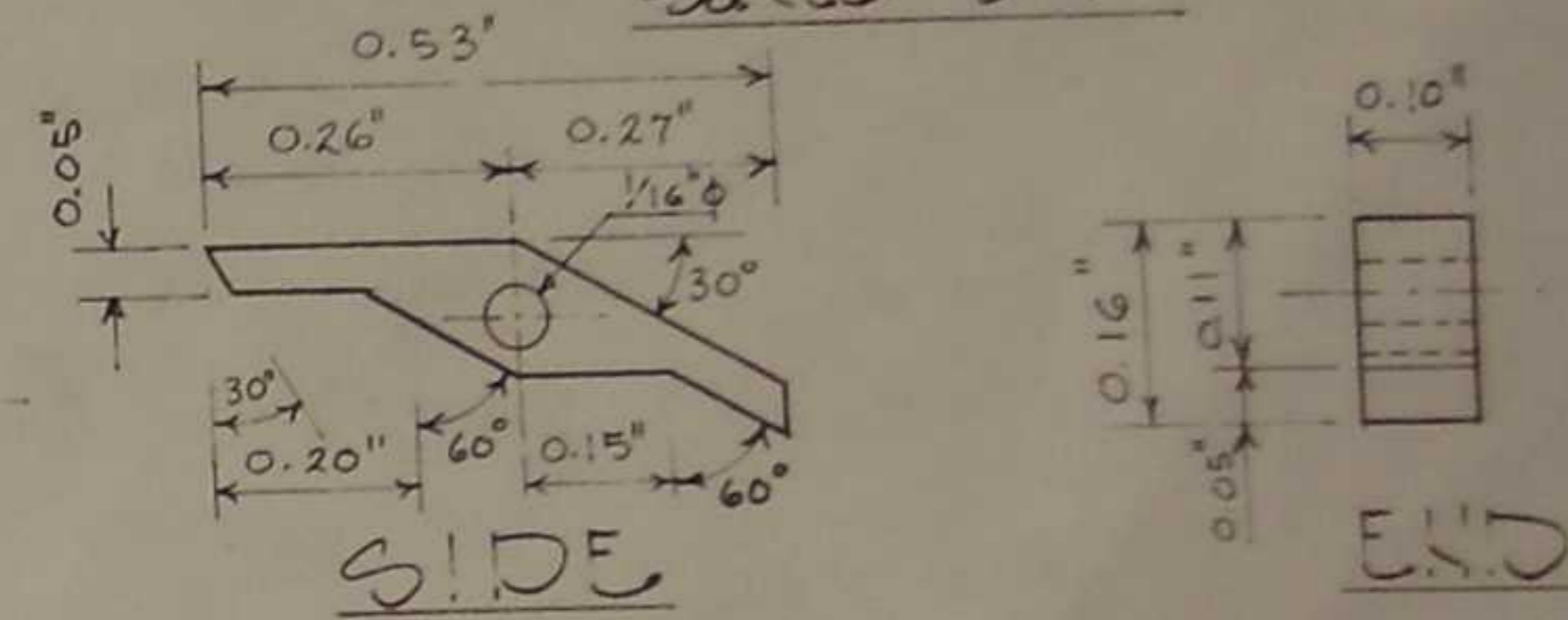
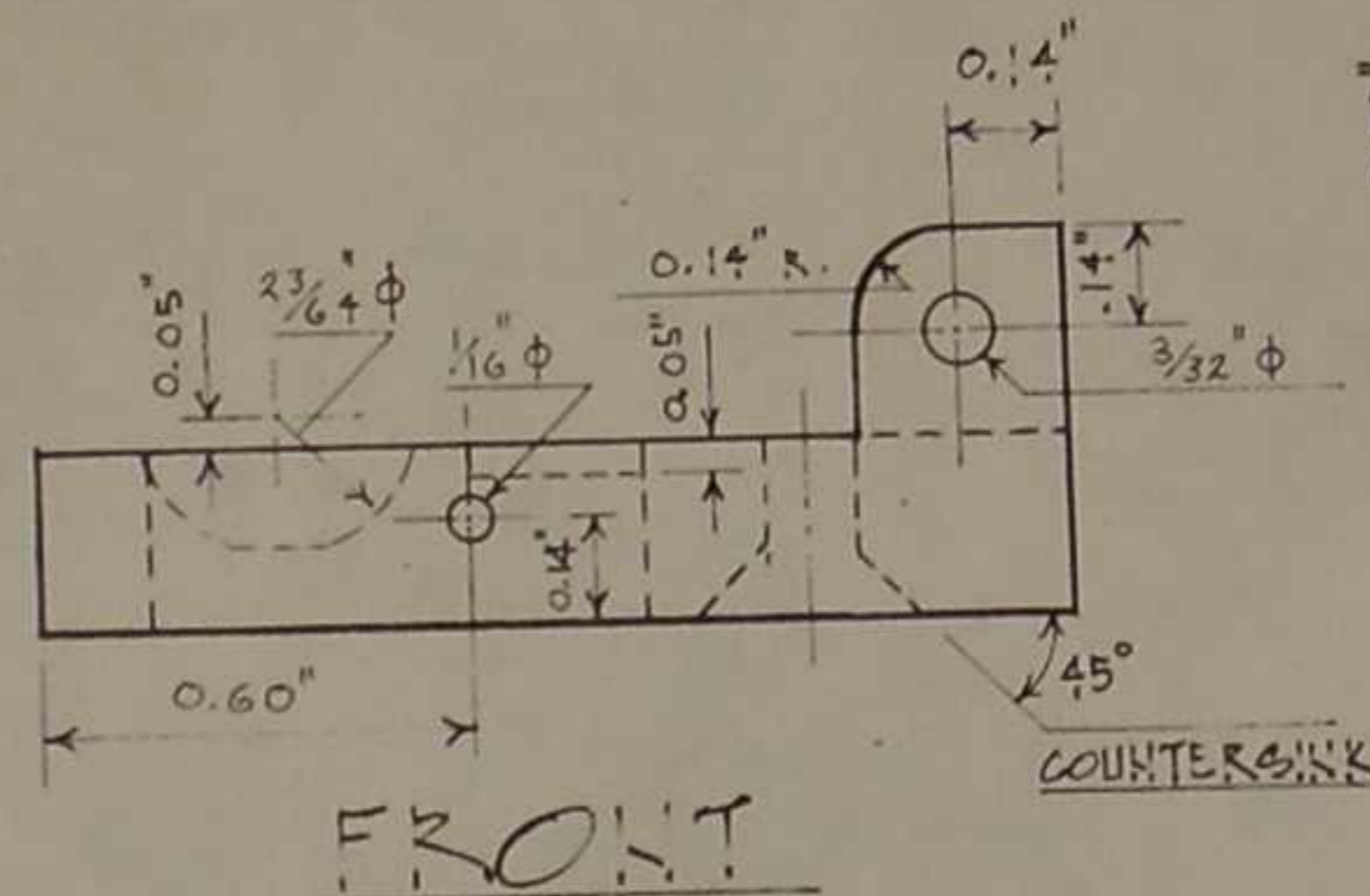
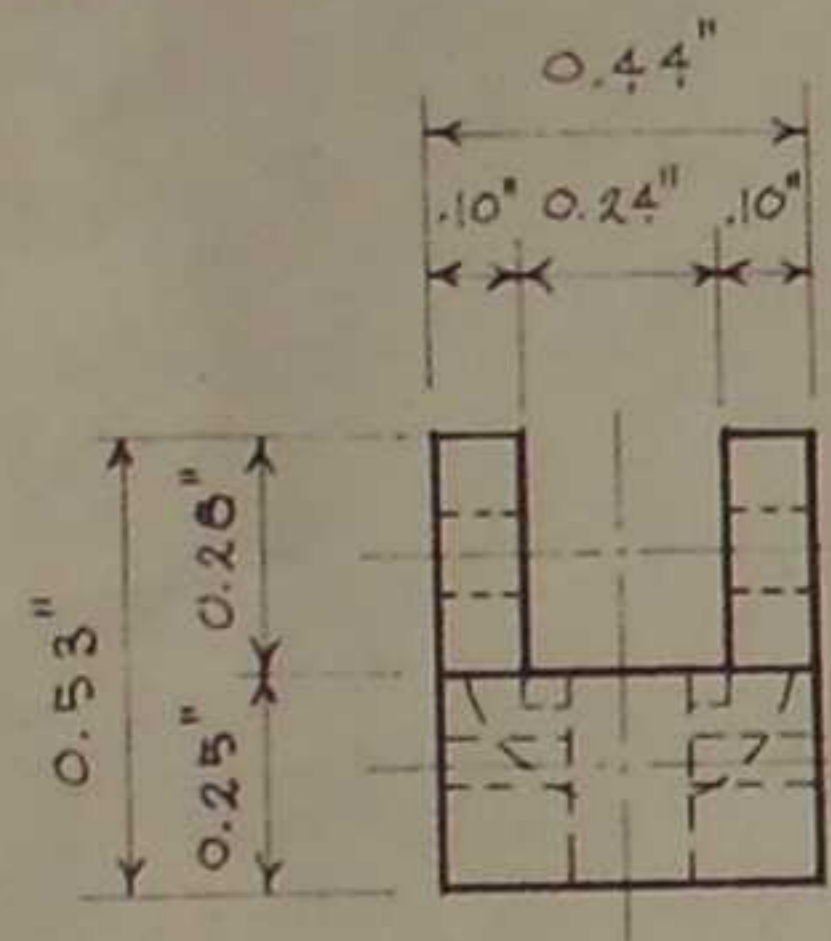
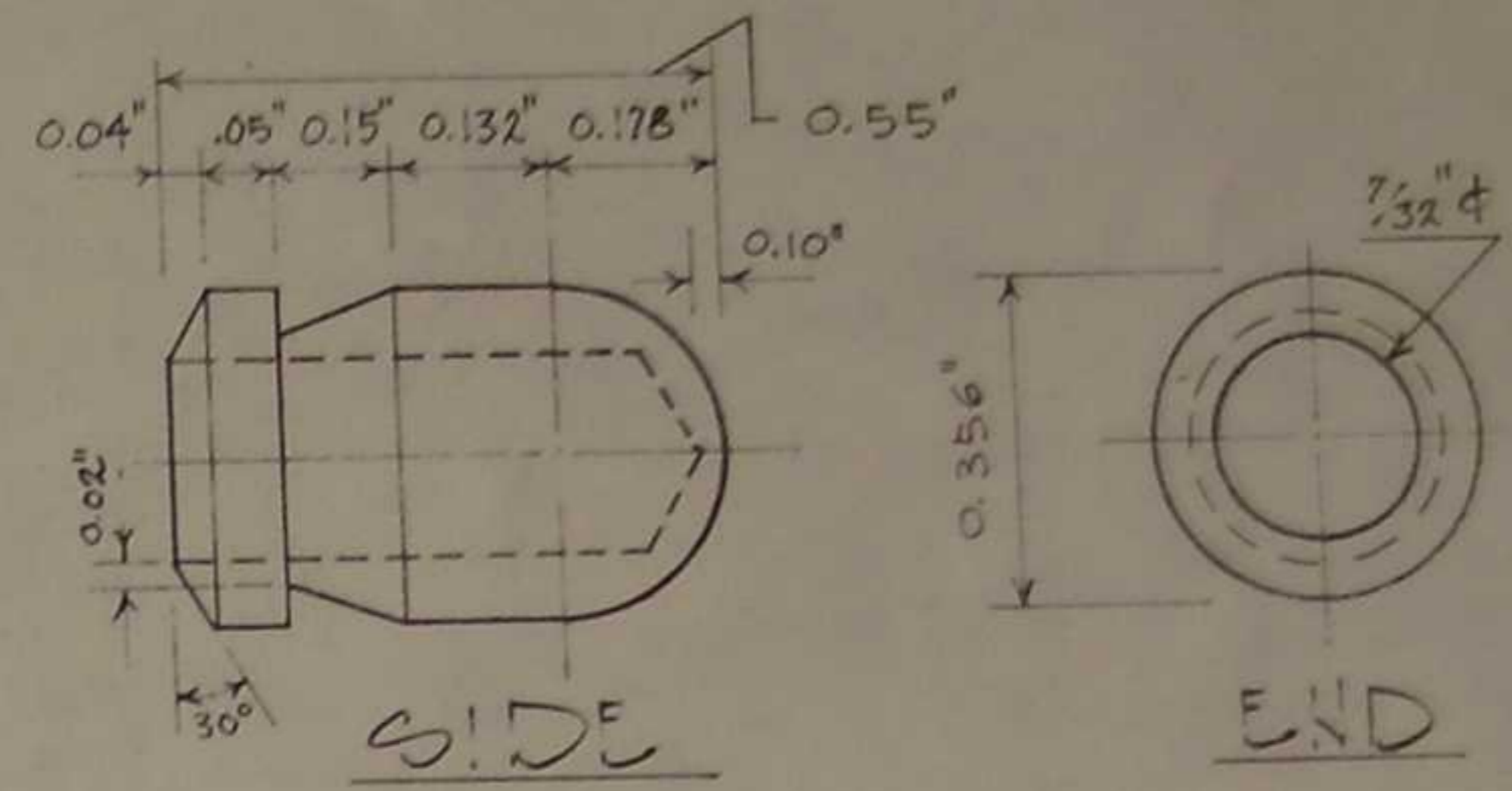
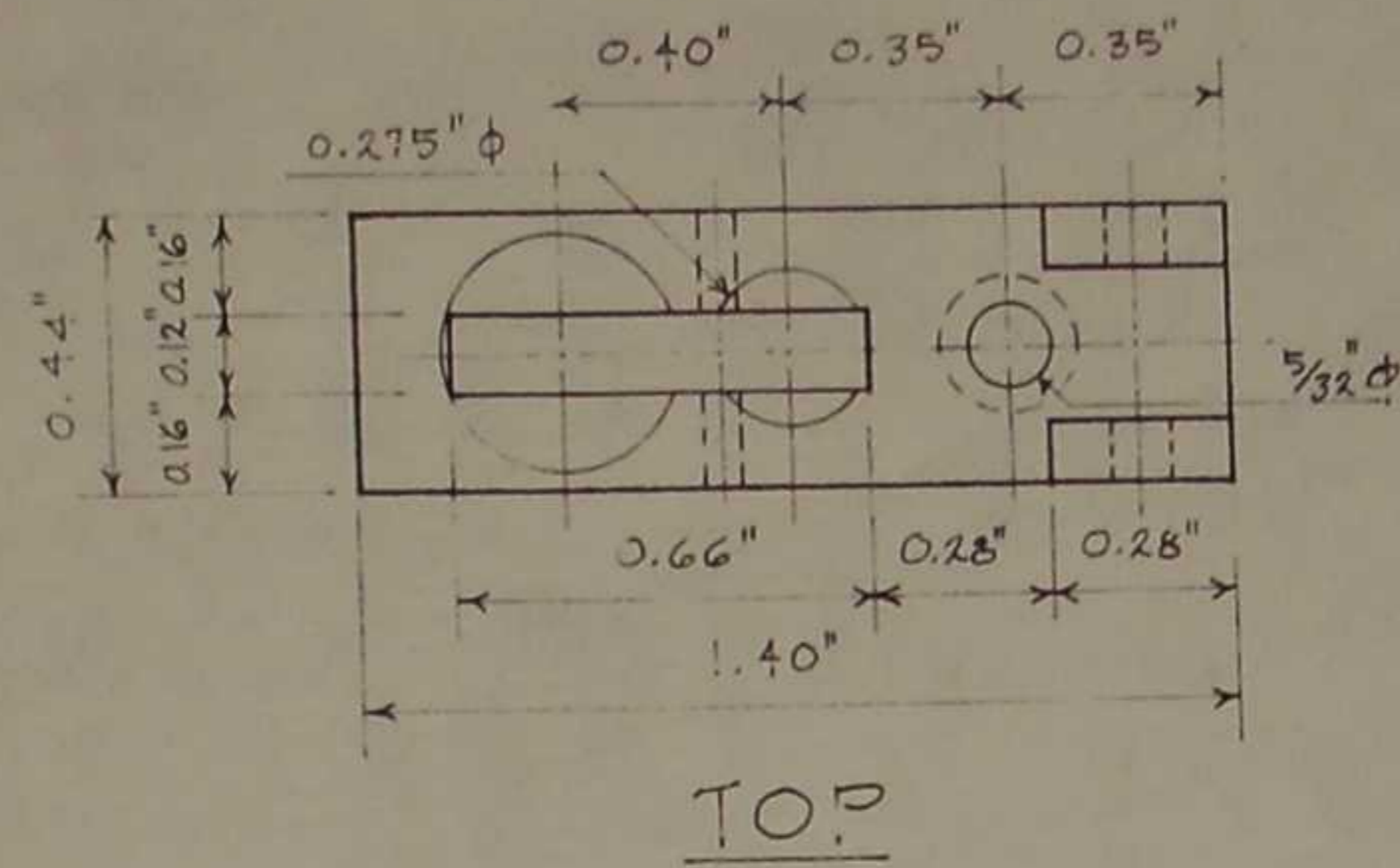
FRAME
SCALE: 2" = 1"



SIDE

NOTE:

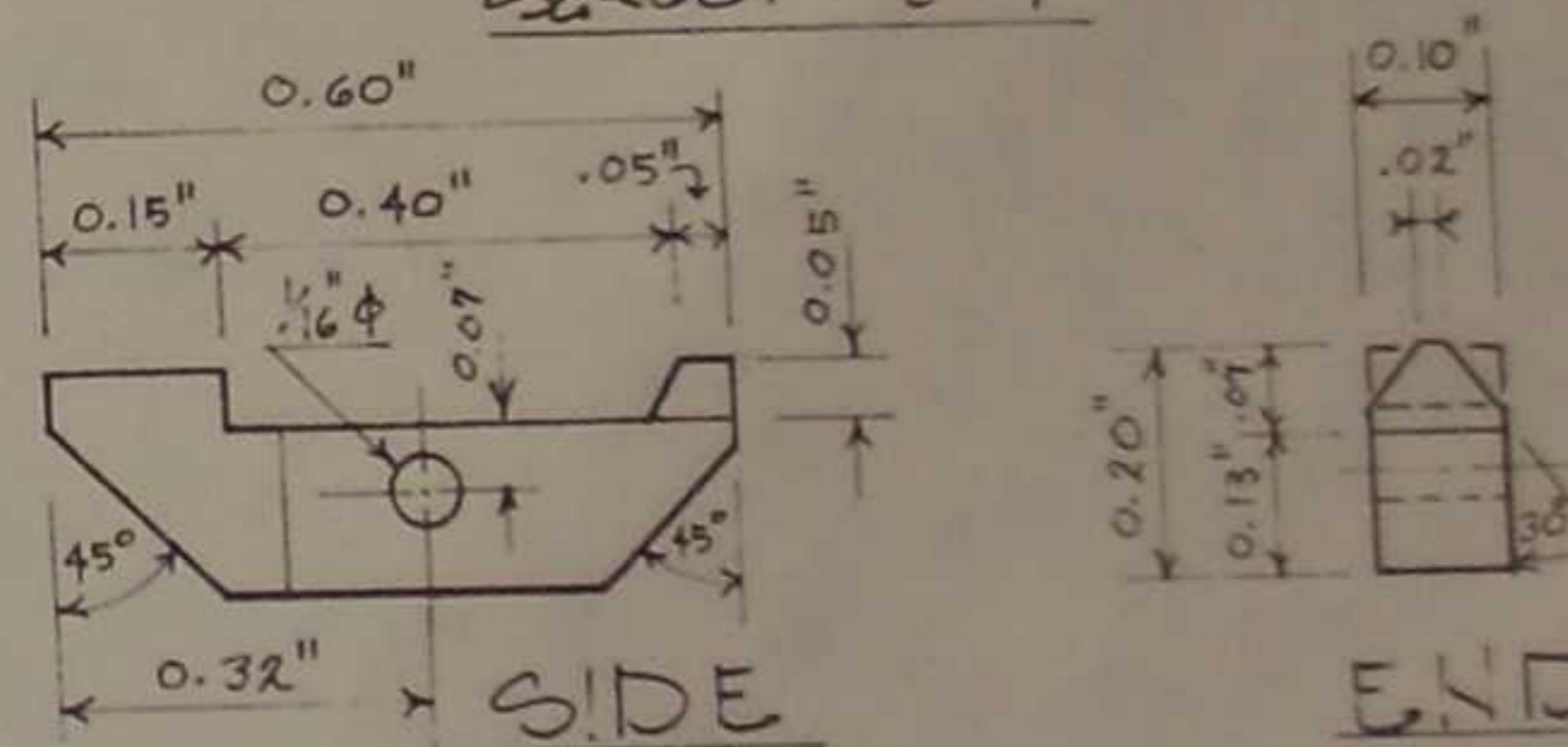
IF HAMMER SPRING CANNOT BE FOUND W/ SUFFICIENT FORCE TO DETONATE PRIMER, NEST TWO OR THREE SPRINGS WITHIN EACH OTHER.



