

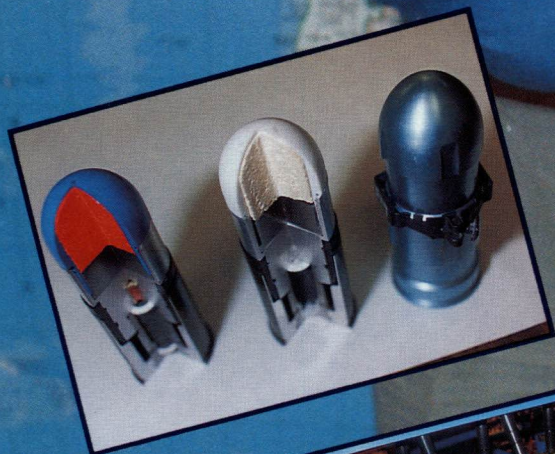
Machine Gun News

**The
Aircraft
Lewis**

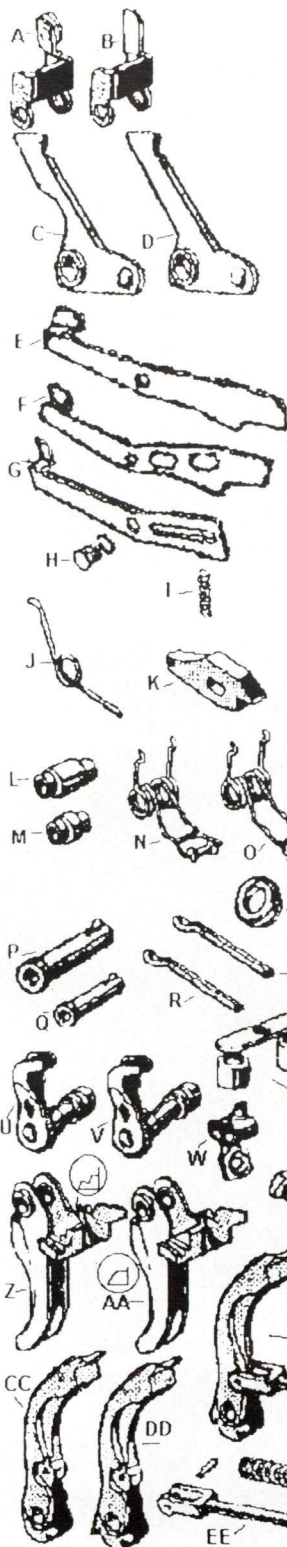
**SACO's MK19
Grenade
Machine Gun**

U.S. Rifle M14

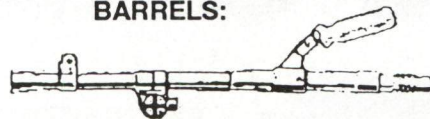
**.22 cal.
Maxim
Model 1910
Silencer**



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Steyr AUG, 42-rd	8	85.
Thompson 30-rd, good	35	22.
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THE MAGAZINE FOR FULL-AUTO ENTHUSIASTS

MACHINE GUN

N E W S

Volume 8 Number 12

May 1995



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On the Cover: President of Saco Defense Bruce Makas. Insets: 1. 40mm cutaways. 2. MK19 Mod 3's that have passed inspection and are ready to go. Photos by Dick Morin.

Machine Gun News is published monthly to serve as a forum for Class 3 dealers and machine gun enthusiasts. We feel it is important that dealers and collectors have a source for new products, news and information involving Title II firearms.

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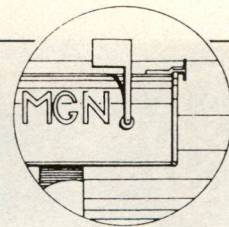
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Incoming



THANKS TO JIM

I was very saddened to see that the March issue is the one to carry the last "Tinkering with Thompson" column. This was always the first thing I read in your magazine. I thought that Jim Klodzinski did an outstanding job covering this SMG. Of all MG's and SMG's, the Thompson is my favorite. I read everything I can get my hands on about them. I find them out-and-out pure interesting history. In the state where I reside (Illinois), it is impossible to own one. The closest I can get is the AO 27A1 semiauto version. If I move to a different state (meant to read "freer" state), you can bet the first thing I will do is to purchase a Thompson. When I get the urge I can't resist any longer, I take a short "vacation" to Las Vegas, rent a Thompson and fire off a few hundred rounds. They are a blast (pardon the pun) to fire. It is also quite a thrill to go to Knob Creek and see them fired in the subgun matches. In closing, once again I will say thanks to Jim. He gave a lot of us useful hints and background on the TSMG. *MGN*-keep up the good work.

