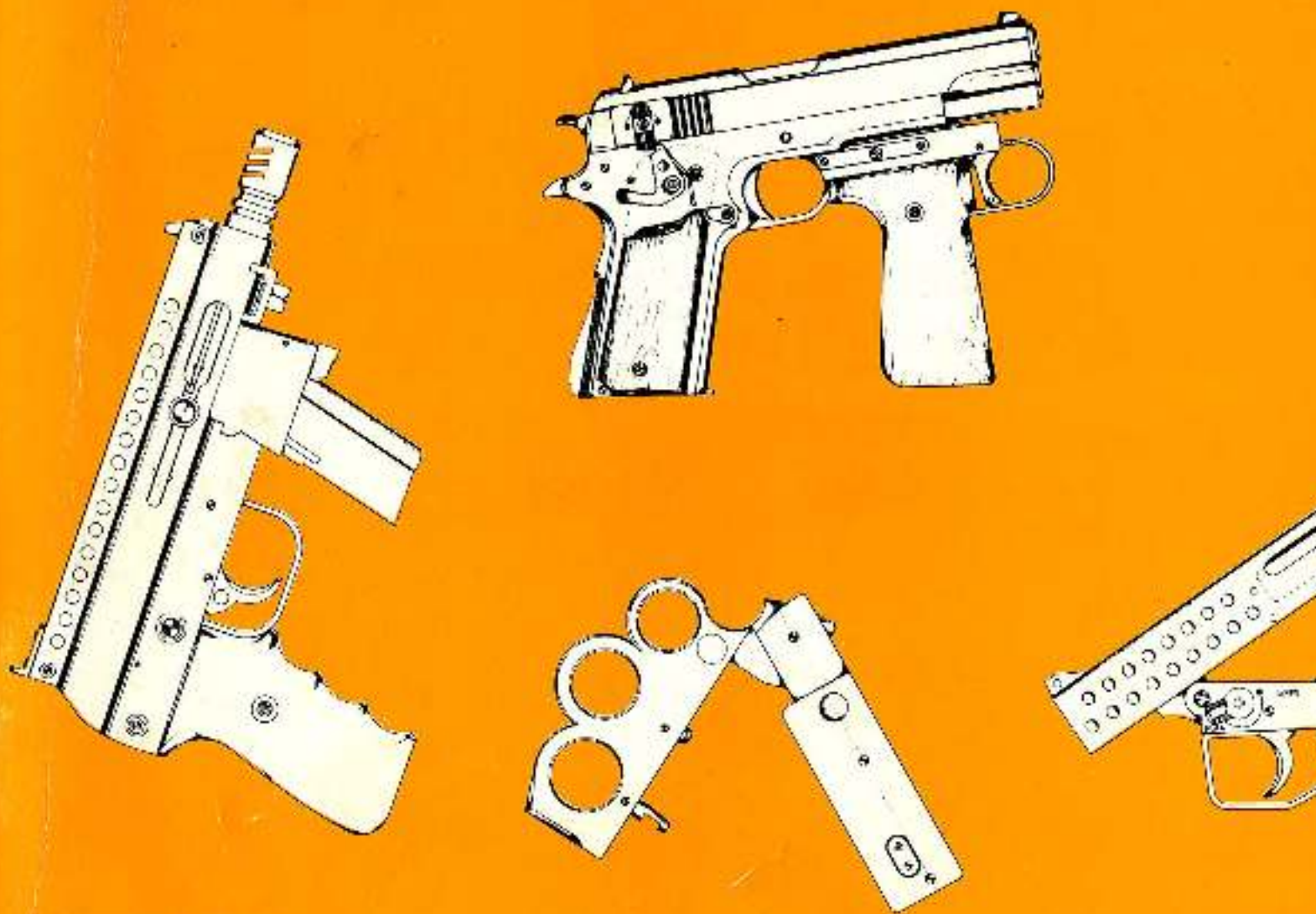


AUTOMATIC AND CONCEALABLE FIREARMS DESIGN BOOK, VOLUME II



**Automatic & Concealable
Firearms Design Book
Volume II**

by the Editors of Paladin Press Books

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WARNING

It is against the law to manufacture a firearm without an appropriate license from the federal government. There are also state and local laws prohibiting the possession of such weapons in many areas. Severe penalties are prescribed for violations of these laws. Be warned!

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FORWARD

Firearm manufacturers today employ production techniques which can differ greatly in approach and form. Some have maintained their traditionally high production standards, while others utilize various short-cut manufacturing methods. Though such short cuts help keep prices down, too often the quality of the finished weapon will suffer as a consequence.

Stamping and casting of parts, two very effective and economical fabrication methods, are employed almost universally by current arms manufacturers. Many reliable, good quality firearms are produced every day with the help of these cost-cutting measures. These techniques were originated by the Germans during World War II, and have been in use ever since.

The primary purpose of this series is to familiarize gunsmiths, collectors, and law enforcement officers with improvised firearms. These volumes incorporate detailed drawings in order to teach the reader principles of automatic weapons conversions, and other mechanical aspects related to improvised weapon construction and modification. The illustrations will also enable law enforcement agents to identify and classify improvised weapons.

Another purpose exists for these books as well. The editors are aware that our society may face violent turmoil sometime in the future. Should this situation occur, the individual citizen will have to depend on himself for protection of his life, family, and property. His means of protection will most likely be a firearm. If he does not have a gun, then these volumes can help him build one. They may also aid him in modifying and improving his commercial firearms, if necessary.

INTRODUCTION

Improvised weapons, most notably firearms, have gained great popularity in the rural areas of the world. The residents of such areas are generally poor, and cannot afford to buy commercially produced firearms. There is not much access to commercial firearms in these areas anyway.

Presented in this book are improvised firearm designs as developed and hand-built by rural gunsmiths in the Philippines. Neighboring countries such as Borneo, Sumatra, and Malaysia have their own versions of these weapons. They may vary slightly in materials, style, and size. Rural gunsmiths in Pakistan and India also produce variants of these designs, many being of relatively good quality.

Most of the firearms built by villagers in the Philippines are completely handmade. The gun parts are individually cut and formed to shape with hand tools. Screws, rivets, and brazing hold the parts together. Some customers special order their firearms, and provide high quality materials for the gunsmith to work with. Most of the jungle gunsmiths make their living by hand-building firearms, and are accomplished in their work. When given high quality materials to use, as with a special order, they can fabricate firearms of surprising quality.

Consider the source of these weapons. It will often be a small hut furnished with a simple workbench, anvil, vise and blacksmith's furnace. The gunsmith's tools are files, hacksaws, punches, and hammers. Such a basic workshop greatly resembles the blacksmith's shops found in the rural Philippines. No wonder, then, the village blacksmith often builds and sells his own improvised firearms where there is no farm equipment to repair.

In urban areas of the Philippines, better equipped improvised gunsmiths also operate. Here they have access to better quality materials, and electricity. Such illegal gunshops are not only found in relatively poor countries, but can be found in any modern nation that restricts the private ownership of firearms.

Many of the Philippine gunsmiths have Wesson and Colt revolvers, and even Colt handguns are rifled in a crude manner. External configurations are well copied, markings. A closer examination will show especially on the receiver of a revolver. The ventilated rib, are also brazed in place to

An internal examination of a Philippine entirely simple double-action lockwork. The need for internal machining of the receiver that found in Colt revolvers. However, the rebounding hammer; the hammer always. This system is very dangerous, and designed so that the firing pin points to the cylinder when not in use.

Some special-order Smith & Wesson copies externally and internally. These show the rebounding hammer as found in the original, still noticeable when closely examined.

Because of the high costs involved, firearms are not special ordered. A village firearm that works. It is a common saying in the Philippines that a *discharge* from a local is distinguished from a commercial model, is

The production of these modern imports in the Philippines when WW II ended. At that time, plagued the rural areas of the island chain. In these areas were three or more days distant from the nearest town. These areas were the base of guerrilla fighters against the Japanese occupation after the war. The majority

recognized the new government, however, and stopped supporting the guerrilla movement.

