

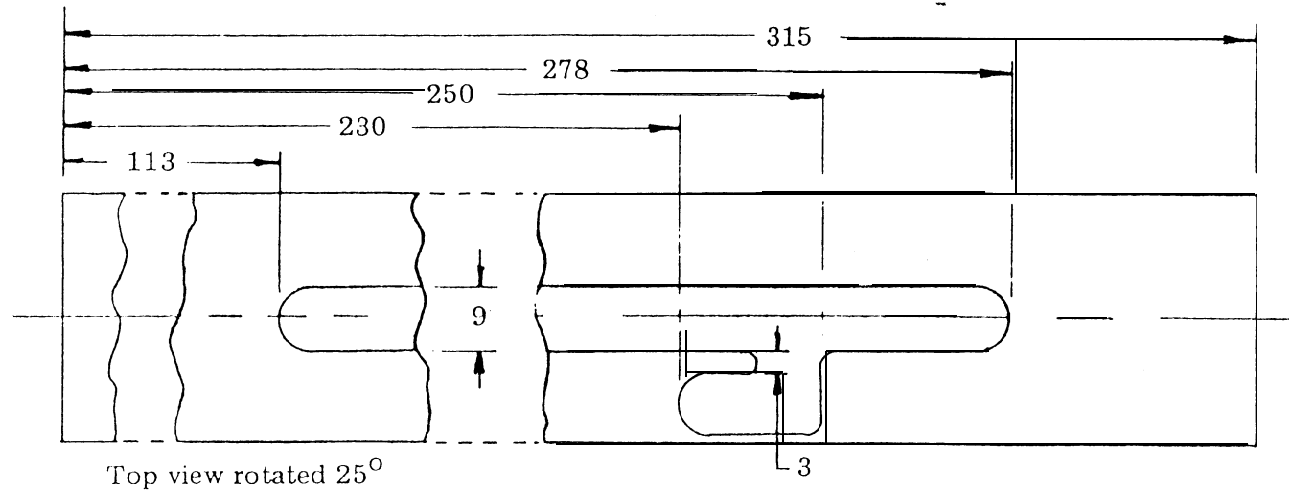
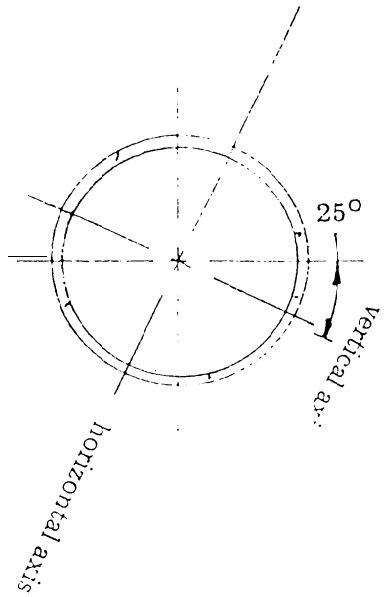
Sten Mk II

PARTS LIST

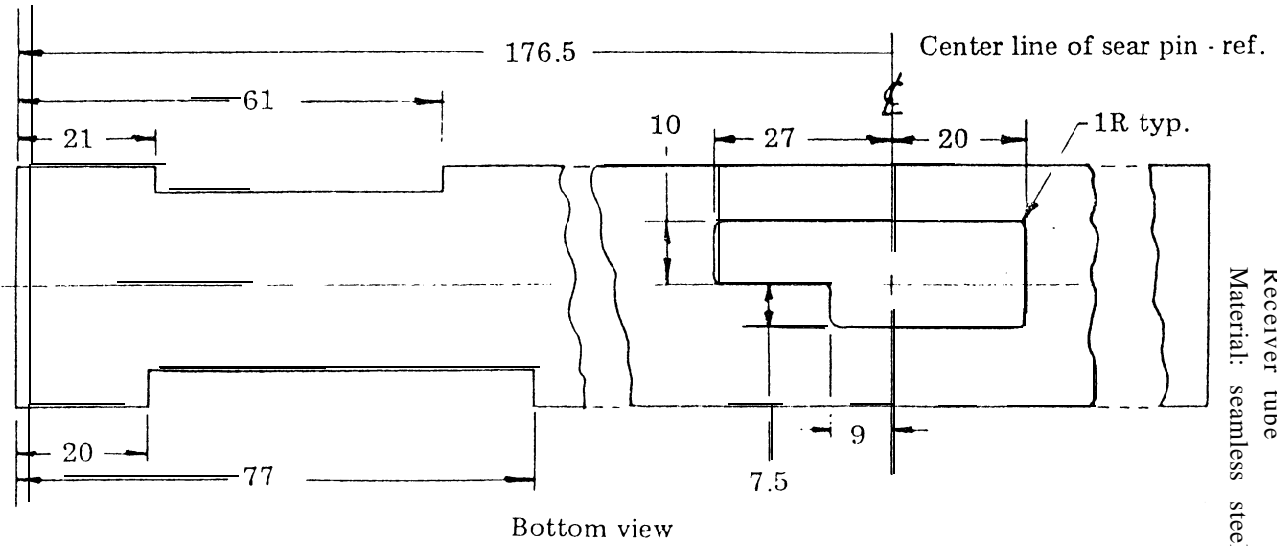
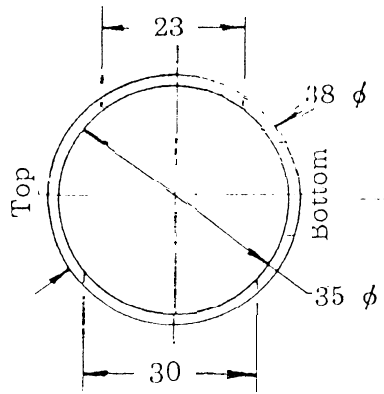
- | | |
|---------------------------------------|-------------------------------------|
| 1. Barrel | 24. Sear |
| 2. Barrel sleeve | 25. Sear spring |
| 3. Barrel sleeve lock | 26. Sear pin |
| 4. Barrel sleeve lock spring | 27. Bolt |
| 5. Front sight | 28. Firing pin |
| 6. Barrel bushing | 29. Extractor |
| 7. Receiver tube | 30. Extractor spring |
| 8. Receiver cap | 31. Extractor pin |
| 9. Trigger housing | 32. Bolt handle |
| 10. Butt stock assembly: stock tubing | 33. Closing spring |
| butt plate | 34. Closing spring cup |
| stock grip | 35. Trigger housing cover |
| stock ring | 36. Trigger housing cover screw (2) |
| 11. Magazine housing | 37. Magazine housing |
| 12. Magazine housing spacer | 38. Magazine follower |
| 13. Magazine housing spacer screw | 39. Magazine spring |
| 14. Magazine latch | 40. Magazine spring latch |
| 15. Magazine latch spring | 41. Magazine bottom |
| 16. Trigger | 42. Rear sight |
| 17. Trigger spring | |
| 18. Trigger pin | |
| 19. Disconnecter | |
| 20. Disconnecter pin | |
| 21. Selector | |
| 22. Selector spring | |
| 23. Selector plunger (2) | |

NOTES:

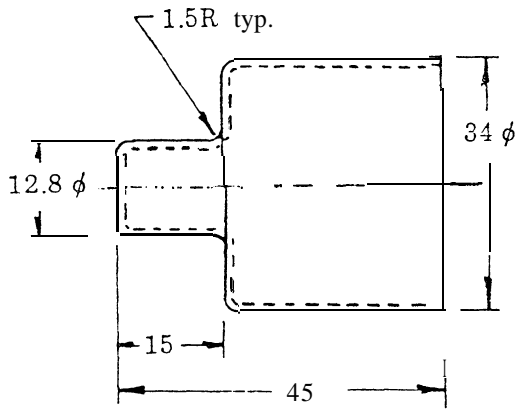
1. Bolt stopping surface on barrel is 1mm forward of magazine well slot.
2. Bolt stroke is



Scale: .87 : 1



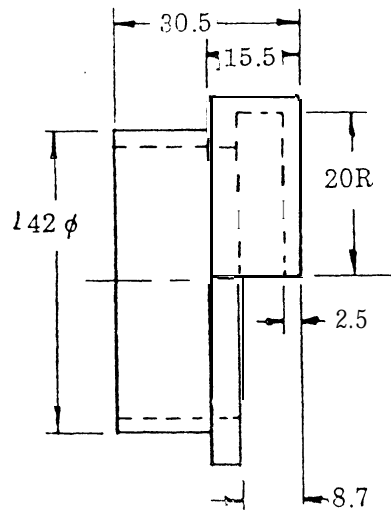
Receiver tube
Material: seamless steel tubing



