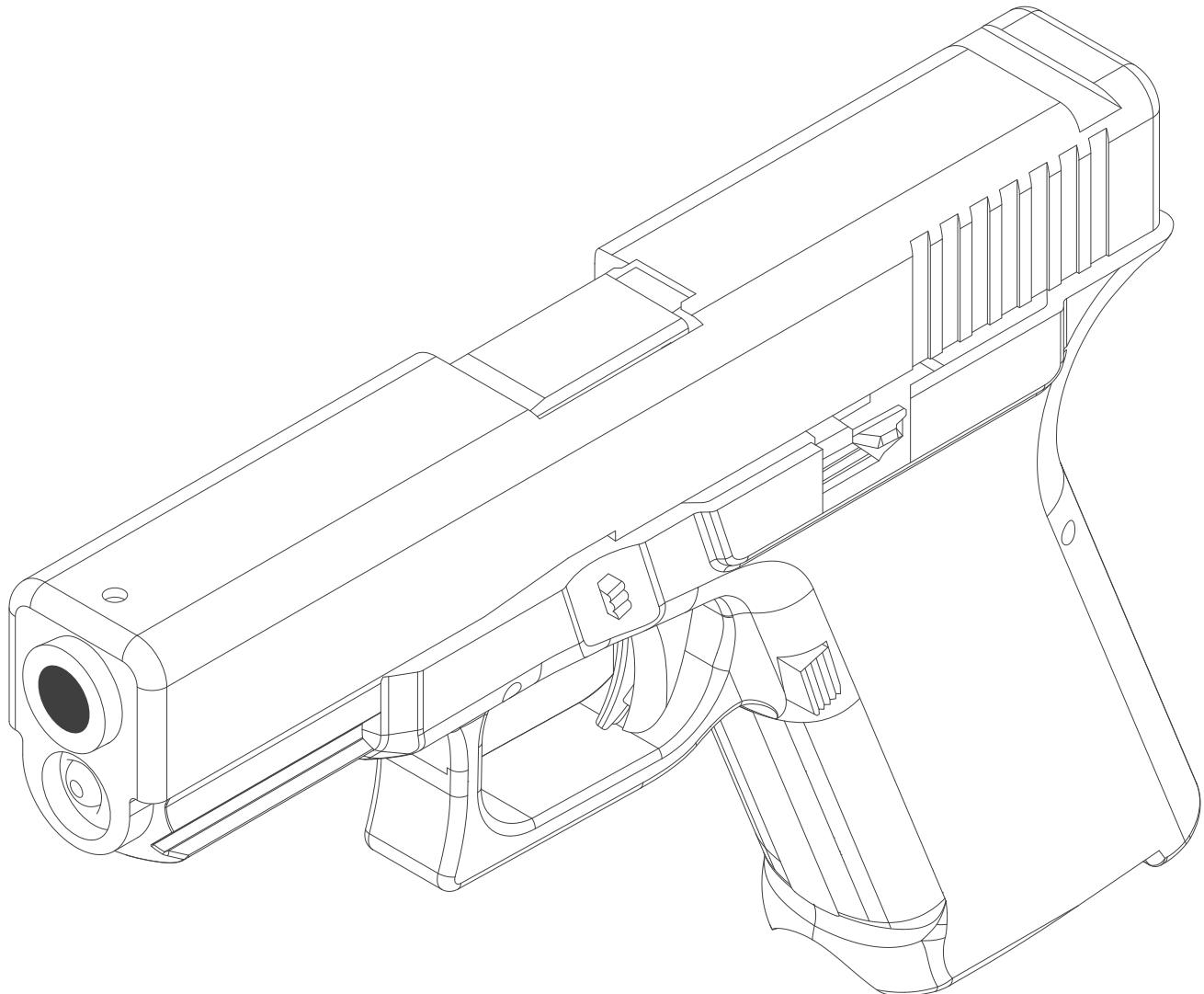


G9



Guide v1.0.1

 DEFENSE DISTRIBUTED

TABLE OF CONTENTS

Where the heck am I?

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WELCOME

The GO Platform awaits you

What is a GO?

The GO is a 9mm G19 Gen 3-style zero percent pistol in which all regulated firearm parts can be fabricated by you, in the privacy of your own home. It is the best zero percent pistol available.

The GO chassis is milled from a metal block on the Ghost Gunner 3 CNC mill. Customers perform the milling procedure by following the simple step-by-step instructions provided in the GO Ghost Gunner cutcode. Once milled, the chassis is next assembled with a standard G19 Gen3 lower parts kit, and then is installed into a GO grip module, which can be printed on a 3D printer or purchased separately. Grip module models have been released for free download at DEFCAD.com, and can be customized to suit your needs and tastes. To complete the pistol, a 9mm G19 Gen3 slide assembly is installed.

GO is the only metal zero percent pistol available on the market, and its one-piece metal design makes it stronger, more reliable, and easier to build than all other DIY pistol designs. We believe you will find the GO to be an excellent firearm, and a fantastic way to exercise your freedom to build your own guns.

Quickstart

For your first GO Zero Percent Pistol:

The absolute easiest and quickest way to gather the materials required to create a GO is to purchase them from **Ghost Gunner** at <https://GO.ghostgunner.net>. Below is a checklist of everything needed to build your GO.

GO Non-Frame Block

The raw metal block

GO Starter Kit

Contains fixtures, cutting tools, and cutcodes

GO Grip Module

Contains grip module and installation hardware

G19 Gen 3 Parts Kit

Available as *GO Build Kit* on [GhostGuns.com](#), or at any other G19 part supplier

Many of these parts can be sourced or fabricated by you. To learn more, continue to the next page.

OVERVIEW

How to get everything you need for GO

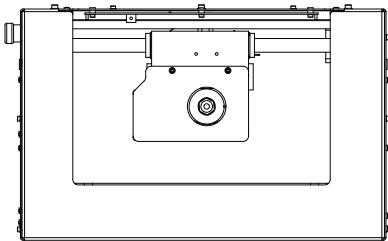
What is a GO?

The following table can be used to quickly determine the methods of acquiring each of the required parts for building a GO Zero Percent Pistol.