J.O.

Illinois

TWO GREAT PEOPLE TO DEAL WITH

After many months of reading articles written by Mark White of Sound Technology, I called him one day with various questions on suppressors. Before he could answer any of my questions, I was invited to come to his shop in Pelham, Alabama and see first hand.

I was on my way the following week-end. My friend and I set out on a Saturday morning and arrived about 11:00 A.M. When we arrived we were met at the door by Mark White and some of his favorite toys that he produces. We were given the grand tour of his shop, and even shown how he manufactures his suppressors. We even tested various of his suppressed Rugers. I was very impressed by his suppressors and his knowledge, but what was more impressive was his hospitality. Mark White is a nice person who is more than anxious to answer any and all questions.

We ended the day with a great shoot. I brought the machine guns, and he supplied the suppressors. It is very rare in this business to receive this kind of treatment. All dealers etc., should pattern themselves like this.

Another great person to deal with is Philip "Doc" Dater whom I have sold quite a bit of suppressors etc. He is more than willing to answer any and all questions that I throw at him. He is another great person to deal with. Both of these guys make great products, but what is more important is that they are there for support, questions, etc. My hat (if I wore one) goes out to these men for making my hobby and business more enjoyable. I can feel very confident when I sell their products. Thanks a million.

Bryan Y. Pritchard

Tactical Weaponry

RESPONSE TO: HOME PARKERIZING CORRECTIONS

I would like to respond to Mr. Souchik of Allegheny Arsenal Inc. He had written a letter "correcting" some mistakes in my article "Home Parkerizing." First of all I would like to apologize to Mr. Souchik for not mentioning his product as a supplier in the article. However, that article was written in August of 1994 and submitted that same month. I have looked through some of my old issues of *MGN* and cannot find Allegheny Arsenal's parkerizing kit advertised around that time period.

The term MANGANESE, as used in the article, was not intended to describe the exact chemical make up of the product. It is the description applied to the chemical by the *manufacturer* to identify the solution that will color the metal "black" or as I described it, "like the M16 finish" which it is.

Using WD-40 is also recommended by the *manufacturer* to stop the chemical process to the metal. The main reason being, in a spray form, WD-40 will get into many hard-to-reach places that may otherwise be overlooked. I agree with Mr. Souchik that WD-40 should not be used to lubricate guns.

Mr. Souchik states that the parts should be rinsed with water after being removed from the solution. The *manufacturer's* instructions with the products I used state: "OMIT RINSE, DRAIN EXCESS WA- (solution) DRY WITH AB- SORBENT CLOTH," "AFTER PARTS HAVE BEEN DRIED, DIP IN LIGHT OIL OR SPRAY WITH WD-40. WIPE EX- CESS OIL OFF WITH CLEAN, DRY CLOTH."

As I stated in my article, I had been parkerizing for several years using the pro- cedure described in the article with very good results.

I am sure that Allegheny Arsenal's parkerizing kit is a fine product that will produce good results, and I do like to pa- tronize *MGN* advertisers. I promise to try it in the near future, and if *MGN* is inter- ested in another parkerizing article, I would be glad to write one.

Regards

Frank Iannamico

INTERESTING PICTURES

I thought you might find these pictures interesting. They were in the back of a restaurant called Greasewoods Flats locat- ed in the Scotsdale, AZ area!