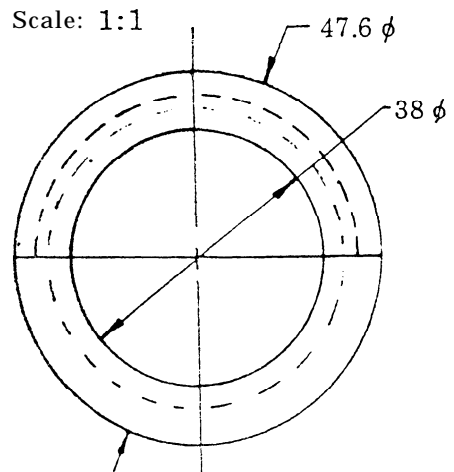
Main spring cap
Material: 1mm stock

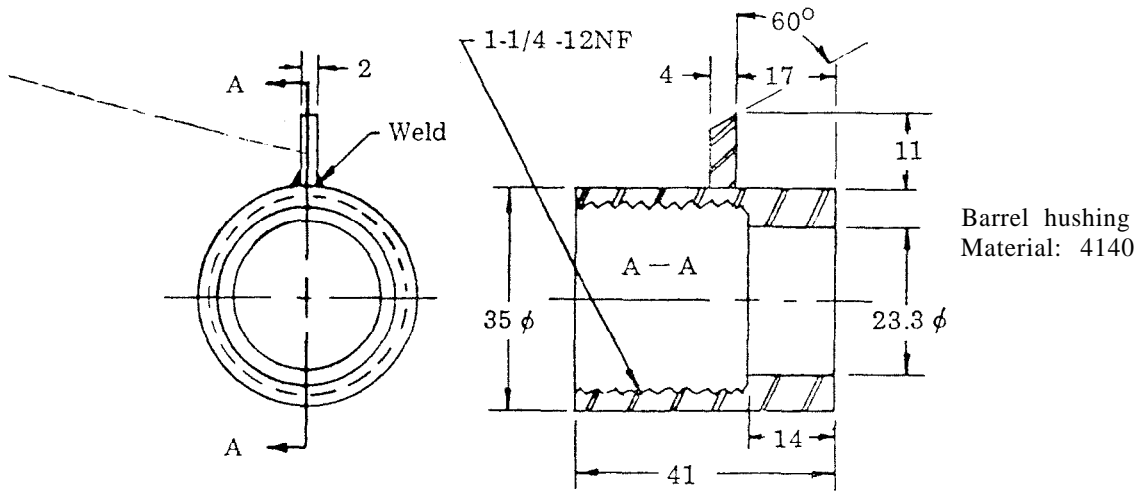
Scale: 1:1

Receiver rear end bushing
Material: AISI 1010 or equivalent

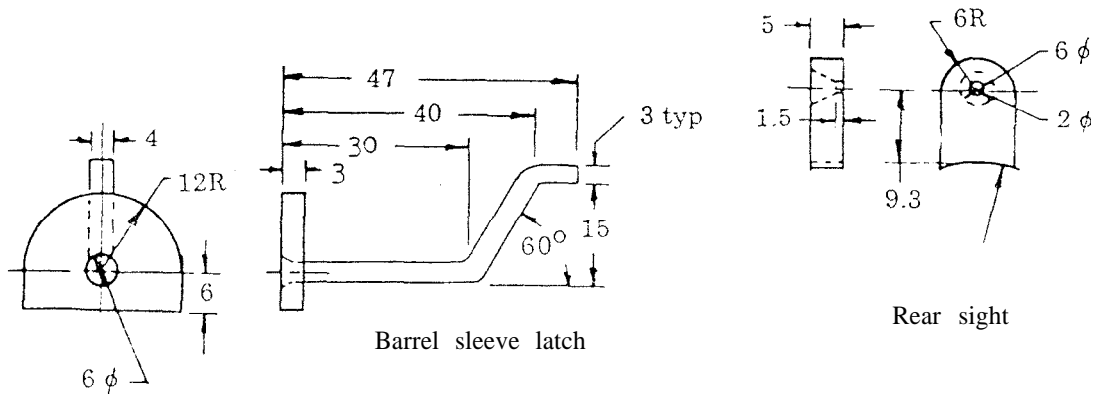
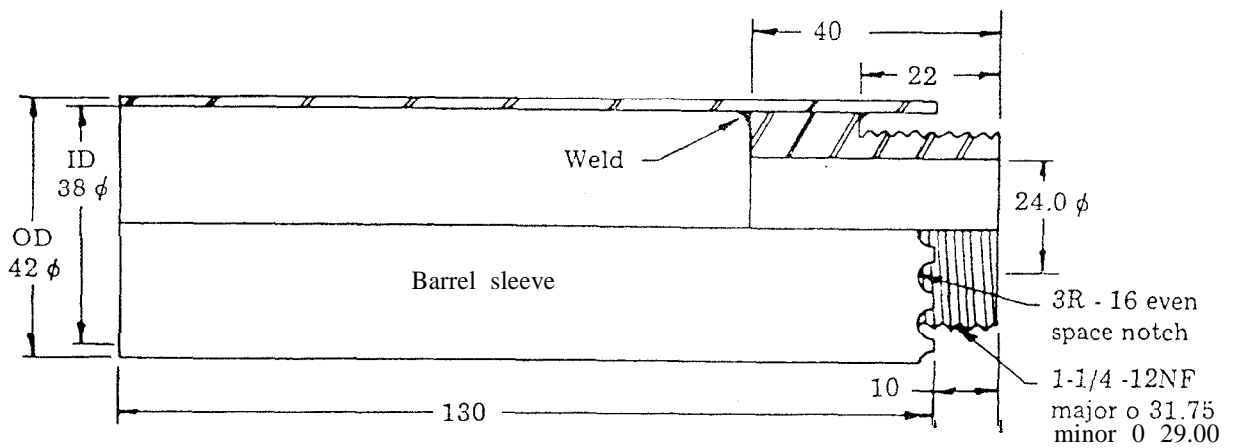


Scale: 1:1



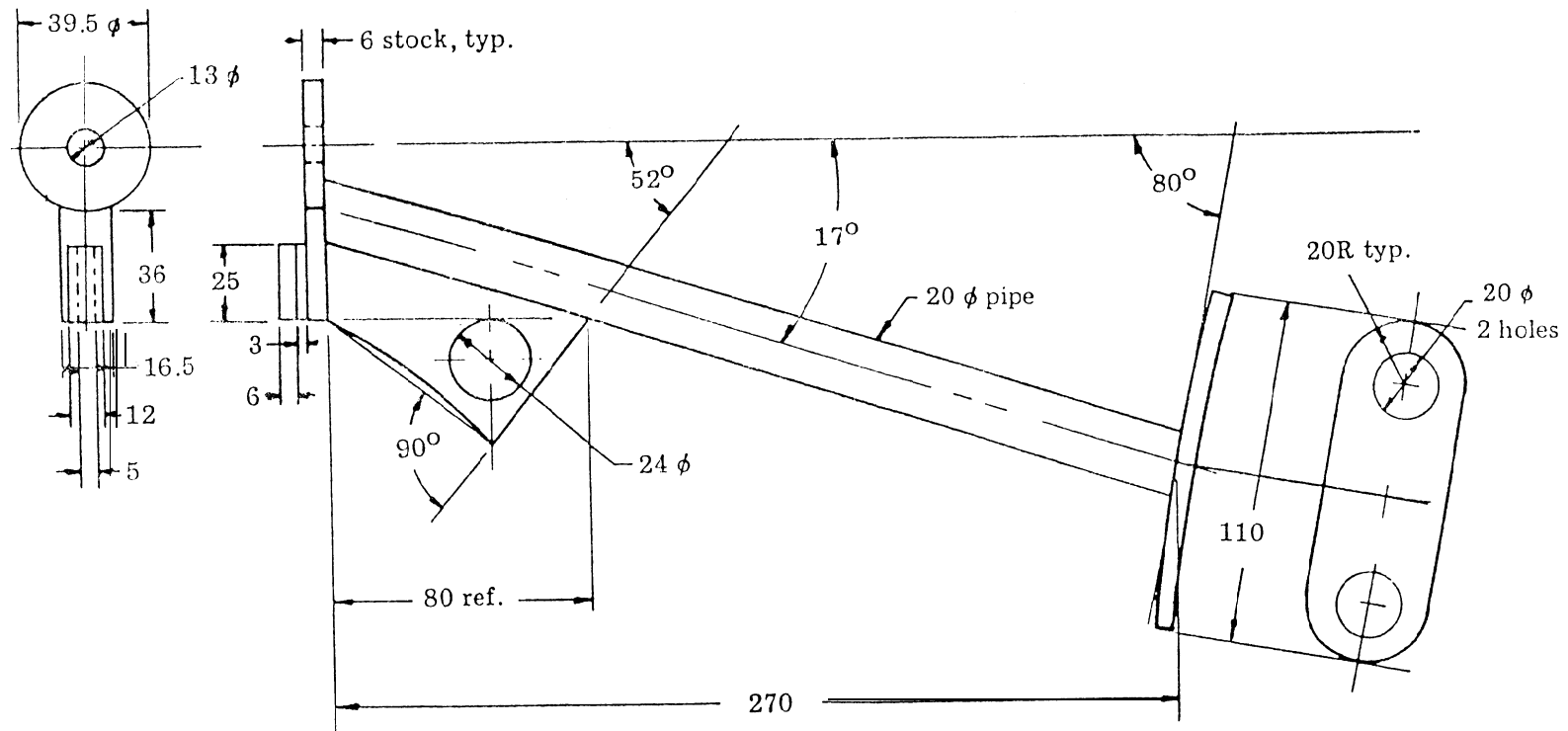


Scale:



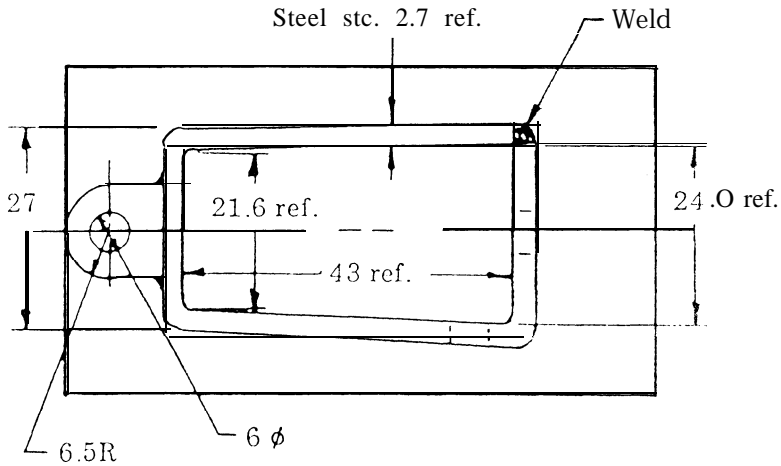
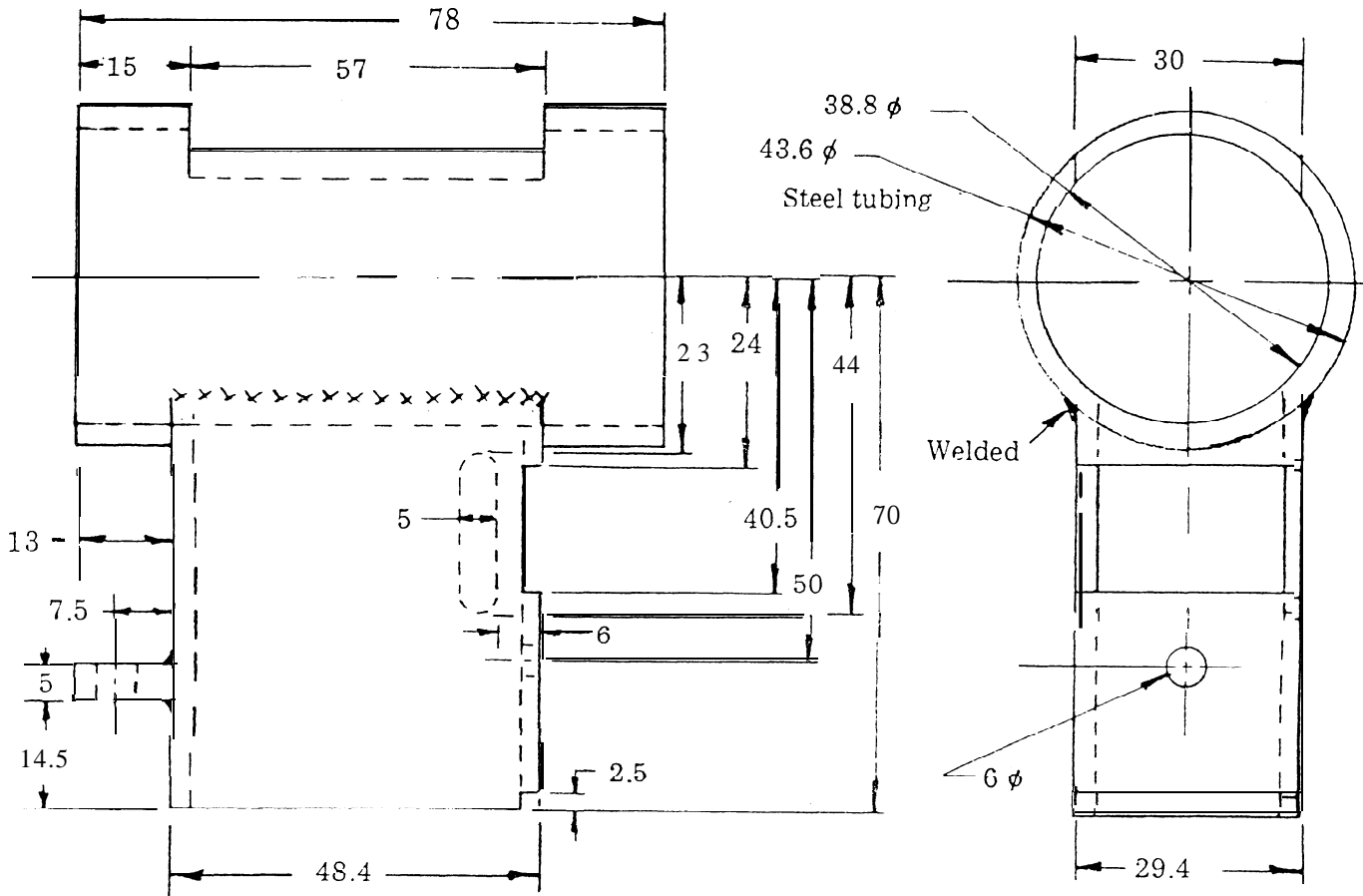
Note: Stake at assembly
with magazine housing

Butt-stock assembly
Material: low carbon steel
or aluminum, welded construction



Magazine housing
Material: as noted

Scale: 1 : 1

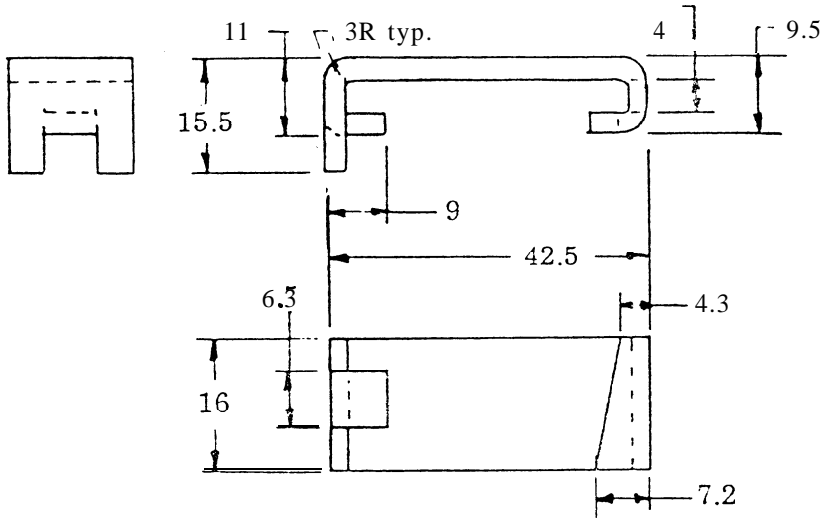


Magazine latch

Material: AISI 1010 or equivalent

2.7mm stock. Case harden 0.1mm deep

Scale: 1:1

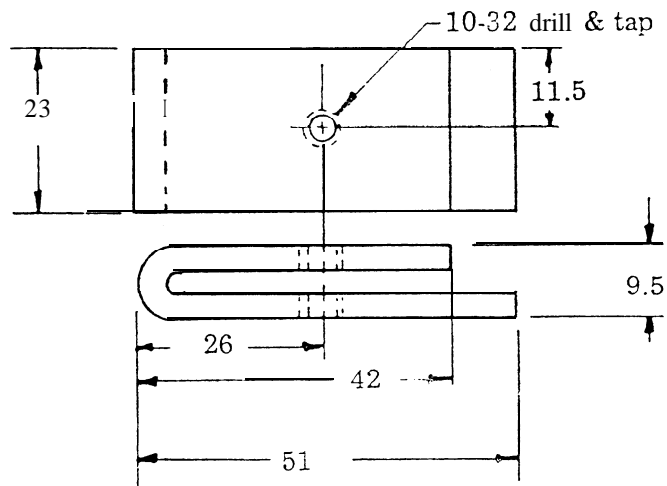


Magazine housing spacer

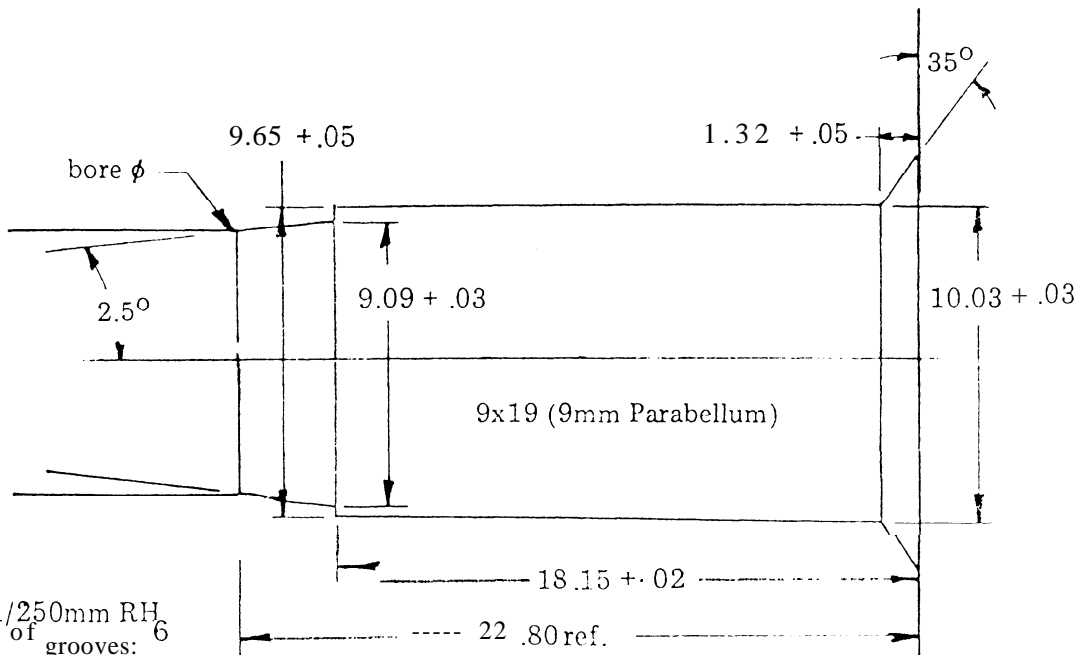
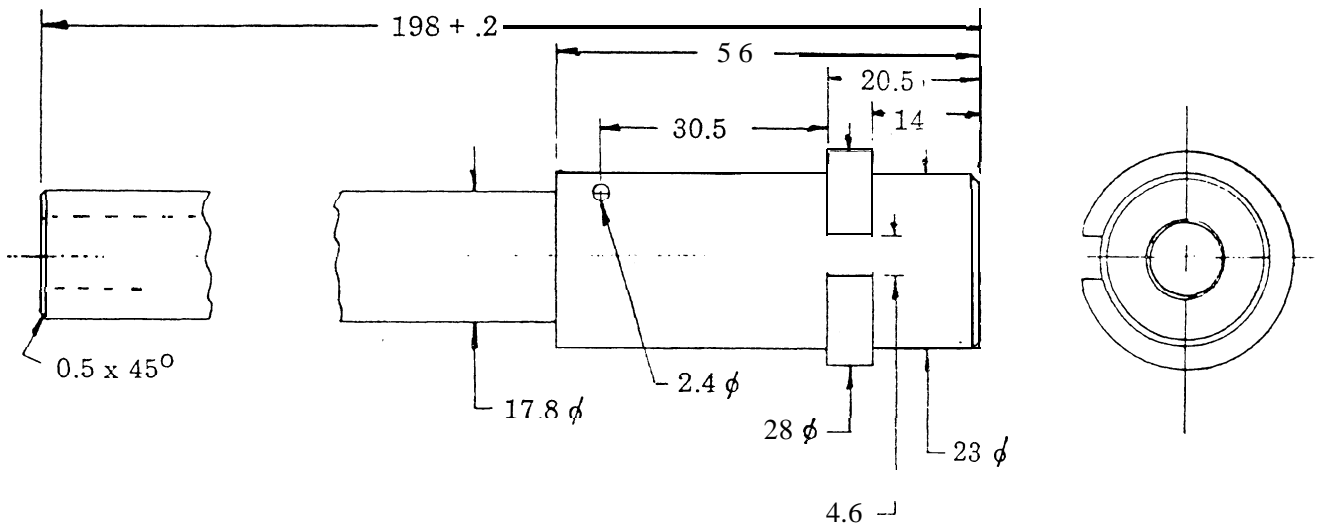
Material: AISI 1010 or equivalent