GO COMPONENTS	Available at GO.ghostgunner.net	Available on DEFCAD.com	Independent source
	Purchase	Download	
GO Non-Frame Block	Yes		Yes
GO Grip Module	Yes	Yes	
GO Special Parts	Yes		Yes
G19 Lower Parts	Yes at ghostguns.com		Yes
G19 Slide Assembly	Yes at ghostguns.com		Yes
Universal Clamps	Yes		
Cutting Tools	Yes		Yes
Ghost Gunner 3/DDcut	Yes		
GO Cut Codes	Yes	Yes	

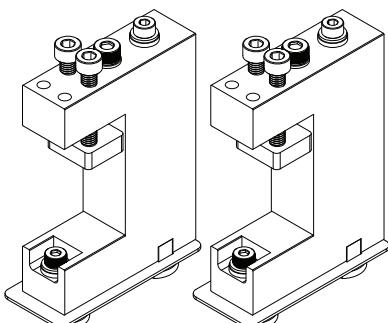
TOOL LIST

Everything you will need to build a GO



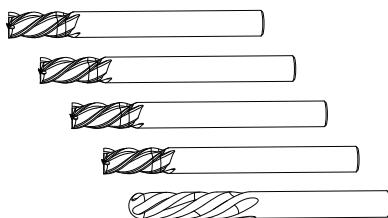
Ghost Gunner 3/DDcut Software/Cut Codes

The Ghost Gunner 3 CNC mill is used to easily perform all milling operations for the GO. The cut code is the instruction and control file that tells your Ghost Gunner how to mill the GO. DDCut is mill control software which reads the cutcode to provides step-by-step instructions for all operations.



Universal Clamps

The clamps are used to mount the GO Non-Frame Block to the Ghost Gunner 3's T-slot table to hold it in place for machining. These clamps are used in several other Ghost Gunner projects, such as the AR-00 and the Optic Cut. They are generic workholding and can be used to hold stock for many different projects.



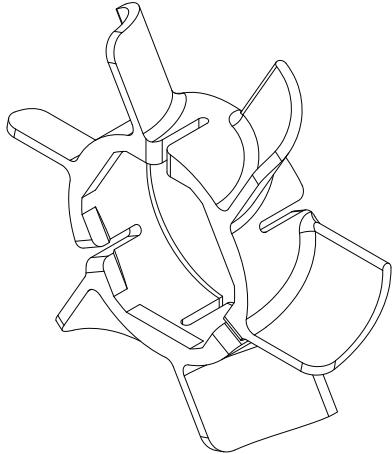
Cutting Tools Kit *

- 2x** 1/4" 4-flute square nose endmill, 2.5" OAL, 3/4" LOC
- 1x** 3/32" 4-flute square nose endmill, 2.5" OAL, 1/2" LOC
- 1x** 1/8" 4-flute square nose endmill, 2" OAL, 1/2" LOC
- 1x** 1/8" 4-flute ball nose endmill, 2" OAL, 1/2" LOC

*** Note:** Customers will also need a 1/4" ER-11A collet
and a 1/8" ER-11A collet to complete cuts

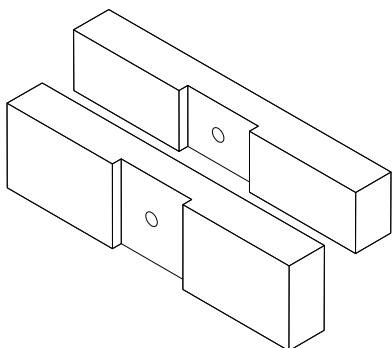
TOOL LIST

Everything you will need to build a GO



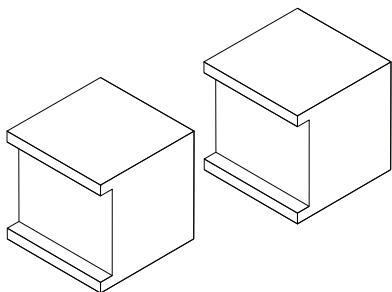
Ghost Gunner 3 Cooling Fan

A model of a cooling fan for use with the Ghost Gunner 3. This fan snaps onto the ER11 collet nut attached to the Ghost Gunner's spindle. It then assists with part cooling and chip evacuation during milling. This fan was designed for use with Ghost Gunner's Zero Percent Receiver project, but can of course be used for other Ghost Gunner projects as well.



Aluminum Fixture Plate Set

These plates will be used to mount the stock parallel to the spindle for milling out the rear rails in Operation 7 of the GO Chassis milling process.

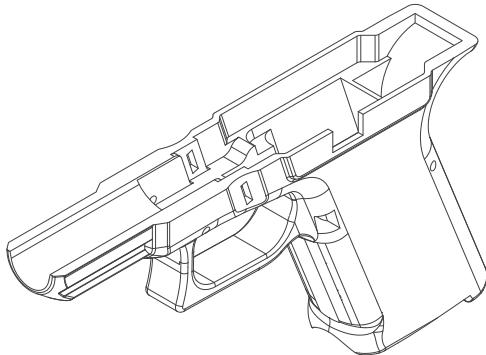


Aluminum Parallels

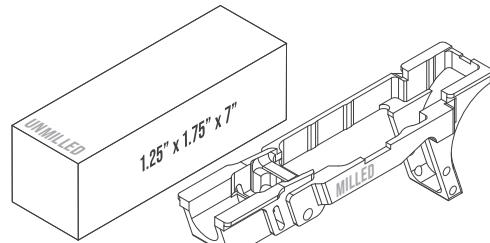
These parallels will be used to help space the stock properly in Operation 2. of the GO Chassis milling process.

PARTS LIST

Everything you will need to build a GO

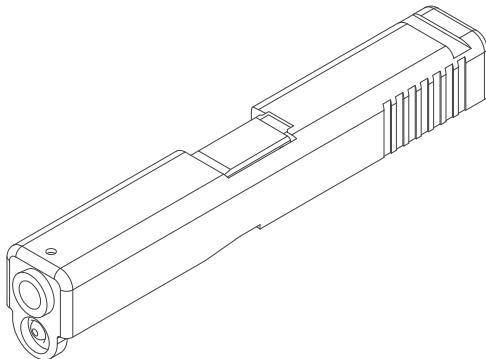


GO Grip Module

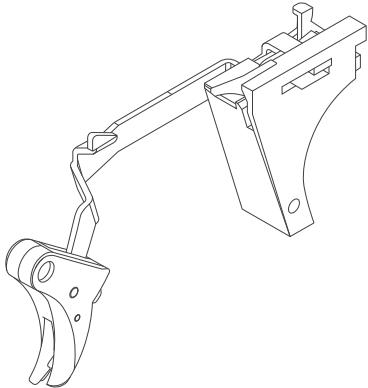


GO Non-Frame Block / GO Chassis

MILLED USING GG3



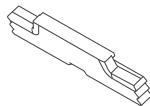
G19 Gen 3 Slide Assembly



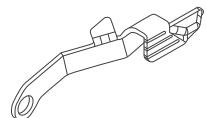
G19 Gen 3 FCG



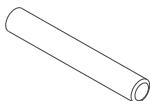
Slide Lock Spring



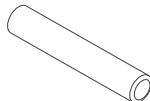
Slide Lock



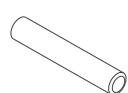
Slide Stop



2x 28x3mm Pin



22x4mm Pin



18x3mm Pin

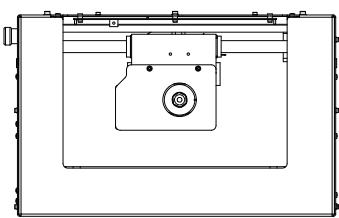
MILLING

Creating the GO from a block of material

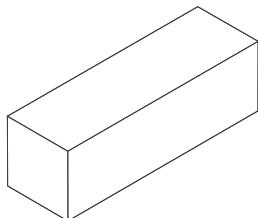
How do I mill a GO?