In turn, the outlaws fled to the mountains, where they began the systematic terrorization of the rural villagers. After stealing anything of value, the outlaw gangs would burn entire villages and their surrounding crop lands. They would finish by stealing the villagers' cattle and water buffalo, upon which the peasant farmers depended for food, and for power to cultivate their land.

This situation led the villagers to begin improvising their own weapons. Jungle workshops began appearing, particularly in the central and northern sectors of Luzon, one of the islands in the Philippine chain.

Villagers first improvised a weapon popularly called "The Flying Icepick." It was simply a sling-shot designed to fire a sharpened length of wire fletched with fine feathers. The missile's head was flattened, sharpened, and notched. When firing, the notches were engaged with a wire catch, found in place of the pouch normally associated with sling-shots. Firing was then achieved in the same manner as with a normal sling-shot. To make the missile more lethal, villagers sometimes dipped the wire point in snake venom.

Along with the bow and arrow, the "Flying Icepick" provided the remote villager with their only means of defense against the outlaw gangs for some years. Their weapons were most effective at night, when they could silently strike at the bandits, killing some of them and unnerving the remainder. But the bandits soon altered their tactics. They began attacking villages by day, taking a great toll among the primitively armed peasants.

Villagers in turn began improvising their own firearms in earnest. Jungle gunsmiths in Ilocos province began making a firearm called the "Paltic". It soon became popular in other areas of the Philippines. Due to scarce supply of ammunition, the most common home-made gun was and still is the shotgun. Many of these are of the "Slam Bang" design, being made entirely from water pipe. The most common improvised shotgun is single shot, utilizing a break open action, and with a very long barrel. Its hammer is exposed and is single action. A separate piece is made and carried to manually eject spent shells from the shotgun's chamber. Outdown versions of these weapons have also appeared, and are known as shotgun pistols.

To increase firepower, the village gunsmiths have made bolt action, magazine fed shotguns. These are copied from commercial rifles. The

magazines' capacities range from four rounds in .410 gauge. Brazing and improvising the receivers and magazine success.

Muslim gunsmiths in southern Mindanao have developed an unusual version of the improvised shotguns with a five round revolving cylinder shotguns with a five round magazine. If these weapons have been confiscated, they are fairly sophisticated. Most of these are .410 models use the double-action lock. The Muslim gunsmiths also rely heavily on their firearms.

The popularity of improvised firearms reached its peak during the early 1960's. Many of the gunsmiths at that time were ex-convicts who had learned their trade in prison. Once released from jail, they began making their own weapons, since Philippine law forbids the sale of firearms. Stricter police control has since subdued the market.

A word of caution here. Any fire arms made from materials of unknown analysis, especially those made from Slam Bang shotguns have blown-up during firing. Similarly, revolver copies have exploded while being fired. This is due to an excessive pressure in the barrel, allowing propellant gases to escape through the stack in the revolver barrel.

Improvised firearms, then, have become a necessary part of the poor farmer or villager's life. He has no other means of self-defense. He has a simple firearm against well-armed terrorist-bandits. His protection takes form as a simple firearm made in a jungle workshop. For him, it is food for thought for he has lived through the hard times and knows that harder times may still come in the future.

COLT .45 MACHINE PISTOL CONVERSION

SPECIFICATIONS:

CALIBRE45 ACP
TYPE OF FIRE SELECTIVE SEMI AND FULL
AUTOMATIC (FIRES SEMI AUTOMATIC
ON CLOSED BOLT AND FULL
AUTOMATIC ON OPEN BOLT.)
CAPACITY 7 SHOT MAGAZINE STANDARD;
30 SHOT MAGAZINE AVAILABLE
BARREL LENGTH 5 INCHES STANDARD;
6 INCHES AVAILABLE

**REMARKS: NUMEROUS ACCESSORIES ARE AVAILABLE:
MAXI COMPENSATORS, SLIDE RELEASES, TIGHT
BUSHINGS, SPEED SAFETY, ETC.**

**SPECIAL NOTE: COLT .45 VARIATIONS AND IMITATIONS
SUCH AS THOSE MANUFACTURED IN EUROPE, SOUTH, AND
CENTRAL AMERICA CAN BE SIMILARLY CONVERTED TO
SELECTIVE FIRE.**

SYSTEM OF OPERATION:

TO FIRE SEMI AUTOMATIC: Set the selector lever to the horizontal position. To disengage the selector lock from the underside of the slide, press the top portion of the selector lever to withdraw its under lug from mating with the slide edge. Once the lug clears the slide edge, it can be rotated horizontally in either direction. Once the selector is set in detent in the horizontal position, the tripping of the selector is out of engagement with the connector lever. Drawing the slide to the rear will cock the hammer and load the chamber in the usual fashion, maintaining that position until the trigger is pressed. The semi automatic operation fires from the standard closed bolt system. *It is*

*important to press the auxiliary trigger
front (auxiliary) rear does not catch the*

TO FIRE FULL AUTOMATIC: Set the selector lever to the vertical position, locking the under lug to the slide. The slide is drawn to the rear and the slide is locked as tightly as possible to avoid any slack in the slide. The slide is then released for full automatic operation of the slide. The slide will be strong to retain its engagement firmly.

In the full automatic setting, the auxiliary trigger is held over. The slide will be held in the open position (auxiliary) rear, ready to fire. The original trigger mechanism is activated automatically by the selector tripping shoulder makes contact with the connector, whether the rear (original) trigger is set. The selector lever tripping shoulder pushes the selector lever to disengage from full cocked hammer, release the hammer and ignite the cartridge. This operation is released or the magazine empty.

CAUTION: NEVER RETRACT THE SLIDE WHEN THE WEAPON IS SET TO FULL AUTOMATIC WHEN THE AUXILIARY TRIGGER IS INSTALLED. THE WEAPON WILL FIRE EVEN WITHOUT PRESSING THE TRIGGER. THE SELECTOR TRIPPING SHOULDER WILL OPERATE THE CONNECTOR WHEN THE SLIDE IS CLOSING.

SAFETY OPERATION:

The original safety can be used on both semi automatic (open bolt) functioning. However, when the auxiliary (front) trigger not be pressed.

automatic and the slide is held open. The connector pin connected to the sear will break if the auxiliary trigger is pressed in open bolt with the selector in the full automatic mode.