BREECH BLOCK
SCALE: 2"=1"

PIH SCHEDULE

BREECH PIVOT PIH:	3/32" ϕ x 0.44"
FIRING PIH PIVOT:	1/16" ϕ x 0.44"
GEAR PIVOT PIH:	1/16" ϕ x 0.44"



PEN GUN

DUAL FUNCTION .22 CAL. DEFENSE WEAPON

A PEN THAT SHOOTS / A GUN THAT WRITES

"THE PEN IS MIGHTIER THAN THE SWORD."

BARON LYTTON

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GENERAL NOTES

This PENGUN is designed to be built without exotic tools or special skills. All critical dimensions are accommodated by utilizing a rifled barrel liner and five sizes of readily available brass tubes which fit snugly inside each other. All other dimensions, which are shown to the nearest hundredth of an inch, are approximate. For instance, part 23, which plugs into part 22, is turned down until it fits snugly inside. No precise measurement is necessary. This "test to fit" method is used throughout.

The technique employed to join the various pieces is known as "sweating" and widely used by plumbers. The pieces are cleaned with steel wool, coated with soldering flux paste, fitted together, heated with a small torch (alcohol lamp, kitchen range, etc.) and acid core solder is applied to the joint. If there is sufficient heat, the lead solder will be drawn into the joint by capillary action making a very strong connection. A trip to the library or a talk with your plumber about sweating is strongly advised. A little practice is also very helpful.

The technique for "turning down" parts 6, 10, 14 and 23 is quite simple. A suitable brass rod or bolt is selected and placed in a drill which is clamped (or other held firmly) in a vise. A file is then used to reduce the diameter of the spinning rod to fit snugly in its proper tube. The piece is then cut to length with a hacksaw and sanded smooth to remove the teeth marks.

There is an alternative to "turning down" a brass rod. Purchase K&S parts 166, 130 & 131 (3/16" solid rod and 7/32" and 1/4" tubes, respectively) and sweat them together with other tubes on hand to form solid pieces needed for 6, 10, 14 and 23.

The brass tubing is cut and slotted with a Dremel hand grinder with no. 402 mandrel and no. 409 cutting wheel. Buy, borrow or rent this tool because it is essential. The PENGUN is designed for one handed firing by the right hand. The angled cocking slot in the housing would be on the opposite side for left handed operation.

Test fire the PENGUN starting with empty .22 cases and progress to blanks, C.B. caps and finally .22 shorts. A more powerful bullet will likely blow up the PENGUN and cause serious personal injury.

TOOLS AND EQUIPMENT NEEDED

Drill bits: #1 (wire size .232" dia.), 1/16", 3/32" & 5/32"
3/8" electric drill (reversible preferred)
Hoppe's gun blue solution (item # 1702)
Dremel grinder bits # 402, 409 & 945
Fine sandpaper or emery cloth
Dremel electric hand grinder
Vise (to hold drill)
Soldering flux paste
Acid core solder
Small round file
Fine steel wool
Small flat file
Hacksaw & blade
Hand torch
Superglue
Pencil

OTHER SARDAUKAR ORIGINALS

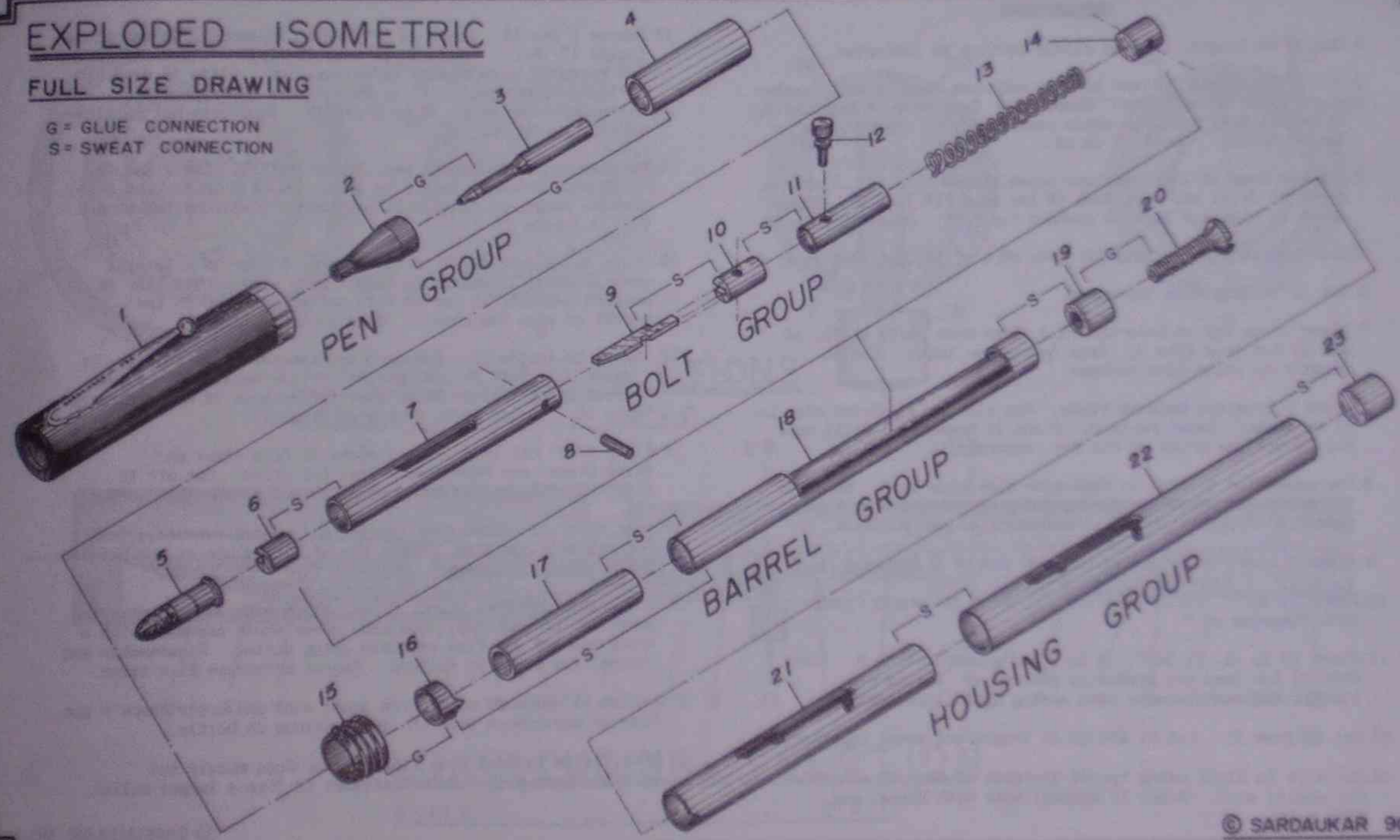
ZAFFER - Cigarette Lighter Derringer
BUCKLER - Dbl bbl Belt Buckle Gun
BLITZER - High Explosive Bullets
TATTLER - Trip Wire Prowler Alarm

SARDAUKAR PRESS
P.O. BOX 38531-D
GERMANTOWN, TN 38138

EXPLODED ISOMETRIC

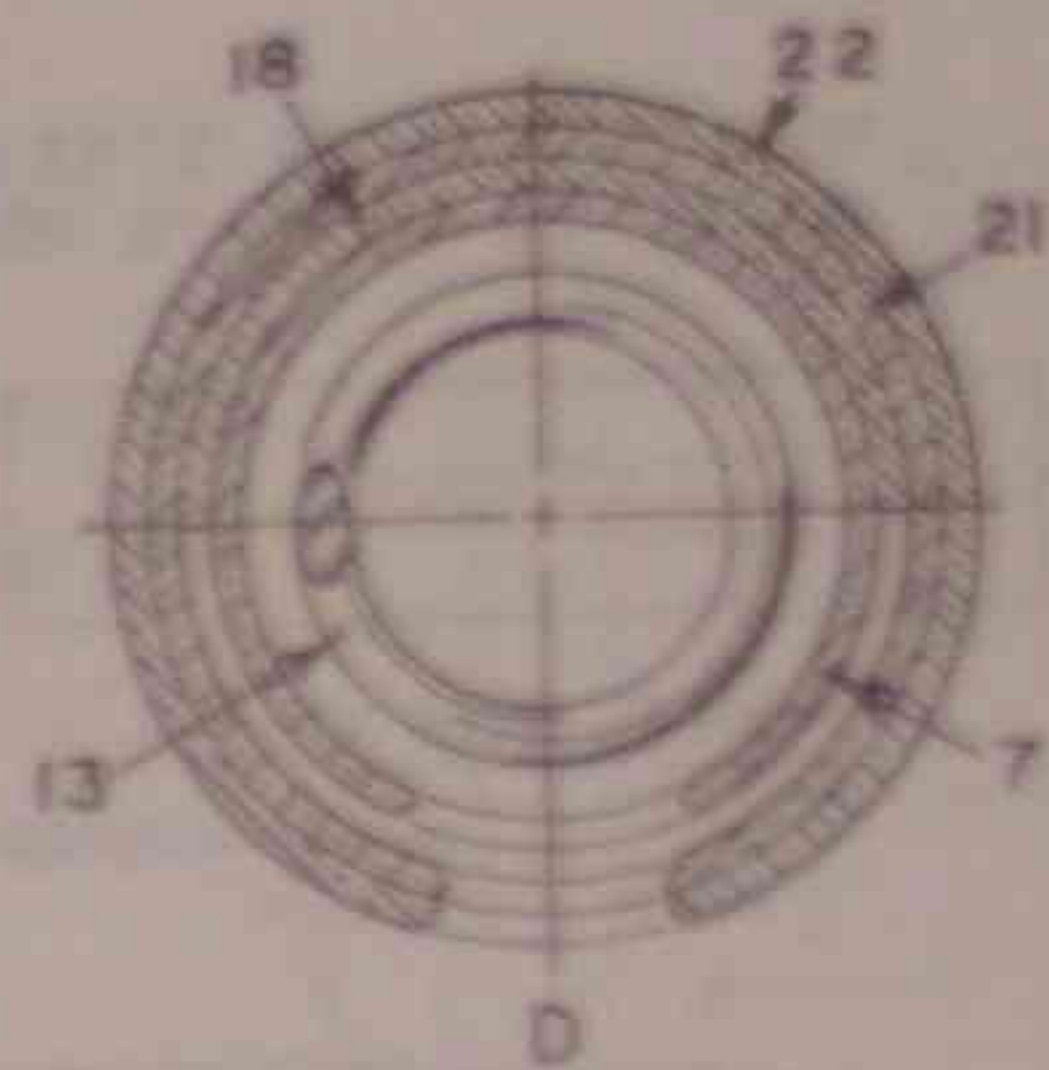
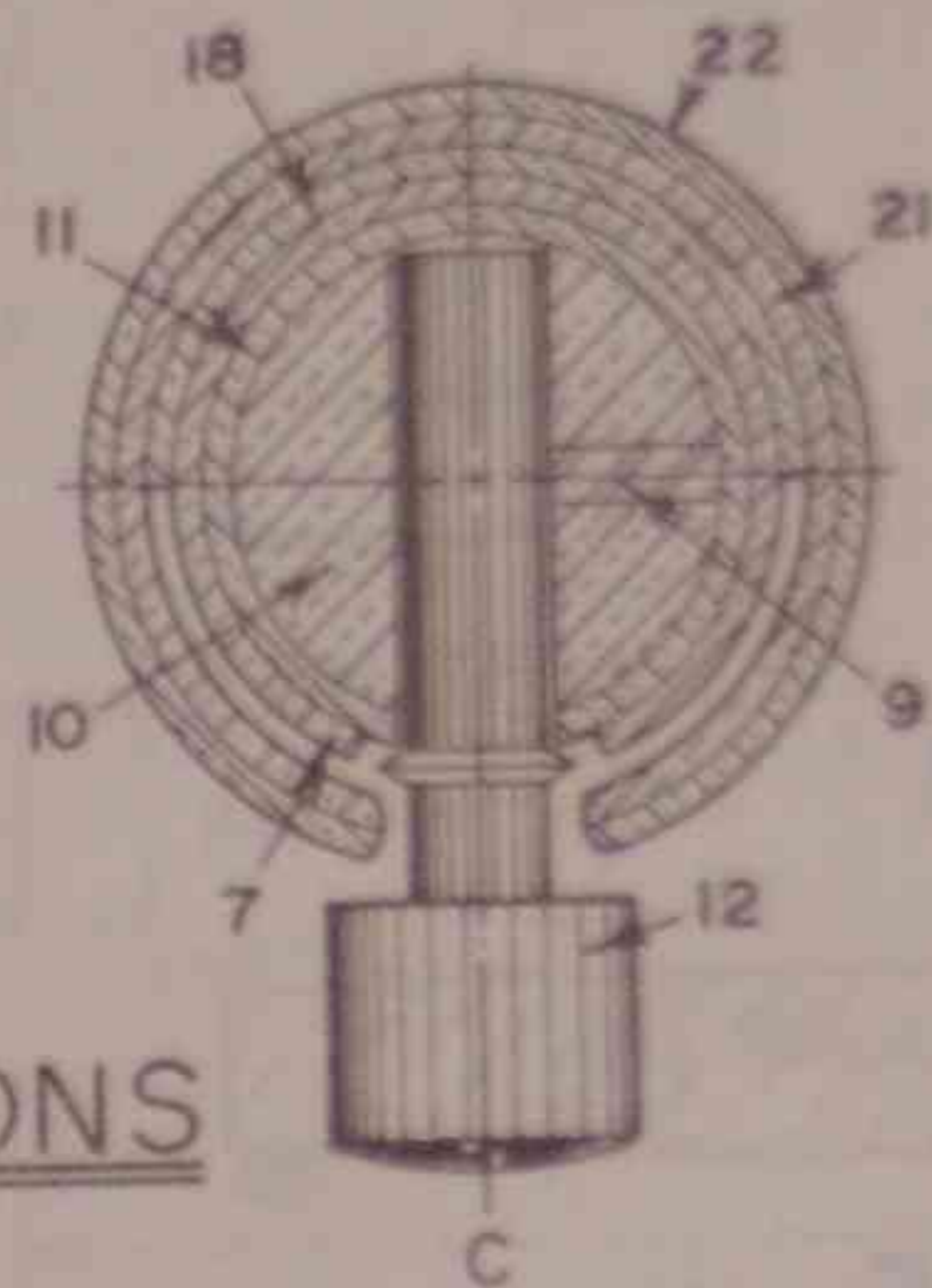
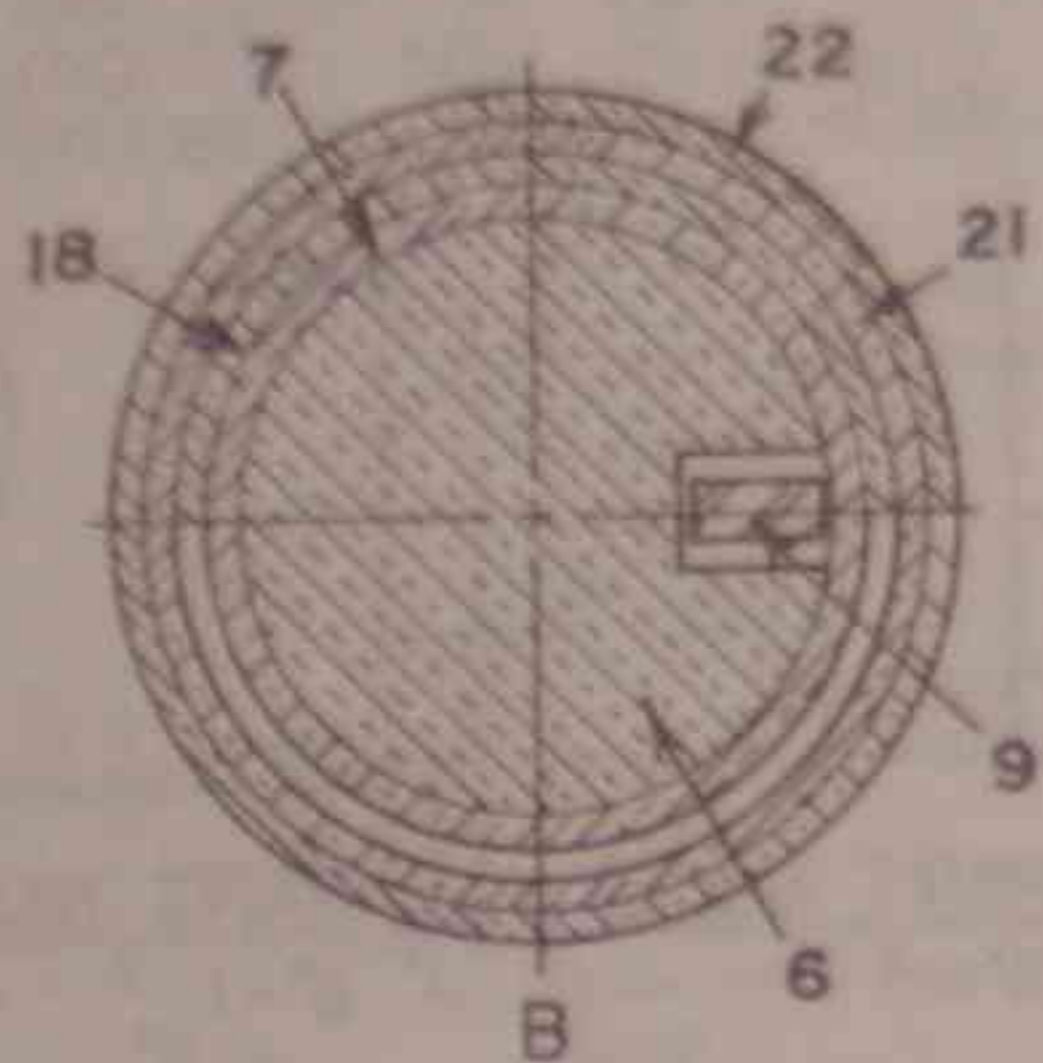
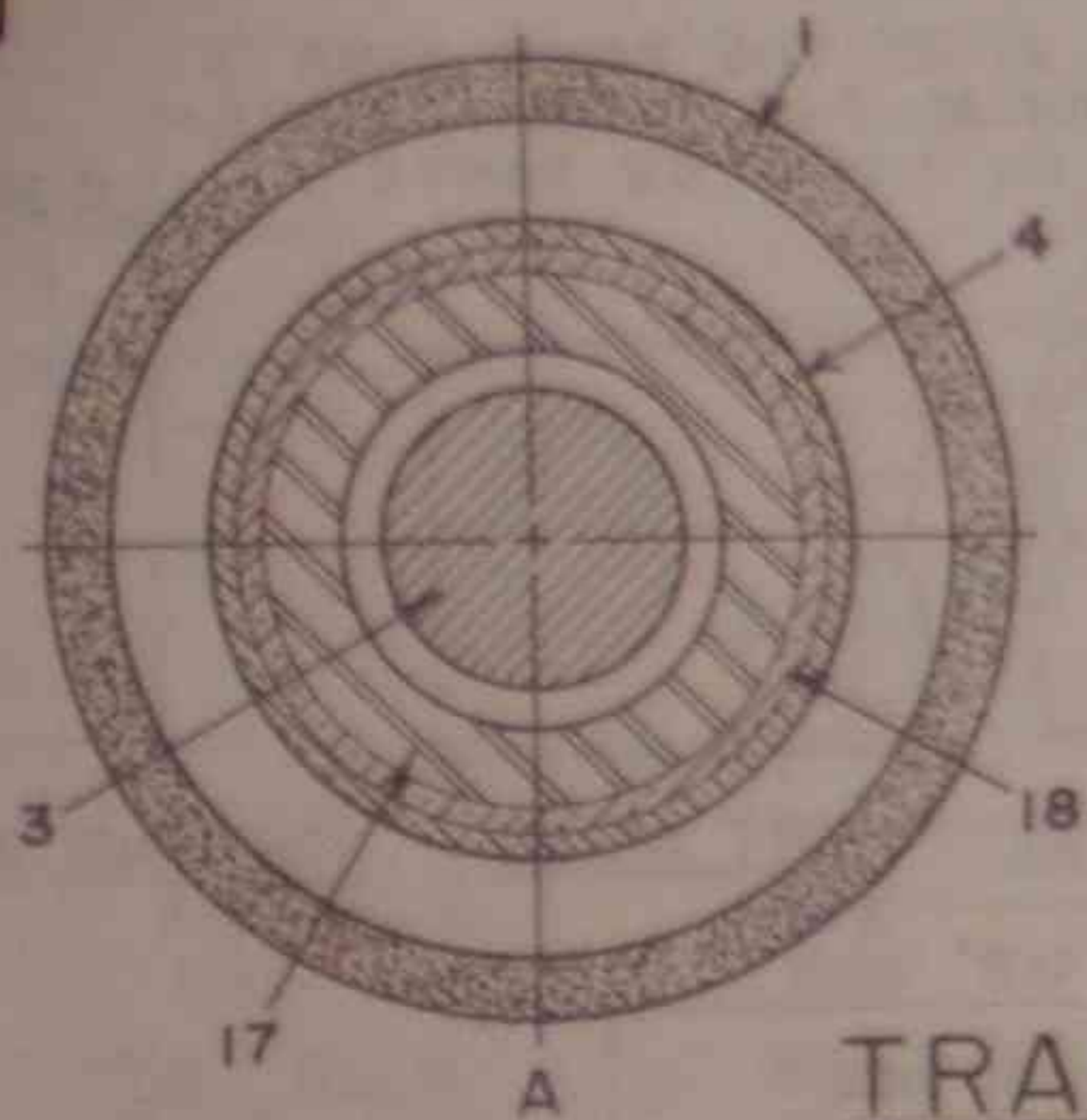
FULL SIZE DRAWING

