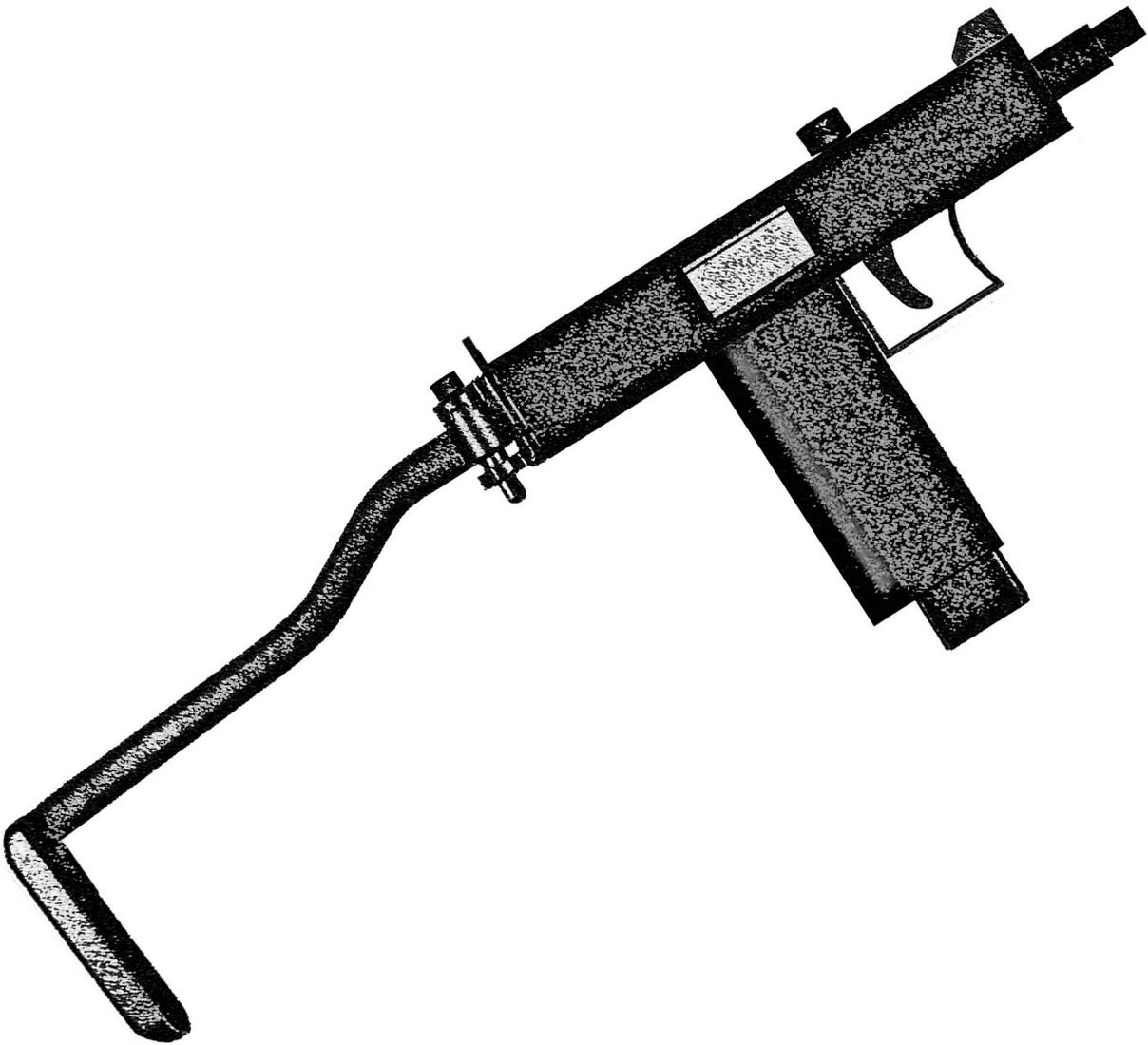


PANTHER-9 MACHINE PISTOL



CONSTRUCTION PLANS



Panther-9 Machine Pistol (Prototype model)

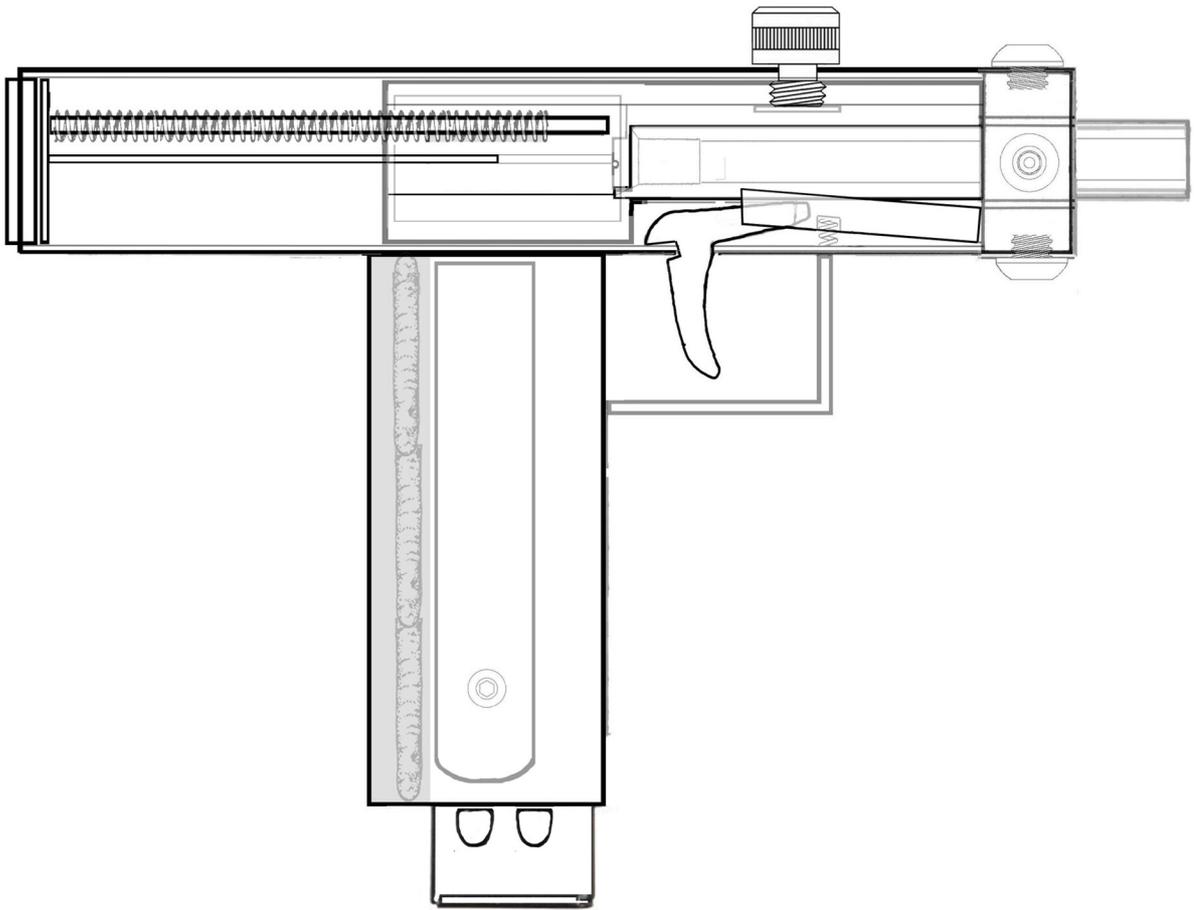


Components: Cocking knob, Bolt, Recoil spring & guide rod, Receiver, Barrel (Non-funtioning dummy), Barrel assembly screws, Trigger, Sear. Sear spring.