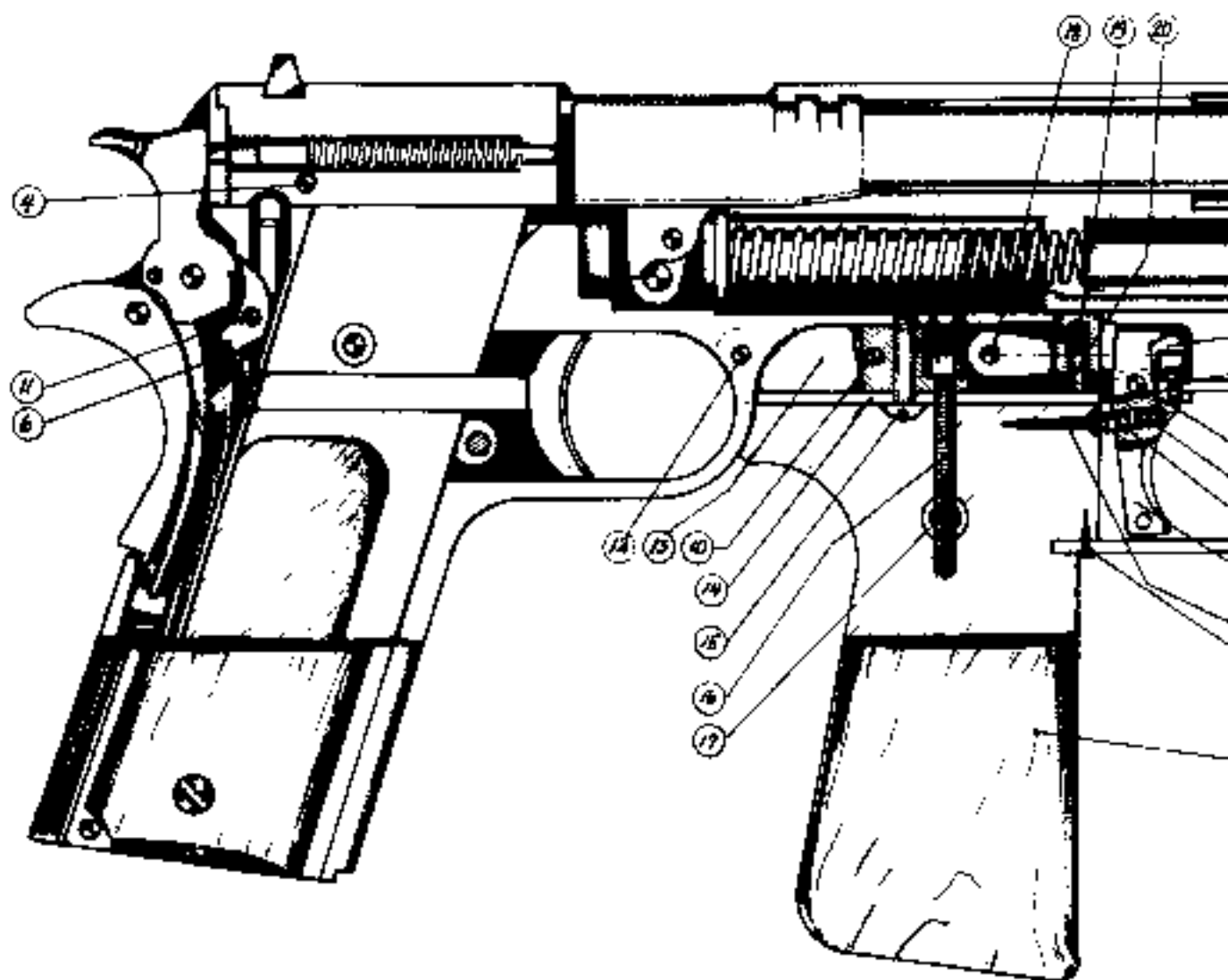
CONSTRUCTION DETAIL OF THE AUXILIARY TRIGGER MECHANISM:

The auxiliary trigger housing is a formed 1/16 inch steel sheet. It contains the auxiliary sear and trigger and can be improvised by machine or handmade. The housing is secured in place to the trigger guard and to the front portion of the receiver by a screw and by a pin riveted to a plate. An insert is used to strengthen the housing and can be riveted or brazed in place. The trigger guard is equal in width to the receiver trigger guard and secured to the housing by a small screw. It can be brazed to the housing if so desired. The other end is pointed and is pressed to the wood grip, secured by a small nail or screw.

The auxiliary housing assembly must be attached to the receiver body before the grip stock can be secured to the auxiliary housing. An assembly hole must be drilled in the receiver for the grip screw.

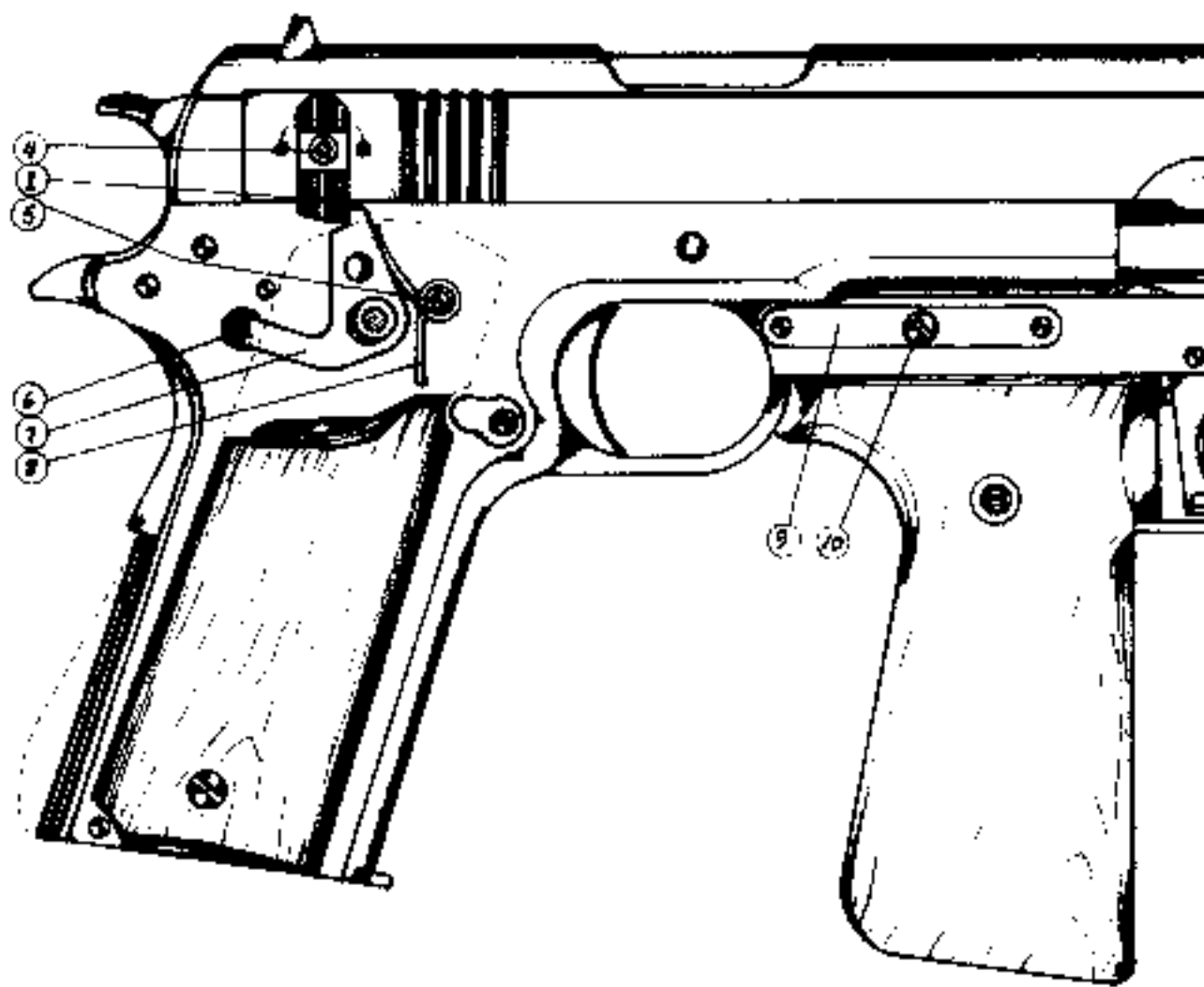
PARTS LIST

1. Selector lever
2. Selector lever index half spring
3. Selector lever index ball
4. Selector lever retaining screw; clearance to disengage from the s
5. Connector spring base; 1/8 inch e
stock screw bushing.
6. Connector mating pin to sear
7. Connector lever
8. Connector lever spring
9. Connecting pins, plate for auxilia
10. Plate retaining screw; left side hole
threaded for this screw.
11. Replacement sear; with provision
12. Auxiliary housing rear securing p
13. Auxiliary trigger housing insert; t
14. Auxiliary trigger housing
15. Auxiliary housing connecting scre
16. Grip stock screw; hex type
17. Stock screw bushing; pressed hor
18. Front sear pin
19. Sear spring
20. Sear spring plunger
21. Sear
22. Trigger guard connecting screw; s
23. Trigger guard
24. Trigger pin
25. Trigger spring
26. Trigger spring plunger
27. Trigger
28. Nail; acts as support against plun
29. Small nail securing the bottom pa
30. Wood stock; one piece constructi