G = GLUE CONNECTION
S = SWEAT CONNECTION



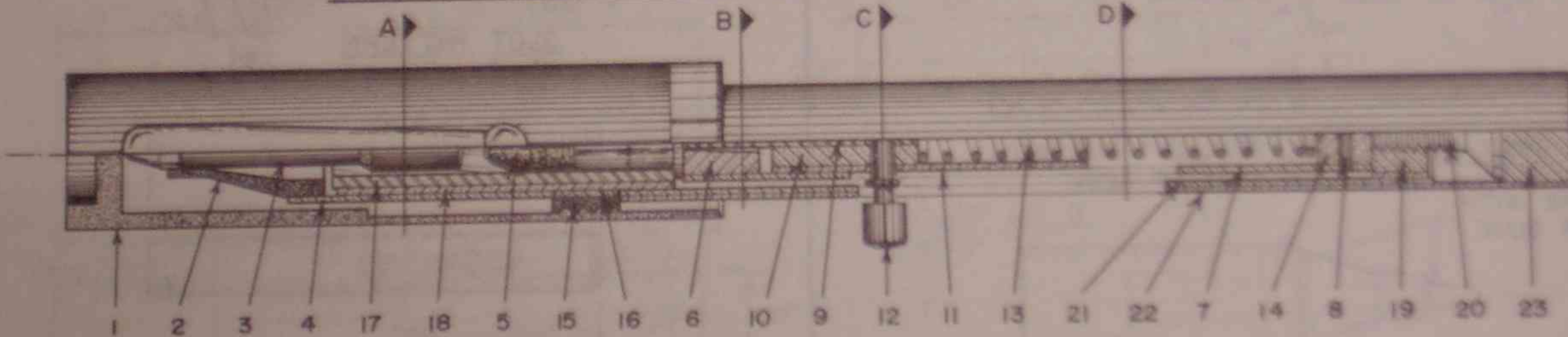
INSTRUCTIONS

1. Cut 18 to length. Cut out middle section as indicated.
2. Cut 17 to length. Place in vise and ream chamber with "number size" drill bit 1 (.2320" diameter). Test correct depth with 5. Do not over drill to avoid possibility of chambering a larger bullet. Sweat 17 to 18.
3. Cut off head of 10x32 machine screw. Screw into 19. Place screw in drill and turn down 19 for snug fit into 18. Place screw in vise and file 19 rounded top flat. Sweat 19 into 18.
4. Cut 7 to length for snug fit into slot of 18. Cut slot in 7.
5. Cut 11 to length as indicated.
6. Place brass rod or bolt in drill. Turn down parts 6, 10, 14 and 23 for snug fits in their respective tubes. Cut to lengths as shown with hacksaw.
7. Grind 9 from old hacksaw blade. Cut slot in 10. Grind slot in 11 as shown. Sweat parts 9, 10 and 11 together. Drill hole for 12 and use shank of bit for temporary 12.
8. Use assembled 9/10/11 to determine slot size in 8. Make slot "V" shaped to allow for firing pin play. Sweat 8 to 7 using assembled 9/10/11/temp.12 to determine proper position.
9. Place 5 in 17/18 and grind (pinned) end of 7 for snug fit.
10. Place 14 in 7. Drill hole for 8. Cut 8 to length flush with diameter of 7.
11. Place 13 in 11. 11 in 7. 14 in 7 and crosspin with 8. Start with 13 too long and gradually shorten so firing pin travels maximum distance from spring at full compression.
12. Cut 16 from 21. Cut 21 and 22 to length and sweat together.
13. Cut slot in 21/22 using travel distance of temp.12 as guide. Cut angled slot. Grind 12 removal hole with Dremel and #854 point.
14. Remove 5 and 13. Assemble 8/7/8/9/10/11/temp.12/14 and place inside 17/18/19. Slide 21/22 over 17/18/19 and operate firing pin assembly to determine 21/22 position. Slide 16 over 17/18/19 to mate with "V" in 21 and mark location. Disassemble and sweat 16 to 17/18/19. Take care not to alter 17/18/19 relationship.
15. Unscrew end of ballpoint pen. Remove refill. Cut 2 and 15 as shown. Cut 4 to length as shown. Glue 2 in 4. Cut 3 to maximum length by trial fitting inside 17 without touching 5. Glue 3 inside 2.
16. Slide 2/3/4 over 16/17/18/19. Slide 15 over 16. Screw 1 over 15 until 15 begins to turn. Stop when pocket clip is perpendicular to 12 (so 12 will not show a bump in the pocket or poke the chest). Glue 15 into place.
17. Sweat 23 inside 22. Reduce head diameter of 20 to slip inside 21. Test fit 20 into 19. Slide housing group over barrel group. Adjust 20 so that it contacts 23 when 21 mates with 18. Secure 18/20 with spot of glue.
18. Place 5/32" bit in drill and shape 12 from shank end using Dremel and #408 disc. Test fit often. Cut off 12 only when fit and function are satisfactory. Get oil helps.
19. Load with .22 primed case (bullet and powder removed). Test for reliable ignition. Shape tip of firing pin or use heavier spring(s) as necessary.
20. Load with .22 short round. Clamp 17 in vice with non-marring jaws, set up backstop, cock pen, cover whole assembly with a heavy blanket and fire remotely using string. Disassemble and inspect for signs of failure. Repeat procedure five times.
21. Polish all exposed metal with steel wool and apply Noppe's gun blue in accordance with the instructions on bottle.
22. When firing by hand keep fingers away from muzzle and maintain good grip. Do not attempt to fire a larger bullet.