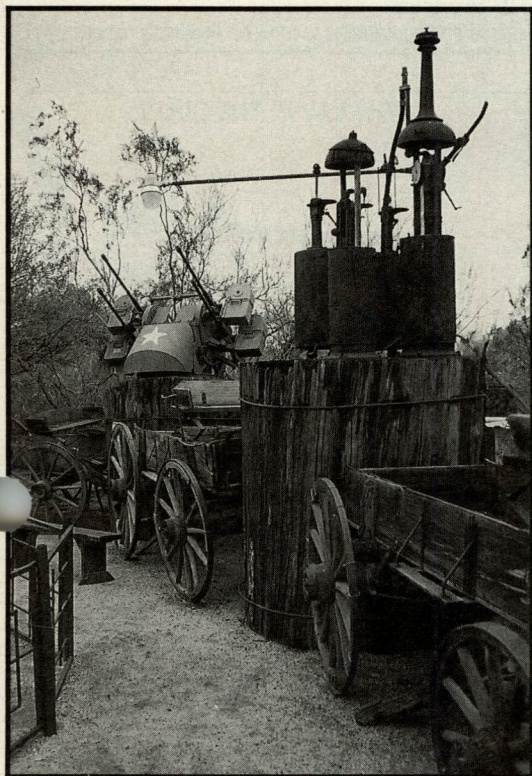
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Bob S.

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WILLIAM FLEMING

On 9 December, 1994, Bill Fleming re- ported to the Federal Correctional Institute in Texarkana, Texas, to begin serving the 46 month sentence that the Federal Court had handed down to him. He was convicted of some fraudulent transfers to evade transfer taxes, by transferring NFA firearms through a police department to "wash off" the tax. He is in medium security.

There is a lot of controversy over the Flem- ing case, with many comments being made about him being "railroaded" out of business. Mr. Fleming plans to write about his case in a future issue of *MGN*.

His wife, Kathy, has taken ownership of Fleming Firearms, Inc., and is following through with all of the current FFL projects including the .22 kits.

Anyone wishing to contribute to his legal de- fense, may do so by sending a check to them at:

William Fleming
7720 East 126th Street N
Collinsville, OK
Phone (918) 371-3624
Fax (918) 371-0404

Anyone wishing to correspond with Bill (he says he would appreciate the letters) may contact him at:

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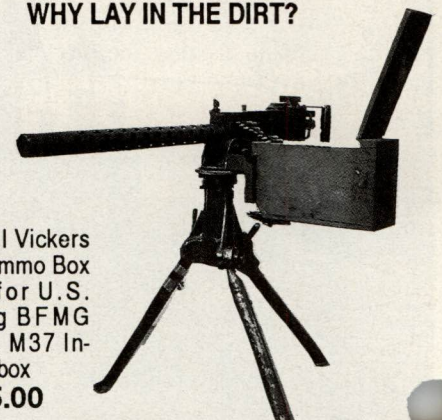


New manufactured all excellent G.I. parts.
Complete with tripod P, T, & E. Test fired
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\$5,000

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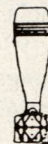


Orig. WW II Vickers
Tripod w/ Ammo Box
Adaptor for U.S.
Browning BFMG
17A1, A4, M37 In-
cludes one box
\$385.00

Quality Machine Gun Complete Parts Sets

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**U.S. 60mm inert
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Comp. w/fins
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10 for	\$100
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B	\$ 30
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Buttstock, .308 barrel, barrel jacket, bipod,
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	2/\$170
	3/\$250
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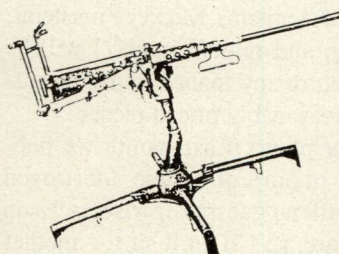
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.308 Chrome-Lined Barrel & Bolt Comp.
Set for Pre-Determined Head Space
.308 Only Feed Tray, New Cond.
.308 Complete Feed Slide Assembly
.308 Hard Chromed Reduced Orifice Booster Cone

U.S.G.I. M63 AA MOUNT

Not cut, in very good cond.
Comp. w/Ammo tray



\$825.00

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1. New unissued .308 IMI barrel.
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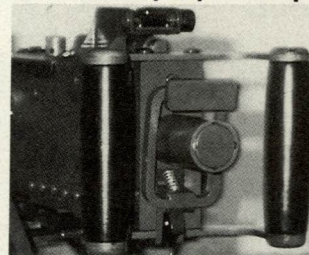
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Will modify your 1919A4 Top
Cover to use .308 Links .. \$ 65.00