For legal purposes the demonstration model shown was built as a non-firing dummy replica. Its dummy barrel is permanently blocked and destroyed with its dummy bolt containing no provisions for a firing pin.



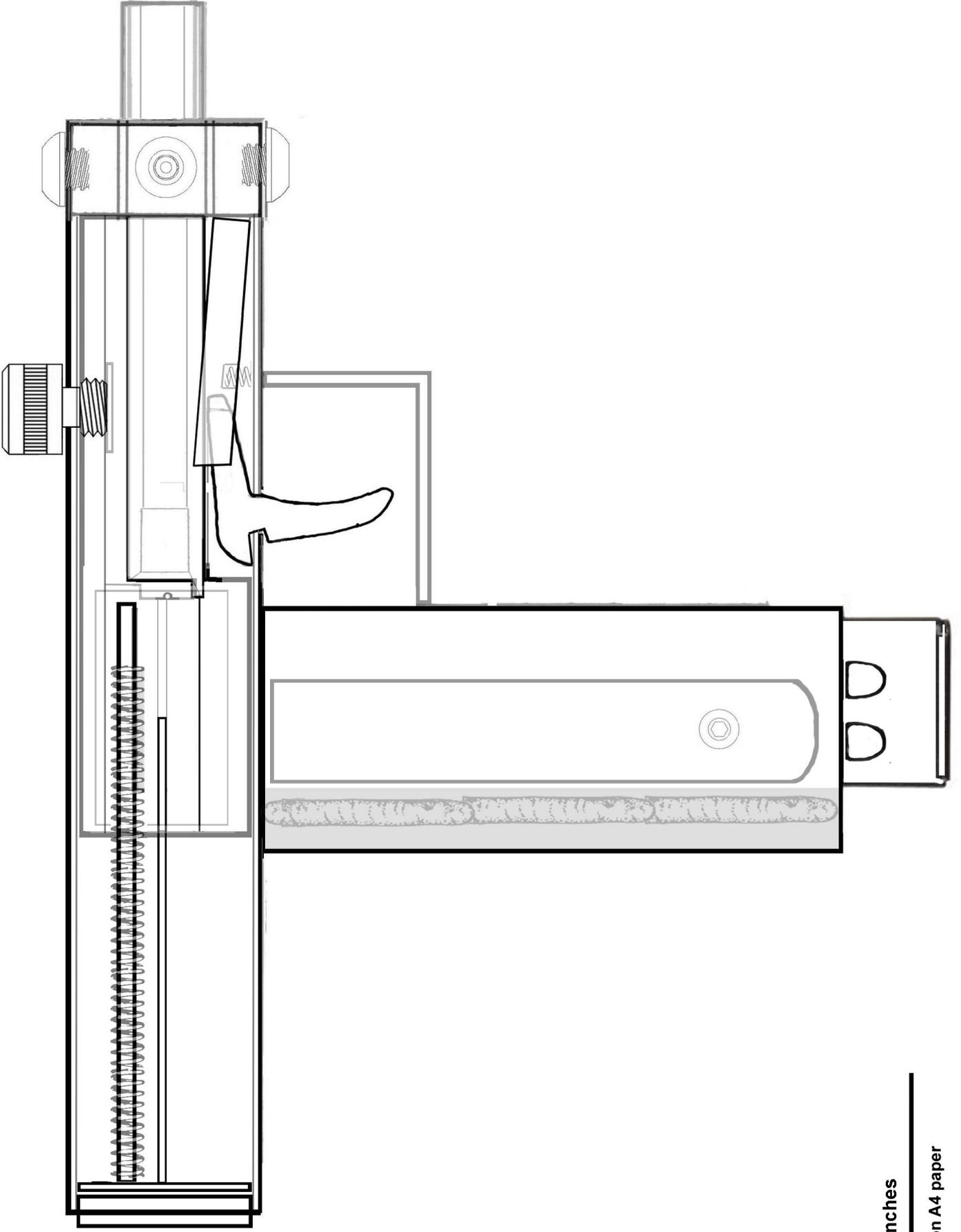
The information contained herein is presented purely for academic study purposes only.



Materials

- 1.5" (38mm) x 1.6mm wall mild steel square box section tubing.
- 1" x 2" (25mm x 50mm) x 1.5mm wall mild steel rectangular section tubing.
- 1/4" (6mm) mild steel plate.
- 3/4" (19mm ID, 35mm OD) shaft lock collar.
- 19mm x 1.5mm / 2mm steel tube.
- 15mm x 3mm or 16mm x 3.5mm wall seamless steel tube.
- Compression spring, 6mm to 10mm wide, 5" long.

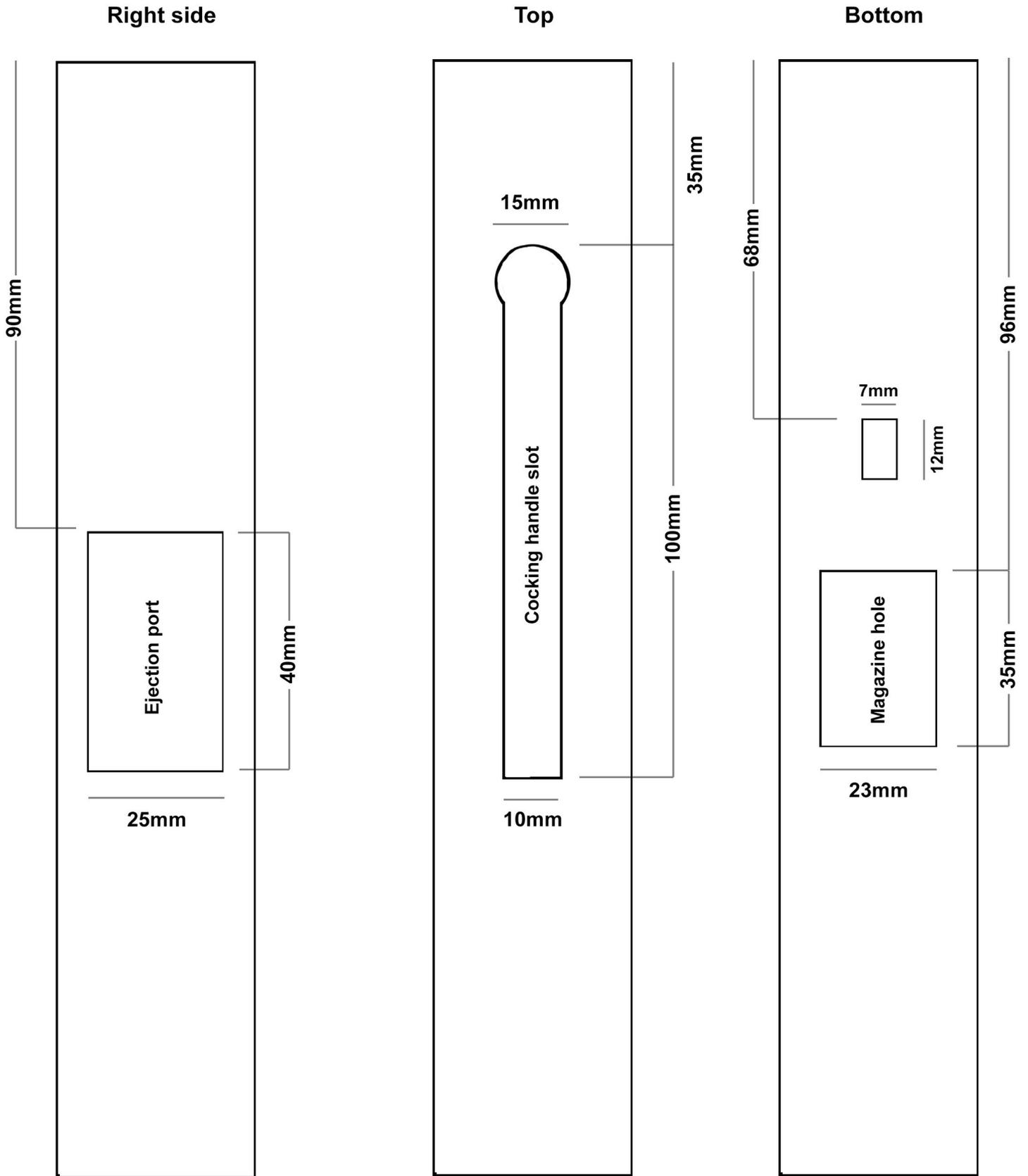
The Panther-9 uses standard 9mm Uzi magazines



