

STEN Mk II SPECIFICATIONS

1. Cartridge:	9mm Parabellum	
	Bullet weight	116 grains
	Powder weight	6 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

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.
2. Eliminate barrel sleeve.
3. Weld barrel bushing into the front end of the receiver for simple, permanent assembly.
4. Turn barrel blank OD (outside diameter) without any shoulder, fit the barrel in the bushing by sliding fit.
5. Fasten the barrel in the bushing by two roll pins of 3/16" diameter, or equivalent.
6. Turn the bolt OD to fit the receiver ID.
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.
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.
9. All pins can be roll pins of standard commercial size, or pieces of drill rod.
10. All springs can be of a standard commercial size.
11. Trigger material may be aluminum or plastic, side tabs may be replaced by spacers or washers to keep the trigger located neutrally.
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

Note: A 1" galvanized pipe fits loosely inside a 1-1/4" pipe and can be welded as a filler-spacer where needed,