Both the core firearm chassis of the GO and the grip module can be manufactured from the privacy and comfort of your own workspace. In this section we will detail the steps for milling the firearm chassis on the Ghost Gunner 3. The **DDcut Software** will guide you through every tool change and part probing step to ensure a quality result. Here is a quick summary of what milling consists of. **NOTE:** All cutting codes and files can be found on DEFCAD

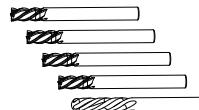
Tools/Part needed for Milling



Ghost Gunner 3/DDcut

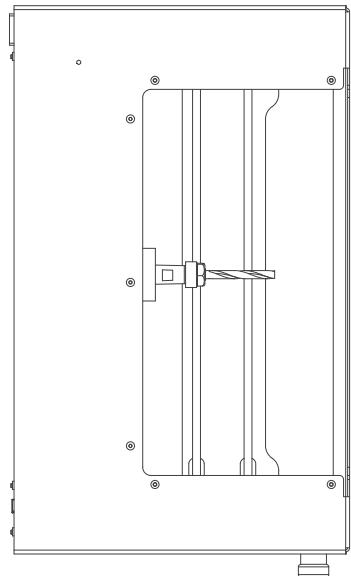


Block of Material



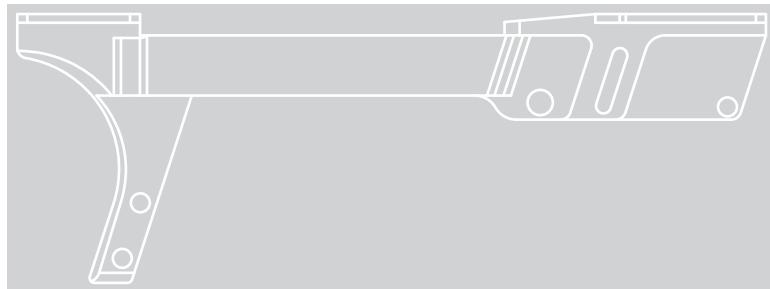
Cutting Tool Kit

1



MILLING RIGHT SIDE

Install stock and tool. Face the entire block and bore a reference hole. Cut contours and perform all feature work on the right side.

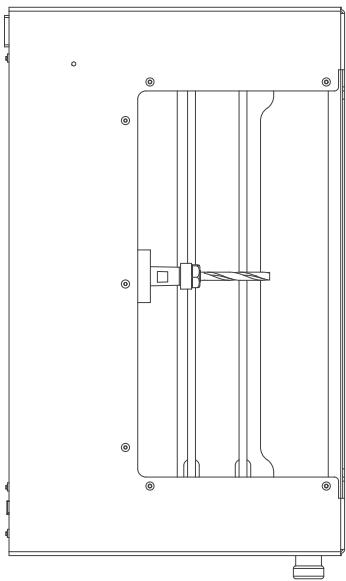


CUT PREVIEW

MILLING

Creating the GO from a block of material

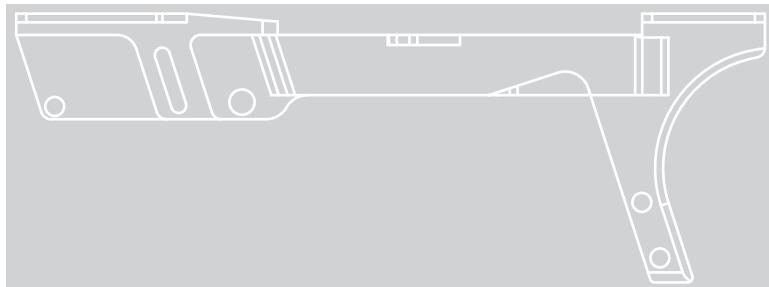
2



MILLING LEFT SIDE

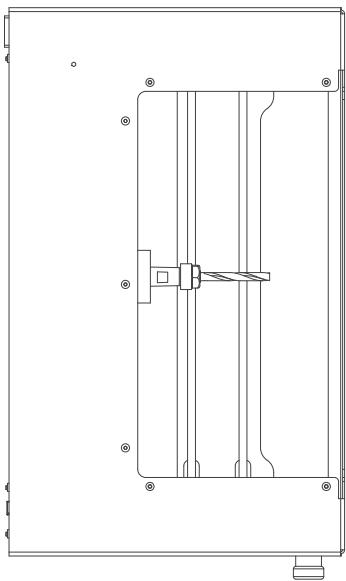
Turn stock around and mill out all feature work on the left side.

Cut off and drop bottom waste stock. (save waste for later)



CUT PREVIEW

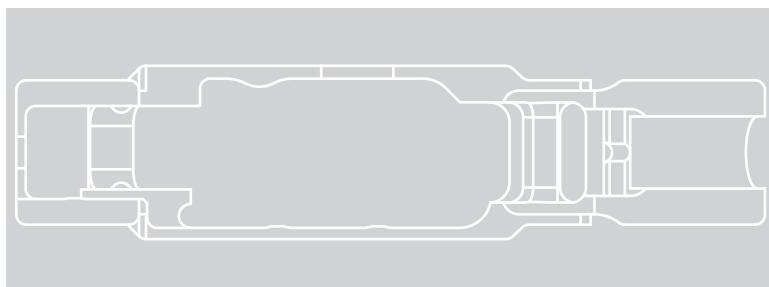
3



MILLING TOP SIDE

Turn stock 90 degrees and mill out the center of the stock.

Cut all top features.