2 inches

Print on A4 paper

Receiver



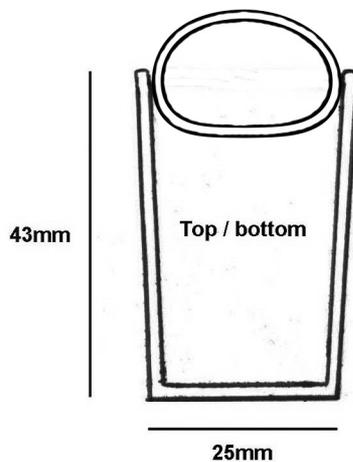
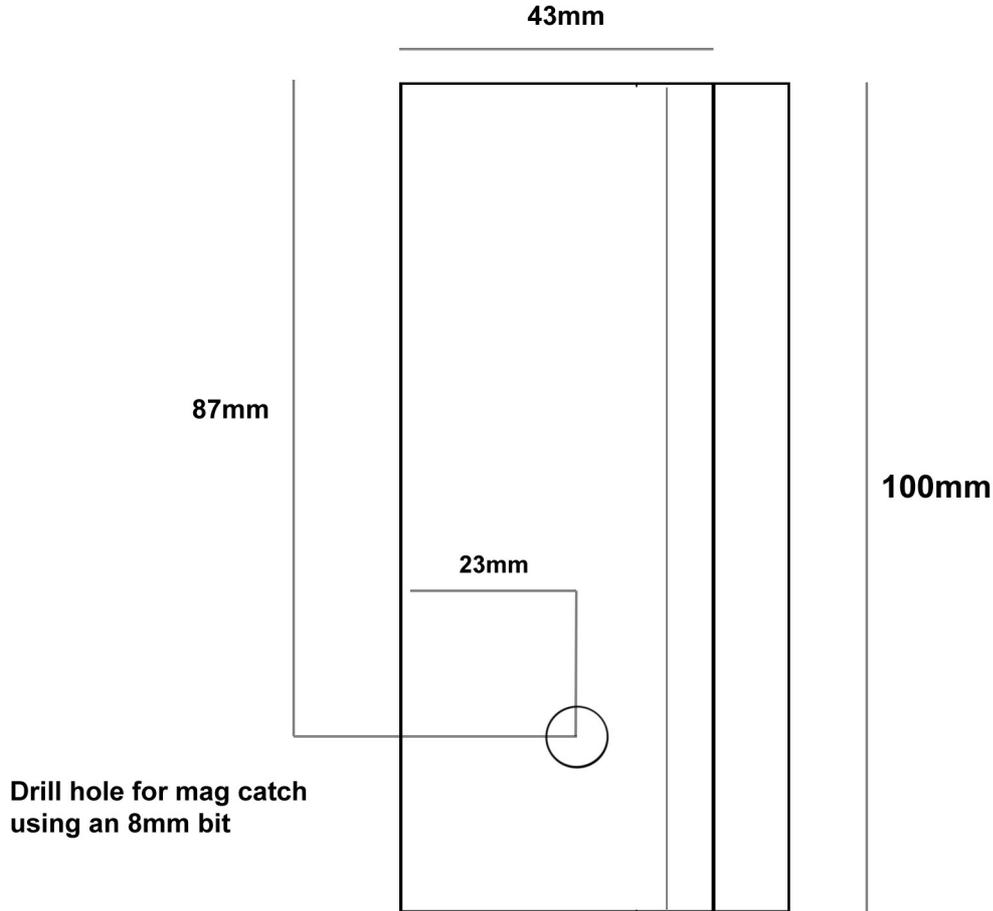
210mm long length of 38mm (1.5") square mild steel box section
(1.6mm (16 gauge) wall thickness)

2 inches

Print on A4 paper

Magazine well

The magazine well consists of a section of 1" x 2" (25mm x 50mm) steel rectangular box section with one side removed. A length of 19mm OD steel tube is hammered into an oval shape and welded in place, forming the backstrap. Use an UZI magazine for reference throughout.