Complete Top Cover modified
to use .308 Links \$150.00

These still function in 8mm & .30-06

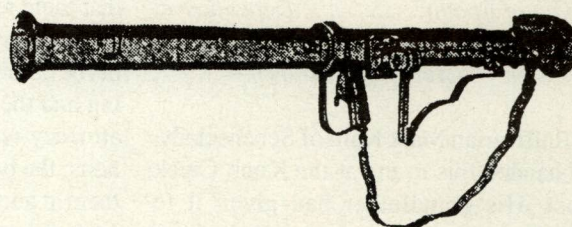
1919A4/1917A1 Comp. Space Grip Assembly



\$275.00

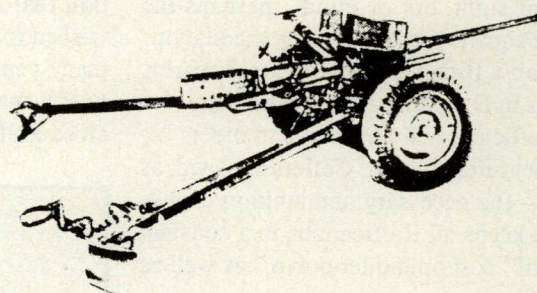
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Orig. Designed by us. Finest quality available.

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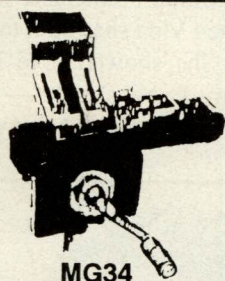


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**MG34
MG3-MAG .308**
Belt Loading Machine
New Cond.
\$350.00

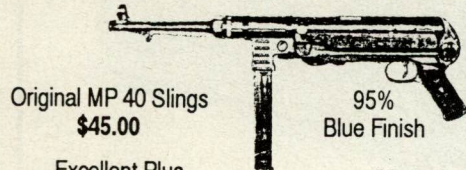
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FINEST CONDITION YOU WILL EVER BUY Original WWII MP40 Part Sets

GRADE A
\$550.00

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Original MP 40 Slings
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95%
Blue Finish

Excellent Plus
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Limited
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Sten Fully-Transferable Finished Receiver. \$350
All NFA Rules Apply.

CZECH MOD ZK 383



Less Bipod
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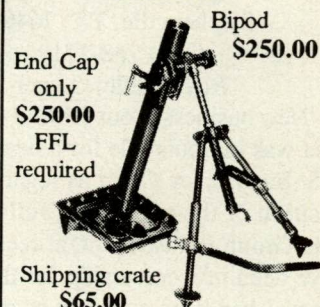
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quick change Barrel w/Bipod &
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With 2,000 links \$300.00

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FFL
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Raffica

by DAN SHEA

AS THE EONS AND ERAS GO:
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Conviction
Out of Spiritual Conviction.....Courage
Out of Courage.....Liberty
Out of Liberty.....Abundance
Out of Abundance.....Complacency
Out of Complacency.....Apathy
Out of Apathy.....Dependence
Out of Dependence.....Bondage
—Author....Unknown

Rafficarian Mark Kalil of Schenectady, NY handed this to me at the Knob Creek Shoot. His grandfather had given it to him....he just wanted to pass it on. In these times of compromising with the enemies of the Constitution, and our different Representatives urging us to silence, hoping that those same enemies will be sated with their victories and forget about us if we are "out of sight, out of mind," perhaps the above equation is worth some meditation.

Don't forget the Rally for Firearms Rights in D.C. on 4 June. I'll be there.

Rafficaria will now come to order:

Treasurer's report: Coffers depleted, as usual—the necessary ammunition expenditure keeps all Rafficarians in a constant state of "post-ammo let-down," as well as broke....

Old business: Info from David J. Mitchell in Colorado regarding the distressed member's request for information regarding the Leatherwood scopes...(4/95 issue MGN)...