3mm stock. Heat treat: none

Scale: 1:1



Barrel
 Material: AISI 4140
 Harden to: Br 255-277



Twist: $1/250$ mm RH
 Number of grooves: 6
 Groove width: $2.5 + .02$
 Bore diameter: $8.84 + .02$
 Rifling diameter: $9.06 + .05$

STEN Mk II SPECIFICATIONS

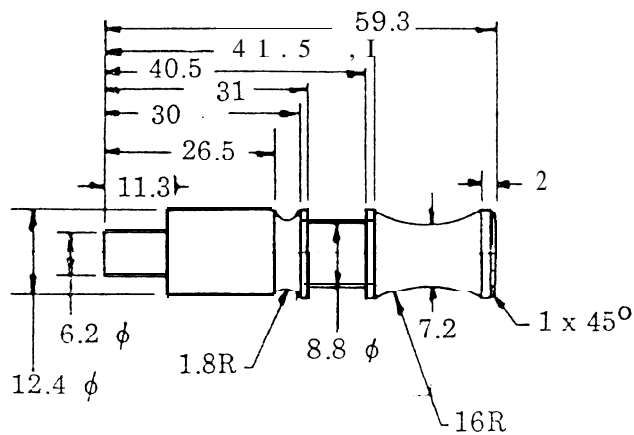
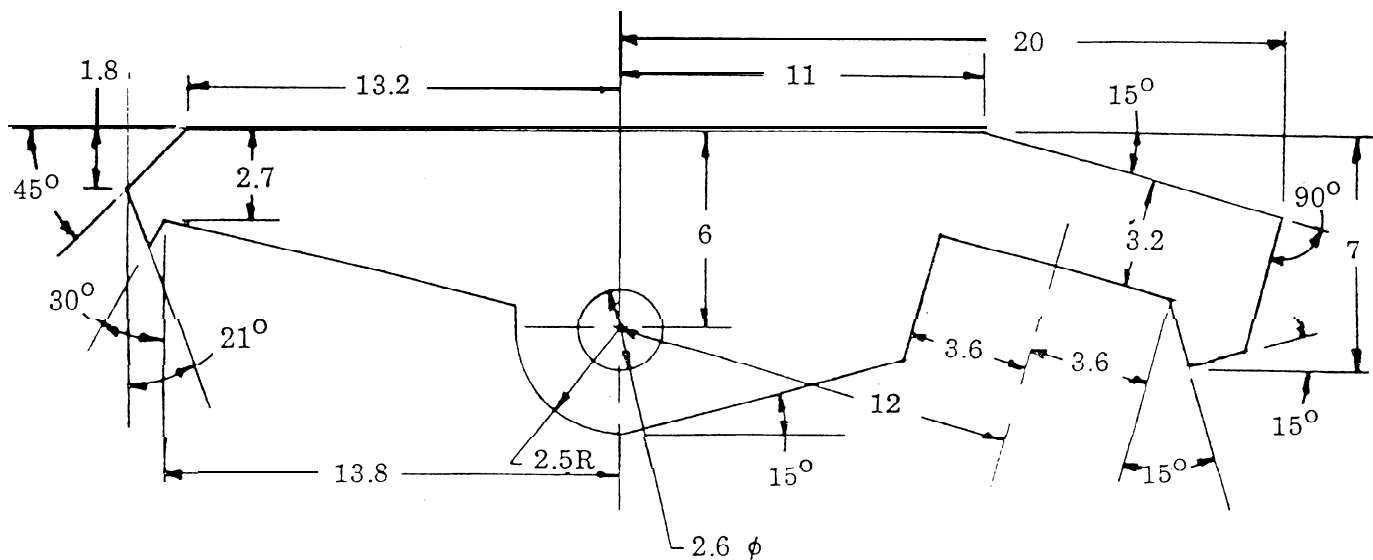
1. Cartridge:	9mm Parabellum	
	Bullet weight	116 grains
	Powder weight	5 grains
	Muzzle velocity	1400 ft./sec.
2. Recoil Spring:	Wire diameter	0.067 in.
	Spring OD	1.00 in.
	Active coils	15
	Free length	9.40 in.
	Initial length	6.80 in.
	Final length	3.20 in.
	Work stroke	3.60 in.
3. Bolt:	Weight	1.327 lb. (9290 grains)
	(including extractor)	
	Cocking handle	0.077 lb. (540 grains)
	Total recoiling weight:	1.404 lb. (9830 grains)
	Bolt maximum dia.	1.381 in.
	Bolt overall dia.	5.75 in.
	Bolt body length	4.21 in.

SUGGESTED STEN MANUFACTURING MODIFICATIONS

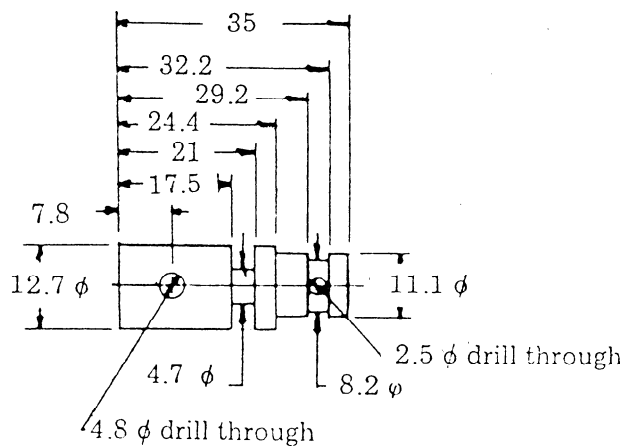
- | | |
|---|--|
| <p>1. Select suitable lightwall steel tubing which is commercially available. For example, a fence post pipe (galvanized) is 38.5mm OD and 35.0mm ID, most suitable for use as a receiver.</p> <p>2. Eliminate barrel sleeve.</p> <p>3. Weld barrel bushing into the front end of the receiver for simple, permanent assembly.</p> <p>4. Turn barrel blank OD (outside diameter) without any shoulder, fit the barrel in the bushing by sliding fit.</p> <p>5. Fasten the barrel in the bushing by two roll pins of 3/16" diameter, or equivalent.</p> <p>6. Turn the bolt OD to fit the receiver ID.</p> <p>7. The external portion of the cocking handle (sticking out of the receiver) may be a straight 8.8mm OD, the same as the inside.</p> | <p>8. The trigger housing cover acts only as a guard against dirt entering the trigger assembly. This cover can be eliminated or made from plastic.</p> <p>9. All pins can be roll pins of standard commercial size, or pieces of drill rod.</p> <p>10. All springs can be of a standard commercial size.</p> <p>11. Trigger material may be aluminum or plastic, side tabs may be replaced by spacers or washers to keep the trigger located neutrally.</p> <p>12. 1-1/4" diameter nominal size galvanized pipe, schedule 40 is suitable for a modified receiver:
 OD: 42.2mm
 ID: 35.05mm
 Wall thickness: 3.55mm</p> <p>Note: A 1" galvanized pipe fits loosely inside a 1-1/4" pipe and can be welded as a filler-spacer where needed,</p> |
|---|--|

Extractor
Scale: 4.5 : 1

Material: AISI 1040 or equiv., stock 4.7 wide
harden to: Rc 48-52



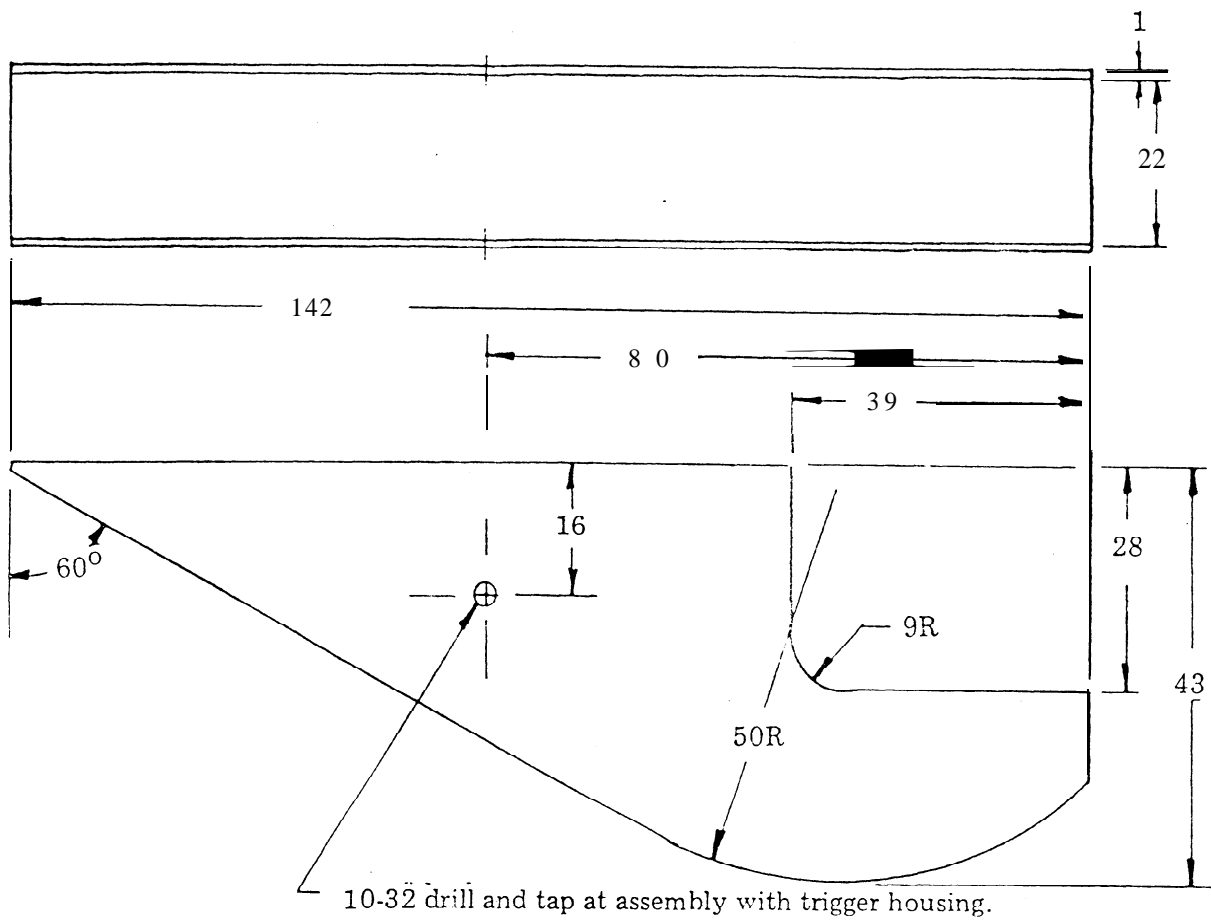
Bolt handle
Scale: .87:1
Material : mild steel
Heat treat: none