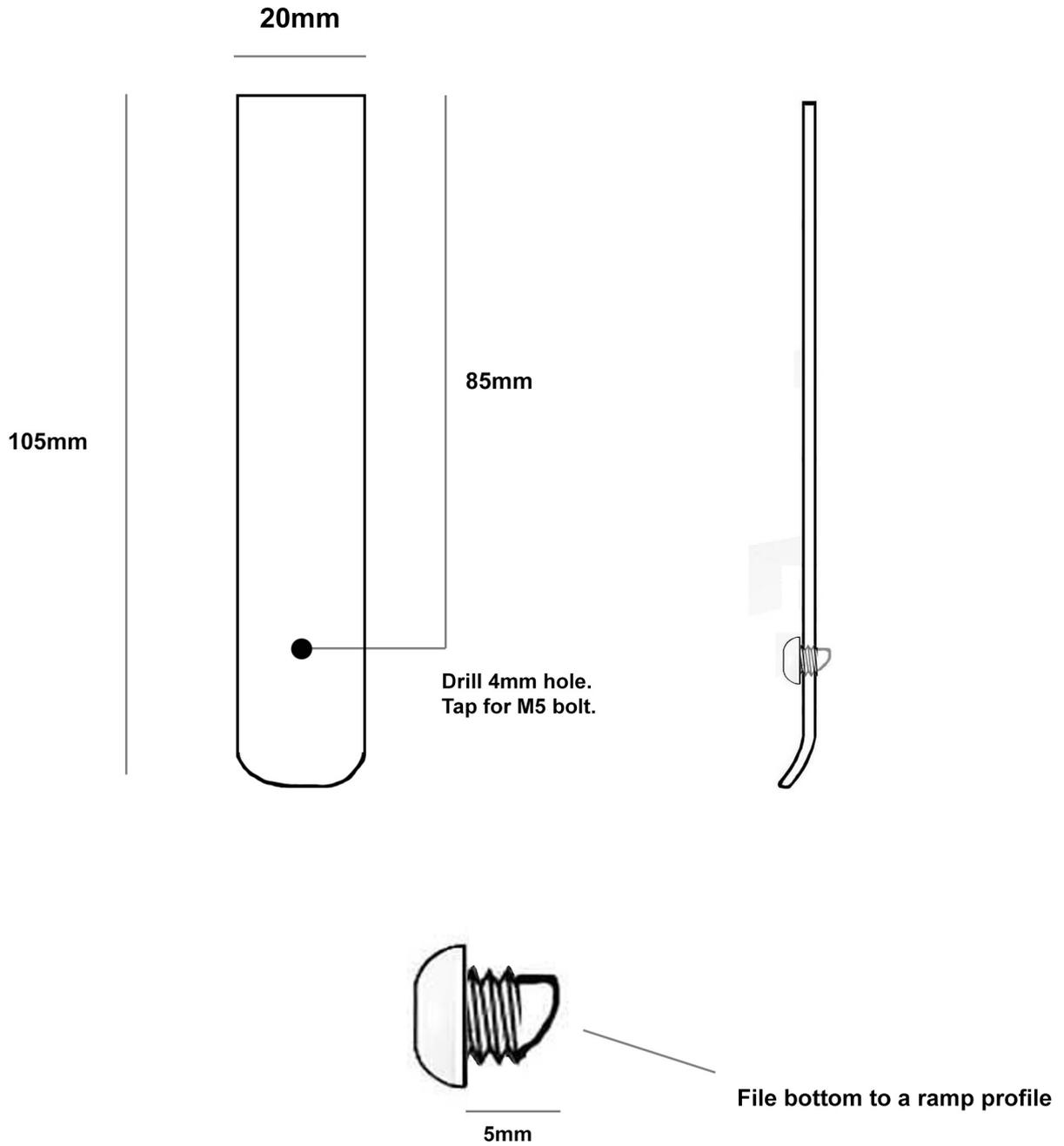


2 inches

Print on A4 paper

Magazine catch strip

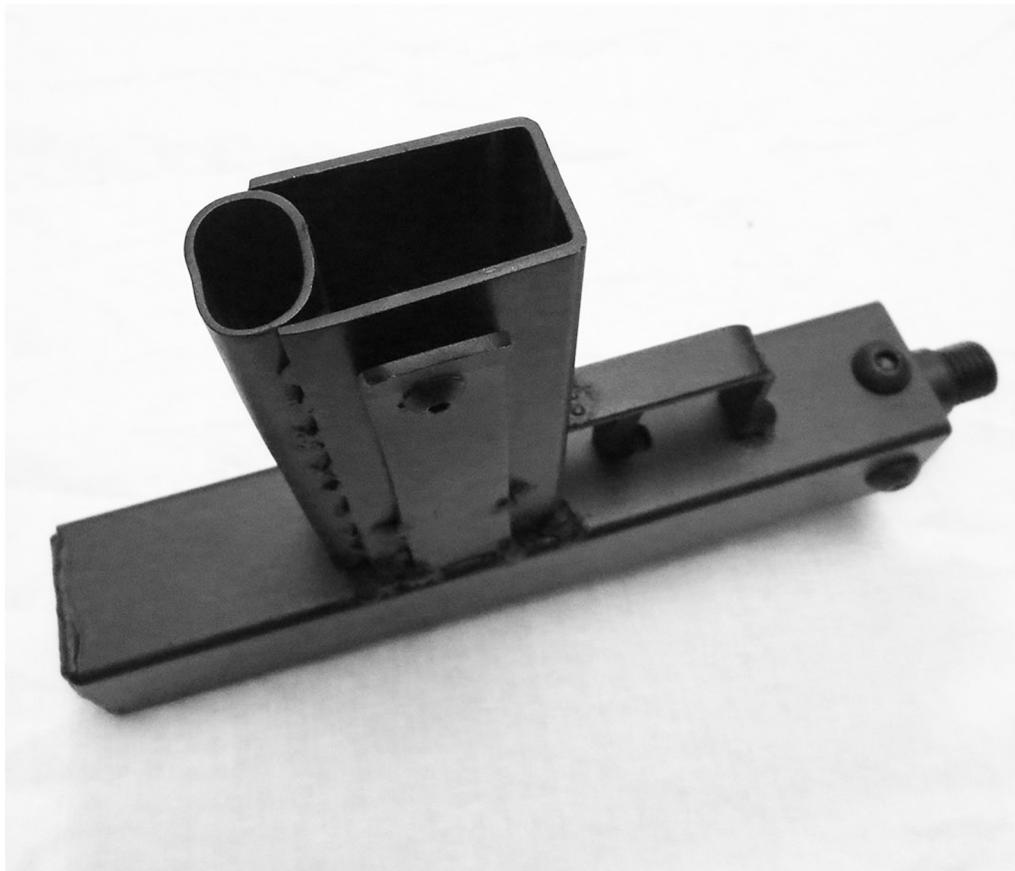
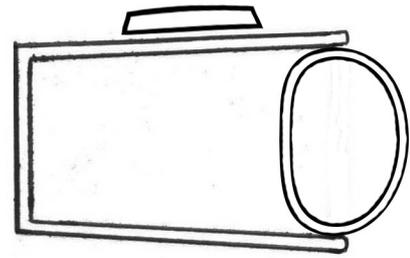
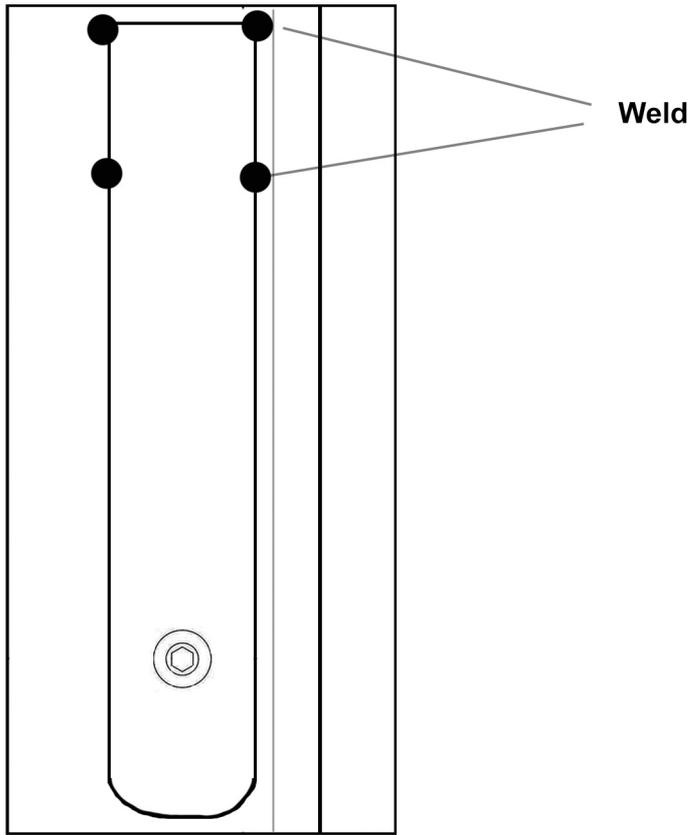
2.5mm thick, 3/4" wide steel strap / sheet