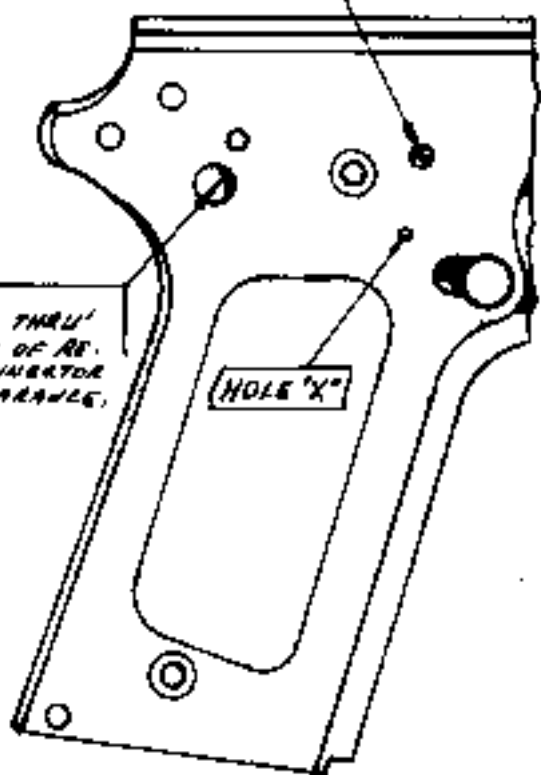


COLT .45 MACHINE PISTOL CONVERSION

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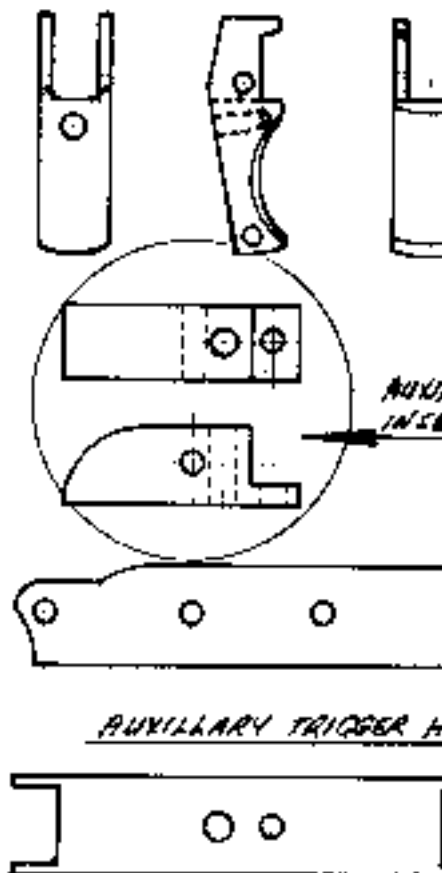


$\frac{1}{8}$ (100%)
 DRILL $\frac{1}{8}$ HOLE TO RIGHT SIDE
 OF RECEIVER AND PRESS TIGHT
 $\frac{1}{8}$ DIA. PIN TO MOUNT BA AS
 BASE FOR CONNECTOR SPRING.



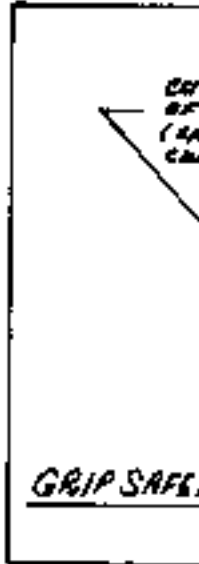
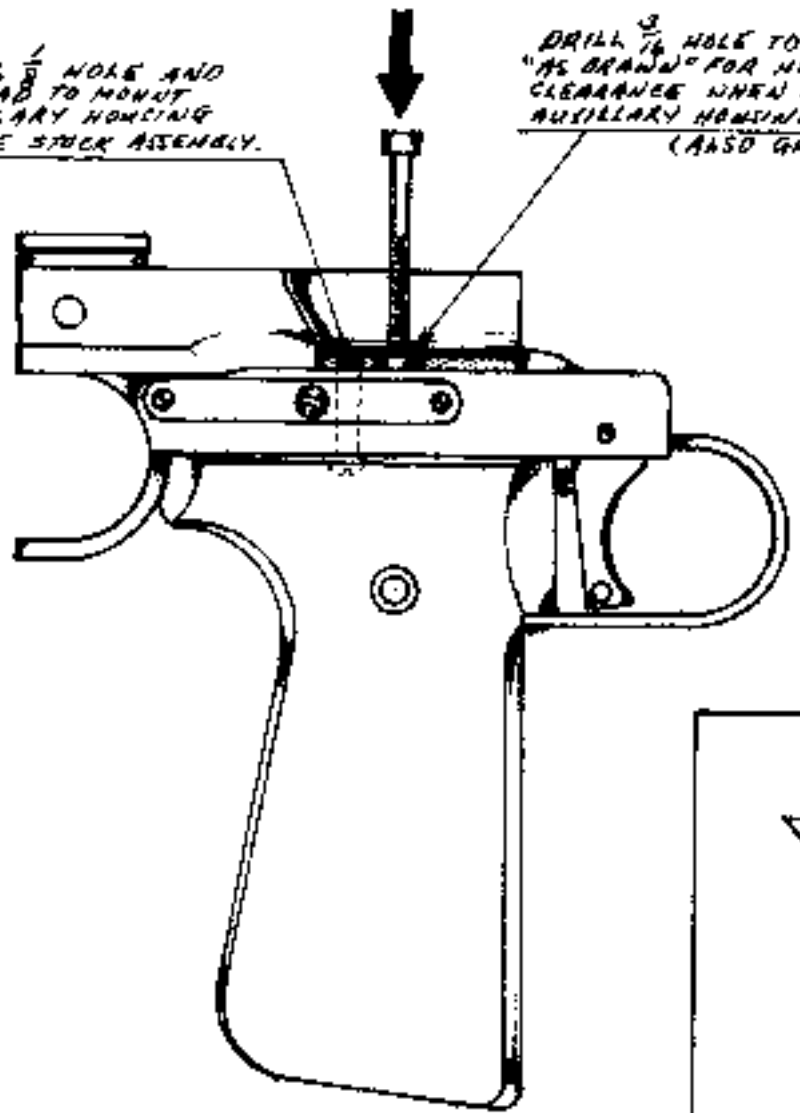
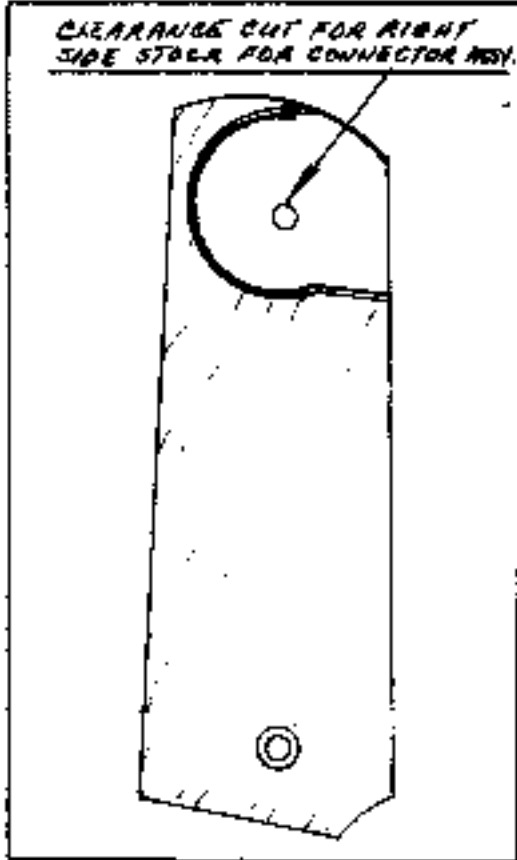
DRILL $\frac{3}{16}$ HOLE THRU'
 TO RIGHT SIDE OF RE-
 CEIVER FOR CONNECTOR
 ARBER PIN CLEARANCE.