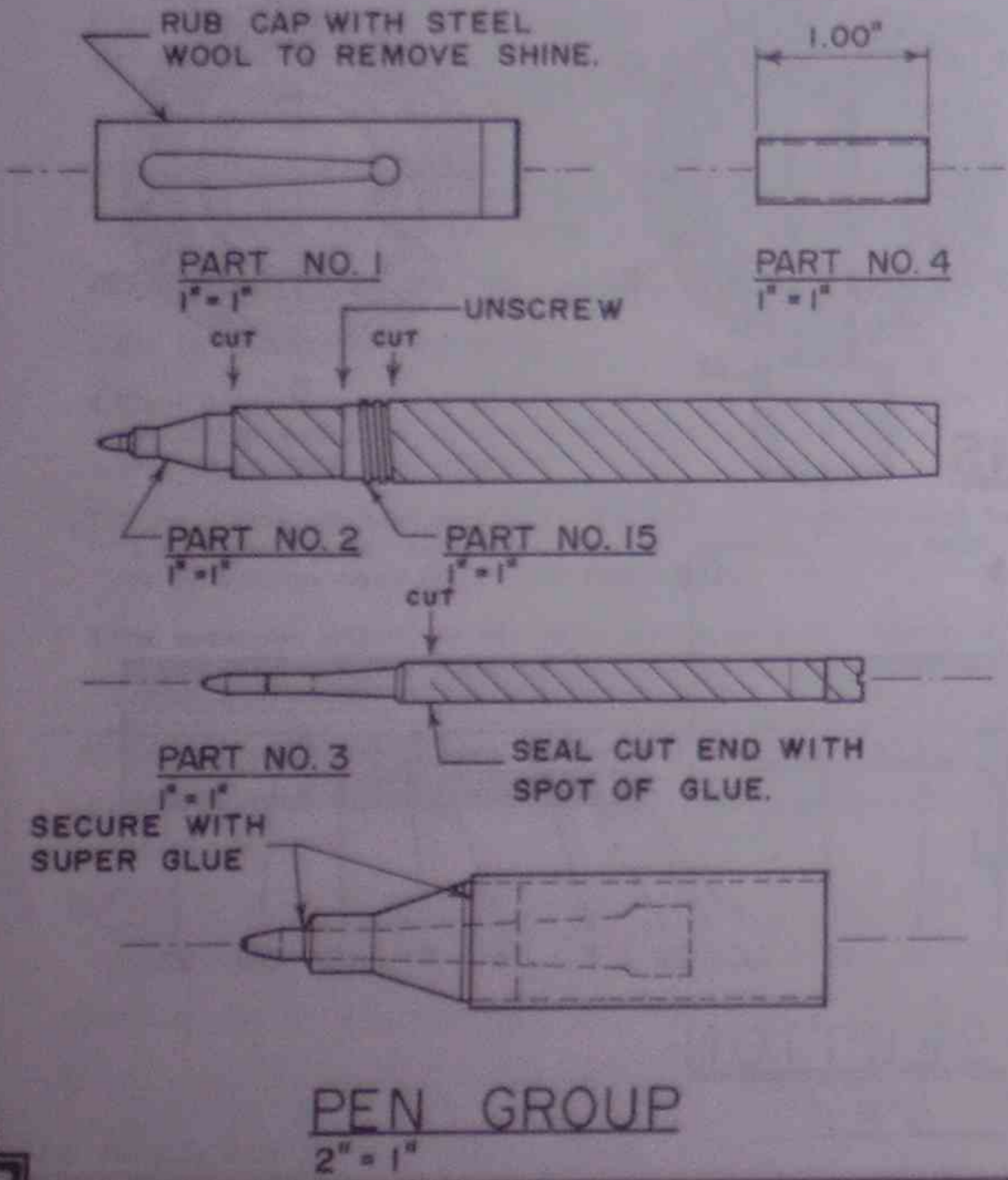
TRANSVERSE SECTIONS

SCALE: $5'' = 1''$

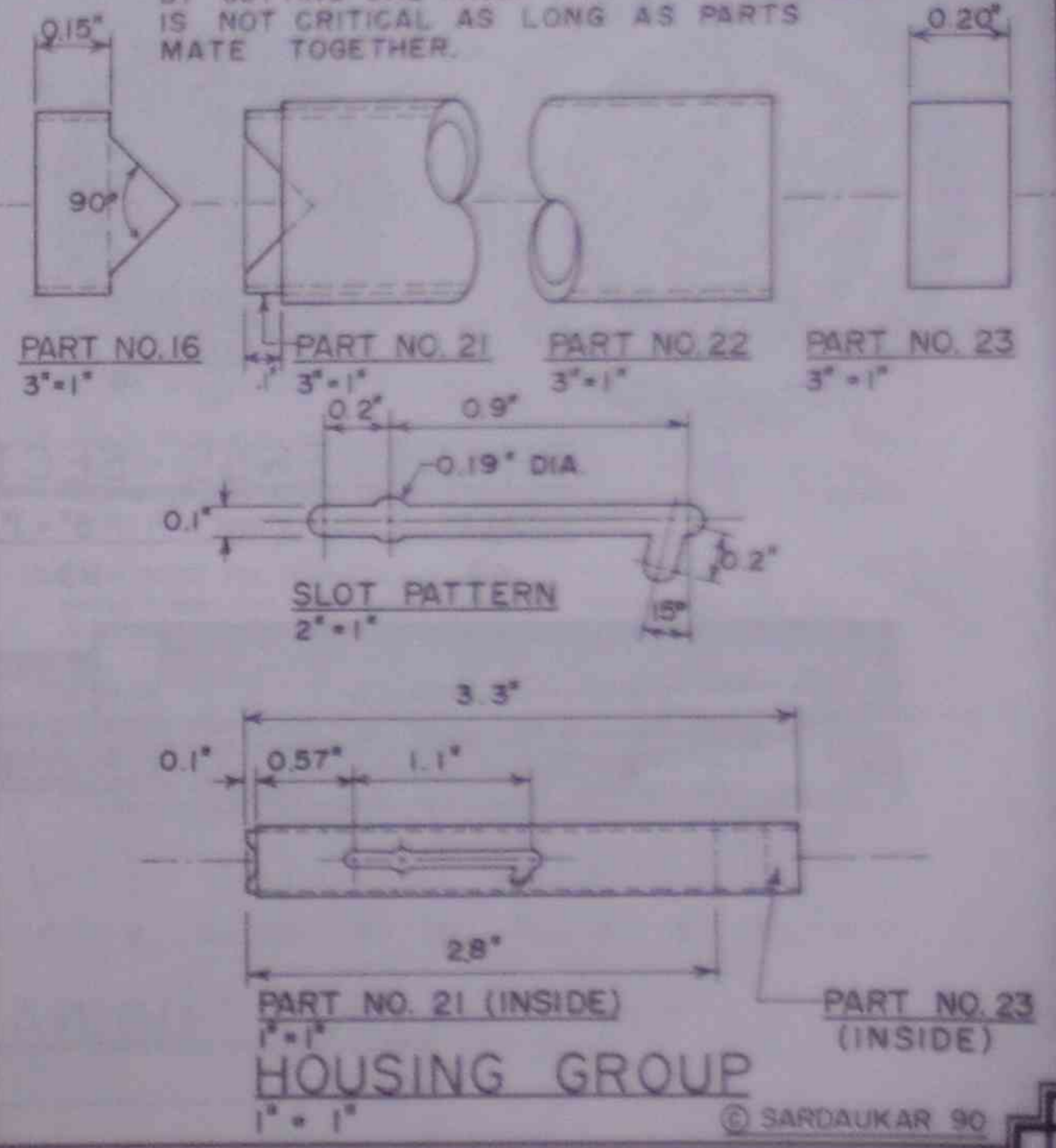


LONGITUDINAL SECTION

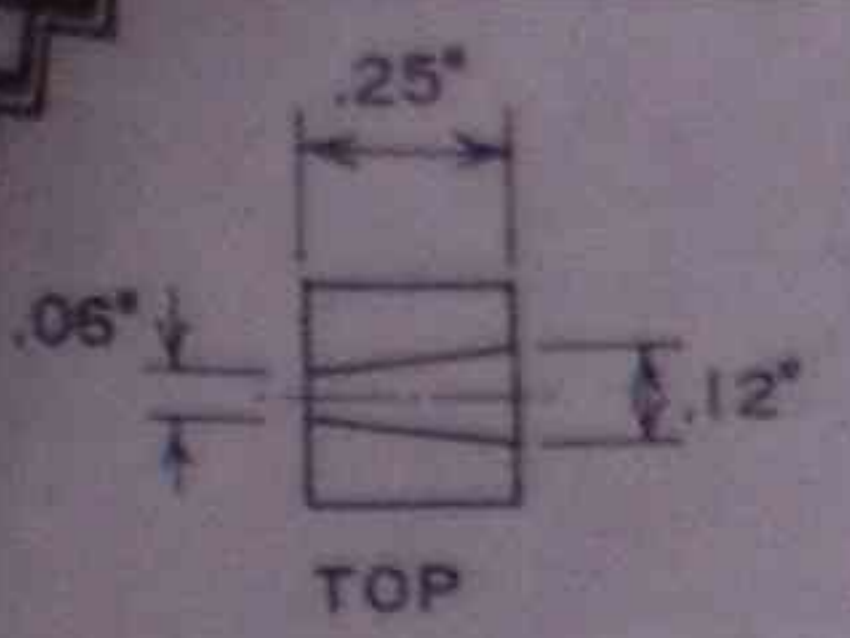
SCALE: $2'' = 1''$



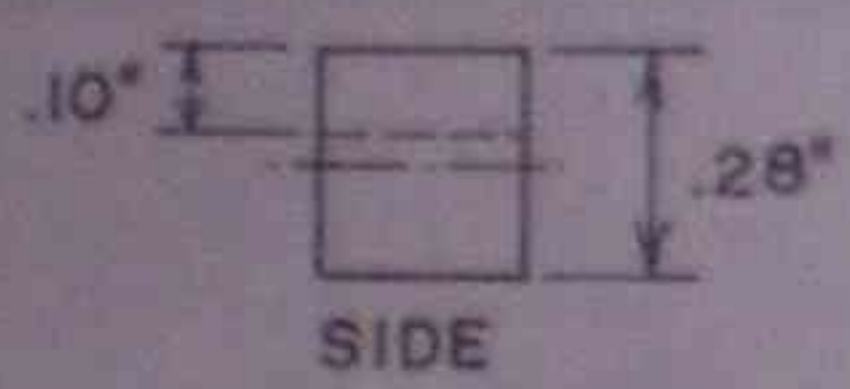
MAKE PARTS 16 & 21 AT THE SAME TIME BY CUTTING ONE FROM THE OTHER. ANGLE IS NOT CRITICAL AS LONG AS PARTS MATE TOGETHER.



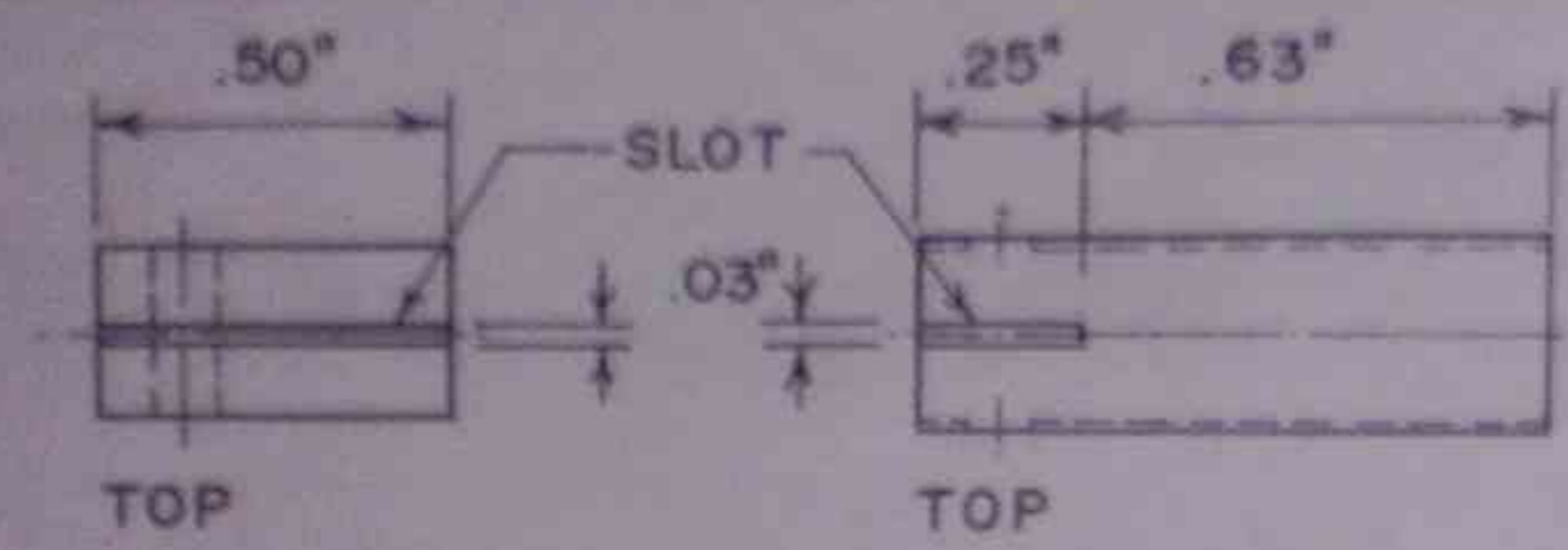
NO. 23
 NO. 23
 (SIDE)
 90



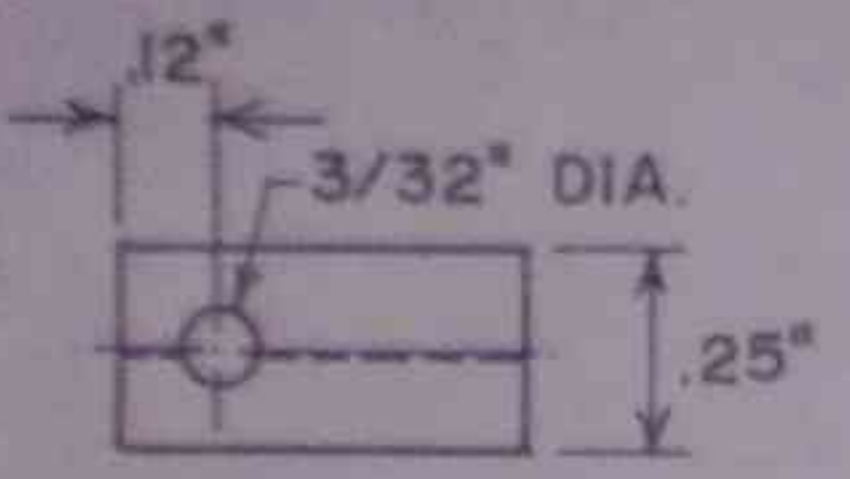
TOP
 PART NO. 6
 2" = 1"



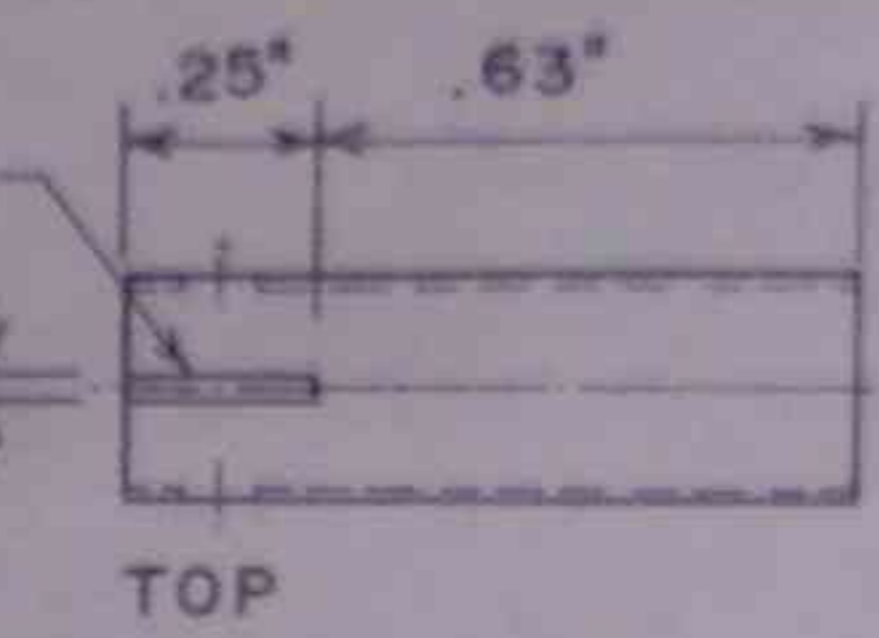
SIDE
 PART NO. 6
 2" = 1"



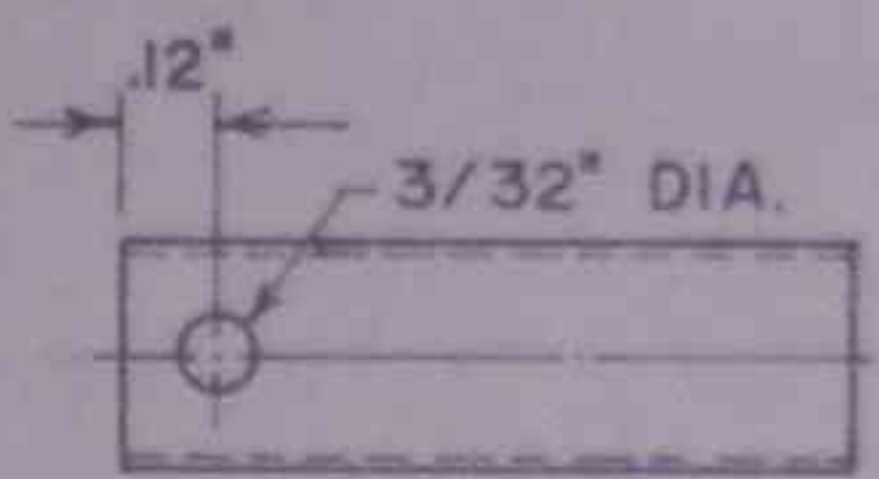
TOP
 PART NO. 10
 2" = 1"



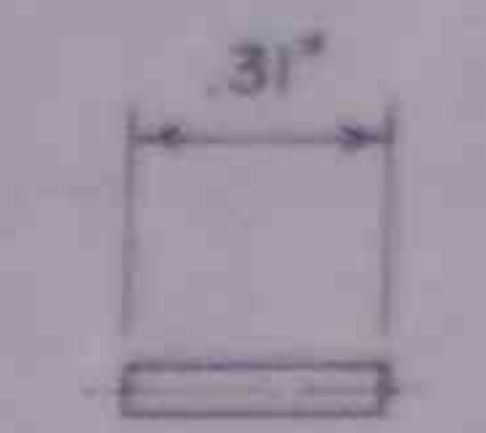
SIDE
 PART NO. 10
 2" = 1"



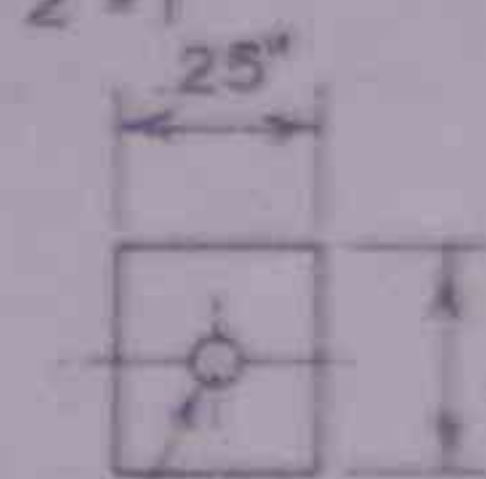
TOP
 PART NO. 11
 2" = 1"



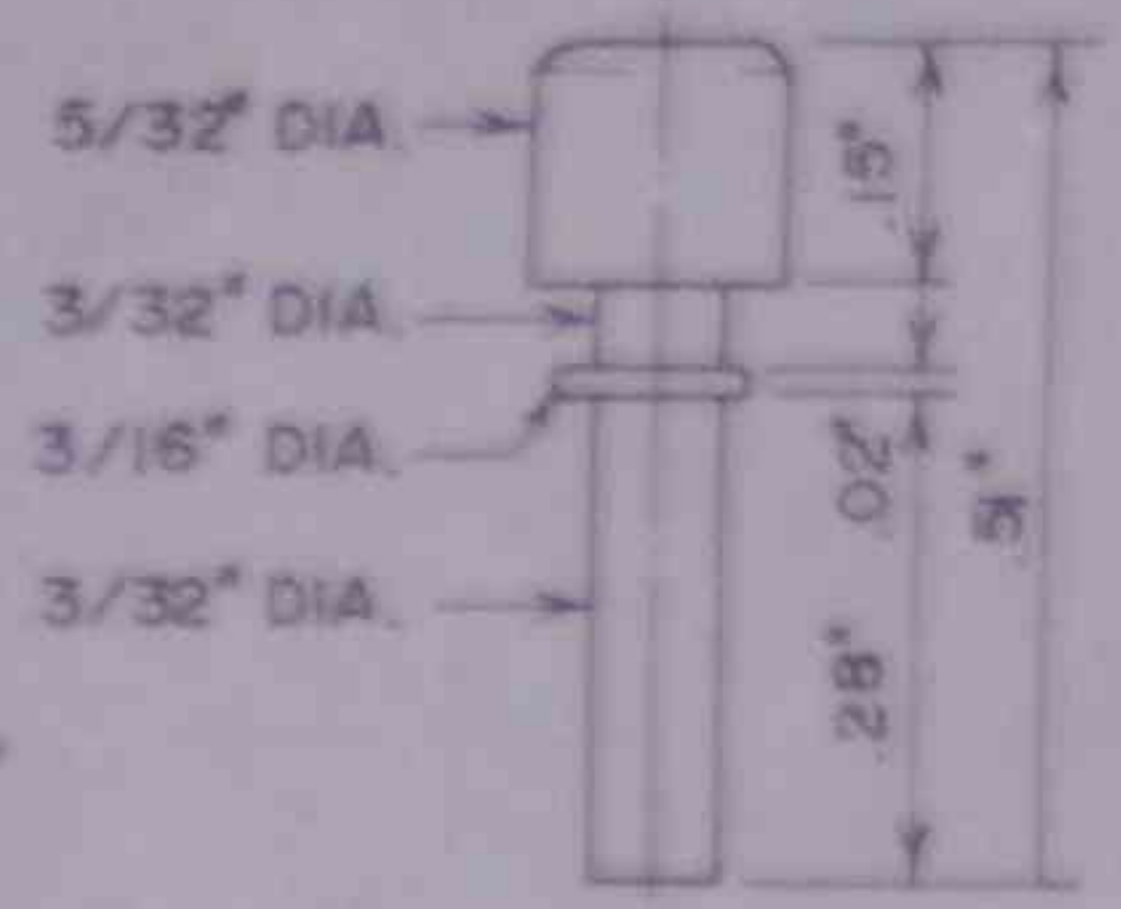
SIDE
 PART NO. 11
 2" = 1"



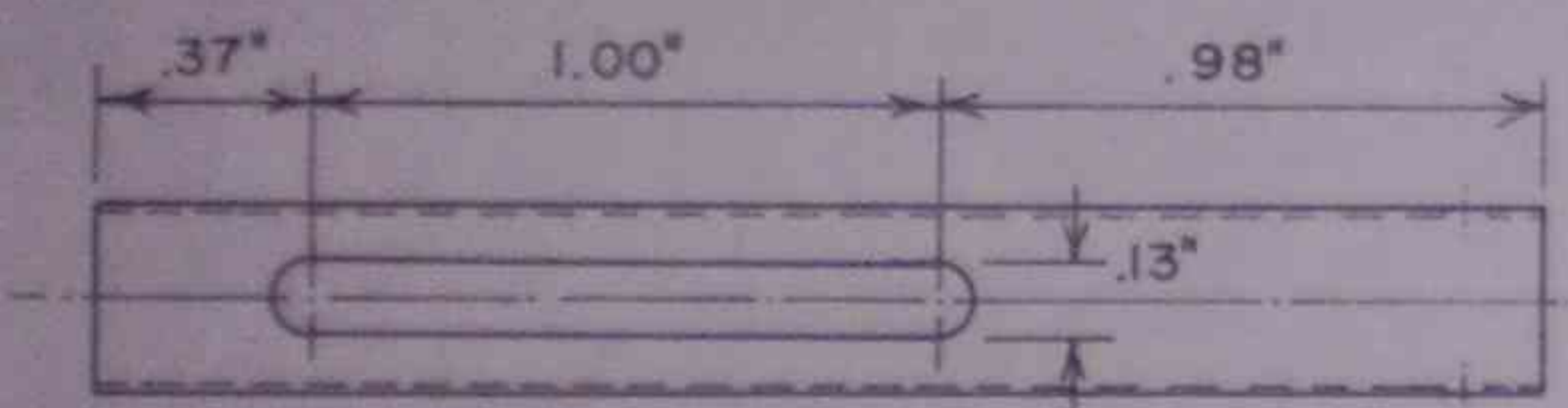
PART NO. 8
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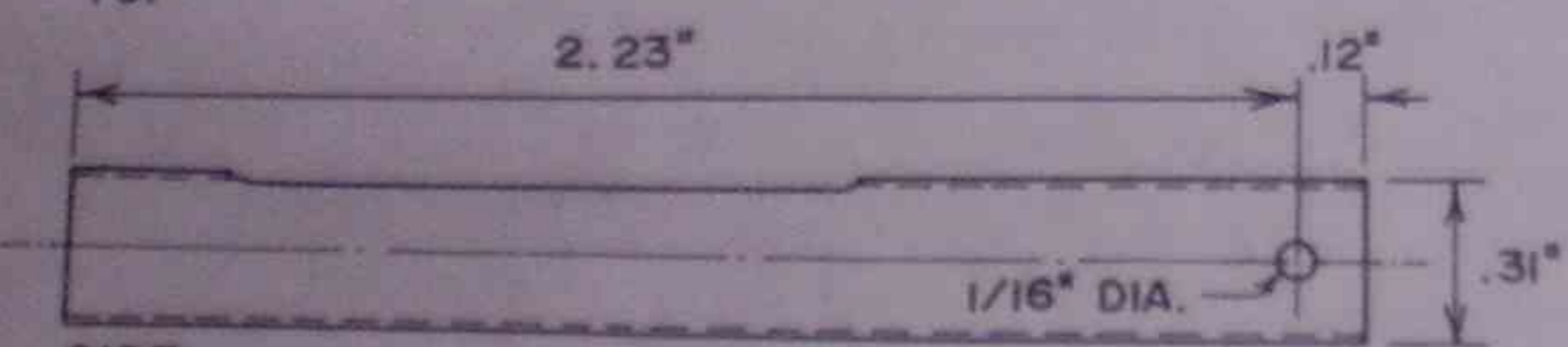
PART NO. 14
 2" = 1"