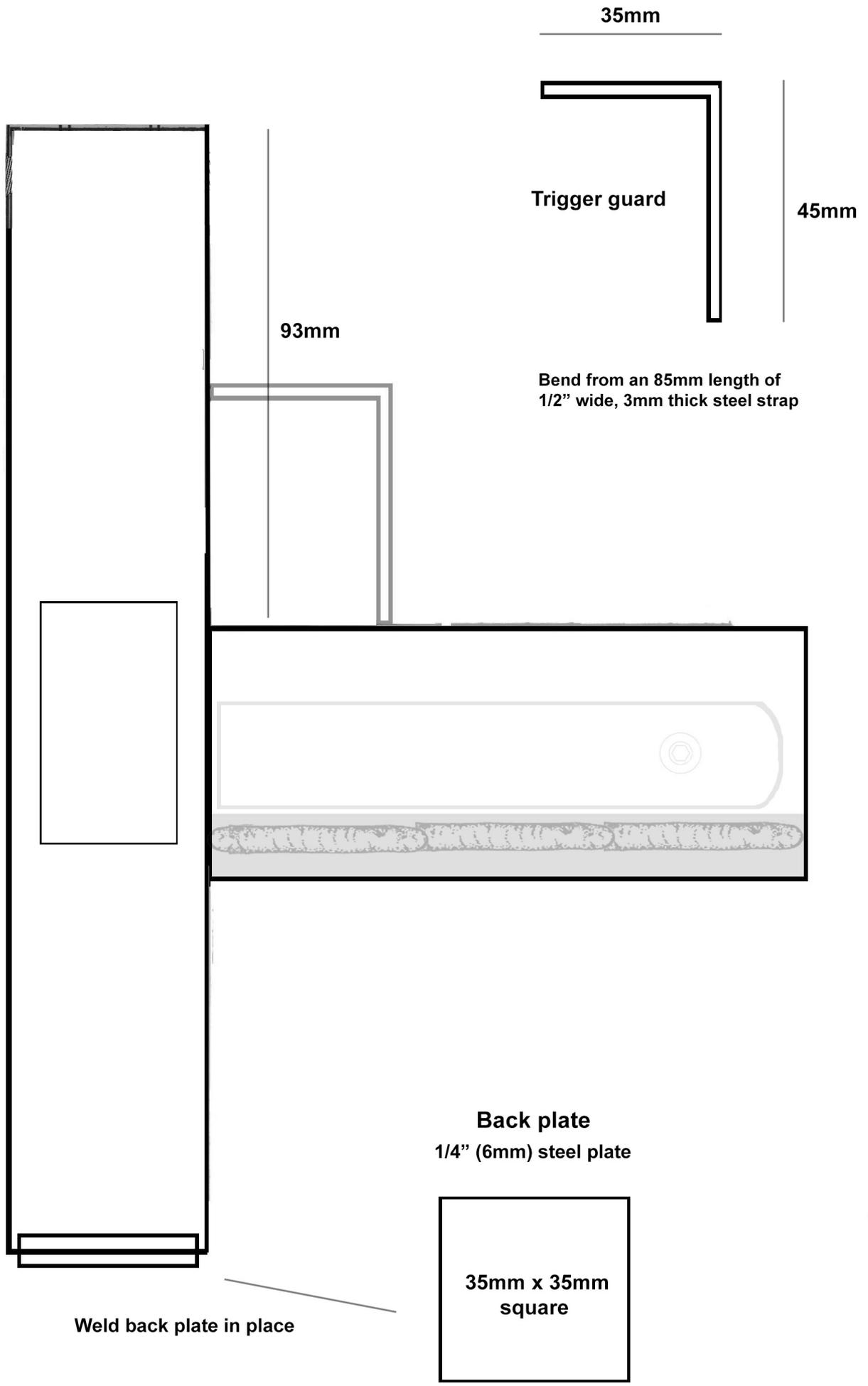


Insert magazine into magazine-well and align catch strip in the correct position before welding in place

2 inches

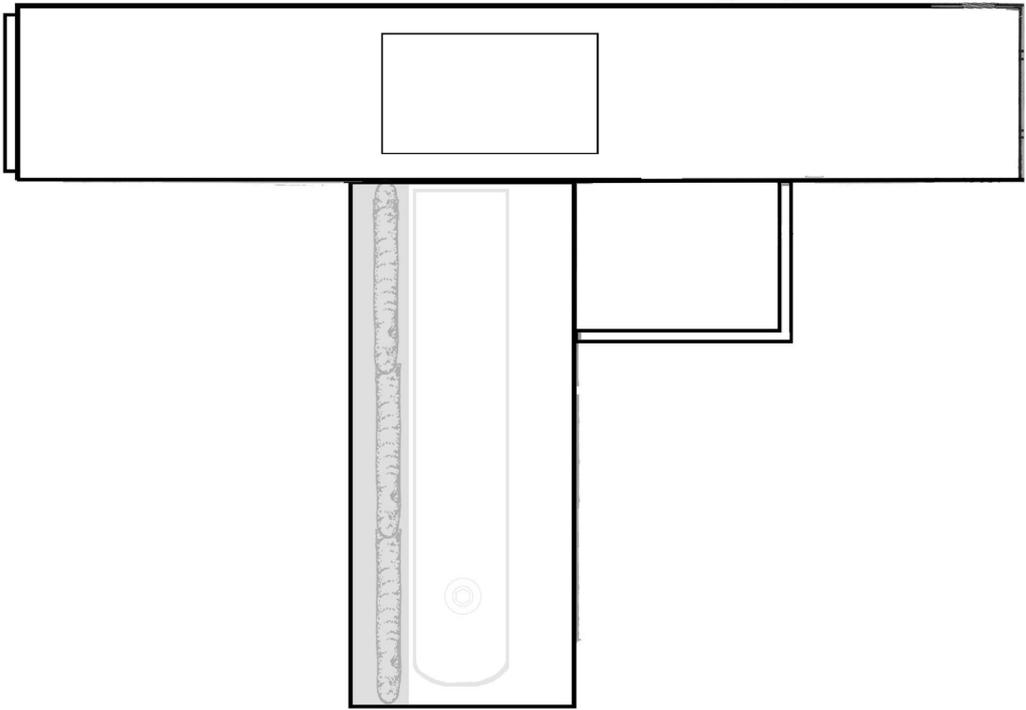
Print on A4 paper







213mm



139mm

Barrel

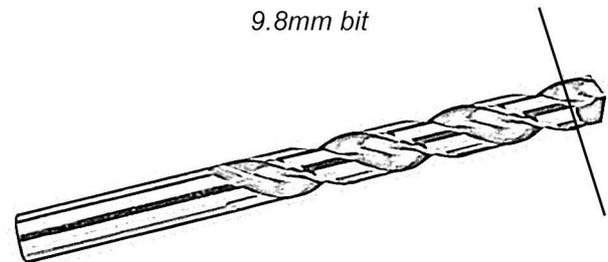
40mm length of 19mm (3/4") tube to match ID of collar.