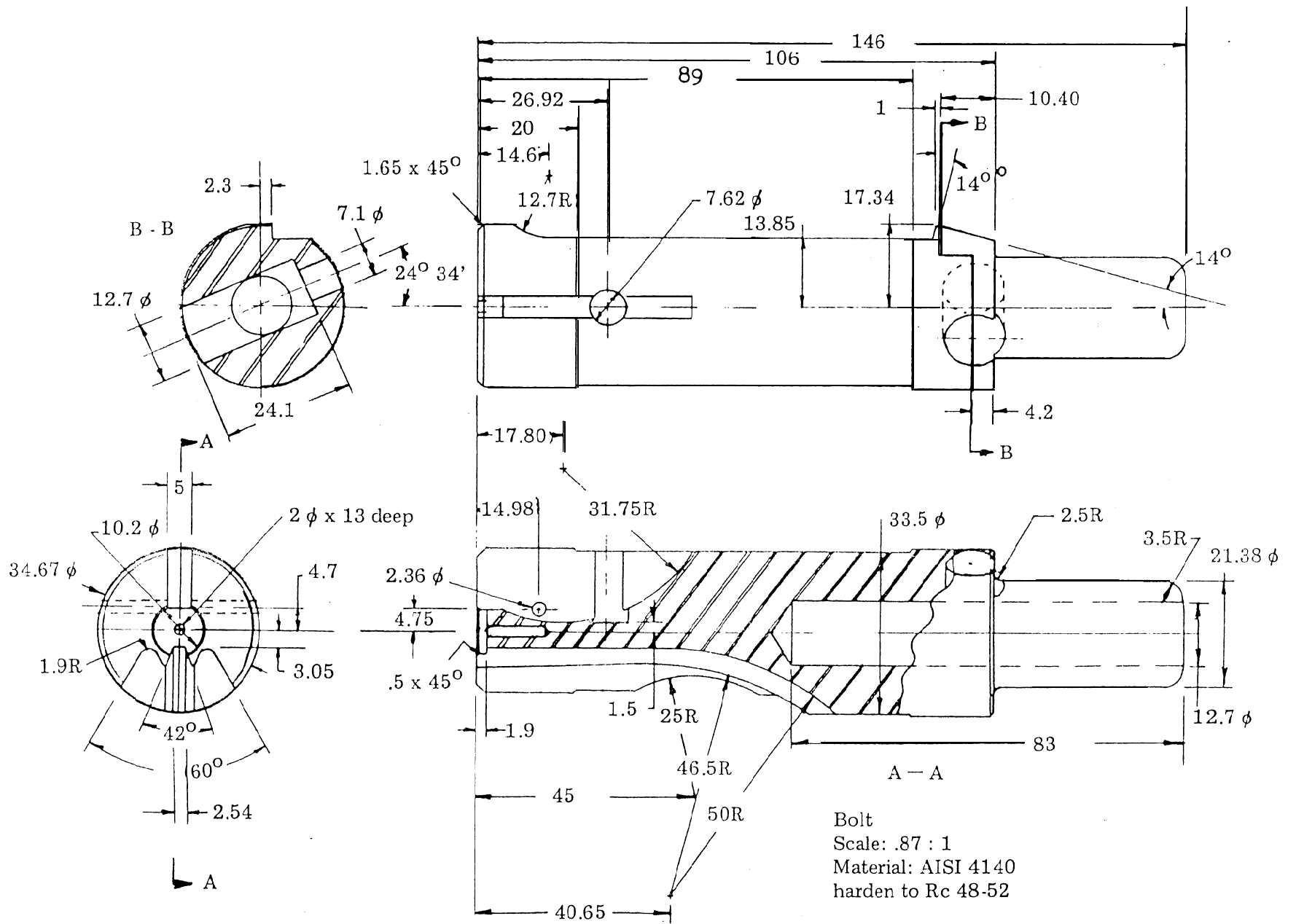
Selector
Scale: .87:1
Material: mild steel
Heat treat : none

Trigger housing cover
Material: 1mm stock, formed
Required: 1

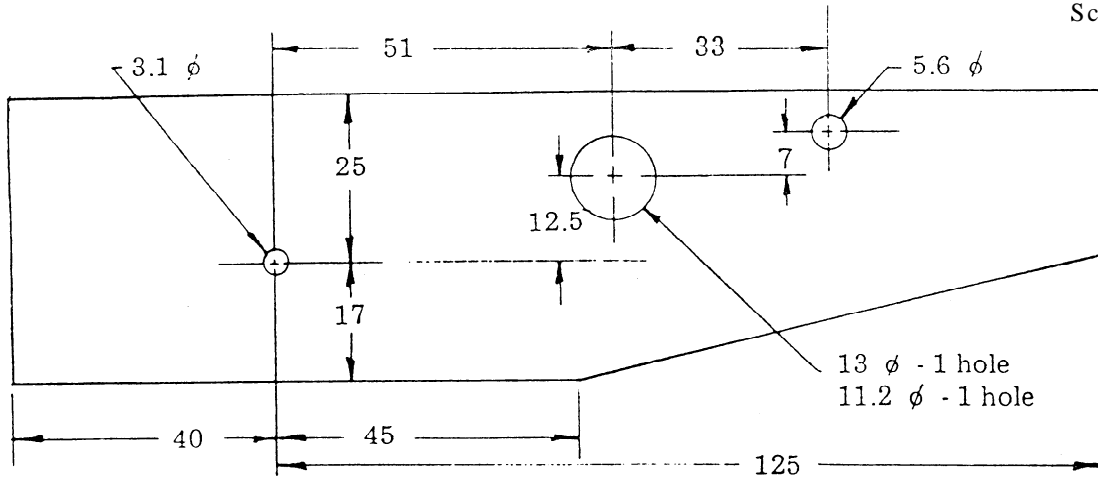
Scale: 1:1



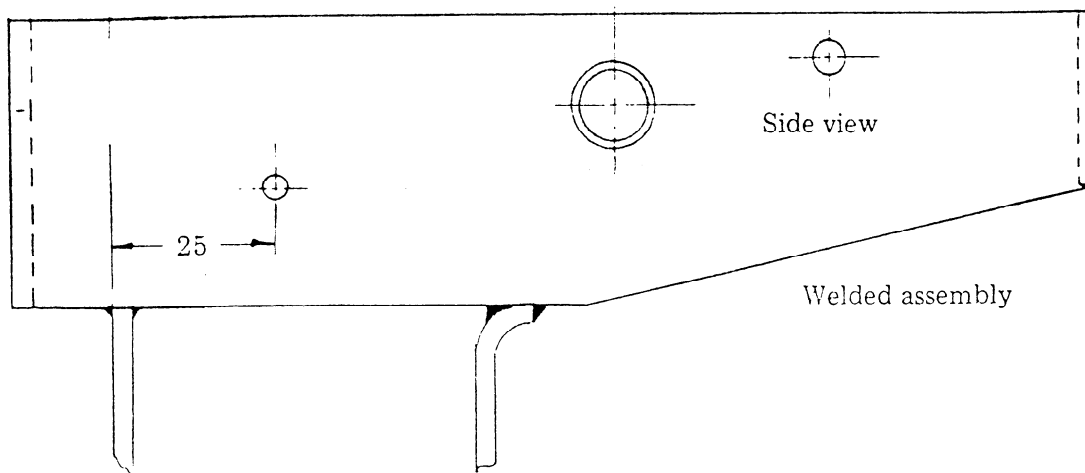
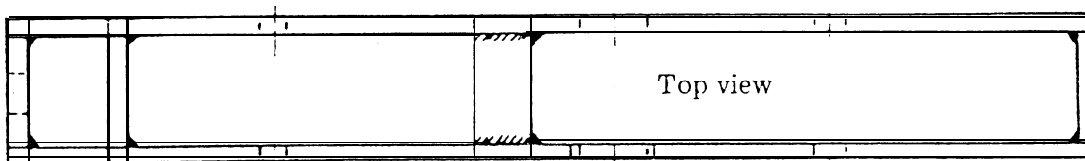
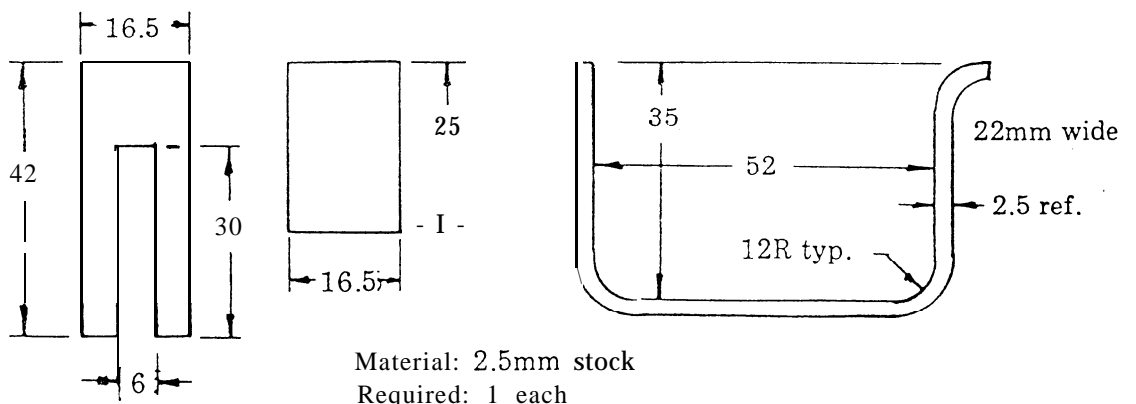
All Sten screws are 10-32 thread, round head type. Trigger housing screws (2) are 13mm long.