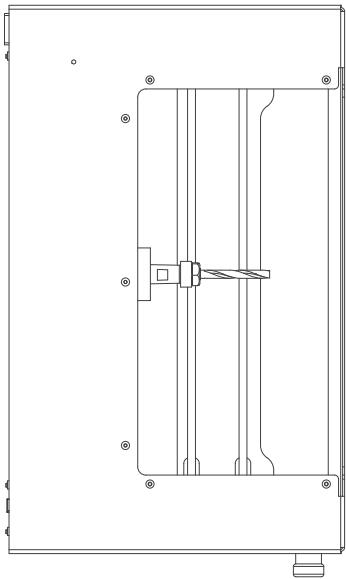


CUT PREVIEW

MILLING

Creating the GO from a block of material

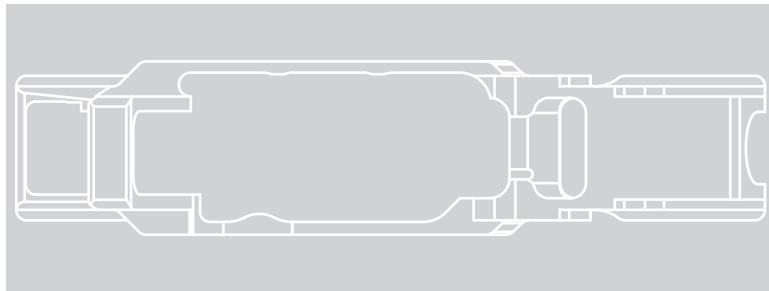
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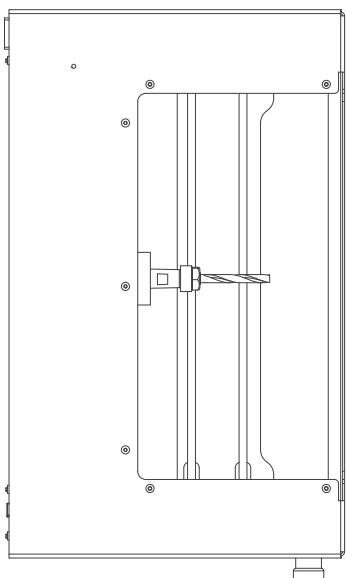
MILLING BOTTOM SIDE

Turn stock around and complete all center clearance.

Mill out all feature work on the bottom.

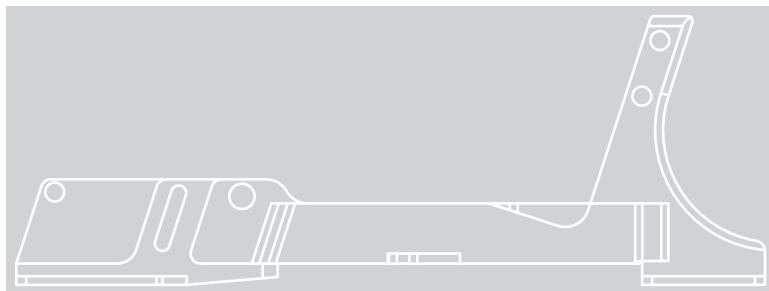


5



LEFT SIDE CLEANUP

Reinstall in modified Step 2 position and cut off left and right waste stock

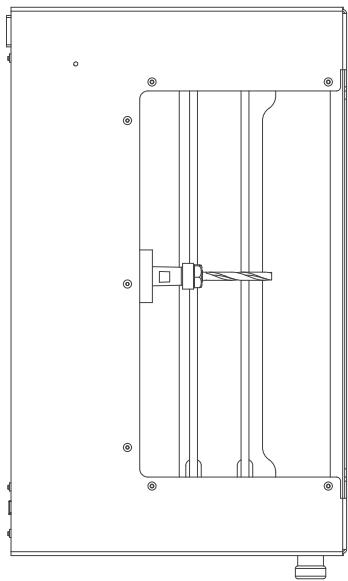


CUT PREVIEW

MILLING

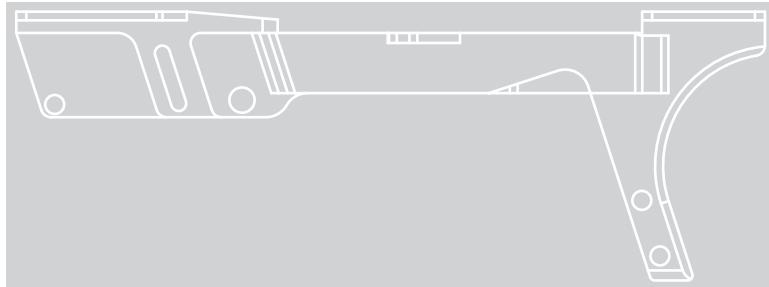
Creating the GO from a block of material

6



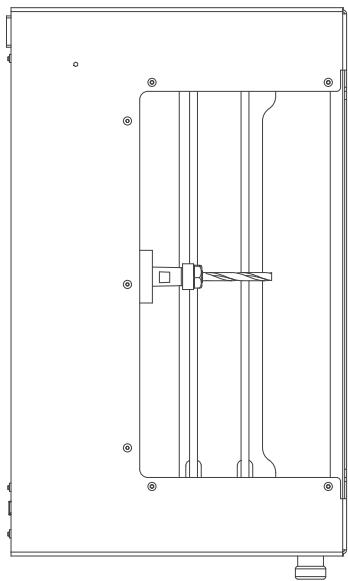
MILLING SLIDE LOCK SPRING HOLE

Orient in clamps with rear rails as reference and bore slide lock spring hole.



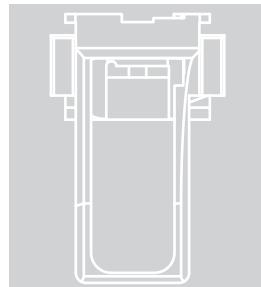
CUT PREVIEW

7



MILLING REAR SIDE

Using fixture plate, orient stock perpendicular to table and clear center of rear rails