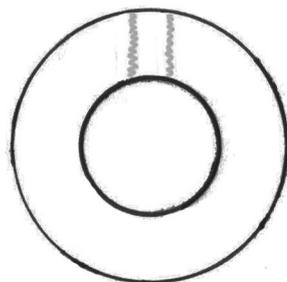
- Drill all the way through a 115mm length of 16mm (5/8") steel bar stock using an 8.5mm drill bit.
- Ream the bore to size using an 8.8mm Valve Guide Reamer.
(Alternatively use a length of 15mm x 3mm or 16mm x 3.5mm wall seamless steel tube.)
- Either push through a 9mm Luger rifling button using a hydraulic press or ream the bore to 9mm ID.
- Create feed ramp by removing material from the top of face of barrel leaving 5mm of barrel wall protruding from the bottom.
- Bevel chamber entrance using a taper cutting tool or large dia bit + polish to ensure smooth feeding and chambering of a round.
- Either chamber using a professional 9mm Luger Chamber Reamer if obtainable or by using a 9.8mm drill bit, drill to a depth of 15mm (Until cartridge protrudes 3mm from chamber).
- Ream the chamber to a final depth of 18mm using another 9.8mm bit. having been modified by removing its tip using an angle grinder.



Integrated feed ramp (Paramax Type)



Improved chamber reamer



3/4" shaft lock collar

- 35mm outer diameter
- 19mm (3/4") inner diameter

Once positioned, drill through grub hole screw until bit creates a shallow dip in 16mm tube. Apply loctite and tighten grub screw. Seal holes with JB Weld to permanently fix. Alternatively weld barrel in place.

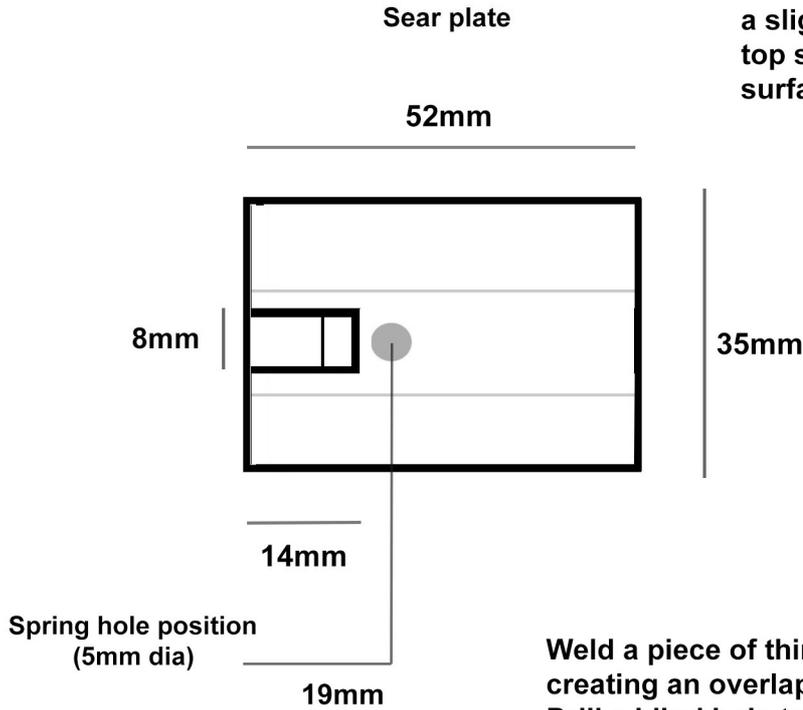
Retain collar in front of receiver via four M8 x 5mm bolts (Top bolt passing through front sight).

Alternatively drill a 15mm or 16mm hole though the center of a block of steel, 35mm x 35mm, 20mm in width.

Trigger & sear

1/4" (6mm) thick steel plate

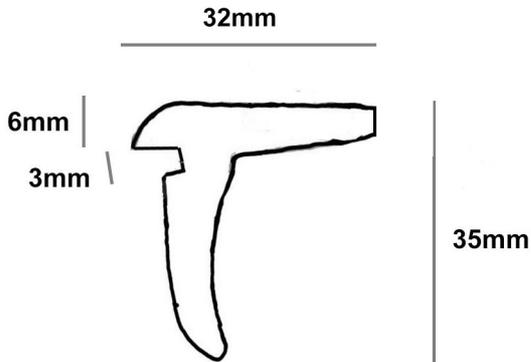
Harden



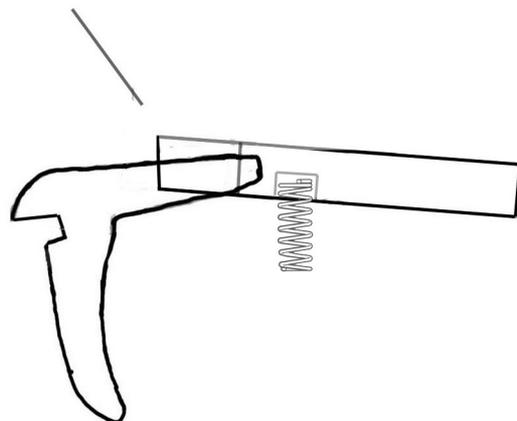
Use an angle grinder to scallop a slight bevel into the front end of the top surface allowing the front contact surface to lift up and catch the bolt.

Weld a piece of thin steel plate to bottom creating an overlapping 'lip' for trigger to contact. Drill a blind hole to house a 5mm wide, 12mm long compression spring at the front end.