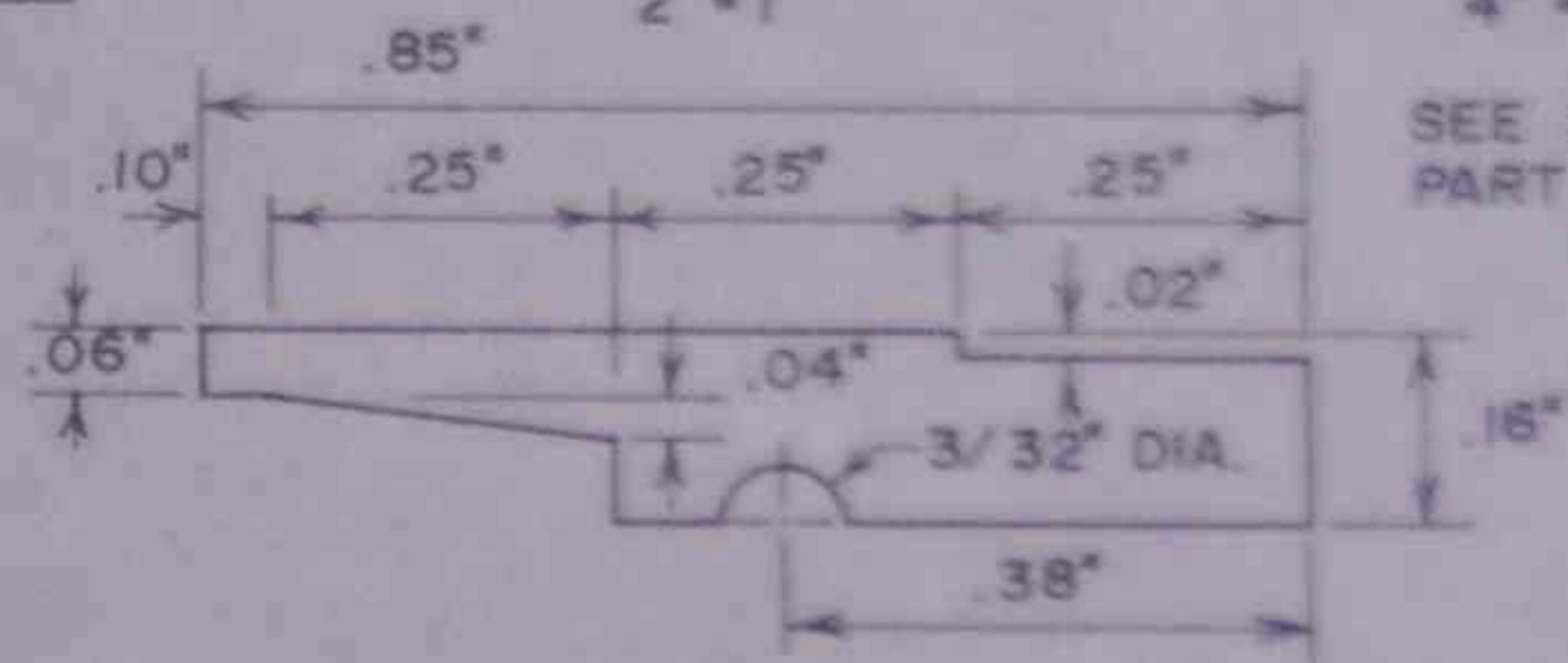
PART NO. 12
 4" = 1"



TOP
 PART NO. 7
 2" = 1"



SIDE
 PART NO. 7
 2" = 1"



PART NO. 9
 4" = 1"

SEE SHEET 3 FOR PART NO. 13.

BOLT GROUP

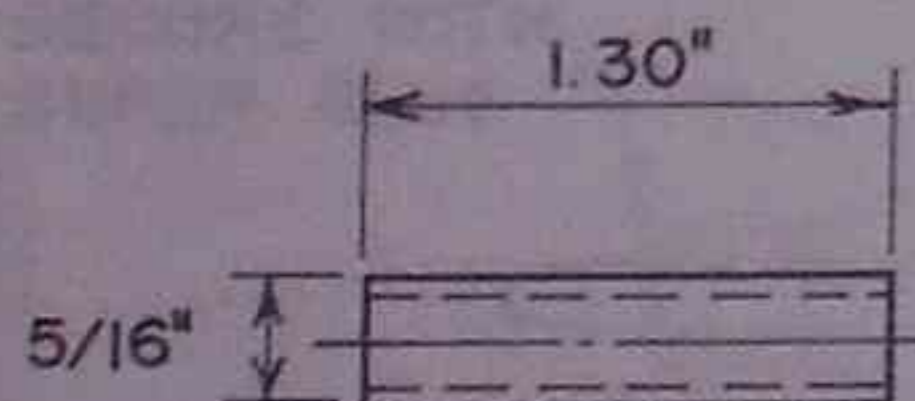
PARTS SCHEDULE

	NO.	NOMENCLATURE	MATERIAL	SOURCE	MFGR	MFGR NO.	COMMENTS
PEN GROUP	1	PEN CAP	PLASTIC	1	1	70000	NO NONSENSE BALLPOINT PEN
	2	POINT HOLDER	PLASTIC	1	1	70000	" " " "
	3	INK REFILL	COMPOSITE	1	1	99425	" " " "
	4	PEN GRIP	BRASS	2	2	135 3/8"	TUBING
BOLT GROUP	5	.22 CAL. SHORT	COMPOSITE	3	3	WW22S	
	6	BOLT FACE	BRASS	6	N/A	(9/32")	1/2" BOLT
	7	BOLT BODY	BRASS	2	2	133 5/16"	TUBING
	8	BOLT PLUG PIN	BRASS	2	2	162 1/16"	SOLID ROD
	9	FIRING PIN	STEEL	4	4	N/A	OLD HACKSAW BLADE
	10	FIRING PIN HOLDER	BRASS	6	N/A	(1/4")	1/2" BOLT
	11	FIRING PIN CARRIER	BRASS	2	2	132 9/32"	TUBING
	12	COCKING HANDLE	STEEL	4	4	15210	5/32" DRILL BIT
	13	FIRING PIN SPRING	STEEL	4	N/A	(1/4")	FOUND IN HARDWARE STORE
	14	BOLT PLUG	BRASS	6	N/A	(9/32")	1/2" BOLT
HOUSING BARREL GROUP	15	PEN CAP THREADS	PLASTIC	1	1	70000	NO NONSENSE BALLPOINT PEN
	16	INDEXING RING	BRASS	2	2	135 3/8"	TUBING
	17	BARREL	STEEL	5	5	5L12R46	RIFLED BARREL LINER
	18	BARREL EXTENSION	BRASS	2	2	134 11/32"	TUBING
	19	BARREL EXTENSION PLUG	BRASS	4	N/A	(5/16")	10 X 32 CAP NUT
	20	RECOIL TRANSFER SCREW	BRASS	4	N/A	N/A	10 X 32 FLAT HEAD MACHINE SCREW
HOUSING	21	INNER HOUSING	BRASS	2	2	135 3/8"	TUBING
	22	OUTER HOUSING	BRASS	2	2	136 13/32"	TUBING
	23	HOUSING PLUG	BRASS	6	N/A	(3/8")	1/2" BOLT

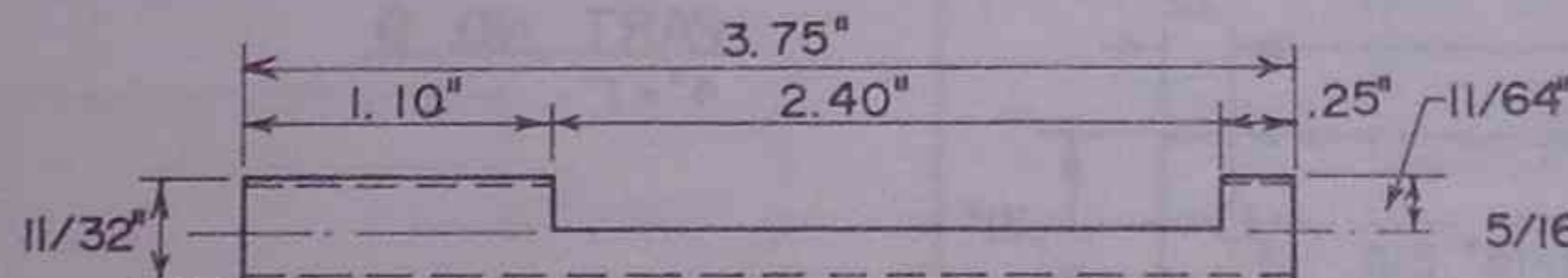
LOCAL SOURCE LISTING	
1	SUPERMARKET
2	HOBBY SHOP
3	SPORTING GOODS STORE
4	HARDWARE STORE
5	BROWNELL'S CATALOG
6	SCRAP PILE

MANUFACTURERS LISTING

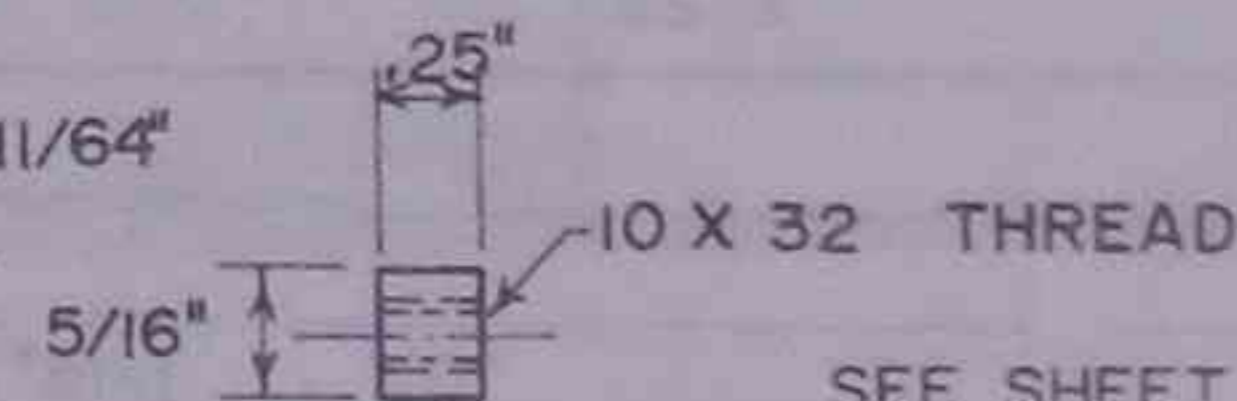
- SHEAFFER EATON, INC.
LINCOLN, RI 02865
- K & S ENGINEERING CO.
6917 WEST 59TH ST.
CHICAGO, IL 60638
- WINCHESTER
EAST ALTON, IL 62024
- BLACK & DECKER
P.O. BOX 21030-0798
HUNT VALLEY, MD 21030
- BROWNELL'S, INC.
ROUTE 2, BOX 1
MONTEZUMA, IOWA 50171



PART NO. 17



PART NO. 18



PART NO. 19

SEE SHEET 6 FOR PARTS
NO. 15 & NO. 16.
SEE SHEET 2 FOR PART
NO. 20.

BARREL GROUP

1" = 1"

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CANE GUN



SILENCED .22 L.R. CAL. DEFENSE WEAPON

DISCLAIMER: THE DRAWINGS HEREIN ARE SOLELY INTENDED FOR THE EDIFICATION AND ELUCIDATION OF THE READER. SARDAUKAR PRESS DISAVOWS ANY RESPONSIBILITY FOR APPLICATION OF THESE DRAWINGS TO ANY PURPOSE OTHER THAN THE USE STATED ABOVE.

WARNING: IT IS A VIOLATION OF FEDERAL LAW SUBJECT TO FINE AND / OR IMPRISONMENT TO MANUFACTURE THIS OR ANY FIREARM OR SILENCER WITHOUT A LICENSE.

GENERAL NOTES

The CANEGUN is a .22 long rifle caliber, camouflaged urban defense weapon designed to be built without exotic tools, complex parts or special skills. The weapon is disguised by sight and sound having the appearance of a classy walking stick and incorporating an ultra efficient internal silencer. All components of the CANEGUN are off the shelf items most of which can be found at any good hardware store. The only essential power tools are a drill press and Dremel hand grinder. The usual assortment of hand tools and a modicum of skill are also needed.

Undoubtedly the hardest task is drilling the 29/64" hole down the center of part #12. V blocks or a machinist vise are helpful. Even so, it may take more than one try. Centering the hole is crucial to the effort. The 5/16" hole through part #7 is easier only because the piece is shorter. It is also advisable to use the drill press chuck as the tap holder when cutting internal threads. If the tool is not perpendicular to the work another piece of scrap is created.

Part #7 is turned down to fit snugly inside part #2 by inserting a 5/16" threaded rod through the hole, securing with two nuts, and turning in the drill press against a hand held file. Likewise, parts #4, #22 and #30 are reduced but #17 is placed directly in the chuck and shaped in its entirety before sawing it from the bolt stock.

The leather which conceals the trigger mechanism was selected from the scrap bin at Tandy Leather. This could also be denim, canvas, plastic, etc. if a suitable piece of leather can not be found.

Part #5 is a copper clad, steel fiber scouring pad stretched out, twisted into a rope and wound around the outside of the perforated, rifled barrel liner. It is held in place by wrapping a piece of tie wire in the opposite direction. Do not use steel wool because it will burn nor string because it will break.

While most dimensions are shown to two decimal places the implied degree of accuracy is not really necessary. Test fitting is used throughout the manufacturing process whereby the dimensions of one part determine the size of the next.

The most delicate art is tapping the small threads. Patience, plenty of cutting oil and a gentle touch is required. The amount of patience used is inversely proportional to the amount of scrap generated.

TOOLS AND EQUIPMENT NEEDED

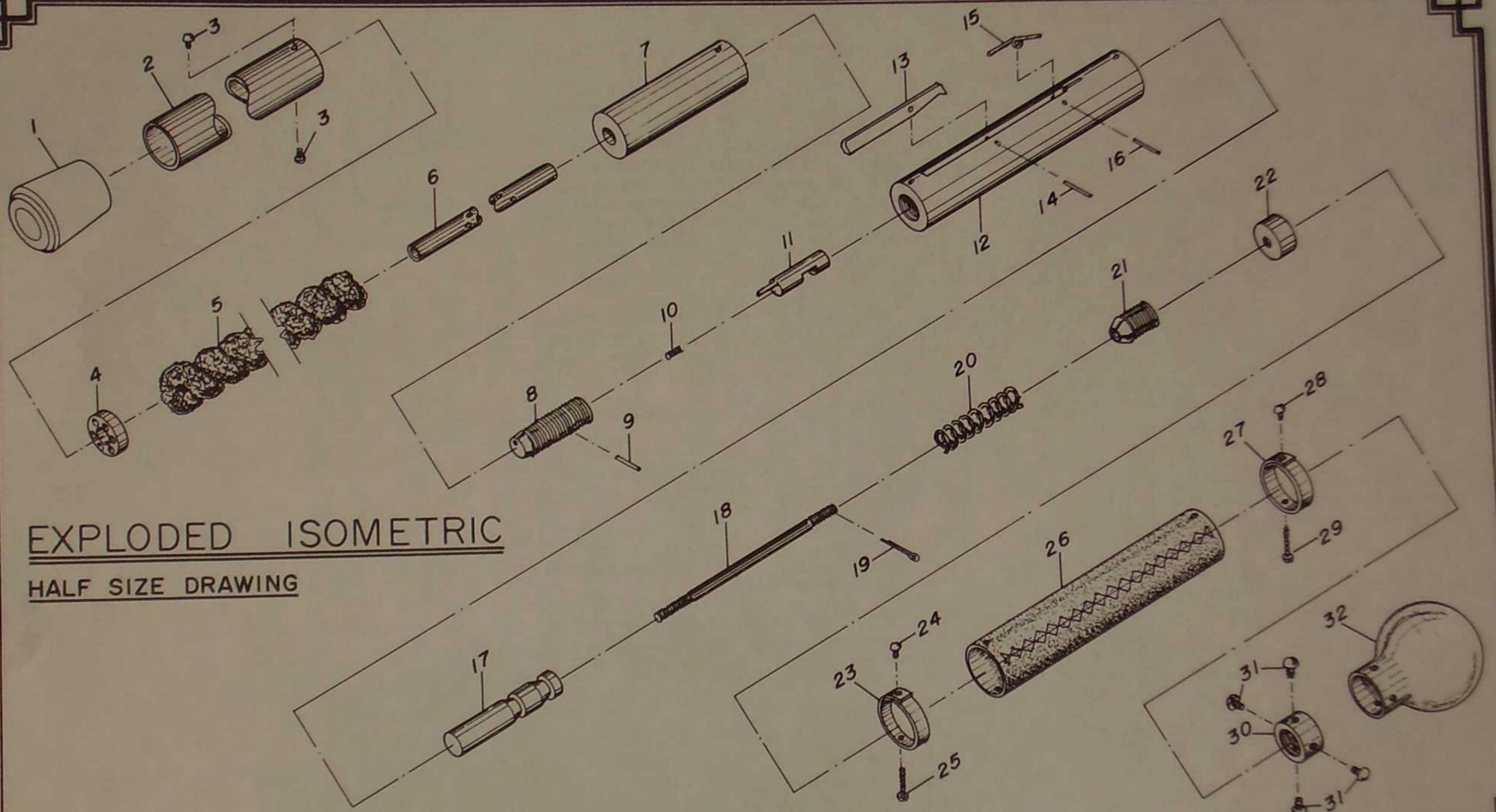
Drill bits: #1, #14, #36, #43, 29/64", 5/16", 13/64", 1/8",
5/32", 7/64", 3/32", 1/16"
Curved sewing needles and heavy waxed thread
Thread taps: 1/2-20, 12-24, 6-32, 4-40
Machinist's vise and/or "V" blocks
Files: flat, round and triangular
Dremel bits: #402, #409 & #932
Razor knife and straight edge
Dremel electric hand grinder
5/16" threaded rod and nuts
Thread dies: 1/2-20, 12-24
Screwdriver, flat blade
.22 l.r. bullets
.05" tie wire
Center punch
Drill press
Cutting oil
Hacksaw
Pencil
Hammer
Ruler