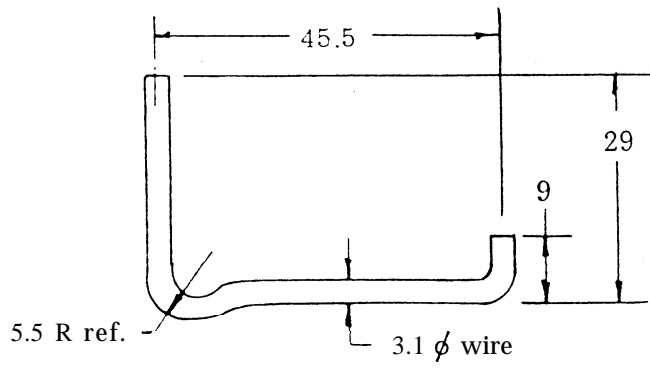


Trigger housing
Scale: .87:1



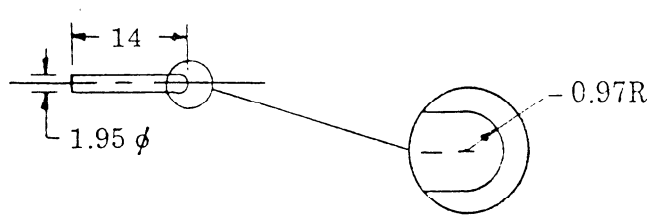
Material: 2.5mm stock
Required: 2





Trigger pin

Note: Trigger pin may be substituted by spring pin 3.1 ϕ by 26 long.



Firing pin
Material: Drill rod
Harden to Rc 50

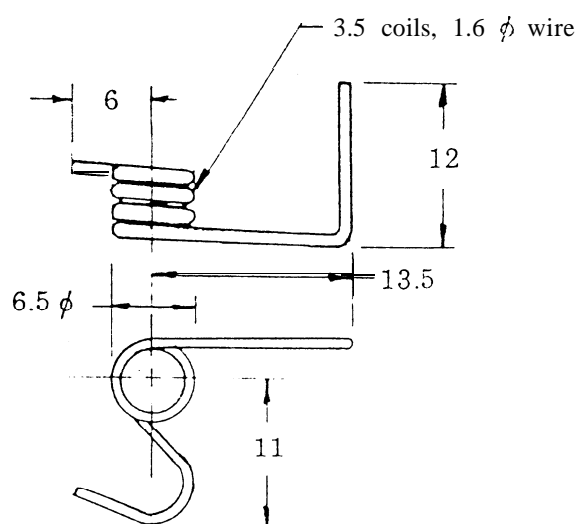
PINS (Spring pins)

USE	DIAMETER	LENGTH
Extractor	2.5	25
Sear	5.5	24

SPRINGS

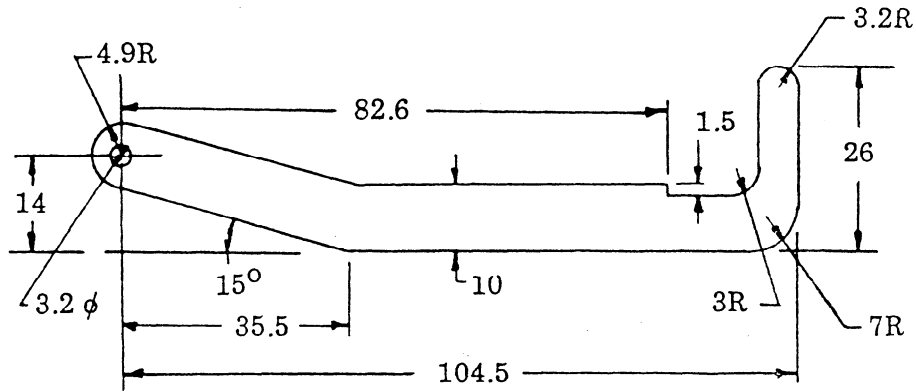
USE	Wire dia.	Coil OD	Free length	Number of coils	Coil ends	SUBSTITUTE":
Extractor	1	7.1	12	5.5	Sq.	LC-040C-4
Magazine latch	1	8.7	15.5	6	Gr.	LC-040C-6
Closing	1.6	26.5	245	17	Sq.	
Trigger	0.7	4.6	57	72	Extension spring loops	LE-026B-7 or LE-026C-8
Selector	0.45	4.6	14	8	Gr.	LC-018B-6
Barrel sleeve latch	1	8.7	35	15	Sq.	

Sear spring, formed
substitute LT-059K-1-R



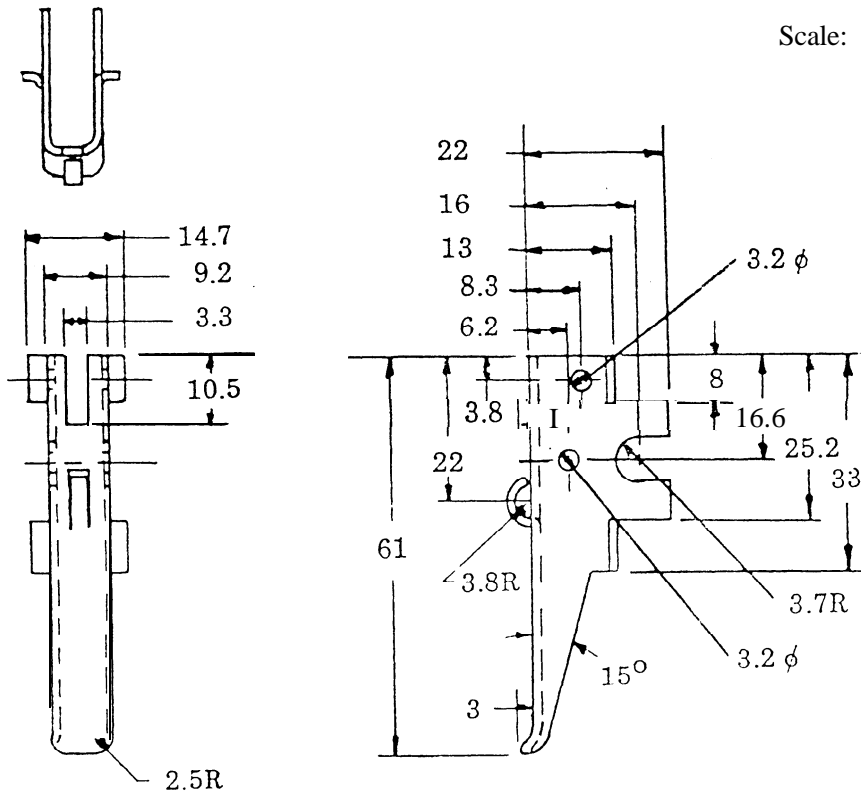
*Lee Spring Company, 30 Main St., Brooklyn, NY 11201; catalog No. 112/1970