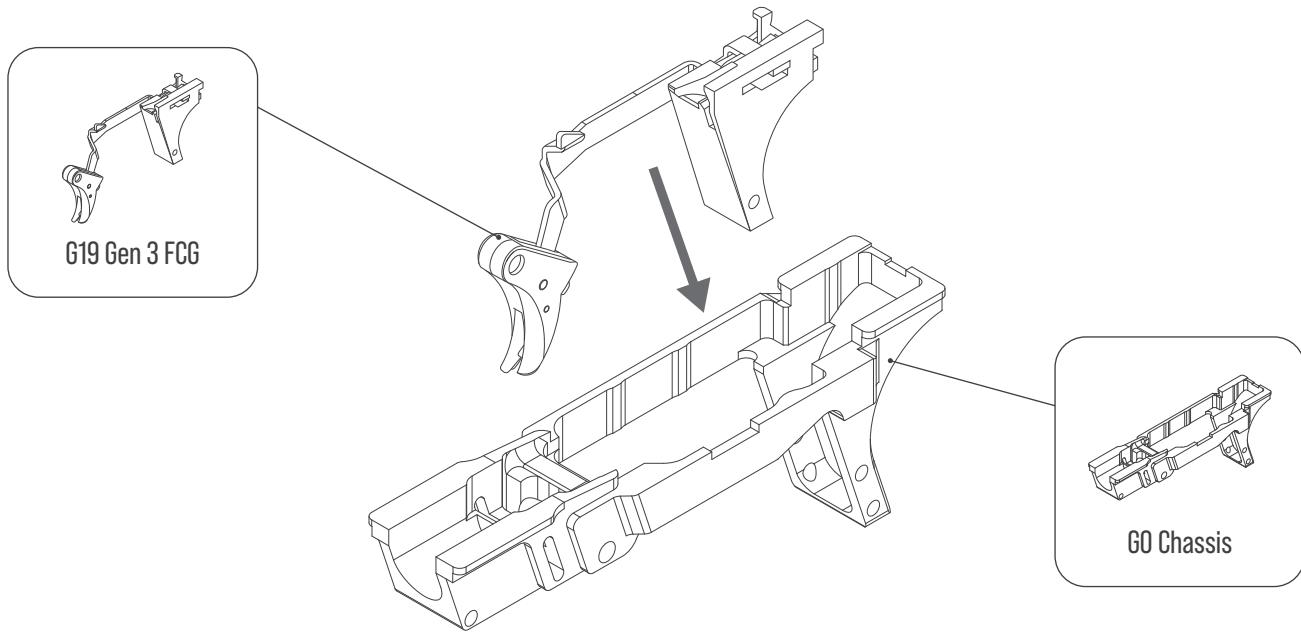


CUT PREVIEW

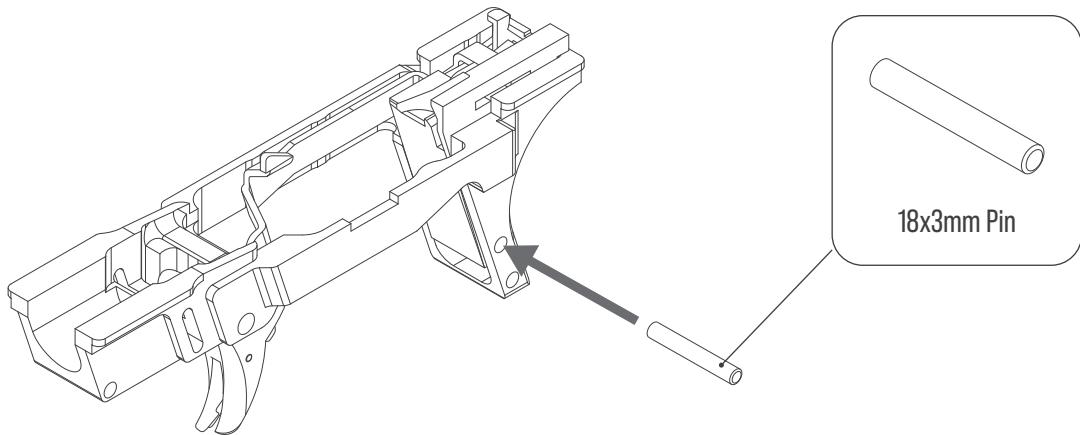
ASSEMBLY INSTRUCTIONS

Assembling the GO

1



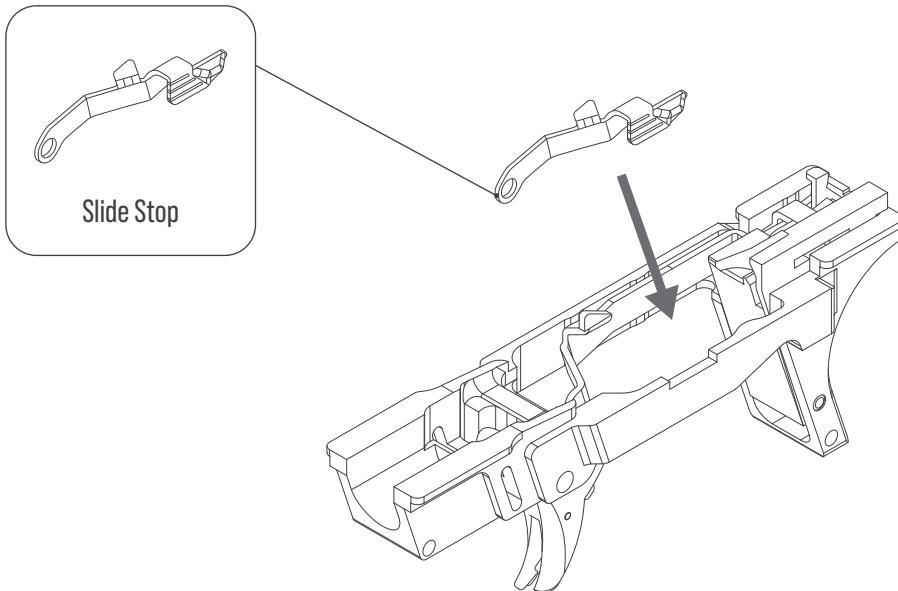
2



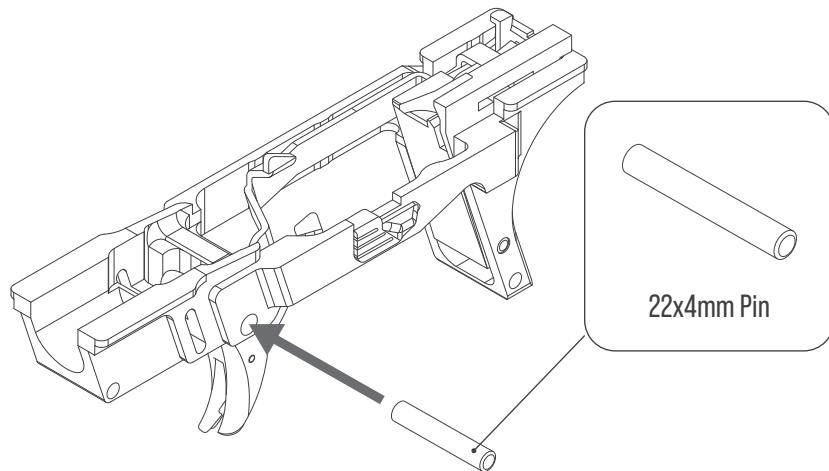
ASSEMBLY INSTRUCTIONS