OTHER SARDAUKAR ORIGINALS

ZAPPER -Cigarette lighter gun
BUCKLER-Db1 bbl buckle gun
BLITZER-High explosive bullet
TATTLER-Trip wire alarm
PENGUN -Writing pen gun
ROCKER -AR7 full auto
FOGGER -pen/smoke bomb

SARDAUKAR PRESS
P.O. Box 38531-D
Germantown, TN 38138

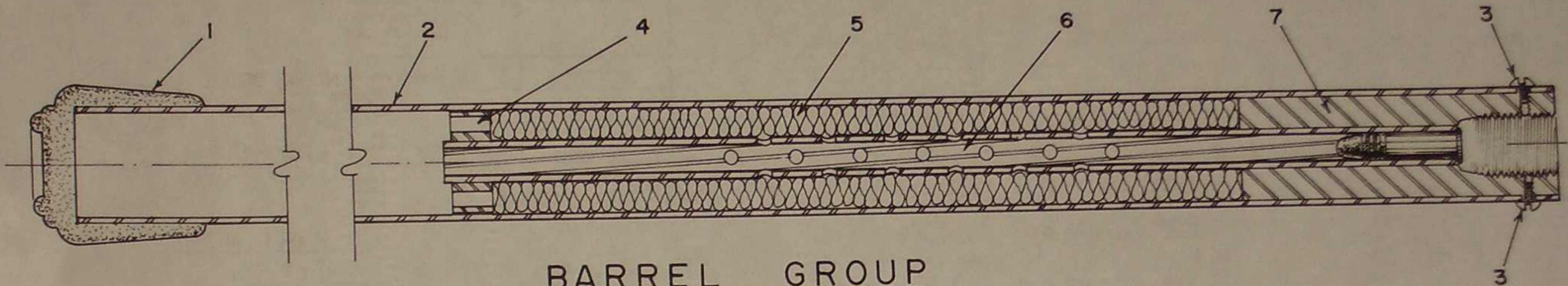
© SARDAUKAR 90



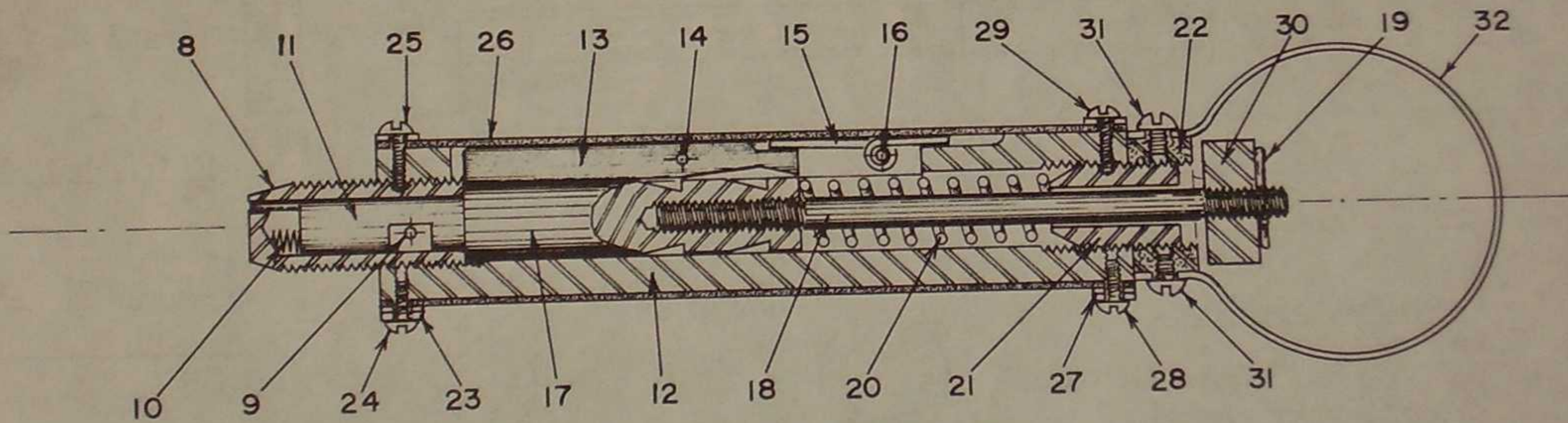
EXPLODED ISOMETRIC
HALF SIZE DRAWING

INSTRUCTIONS

1. Cut 12 to length. Tap threads in both ends. Cut slot, groove and drill 1/16" dia. holes for 14 & 16.
2. Cut 3" section from 1/2" bolt for 8. Cut 1/2-20 threads for 2". Drill 5/16" hole (hint: chuck 8 in drill press and secure 5/16" bit in machinists vise). Cut 8 to length and square face. Drill 3/32" firing pin hole. Bevel end.
3. Grind 11 using Dremel hand grinder and #409 cutting wheel. Use 11 to locate 3/32" hole in 8 and drill same. Cut pin 9 and spring 10 to fit.
4. Cut 7 to length. Chuck in drill press and reduce diameter until 7 will fit snugly in 2. Drill 29/64" to depth as shown and tap 1/2-20 threads.
5. Cut 6 to length. Drill 7/64" gas holes (hint: "V" blocks are helpful). Cut chamber with wire size drill #1 (.228" dia) using .22 long rifle bullet to confirm depth. The first round fired will remove all internal burrs.
6. Cut 4 to length and drill 5/16" hole in center. Using step 4 technique reduce diameter to fit loosely into 2. Drill 6 gas vent holes as shown.
7. Screw 8 into 7. Put .22 round into 6. Coat end of 6 with glue (use auto rear view mirror adhesive or Loctite) and insert into 7 being careful to keep glue off bullet. Set 4 on 6 in same manner. Allow to set over night.
8. Cut 3" piece from 1/2" bolt for 17. Drill 29/64" hole in scrap metal for gauge. Chuck into drill press and reduce the diameter until it will pass through gauge. Drill hole as shown using #14 wire size drill (hint: hold bit in machinist's vise keeping 17 in chuck). Shape grooves in 17 using hacksaw, Dremel grinder and file. Tap 12-24 threads and cut to length using hacksaw (hint: spin 17 in chuck for square cut). Bevel end slightly.
9. Unit.
10. Cut 18 to length. Drill 1/16" dia. hole and cut threads.
11. Cut 22 to length, drill and tap 12-24 threads as shown. Chuck 18 in drill press, screw on 30 and reduce diameter.
12. Remove escutcheon plate from 32 by grinding off rolled lip of metal insert. Remove insert by placing hacksaw blade inside square hole and cut through in two places. Hammer out four indentions (hint: lay shaft of knob on piece of wood, insert 1/2" rod over indentions and hit rod with hammer) and grind smooth from inside with Dremel and #932 bit. Drill 1/8" dia. holes 90 degrees apart centered 5/64" from the edge. Grind off any burrs.
13. Cut 2" piece from 1/2" bolt for 21. Thread for 1". Drill 13/64" hole and bevel end. Cut 30 to length, drill and tap. Screw onto 21 and reduce diameter as in step 4 for tight fit into 31. Remove 30 and cut 21 to length.
14. Mark holes for 22 with holes in 31. Drill and tap.
15. Assemble 4/6/7, 8/9/10/11, 12, 17, 21, 22 & 30. Cut out 13 and trial fit. Cut pins 14 & 16 to length. Bend spring 15 around nail in vise. Cut ends to proper length after trial fit.
16. Cut spring 20 to have slight pressure when uncocked. Test fire on empty .22 case, make adjustments as needed. Set 18 in 17 using adhesive as in step 7.
17. Cut out 26 to fit 12. Mark holes 1/4" apart 1/8" on either side of seam. Sew together in "shoelace" stitch with heavy waxed thread using two curved needles (Item 01025, The Singer Co., Edison, NJ 08837).
18. Wrap 23 & 27 around 26/12, cut to length and drill #43 holes (hint: secure 23 & 27 in position with tie wire or small hose clamp prior to drilling). Mark all parts for proper relationship and disassemble. Tap 4-40 threads in 12.
19. Reassemble 4/6/7, 8/9/10/11 (using empty .22 case to set headspace) into 12. Mark and drill set screw indentation. Repeat procedure for 21. Cut screws 25 & 29 to length.
20. Cut 2 to length. Install over 4/6/7, drill holes for 3 and tap threads in 7. Paint 2 (Black enamel recommended).
21. Remove 5 from handle, unwind and twist into "rope". Rewind around 6 and secure with tie wire.
22. Assemble all parts and the work is finished.
23. To load: unscrew barrel group from breech group, drop .22 long rifle bullet into chamber and screw pieces together.
24. To cock: unscrew knob and pull reward. Two clicks will be heard as the trigger engages the half cock then full cock notches on the hammer. The bulge of the trigger can be felt under the leather grip. Screw knob back into place.
25. To fire: press trigger bulge in leather with thumb.

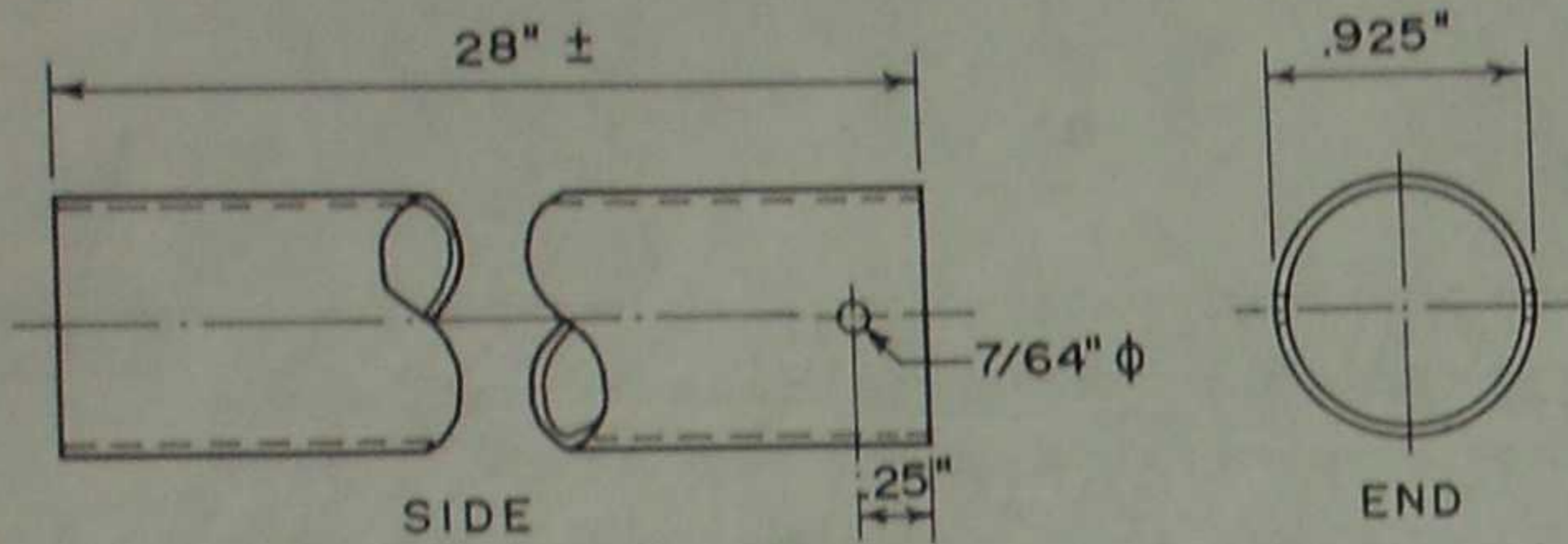


BARREL GROUP



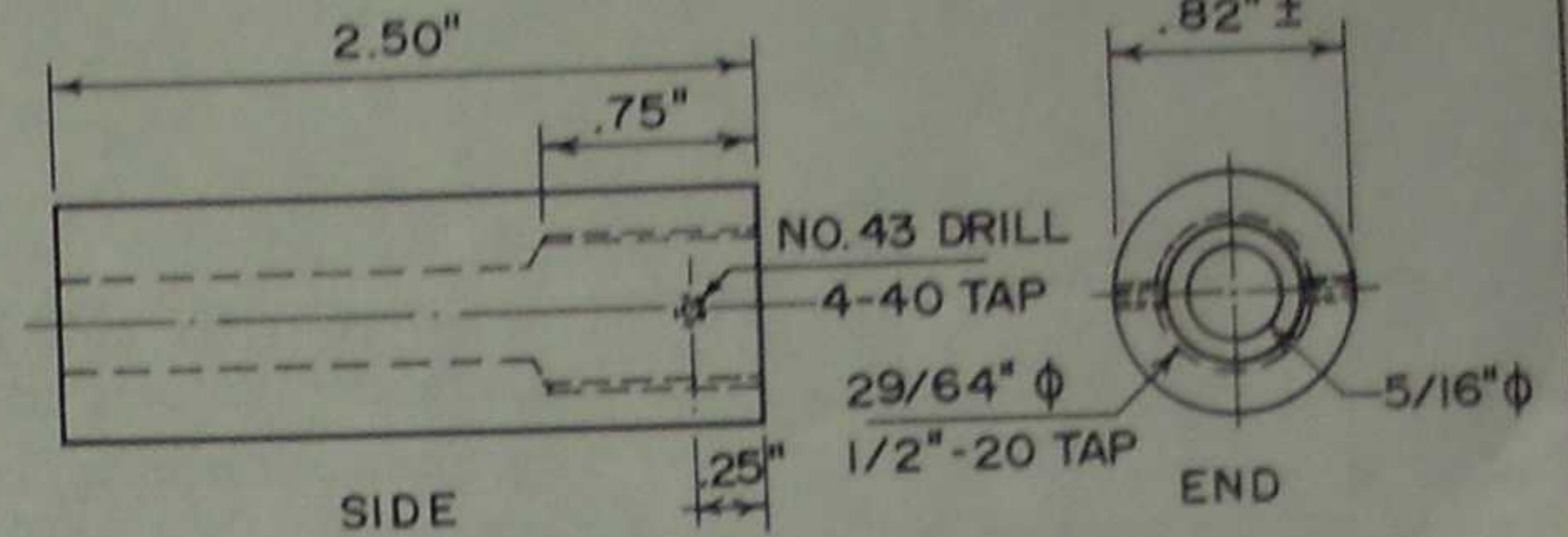
BREECH GROUP

LONGITUDINAL SECTION
FULL SIZE DRAWING



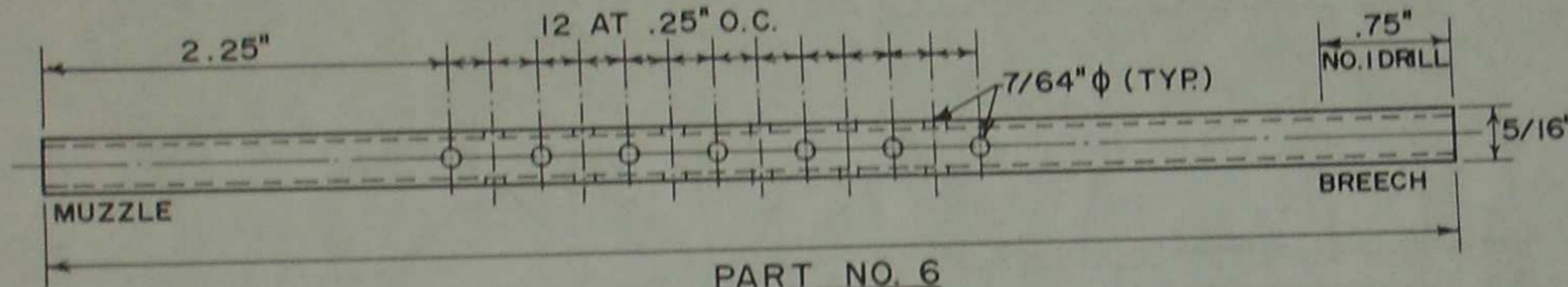
PART NO. 2

1" = 1"



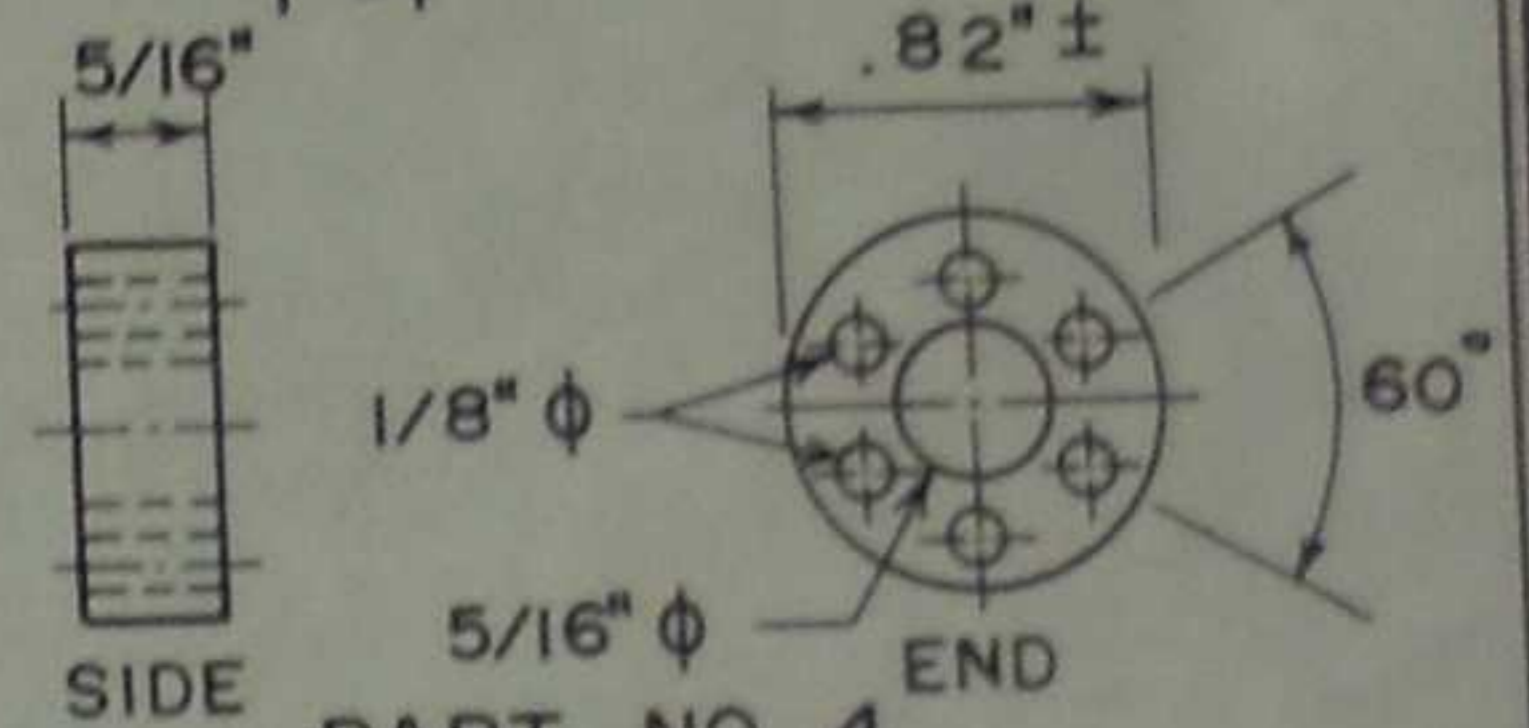
PART NO. 7

1" = 1"