Trigger template



File sear to a sharp angled edge

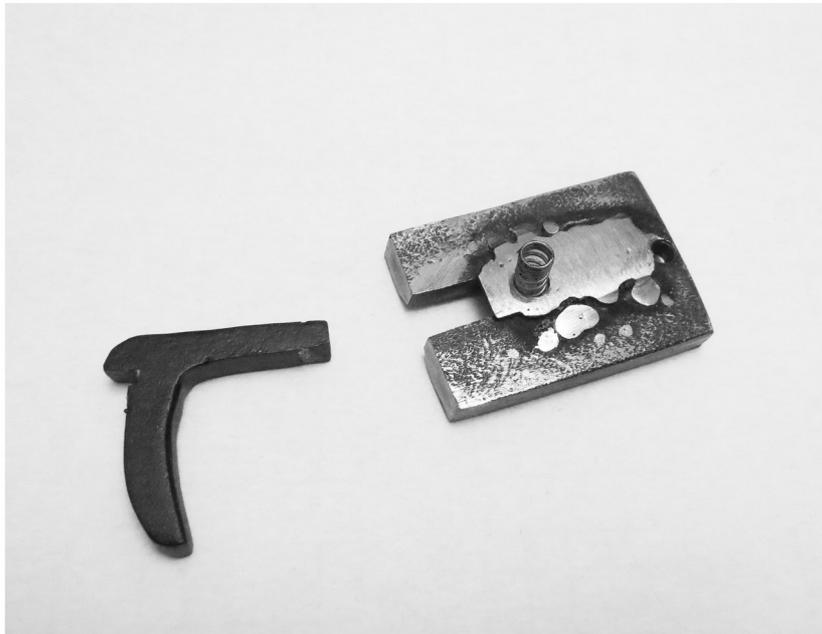


2 inches

Print on A4 paper



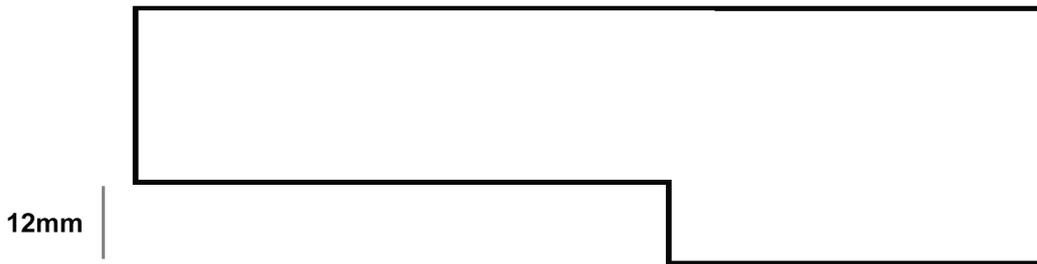
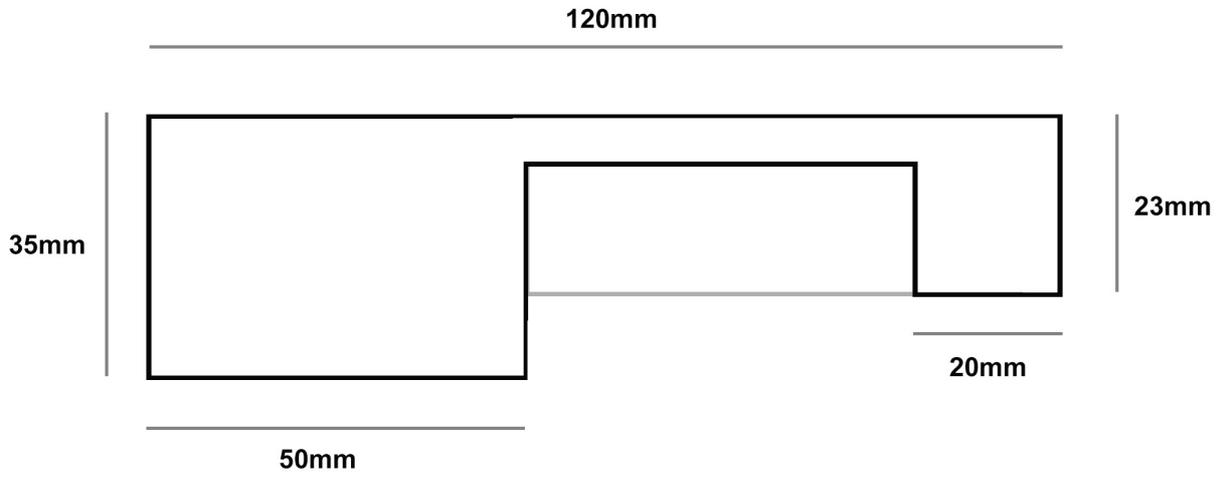
Trigger & sear (Top view)



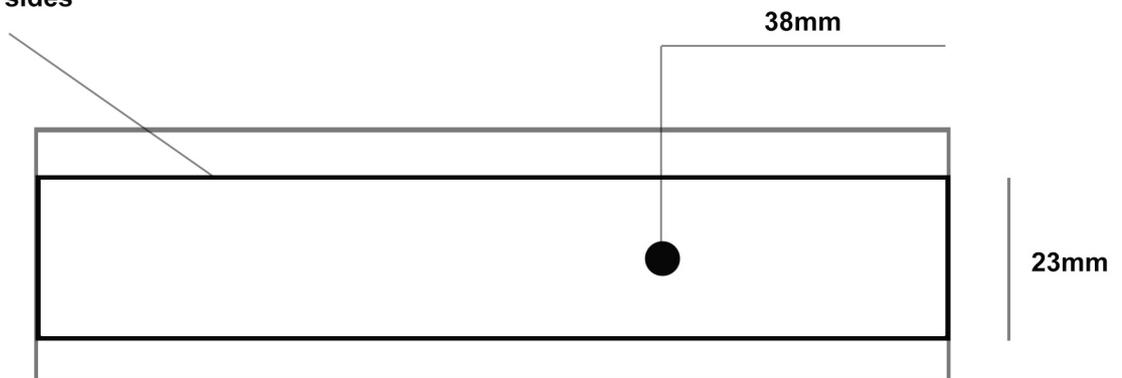
Sear (Bottom view)

Bolt body

Weld together from 3 pieces of 6mm thick (1/4") steel plate. Cut to profile after welding.



Weld along sides



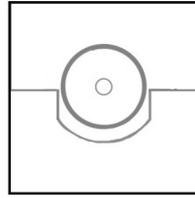
2 inches

Print on A4 paper

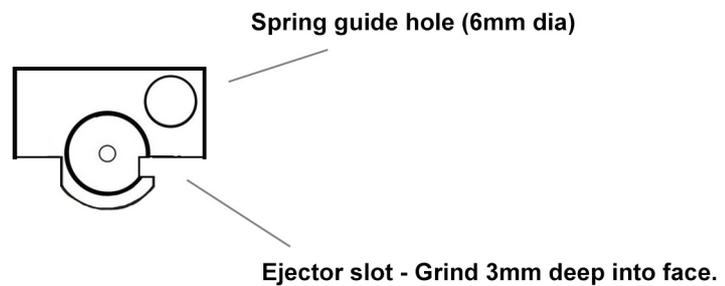
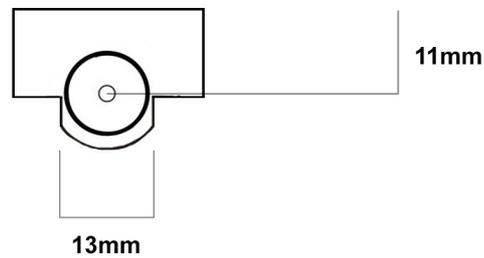
Bolt Breech Insert

Cut to shape from a length of 1" (25mm) dia square steel bar.

'Chain drilling' combined with the use of an angle grinder fitted with a 1mm slitting disc can be used to easily remove the marked shape. Use a magazine for reference throughout.



Drill the breech face 11mm from the top using a 10mm bit. Level flat using a 10mm bit with its tip ground flat until 3mm deep.



The firing pin consists of an 11mm length of 3mm dia drill bit shank epoxied in place and protruding 1mm (tip should be rounded).

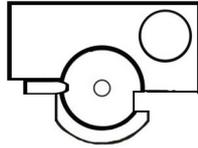
Using a belt sander, reduce overall width of bolt piece to 23mm.