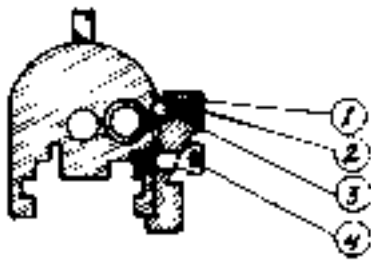
DETAIL: "AUXILIARY TRIGGER H"



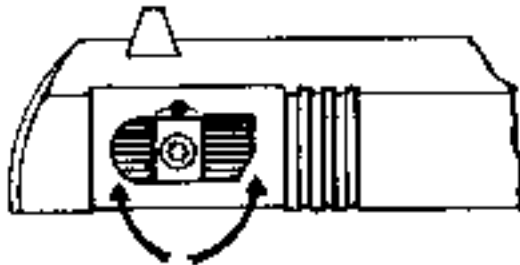
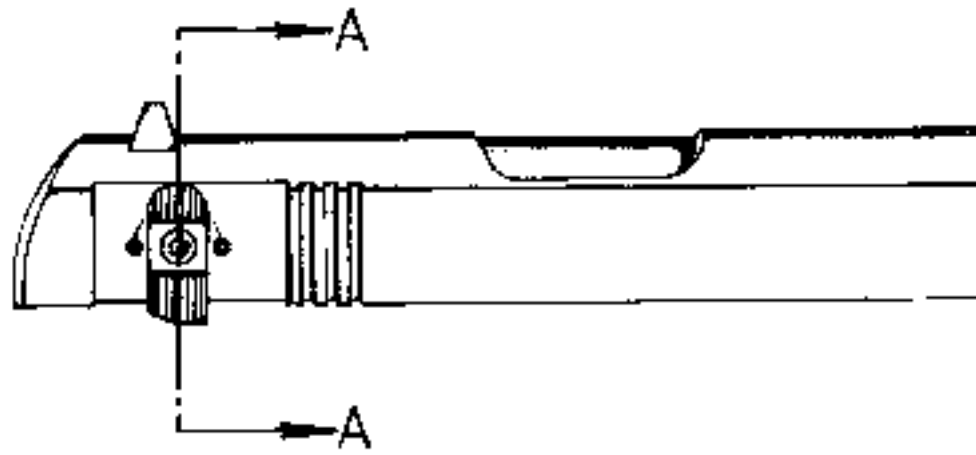
DRILL $\frac{1}{8}$ " HOLE AND
THREAD TO MOUNT
AUXILIARY HOUSING
BEFORE STOCK ASSEMBLY.

DRILL $\frac{3}{16}$ " HOLE TO RECEIVE
"AS DRAWN" FOR HEX SCREW
CLEARANCE WHEN COMBINING
AUXILIARY HOUSING TO
(ALSO GRIP SAFETY)

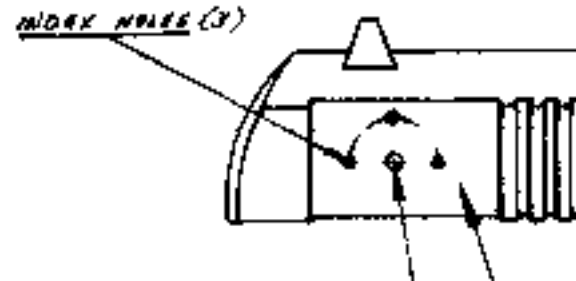




Section "AA"

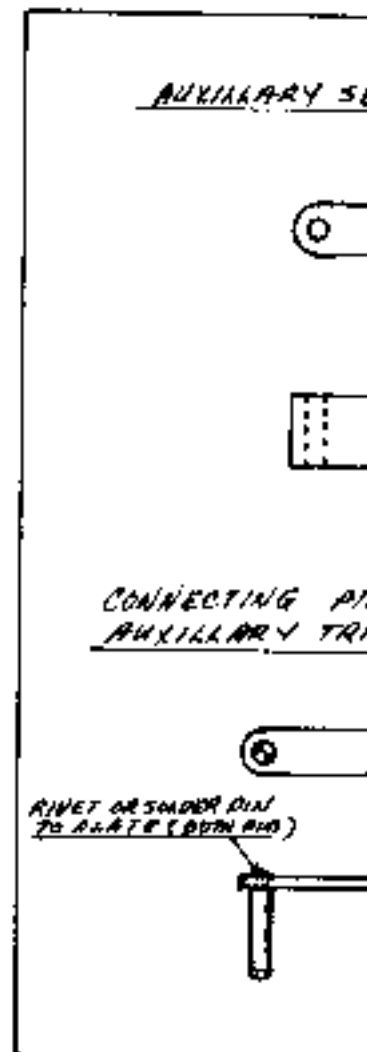
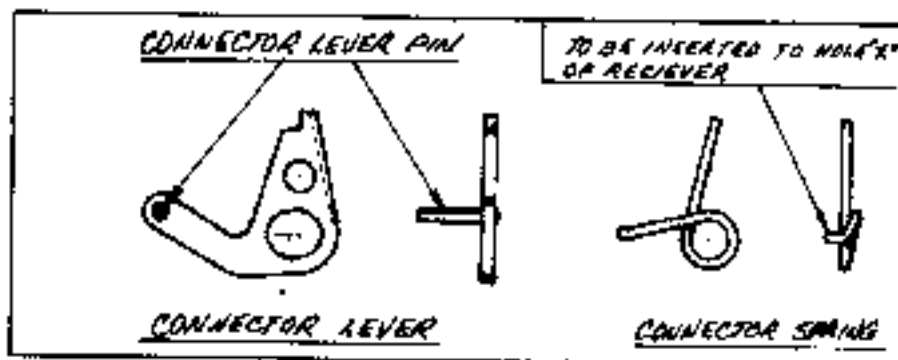
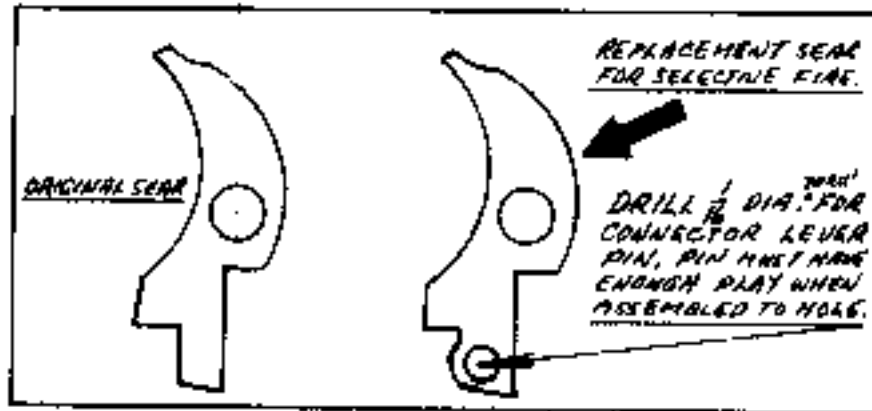
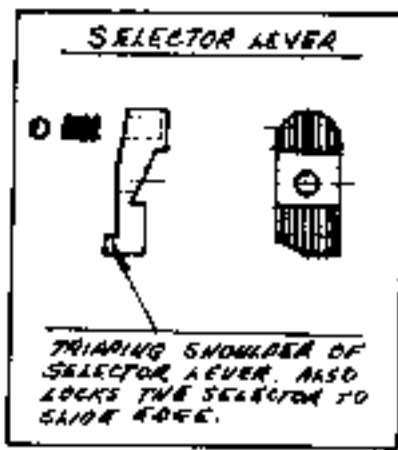


SELECTOR CAN BE ROTATED
 IN EITHER WAY FOR SEMI-AUTO,
 FUNCTIONING, TRIPPING SHOTLOCK
 WILL NOT ENGAGE CONNECTOR TIP.