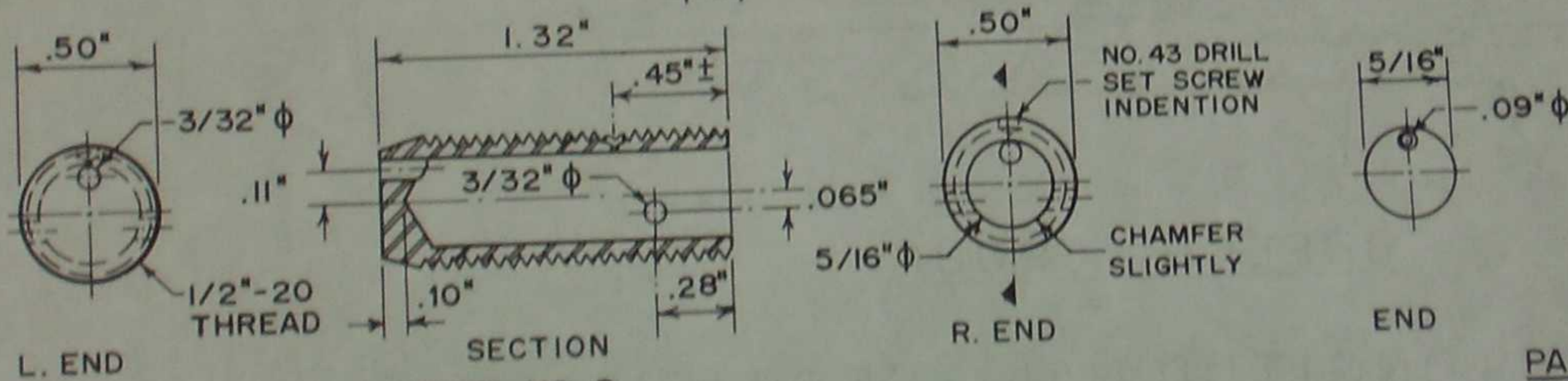
PART NO. 6

1" = 1"



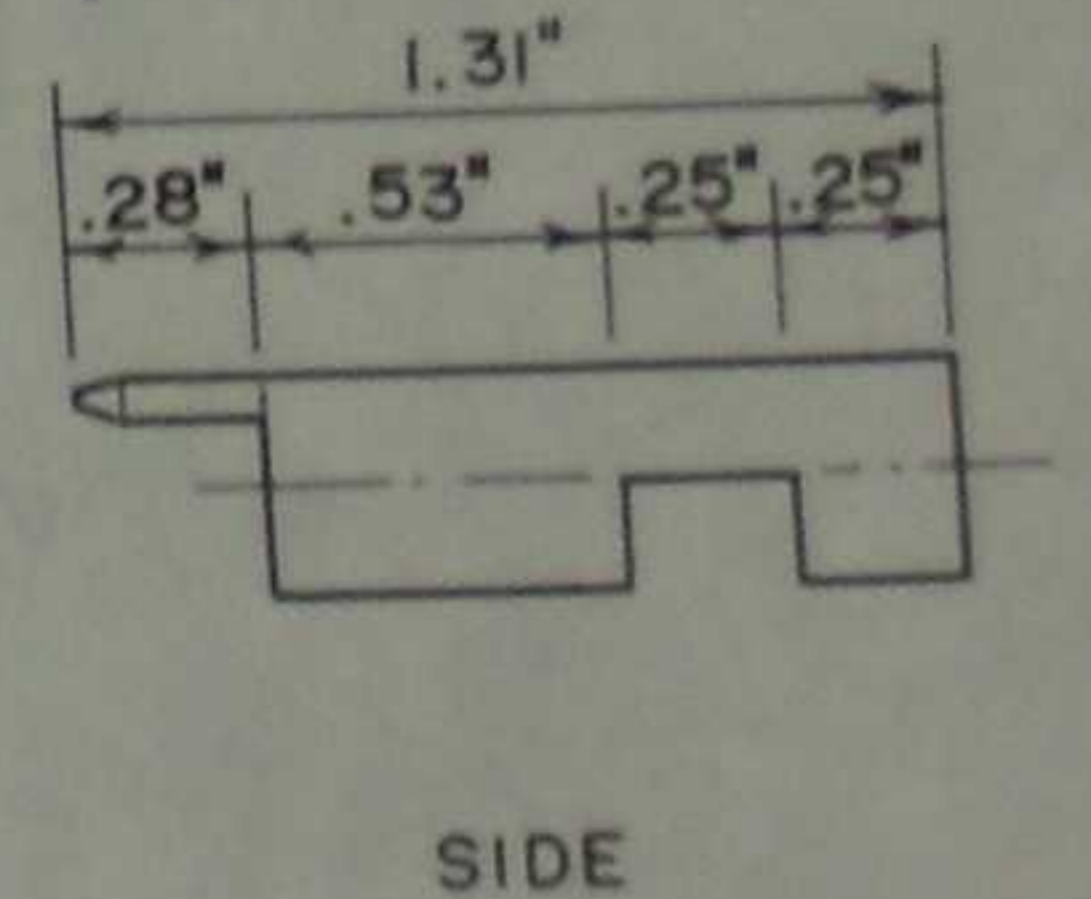
PART NO. 4

1" = 1"



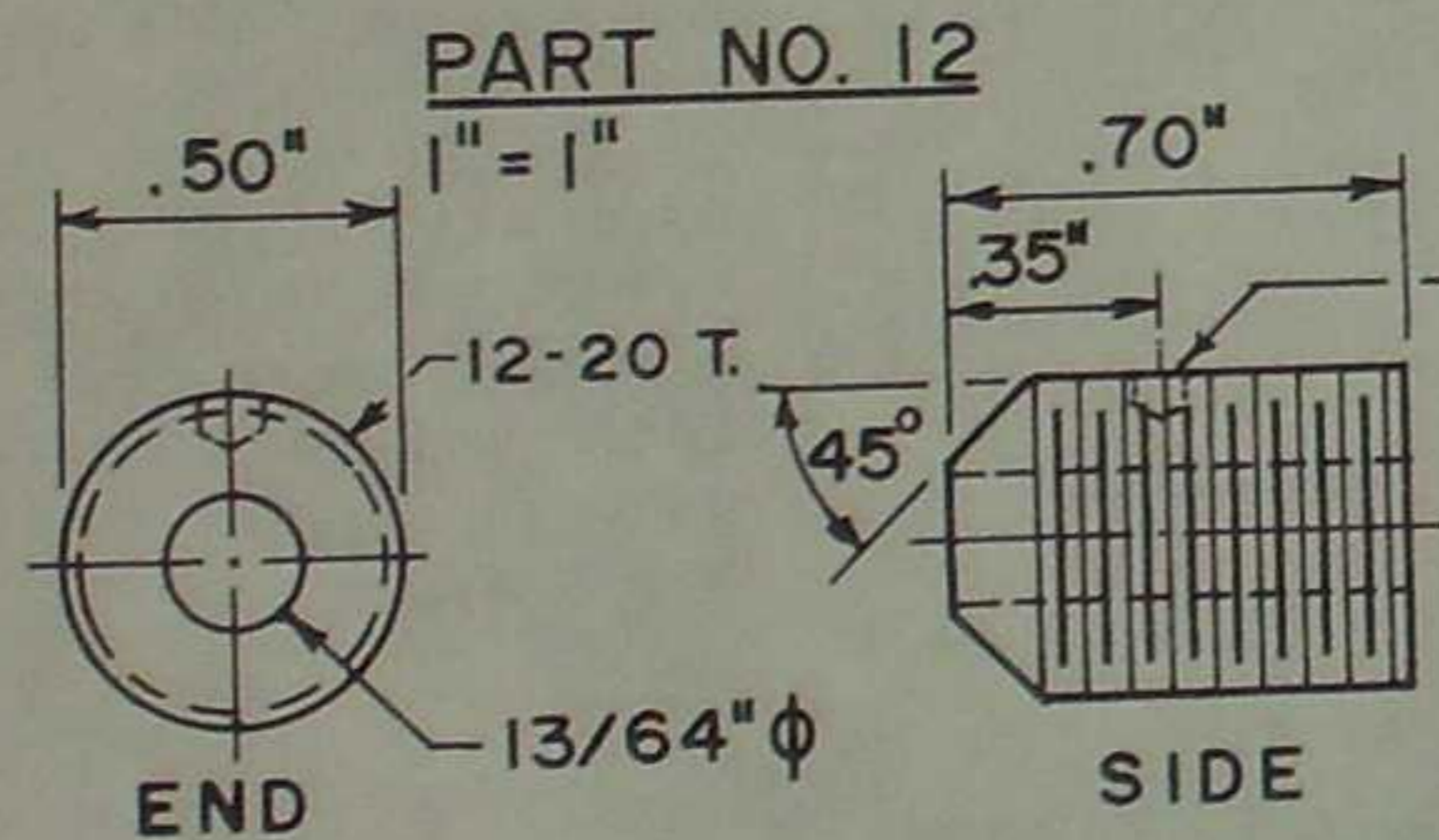
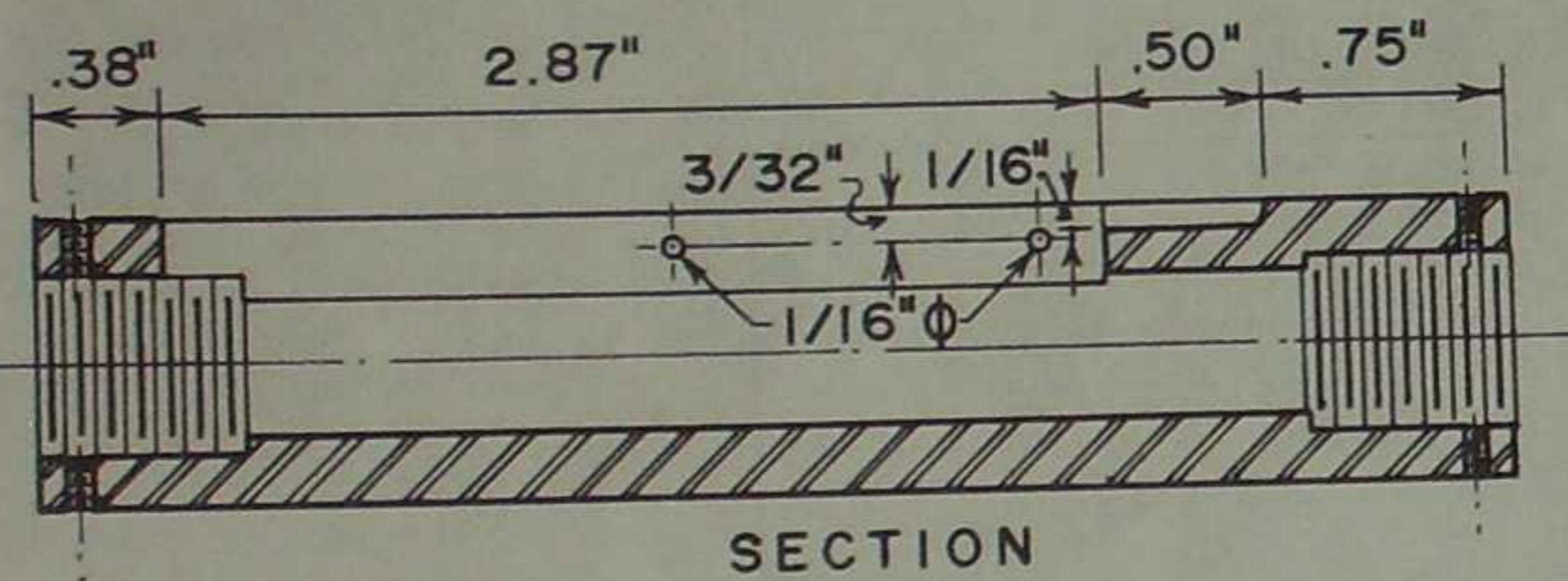
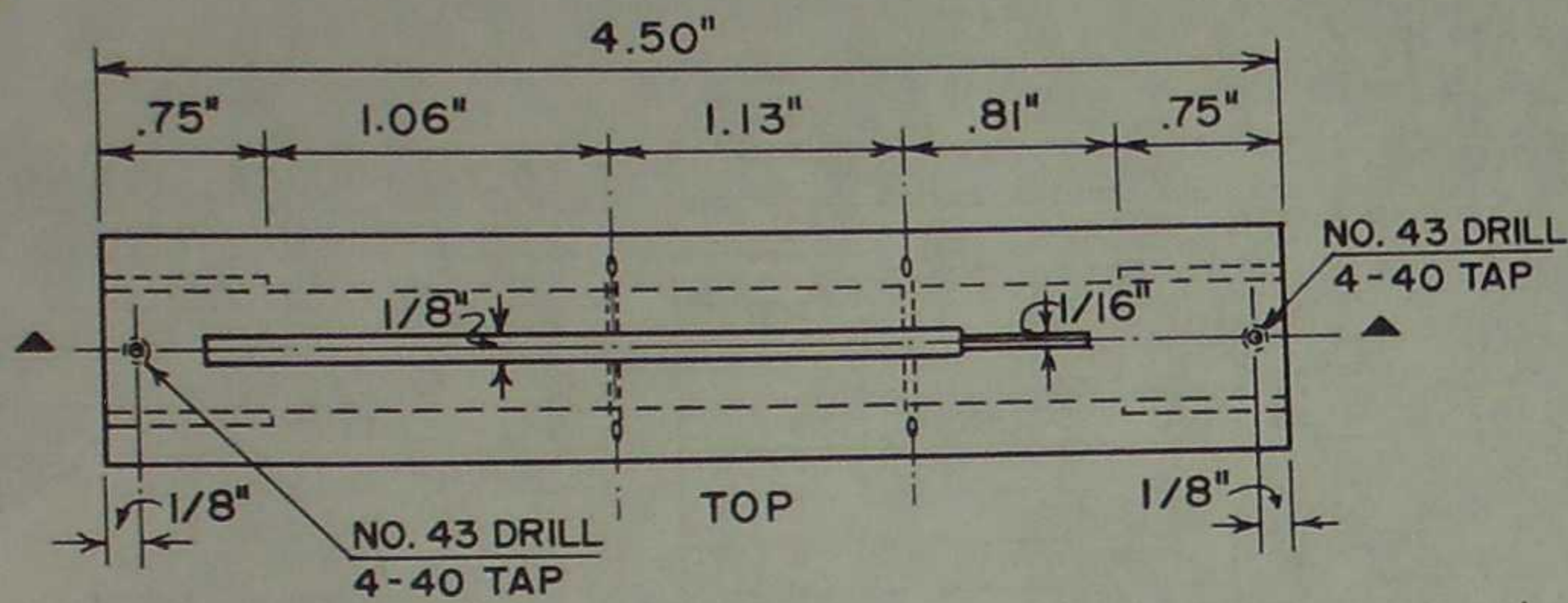
PART NO. 8

3" = 2"



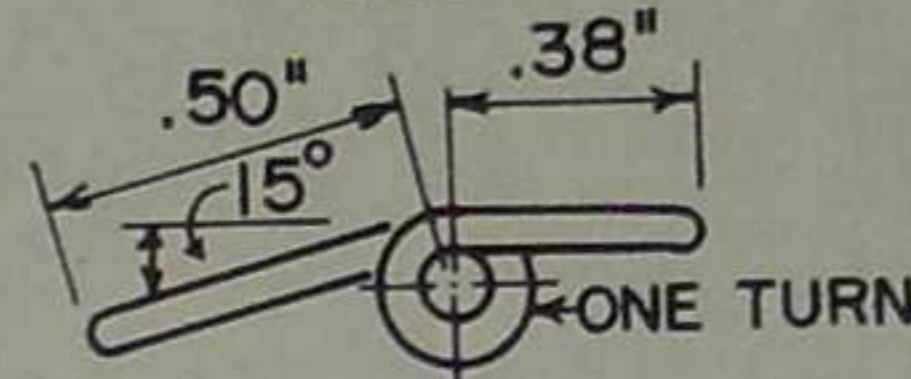
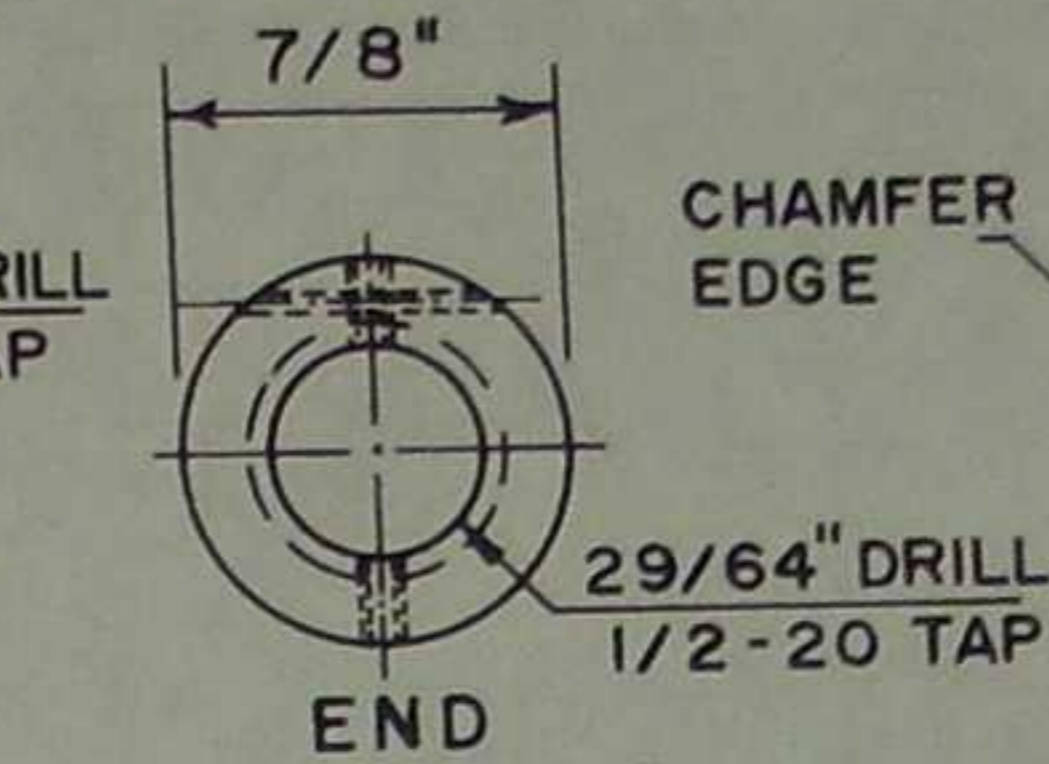
PART NO. 11