Assembling the GO

3



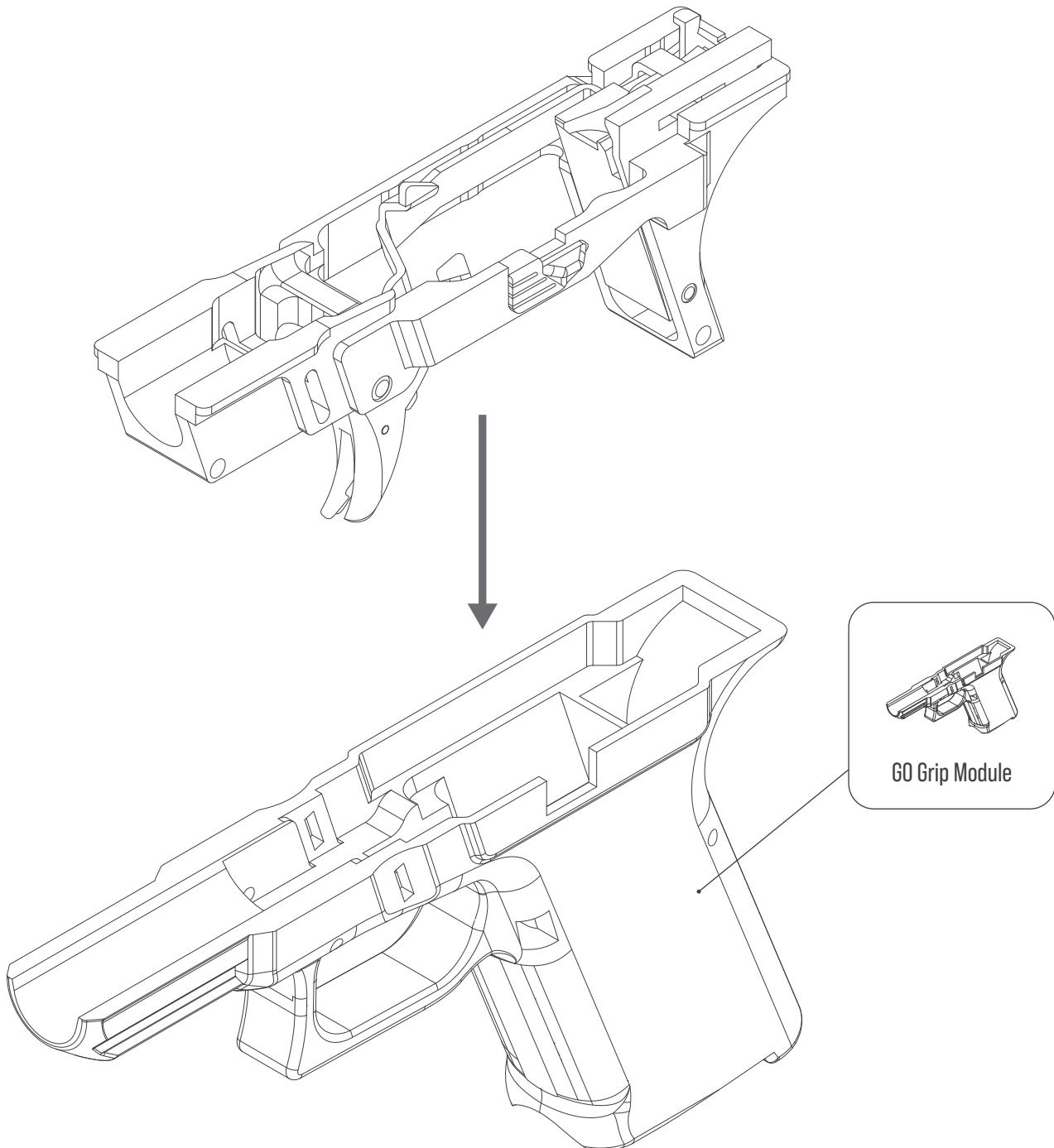
4



ASSEMBLY INSTRUCTIONS

Assembling the GO

5



GO Grip Module

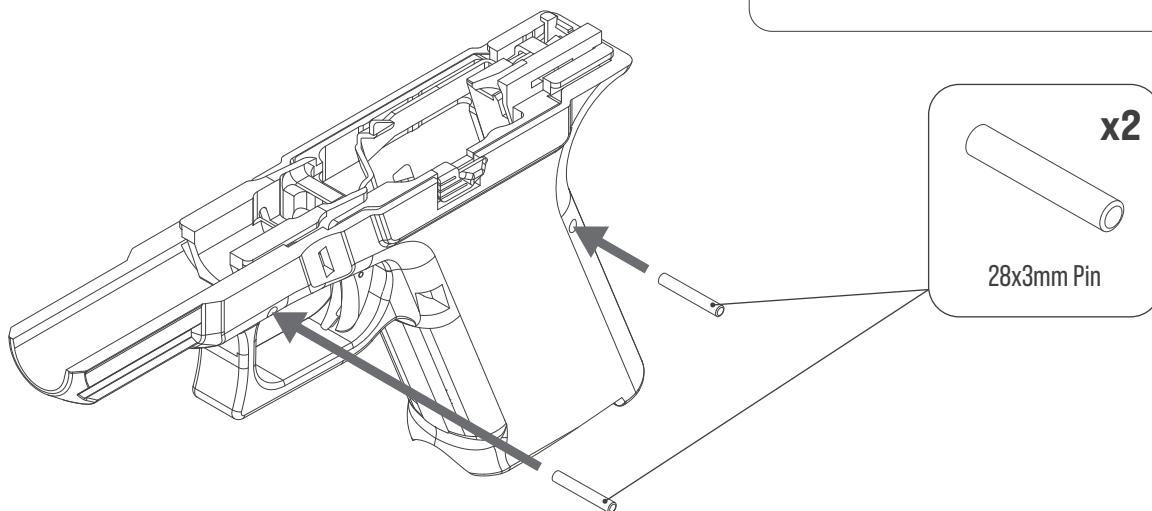
ASSEMBLY INSTRUCTIONS

Assembling the GO

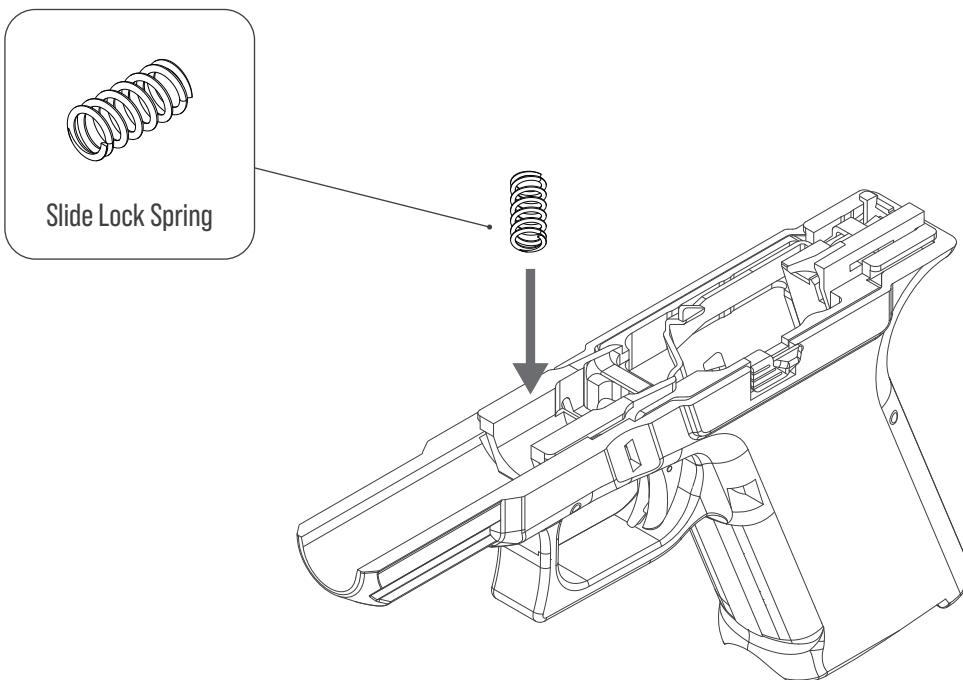
6

NOTICE!