2 inches

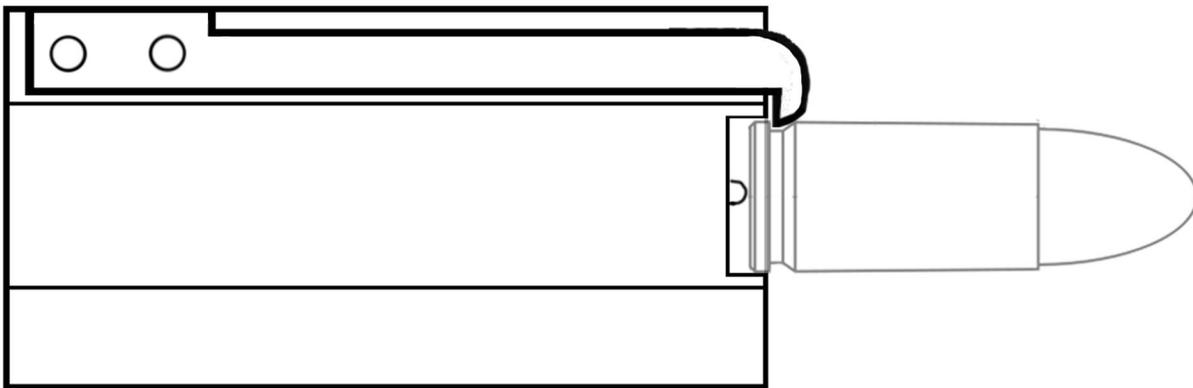
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Extractor (Optional)

Cut from a 5mm wide, 50mm length of 2mm thick spring steel strip



A width equal to the thickness of the rim of a 9x19 cartridge (1.27mm) should exist between the firing pin and the claw surface of the extractor. Verify using a cartridge before fixing in place.



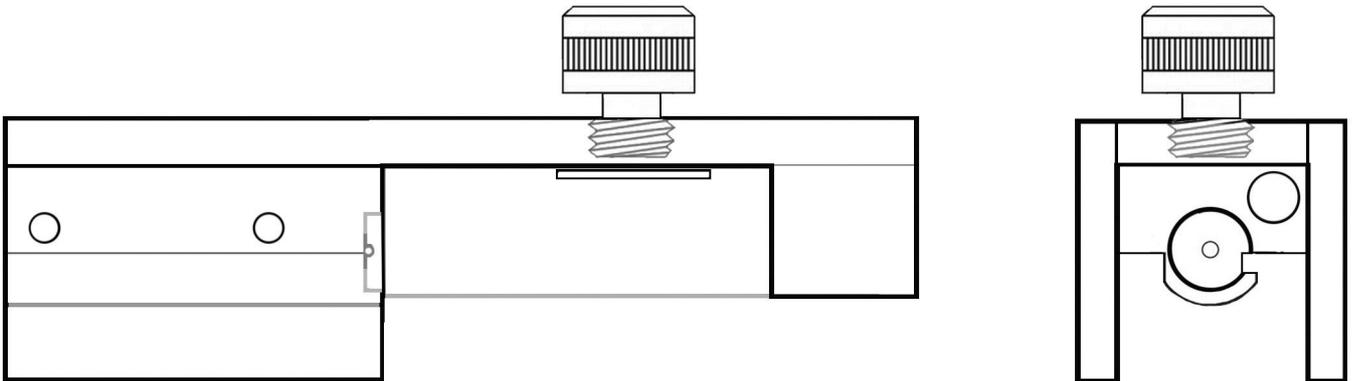
A 3mm deep recess to accommodate the extractor will need to be cut into the right side wall of the barrel's chamber end.

2 inches

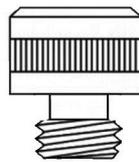
Print on A4 paper

Bolt (Assembled)

Weld at rear + drill & tap sides for 4 M5 bolts to attach breech piece. Grind off heads.



Cocking handle (M10 socket head bolt)

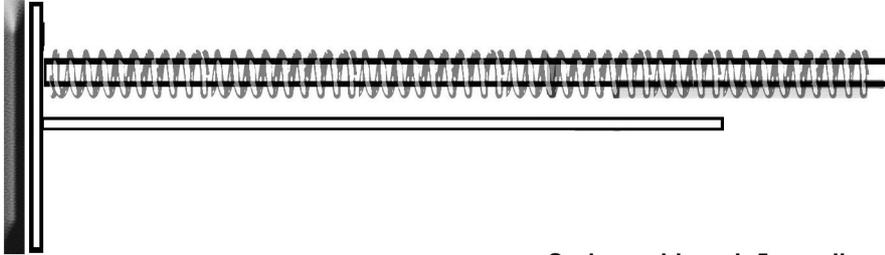


Create 'neck' using a drill press + file

Seal cocking handle hole in bolt by welding in place a piece of 1mm steel plate.

Recoil spring / ejector assembly

Recoil spring: Compression / 9mm OD, 110mm long



Spring guide rod: 5mm silver steel rod - 110mm long

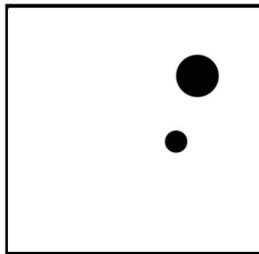
Ejector rod: 3mm tool silver steel bar - 90mm long

Buffer pad (Cut a 35mm square from 1/4" neoprene sheet)

Back plate

2mm thick steel plate. 35mm x 35mm

Template:



Drill through plate and weld or silver solder guide rod and ejector at back.

2 inches

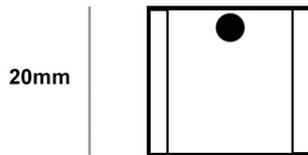
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Sights

Front sight

20mm x 20mm steel box section

4mm dia hole



Top



Side



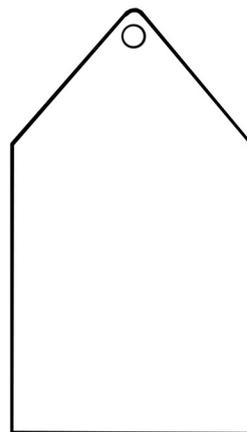
Front

Sight Post: Silver solder or tap in a 15mm length of 4mm dia steel round bar. The head dia of the top barrel retaining bolt may need to be reduced slightly to clear.

Rear sight

2mm mild steel plate

Sight hole: 4mm



56mm

32mm

Position flush with bottom of receiver and weld along sides.

2 inches

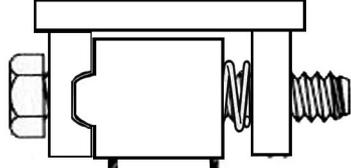
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2 inches

Print on A4 paper

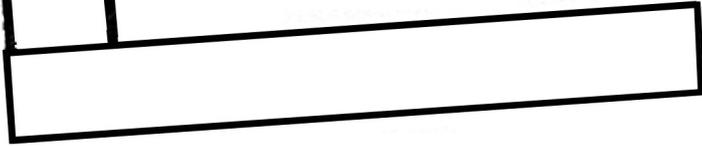
Side folding stock

Weld stock tube to left side of drum



Heat and bend to profile

16mm OD steel tube, 8" long



20mm steel square box section

Bracket - Weld together from 1/4" (6mm) steel plate

16mm dia steel round bar

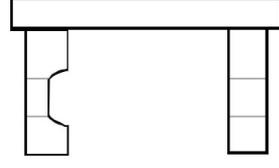
16mm

File sides down 3mm

6mm

20mm

35mm



Tap bottom lug



Additional Firepower...