Scale: .87 : 1

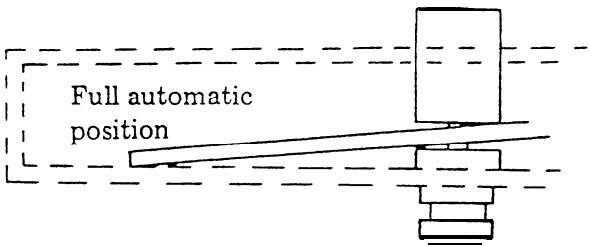


Trigger
Material: AISI 1010 or equivalent.,
1.6mm stock
Heat treat: none

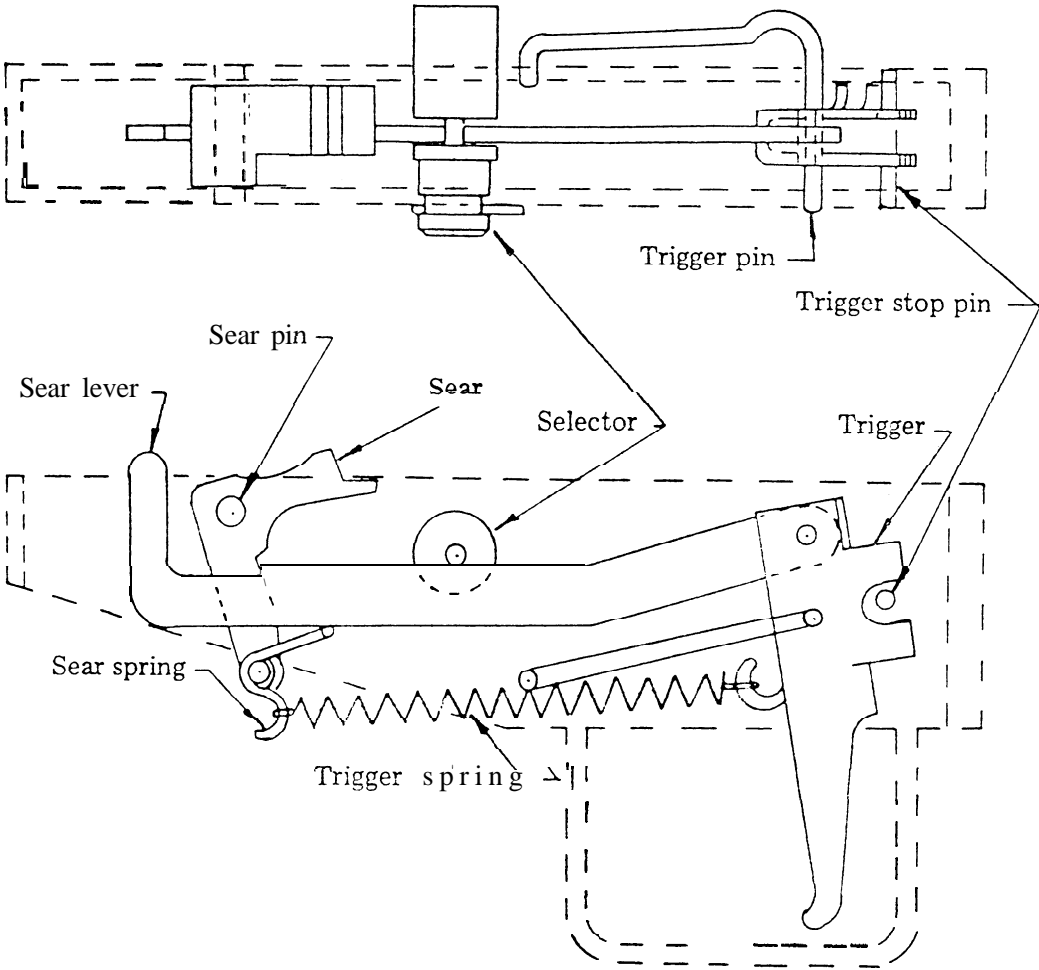
Scale: .87 : 1



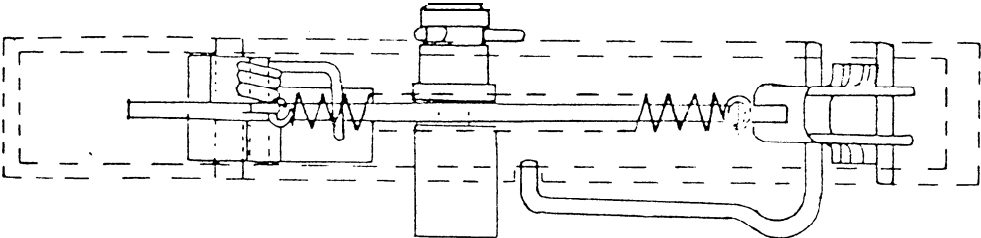
Trigger assembly



Top view

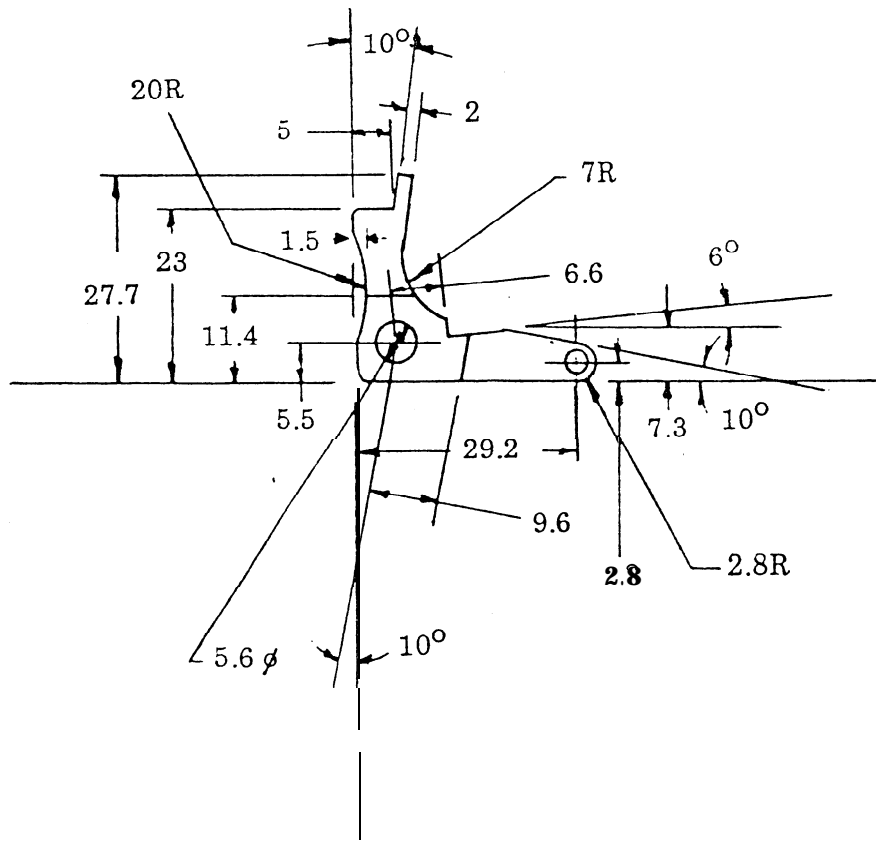
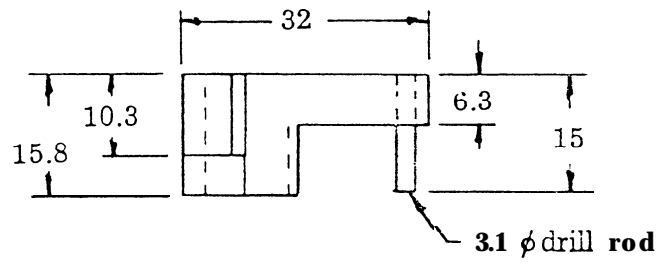