DRILL $\frac{1}{8}$ " HOLE AND
 THREAD (SEE DIAGRAM)
 TO MOUNT SELECTOR LEVER

FILL
 SER.
 GRAB
 FOR



SHOTGUN PISTOL

SPECIFICATIONS:

CATEGORY HANDMADE - IMPROVISED
CALIBRE 410 TO .12 GAUGE
CAPACITY SINGLE SHOT - DOUBLE BARREL
VARIANTS POSSIBLE
TYPE OF OPERATION MANUAL

REMARKS: VARIOUS STYLES AND BARREL LENGTHS ARE ADAPTABLE.

TO LOAD:

To load the pistol, rotate the latch lever 180 degrees counter-clockwise. The latch lever pin secures the barrel connecting lug to the receiver frame. Once the latch lever is rotated, the barrel can be hinged open for loading.

After inserting the cartridge, push the barrel back to its seat on the receiver. Then rotate the latch lever clockwise to lock the barrel connecting lug to the receiver body. The barrel chamber must be centered for a cartridge rim seal.

TO FIRE:

Once the barrel has been fully seated and locked in place, pull the cocking handle on top of the bolt tube to the rear until it engages the sear. Pressing the trigger will release the bolt (which contains the firing pin) from sear engagement, discharging the pistol.

SAFETY MECHANISM:

A safety lever is incorporated in this model to prevent accidental release of the bolt mechanism. When the bolt is in the full cocked position, engaged with the sear, the safety lever pin blocks and prevents any movement of the sear. The bolt also can be lowered by simply

cocking the cocking handle slowly to its rear position. The bolt will be cocked if safety is applied.

CAUTION: IT IS NOT SAFE TO CARRY A SHOTGUN PISTOL IF THE FIRING PIN IS PRESSING AGAINST THE PRIMER WHEN THE BOLT IS IN ITS FULLY COCKED POSITION. ONLY WHEN READY TO FIRE, OPEN THE BOLT AND APPLY THE SAFETY.

EXTRACTOR:

An improvised extractor is housed inside the receiver body. The extractor is a simple formed steel sheet about 1/16 inch thick. It is loaded plunger. Pull the extractor by its handle when needed.

CONSTRUCTION DETAIL:

Like most of the modern improvised models, the receiver body is simple formed steel sheet about 1/16 inch thick. The barrel connecting lug are brazed or welded and used for loading and unloading purposes.

The barrel is thick seamless tubing (dia. 1 1/2 inch or gauge). A commercial type barrel is cast in steel. The same diameter as the barrel. It is retained in place by a grip base connecting the breech block to the receiver body which is welded or brazed in place.

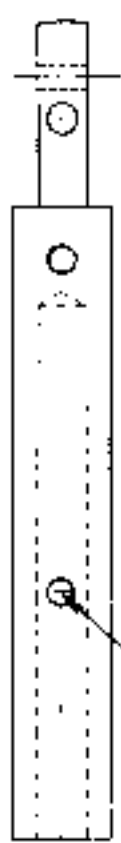
The grip is one piece. Make it from wood or plastic. It is to be inserted through the grip base. Secure it with a screw positioned at the back of the stock, through the grip base.

All trigger mechanisms (trigger, sear, etc.) are made of (equally or less thick) with the barrel pivot

lug of the bolt tube in order to function freely when assembled inside the receiver frame; preferably 1/4 to 3/8 inch thick.

PARTS LIST

1. Front sight - brazed or silver soldered in place (top of barrel)
2. Barrel - thick seamless tubing or cut down commercial barrel (chamber is counterbored)
3. Steel washer
4. Hex screw - securing barrel connecting lug to trigger housing
5. Barrel lug latch lever
6. Latch lever pin
7. Latch lever ball spring
8. Ball (steel)
9. Latch lever retaining pin - if possible roll pin
10. Hex screw - retaining firing pin spring & guide post and its base to trigger housing
11. Steel washer
12. Hex nut
13. Steel washer
14. Hex nut
15. Steel washer
16. Breech block
17. Firing pin
18. Breech block retaining post pin
19. Cocking knob
20. Firing pin spring
21. Bolt
22. Receiver - same diameter as barrel
23. Spacer (2 pr.) for sear pin
24. Receiver back cover
25. Firing pin spring & guide post retaining pin
26. Firing pin spring & guide post
27. Barrel connecting lug - brazed to barrel (1/2 in. thick plate)
28. Same as #4
29. Front screw retaining trigger guard
30. Trigger guard
- 30A. Same as #6
31. Spacer (2 pr.) for trigger
32. Trigger
33. Trigger bar
34. Trigger bar support pin (front)
35. Rear screw securing trigger guard
36. Extractor catch (plunger) spring pin
37. Plunger spring
38. Extractor catch (plunger type)
39. Melt base for trigger housing & re
- 40.
41. Grip (one piece wood)
42. Extractor extension (handle)
43. Extractor head
44. Extractor retaining pin
45. Trigger housing - formed steel sheet
46. Sear
47. Sear pin
48. Sear spring
49. Same as #10
50. Firing pin & spring guide base sup
51. Receiver back cover retaining screw
52. Trigger bar support pin (rear)
53. Grip screw

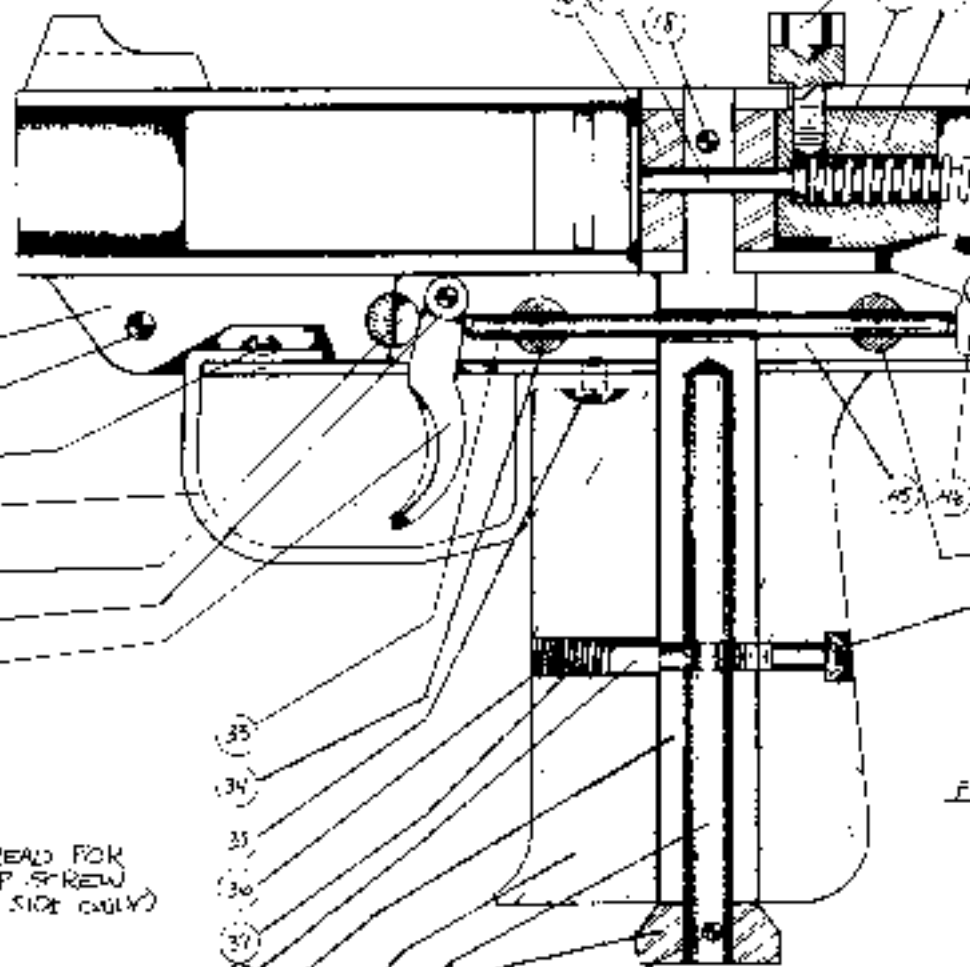


- (27)
- (28)
- (29)
- (30)
- (31)
- (32)