To ensure proper fitment, it is important that the pins fit snugly. If necessary, reaming the pin hole can be beneficial to avoid the use of excessive force.



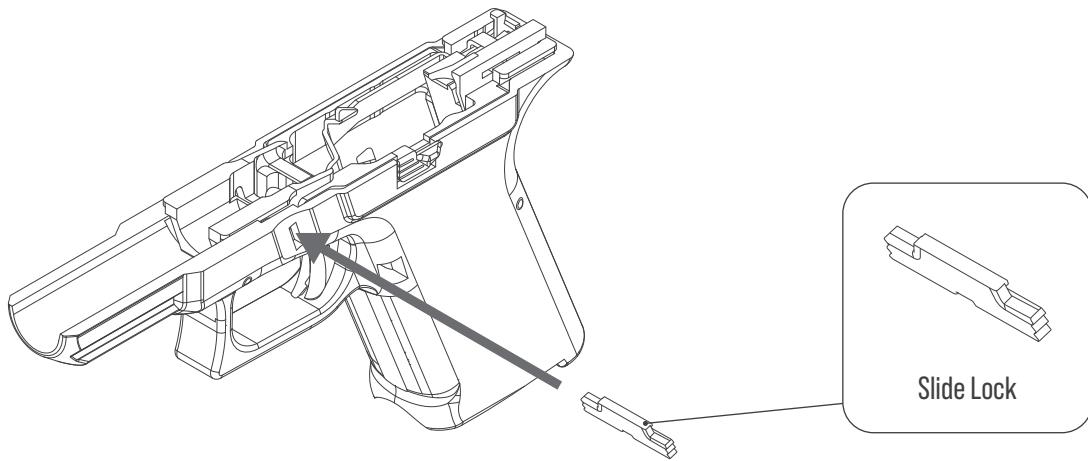
7



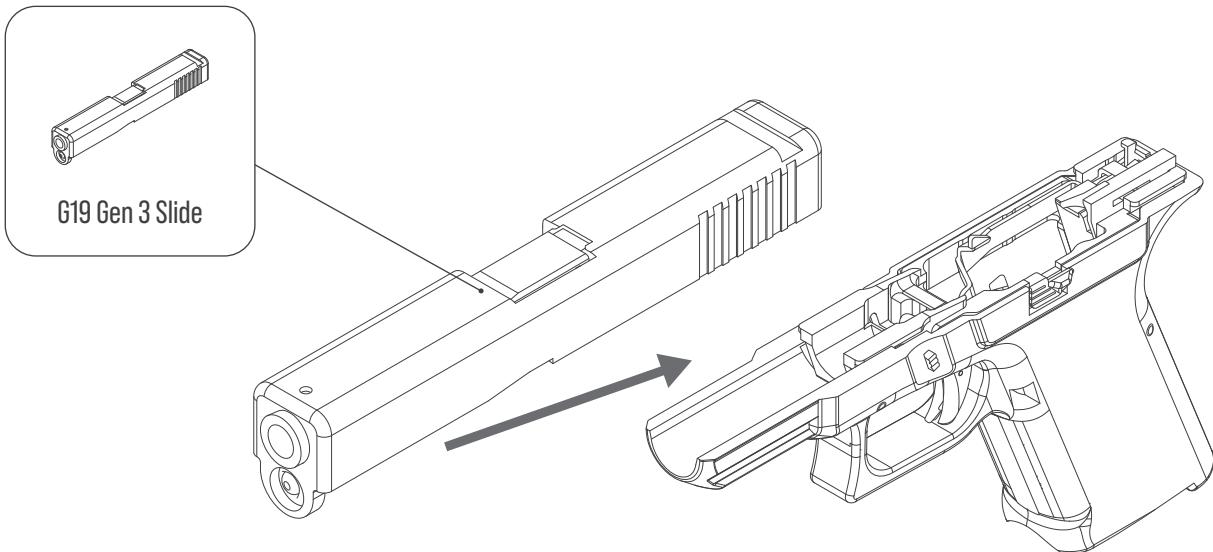
ASSEMBLY INSTRUCTIONS

Assembling the G0

8



9



TESTING

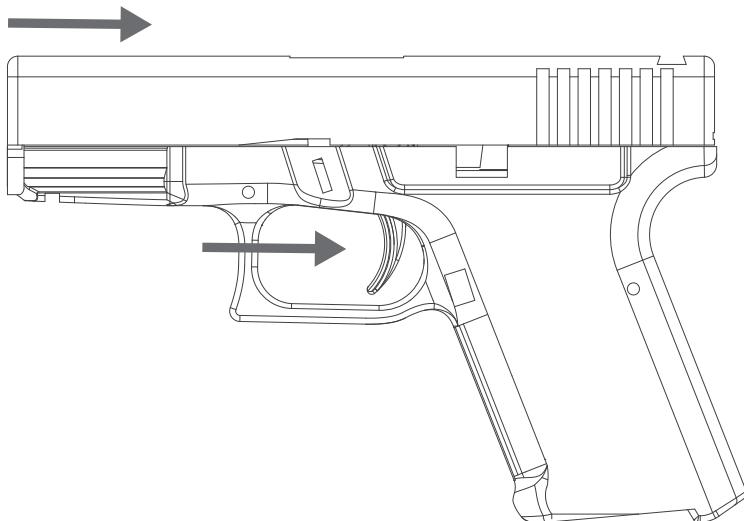
Test your new GO Assembly

⚠ WARNING ⚠ NO AMMUNITION SHOULD BE ANYWHERE NEAR THE GUN DURING FUNCTION TESTING ⚠ WARNING ⚠

**BEFORE TESTING, ENSURE FIREARM IS UNLOADED AND NO MAGAZINE IS IN,
OR NEAR THE FIREARM AND THE CHAMBER IS EMPTY.**

To test your new GO,

Rack the slide, we recommend doing this multiple times to ensure a smooth consistent feel and check that nothing is obstructing the slide from working as intended.



Now the moment of truth, point your GO in a safe direction (where you have also verified a safe backstop), and pull the trigger to verify functionality. Dry fire test the GO a couple of times to ensure all mechanisms inside and out are working as intended. After depressing the trigger on a dry fire test, hold the trigger to the rear and rack the slide again. Slowly let the trigger out after racking the slide, and verify you can hear the click of the trigger resetting as you let the trigger out.

If everything is working as expected, you're ready to take the GO out to the range and test it out!

Enjoy your GO!