Bottom view

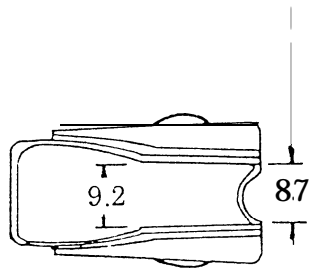


Sear
Material: AISI 4140 or equivalent
Harden to Rc 55

Scale: 1:1

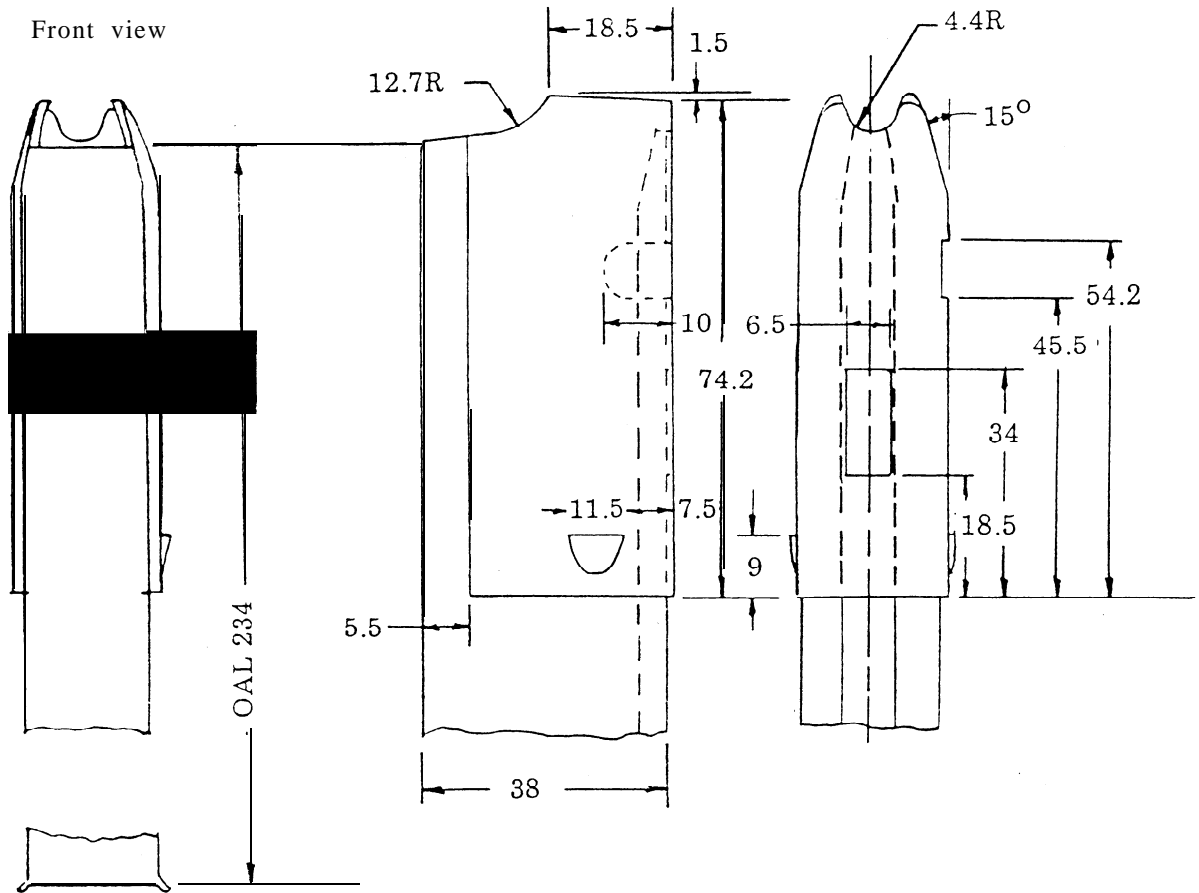


Top view

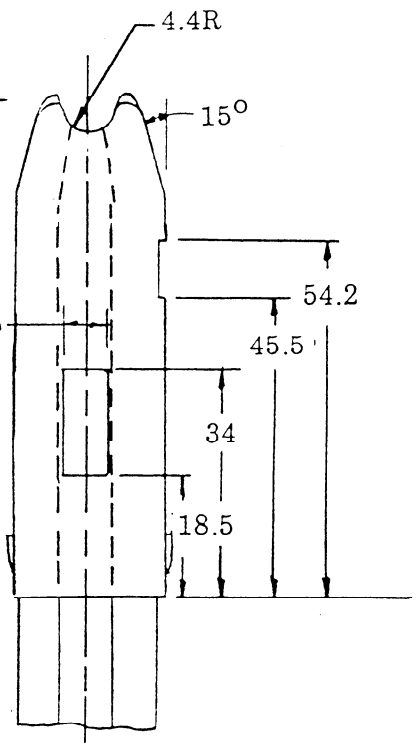


Magazine
Material: 1mm steel stock

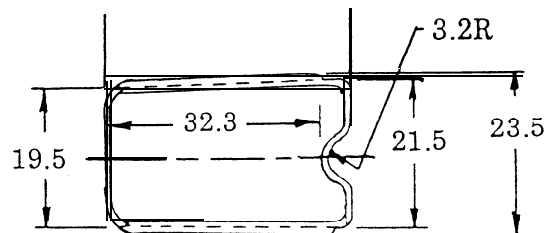
Front view



Rear view

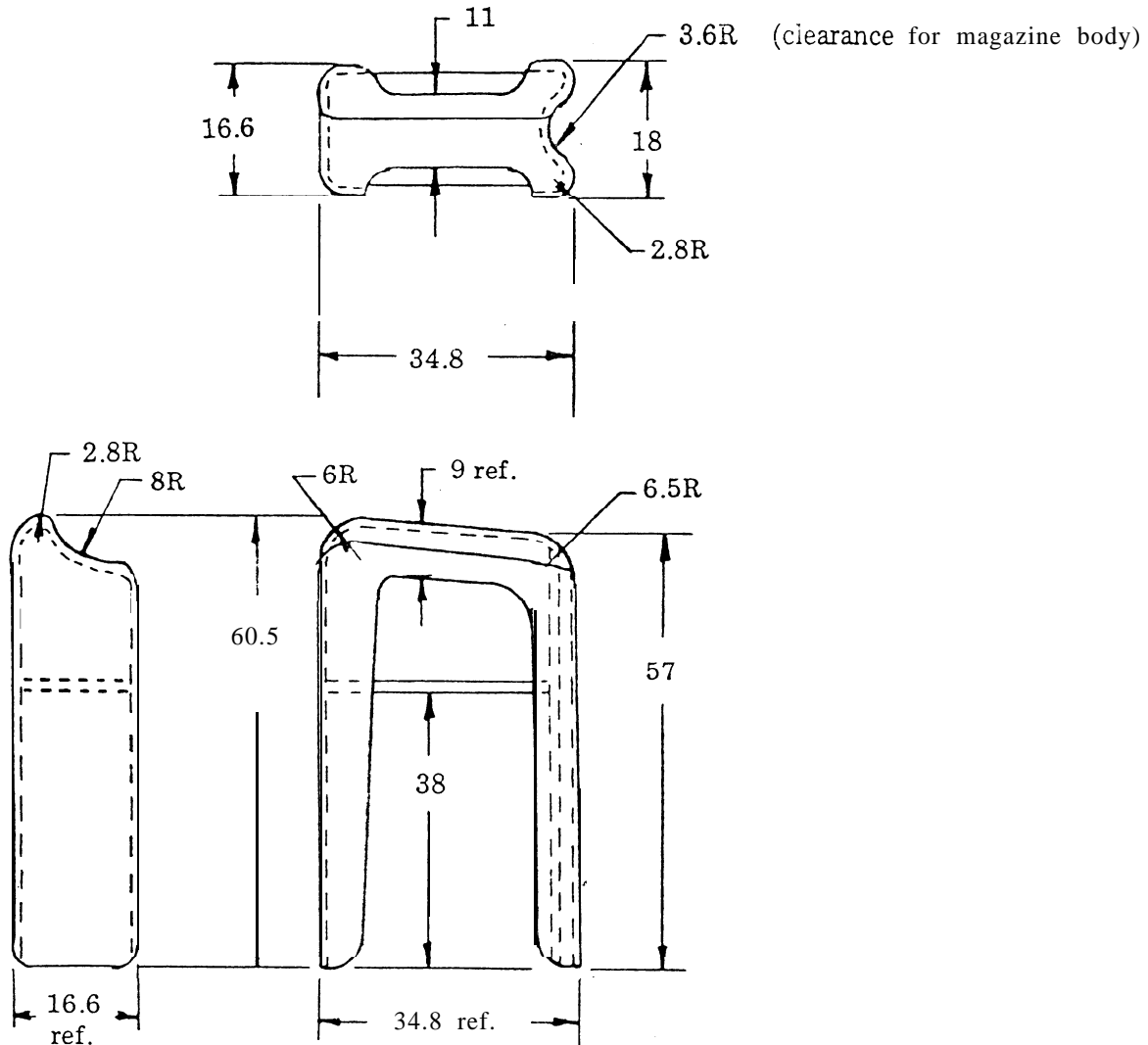


Bottom view



Magazine follower
Material: low carbon steel

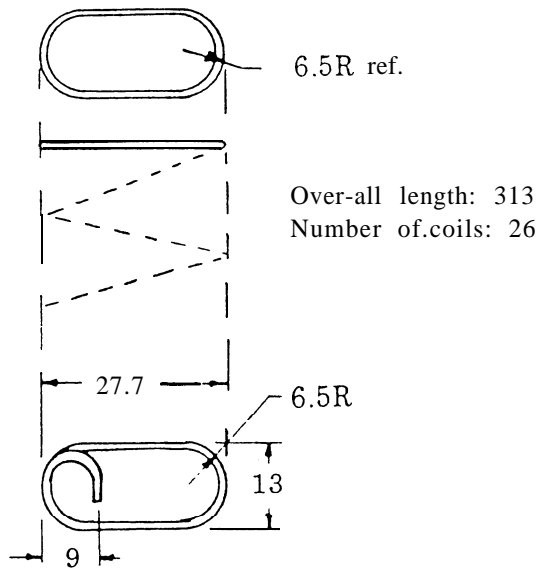
Scale: 1:1



Note: The magazine follower is a complex stamping made on a progressive die. To make a follower in a simpler way is to follow the Degtyarev DP LMG approach — using a dummy round as the last one in the magazine. Thus a simple, flat follower with a dummy round soldered and/or screwed to it will replace a complicated stamping.

Magazine spring

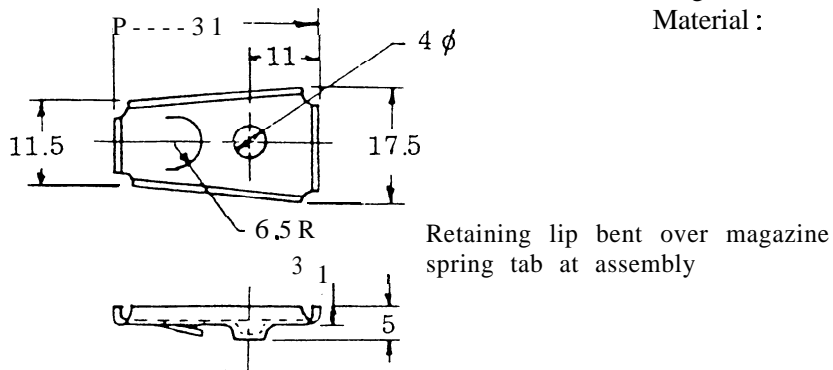
Material: Music wire 1.5mm dia.



Scale: .87:1

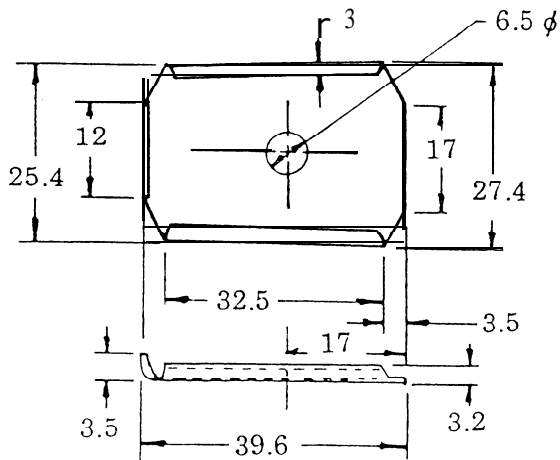
Magazine bottom retainer

Material: 1mm mild steel

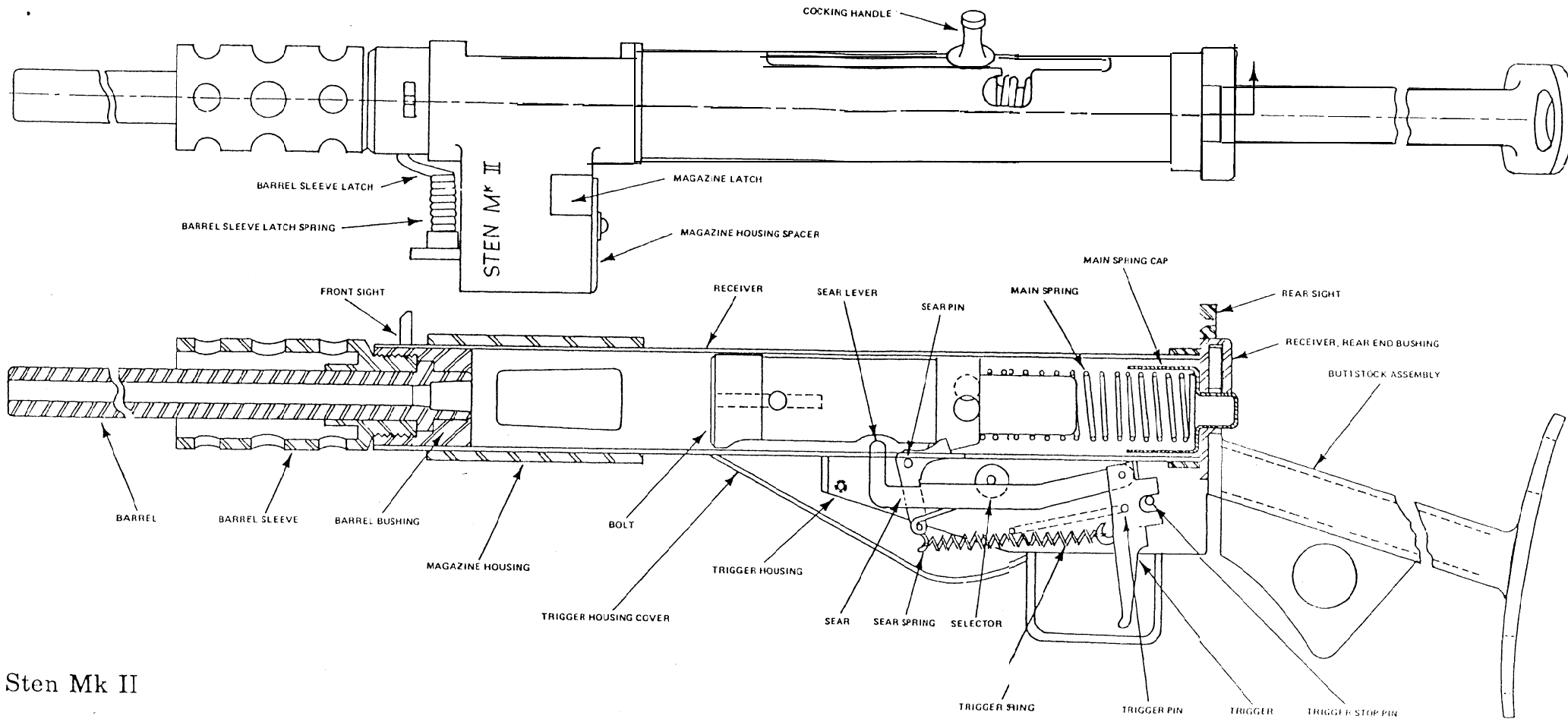


Magazine bottom plate

Material: 1mm mild steel



Scale: .87: 1



Sten Mk II