THREAD FOR
GRIP SCREW
(ONE SIDE ONLY)

- (33)
- (34)
- (35)
- (36)
- (37)
- (38)
- (39)
- (40)
- (41)
- (42)
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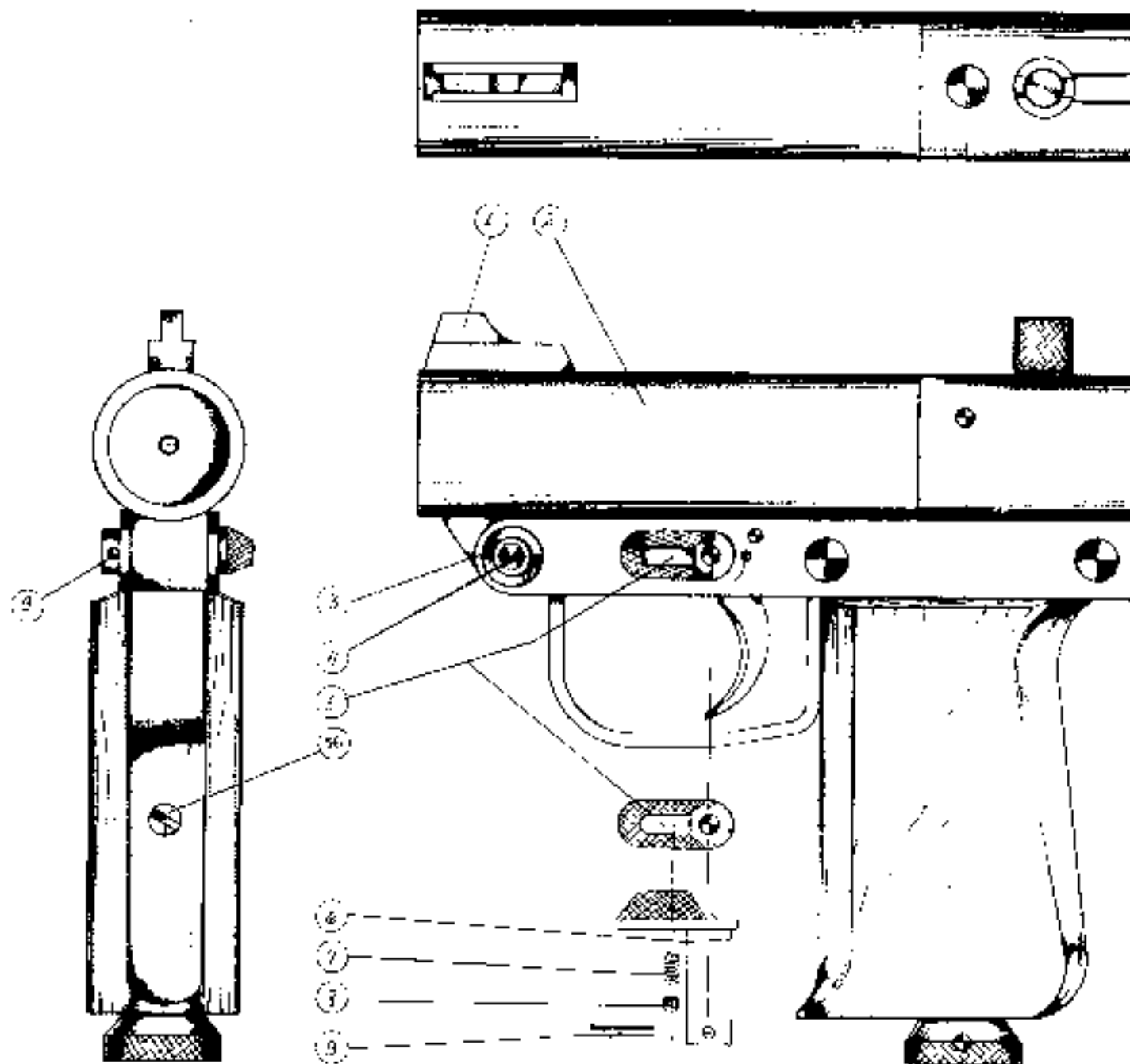
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- (50)
- (51)



MAIN RECEIVER/GRIP BASE

SHOTGUN PISTOL

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CIBORED CHAMBER

FIRING PIN SPRING
GUIDE BASE (POST)