3" = 2"

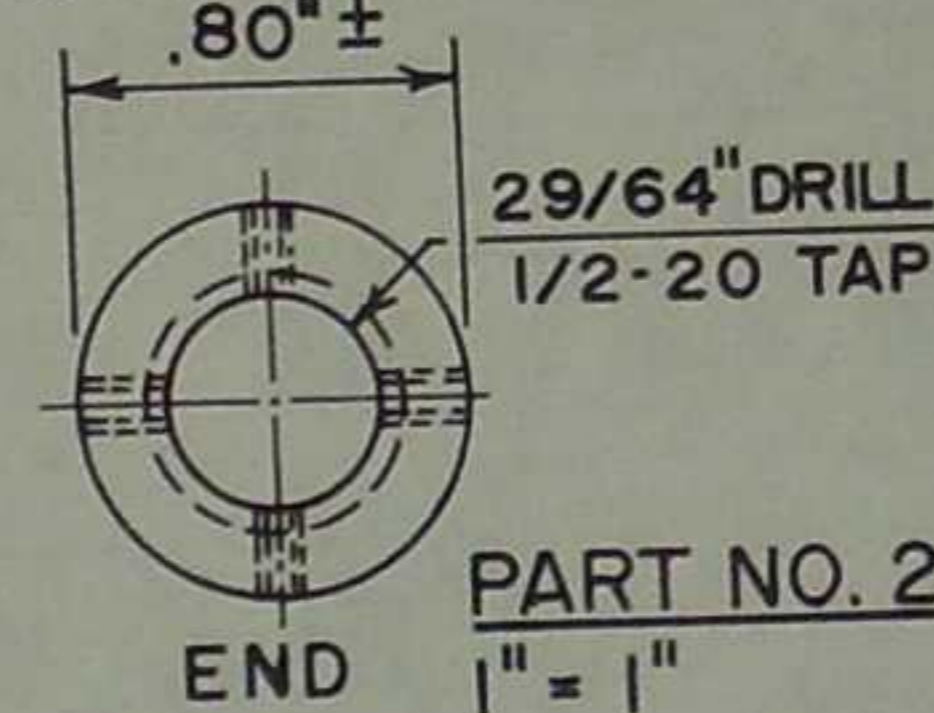


PART NO. 21
 3" = 2"

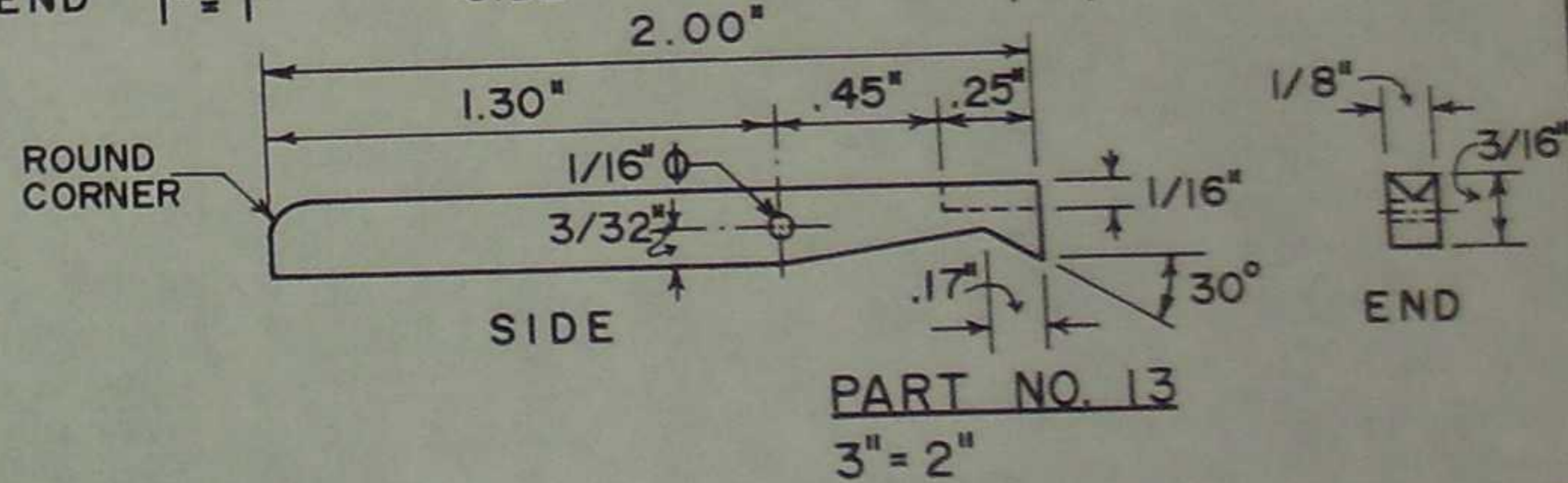
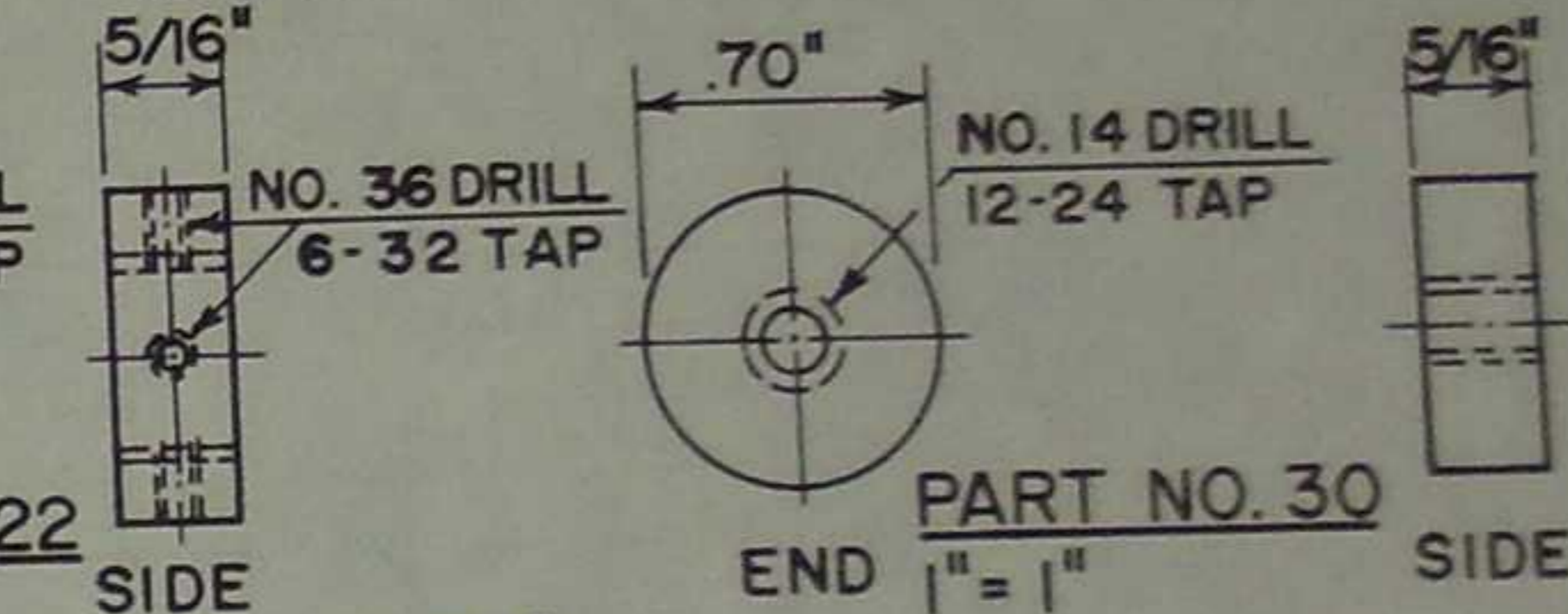
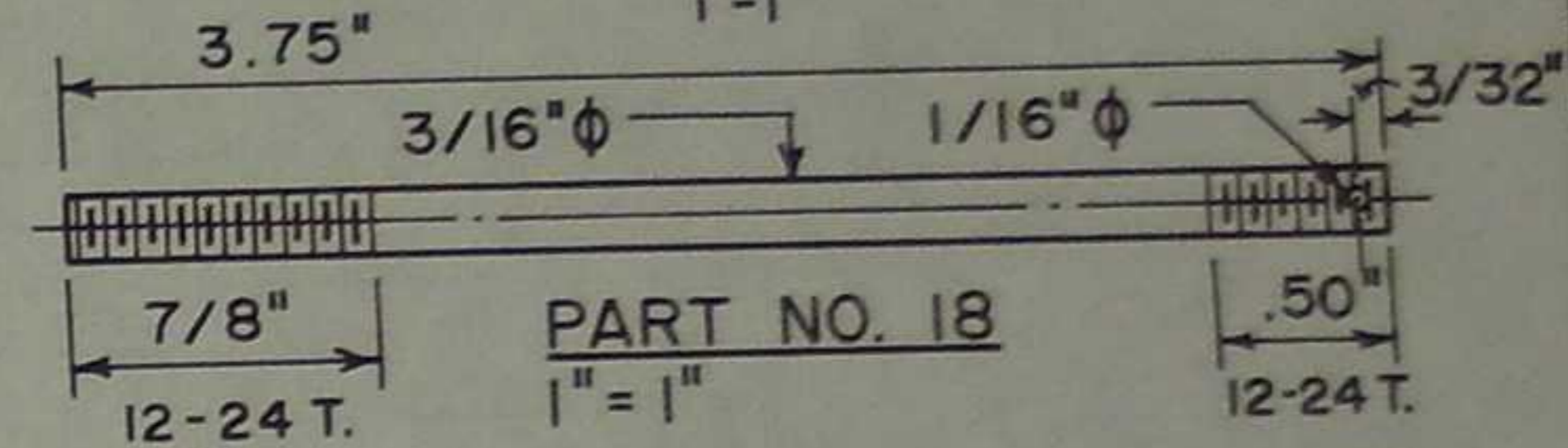
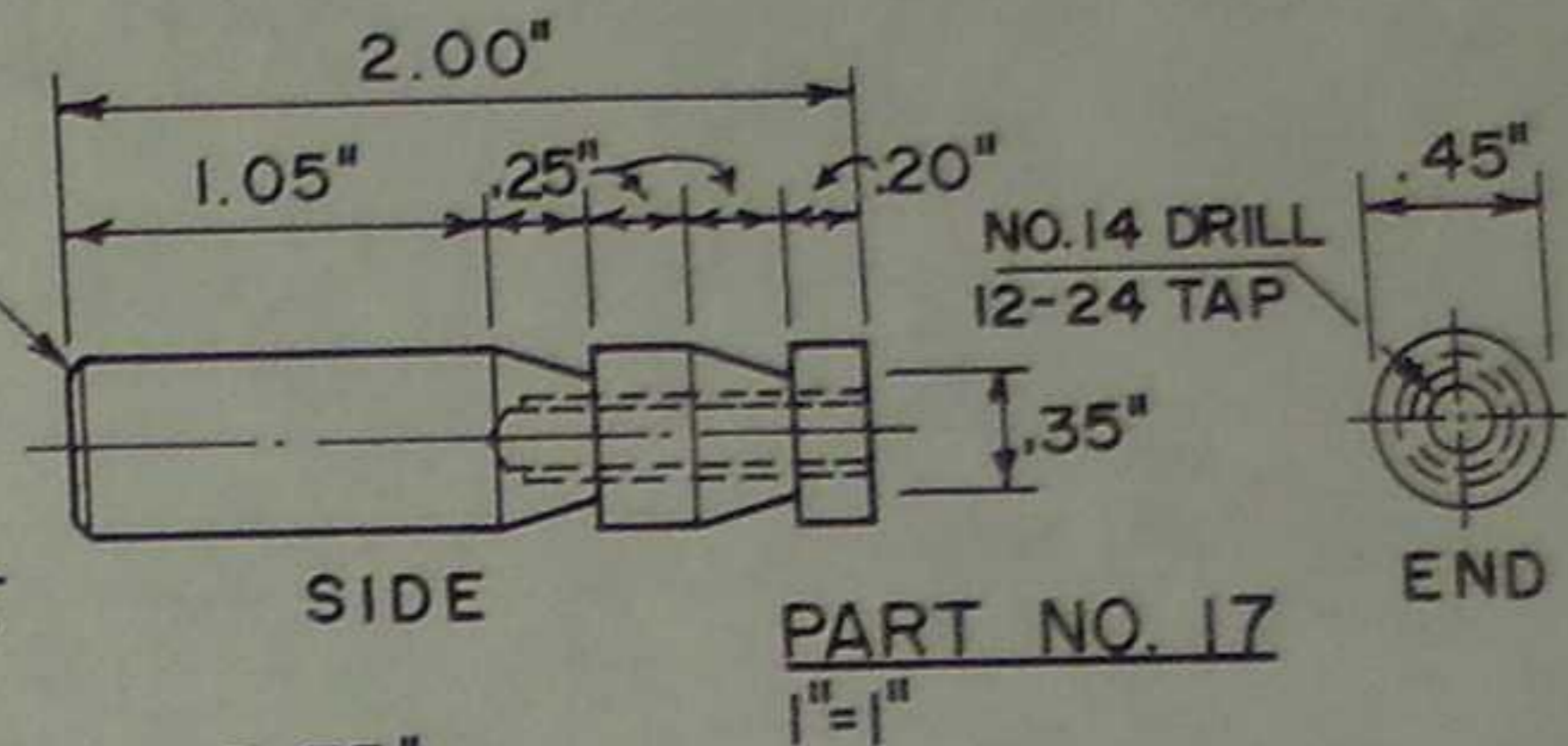
PARTS NO. 23 & 27
 1" = 1"



PART NO. 15
 3" = 2"



PART NO. 22
 1" = 1"



PARTS SCHEDULE

NO.	NOMENCLATURE	MATERIAL	SOURCE	MFGR	MFGR NO.	COMMENTS
1	CANE TIP	PLASTIC	1	1	ACE51241	7/8" ϕ FURNITURE TIP
2	BARREL SHROUD	STEEL	1		-	3/4" ϕ E.M.T. (THIN WALL) CONDUIT
3	BARREL SHROUD SCREWS(2)	BRASS	1	2	54060322	4-40 X 1/4" RD. HD. SCREW
4	GAS VENT	STEEL	1	3	P2144-903B	7/8" X 12" GRADE 2 BOLT
5	SILENCING MEDIA		2	4	44-1395	"ERGO" COPPER-CLAD SCOURING PAD
6	BARREL (RIFLED)		3	5	5L-12R46	MAIL ORDER ITEM
7	BARREL EXTENSION		1	3	P2144-903B	7/8" X 12" GRADE 2 BOLT
8	BREECH PLUG		1	3	P2144-744B	1/2" X 10" GRADE 2 BOLT
9	FIRING PIN RETAIN'G PIN		4	6	506	3/32" MUSIC WIRE
10	FIRING PIN SPRING		2	-	-	FROM RETRACTABLE BALL POINT PEN
11	FIRING PIN		1	-	-	5/16" DRILL BIT
12	FRAME		1	3	P2144-903B	7/8" X 12" GRADE 2 BOLT
13	TRIGGER		1	7	F37110	1/8" X 3/4" X 36" GALV. FLAT STOCK
14	TRIGGER PIVOT PIN		4	6	504	1/16" ϕ MUSIC WIRE
15	TRIGGER SPRING		4	6	503	.055" ϕ MUSIC WIRE
16	TRIGGER SPRING PIN		4	6	504	1/16" ϕ MUSIC WIRE
17	HAMMER		1	3	P2144-744B	1/2" X 10" GRADE 2 BOLT
18	COCKING ROD		1	7	R36103	3/16" ϕ X 36" GALV. ROD
19	COCKING NUT PIN		1	-	-	1/16" ϕ X 1" COTTER PIN
20	MAINSRING		1	8	32	SUPPLEMENT WITH NO. 76 X IF NEEDED
21	FRAME PLUG		1	3	P2144-744B	1/2" X 10" GRADE 2 BOLT
22	COCKING NUT		1	3	P2144-903B	7/8" X 12" GRADE 2 BOLT
23	LOWER FERRULE	BRASS	4	6	240	.032" X 12" BRASS STRIP
24	LOWER FERRULE SCREW		1	2	54060322	4-40 X 1/4" RD. HD. SCREW
25	BREECH PLUG SET SCREW		1	2	54060389	4-40 X 1" RD. HD. SCREW
26	GRIP	LEATHER	5	-	-	SOFT LEATHER
27	UPPER FERRULE	BRASS	4	6	240	.032" X 12" BRASS STRIP
28	UPPER FERRULE SCREW		1	2	54060322	4-40 X 1/4" RD. HD. SCREW
29	FRAME PLUG SET SCREW		1	2	54060389	4-40 X 1" RD. HD. SCREW
30	COCKING RING	STEEL	1	3	P2144-903B	7/8" X 12" GRADE 2 BOLT
31	COCKING RING SCREWS (4)	BRASS	1	2	54060405	6-32 X 1/4" RD. HD. SCREW
32	HANDLE	BRASS	1	9	488P	DUMMY DOOR KNOB, U.S.3 FINISH

LOCAL SOURCE LISTING	
1	HARDWARE STORE
2	SUPERMARKET
3	BROWNELL'S CATALOG
4	HOBBY SHOP
5	LEATHER SHOP

MANUFACTURERS LISTING

- ACE HARDWARE
2200 KENSINGTON CT.
OAK BROOK, IL 60521
- CENTRAL HARDWARE
III BOULDER INDUSTRIAL DR.
BRIDGETON, MO. 63044
- ROCKFORD PRODUCTS
P.O. BOX 6306
ROCKFORD, IL 61125-1306
- EMPIRE BRUSHES, INC.
GREENVILLE, NC 27835
- BROWNELL'S, INC.
ROUTE 2, BOX 1
MONTZUMA, IOWA 50171
- K & S ENGINEERING CO.
6917 WEST 59th ST.
CHICAGO, IL 60638
- MEDALIST
9375 WEST CHESTNUT
FRANKLIN PARK, IL 60131
- SERVALITE PRODUCTS
EAST MOLINE, IL 61244
- KWIKSET CORP.
ANAHEIM, CA.