CUSTOMIZING

Add your style to the GO Grip Module

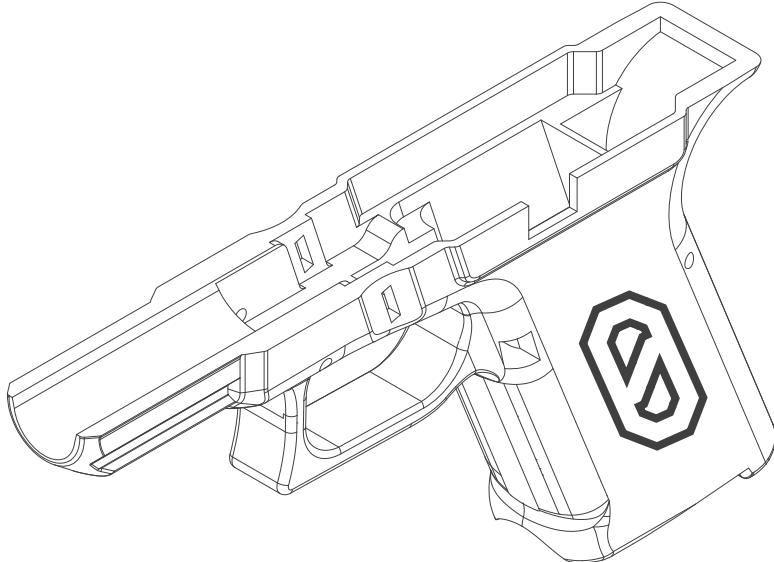
Customizing the GO Grip Module

The GO is a fully open source project. All GO models and code are available to the public for review and customization.

In particular, this means that the GO grip module, as a 3D-printable part, can be easily remixed and customized.

We have included models to assist with these remixes:

The GO Grip Module Model - This is our own basic model for the grip module. We have left it unadorned to allow you to add your own texture, stippling and other changes. The only critical geometries in the Grip Module are those which interface with the assembled GO chassis, all other geometries can be changed and customized as you like.



The GO Boolean Model - This is for developers who wish to take things to the next level. If you wish to install a GO chassis in something other than our basic Grip Module design – including a grip module that you've developed from scratch, or even a totally different sort of firearm platform, the GO Boolean Model can help. This model matches the critical GO Chassis geometries exactly – you need only insert this model where you intend the chassis to sit, and then use a negative operation to “cut out” the chassis shape.

These models are included both with the cutcode, and are available on [DEFCAD](#). Additionally, multiple remixes of the GO Grip Module are available at time of release, and can be found in these same places. Have fun remixing the grip module, and make sure to share your work with us!

ZERO PERCENT

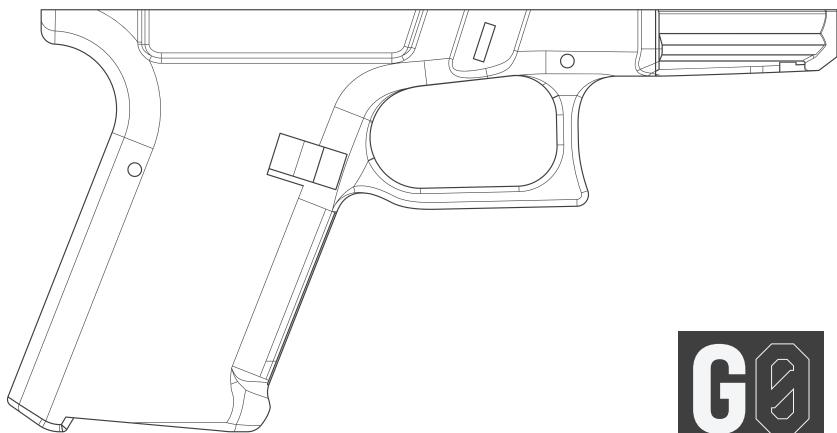
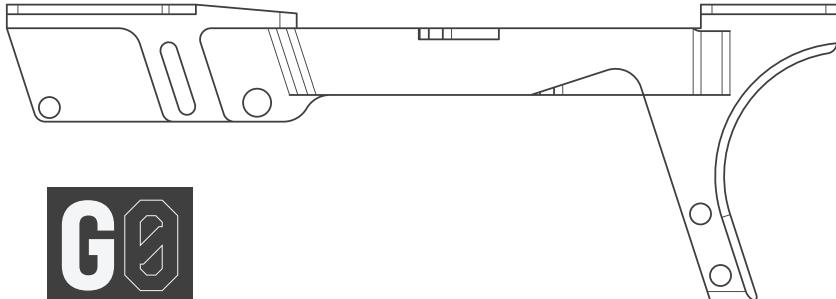
The future is zero percent

What is a Zero Percent?

"Zero percent" firearms are those builds where the receiver is made from an unformed block of metal or other raw material.

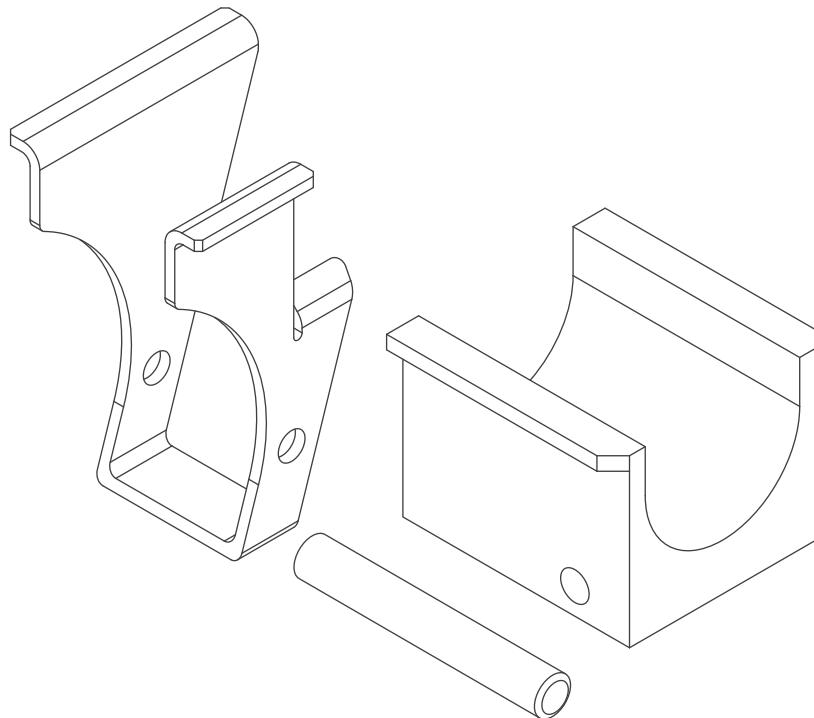
For Ghost Gunner GO pistol builds, the metal chassis is the firearm's receiver, and the GO grip module is a non-firearm accessory component.

The GO chassis may be milled on the Ghost Gunner 3 from unformed blocks of metal, and the GO Grip Module may be printed on a 3D printer.



Grip Module Accessory

ALSO AVAILABLE



FMDA Rails on GG3

The FMDA pistol is a printed Glock design and is a direct antecessor of the GO.

This design uses two metal rail inserts (front and rear) to secure the slide.

Ghost Gunner is proud to offer cutcodes to mill these rails.

Learn more at fmda.ghostgunner.net