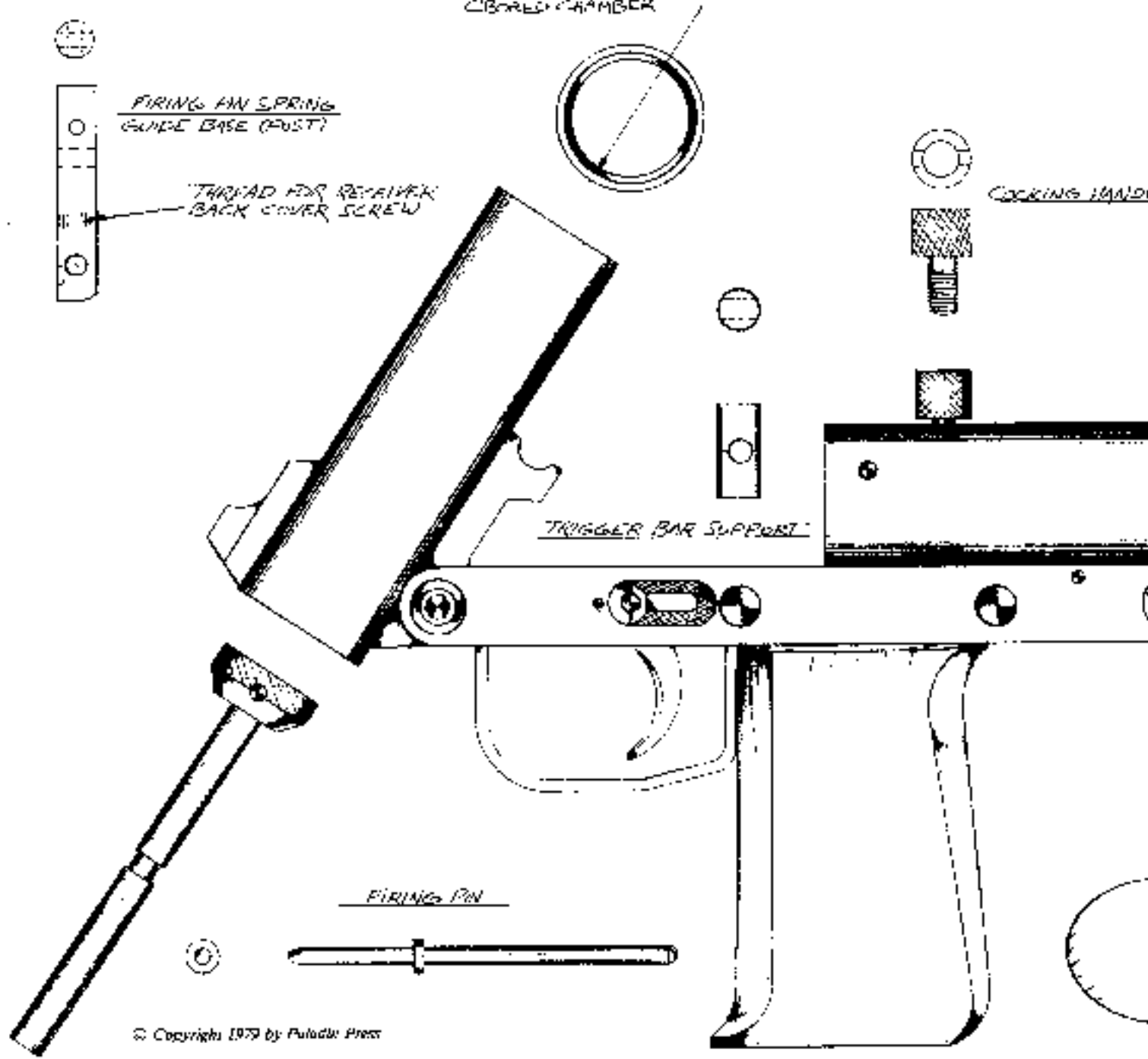
THREAD FOR RECEIVER
BACK COVER SCREW

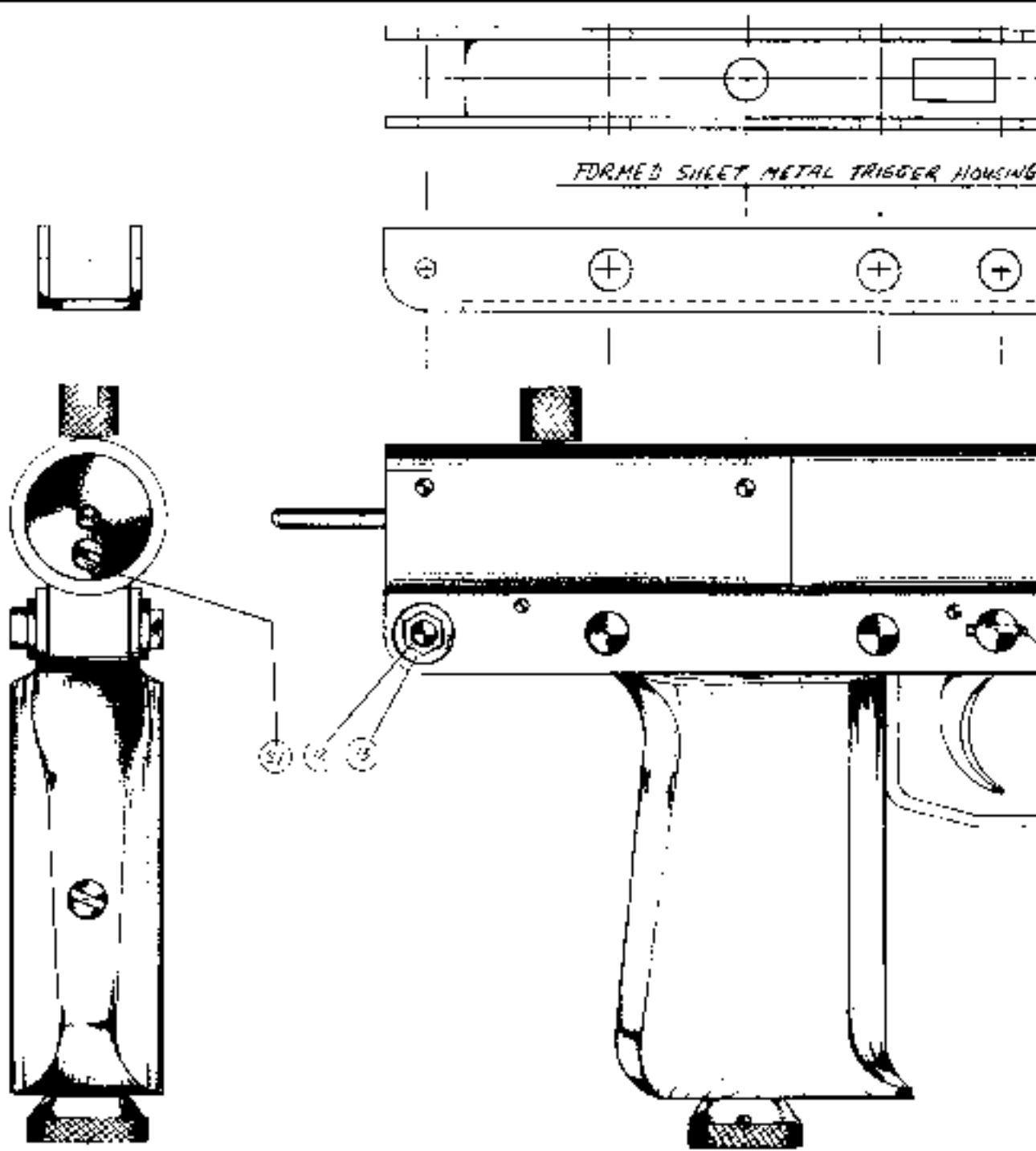
COCKING HANDLE

TRIGGER BAR SUPPORT

FIRING PIN

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MINI-MAGNUM .22 M.R.F.

SPECIFICATIONS:

CLASSIFICATION IMPROVISED · HANDMADE
CALIBRE22 L.R. .22 M.R.F. ADAPTABLE TO
VARIOUS PISTOL AMMUNITIONS,
OPERATION MANUAL SINGLE ACTION
TRIGGER SYSTEM. NO AUTOMATIC
EXTRACTOR.
OVERALL SIZE DEPENDS ON CALIBRE
TYPE USED.

*REMARKS: MANY VARIANTS HAVE BEEN ENCOUNTERED
IN VARIOUS CALIBRES.*

SYSTEM OF OPERATION:

To load the weapon, pull the slide to cocked position, then apply the safety by rotating the safety lever upward 90 degrees. The safety lever pin will lock the sear in place. The latch lever located on the right side of the frame has to be rotated 180 degrees towards the thumb. The latch lever pin locks the under lug of the barrel to the frame. The barrel can then be pivoted upward with the left hand into open position exposing the dual chambers, ready for loading.

Since the dual firing pins protrude on the breech block when in the forward position, it is safer to have it in the open cocked position with the safety applied. If the slide is eased forward on a loaded chamber, the firing pins are pressing against the cartridge rims by the pressure of the slide spring, liable to ignite it any time and fire the weapon unintentionally.

There is no built in extractor on the weapon. A separate extractor with double fork type plungers is improvised and can be carried conveniently in the pocket. A pocket clip built in to the extractor holds it in place.

CONSTRUCTION DETAILS:

Every part of this weapon is hand made. It is designed for a complete known analysis, so that the parts can be made and assembled for final assembly and use.

The frame sides are constructed from 1/8 inch thick steel plate formed to shape with hand tools. Two separate pieces are used for the base (14), breech block (6), and the underlug (14). The underlug guard is made from 1/16 inch thick by 1/4 inch wide steel plate. If the equipment is available, braze the grip base to the underlug guard in place on one frame side. Use rivets to secure the receiver body to the receiver body by the barrel pivot screw, under the slide just above the grip angle.

Make the slide from 1/16 inch sheet steel. The slide is secured to the dual firing pins. This plate is secured to the frame by a rear sight which is positioned to act as a rear sight. The slide is secured down pistol or revolver hammer spring, available in most gun shops. It should not be larger than 1/4 inch in diameter.

Form a barrel from 1/2 inch thick steel plate. The barrel should be machined and rifled if you have a machine. If not, it should be a smooth bore, if you do not. The barrel's diameter should be 1/4 inch wide, to fit in its space in the frame.

To retain the latch and safety levers in place, the balls must be fitted in them.

The two piece grip can be made from either wood or metal. It is attached to the grip base by two screws with appropriate washers and a stock panel.

PARTS LIST

1. *Firing pin base guide rod*
2. *Firing pin base*
3. *Slide retaining pin - pin head slotted as rear sight*
4. *Firing pins*
5. *Slide plate (2 pcs.) also receiver body*
6. *Breech block*
7. *Counter bored chambers*
8. *Cal. 22 magnum chamber*
9. *Barrel - no riflings (improvised)*
10. *Barrel latch lever pin*
11. *Front sight*
12. *Slide*
13. *Ignition spring*
14. *Base for ignition spring*
15. *Sear*
16. *Sear spring*
17. *Base for grip stock*
18. *Grip stock - wrap around*
19. *Barrel pivot screw*
20. *Trigger guard*
21. *Safety lever pin*
22. *Stock screws*
23. *Trigger*

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