Leatherwood Scopes

Box 111

Stephenville, TX 76401

(817) 968-2719

Roy Riddle, Owner

New business: Your faithful correspondent was in Louisville for a hearing of the U.S. Bankruptcy Court as regards the disposition of the registered, fully transferable Group Industries' Uzi receivers that have been in receivership for the last few years. I had been called in as an "expert" by one of Group's creditors to help estab-

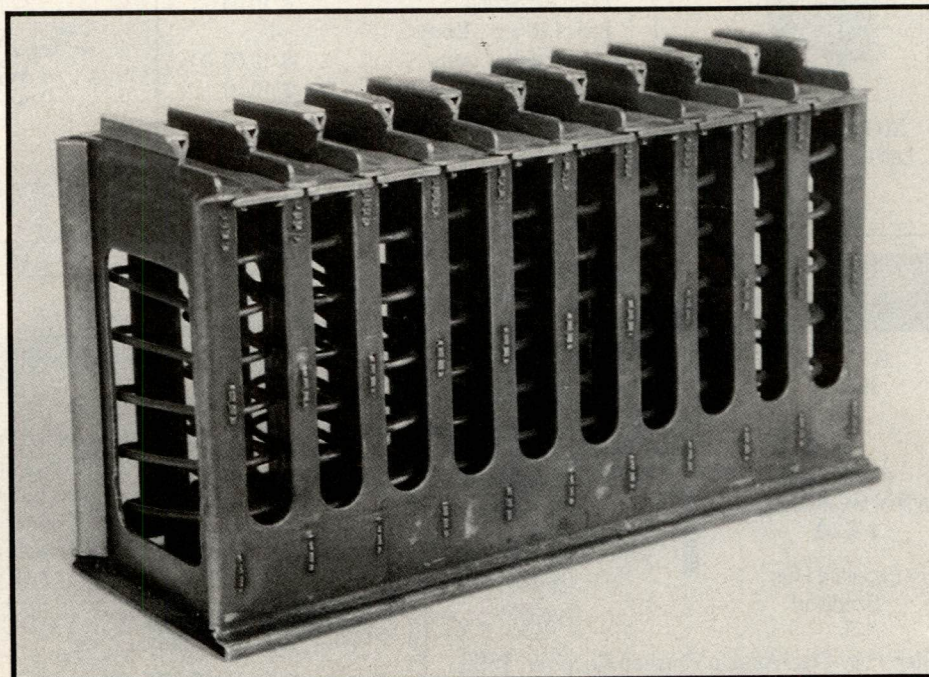
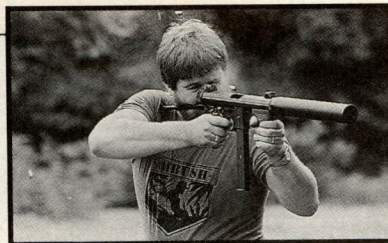
lish a real value of the 3326 (that's right, folks, three thousand, three hundred and twenty six UZI's) receivers. Readers of Raffica know that I hate the "expert" moniker, as I am only a Reasonably Knowledgeable Individual. (Further proof of that later in this column.) There are many complex issues involved in valuing these, not the least of which is the risk to the investor who buys them. After it became apparent that there was a large discrepancy between the perceived value from the perspective of the creditor who had requested the hearing and the perspective of the government attorney who is trying to recover for tax liens, the bankruptcy judge decided to sell them at auction, along with machinery, and 14,000 semiautomatic Uzi receivers that are "Post-94 ban" firearms. The auction must be held within the next few months. This will be the climax of the long running conflict between Group Industries Inc., and the old Automatic Weaponry, Inc., a situation that many of us in the industry had wished to see settled at the arbiter's table many years ago. It is driving a wedge between many of what was once a fairly close-knit group of people in the Class 3

business.

Machine Gun News will be carrying the "notice of sale at auction" as will *Shotgun News*. I will attempt to be there to make sure that the full story is recorded for history. There are some parallels with the MAC auctions in the Seventies—that here, twenty something years later, we would like to get the information.

More new business: On a personal note, I am doing some research on early firearms suppressors. I need catalogs, suppressors, Maxim, OSS, early experimentals, MAC items, Doc Dater items, Mickey Finn items, advertising, and related items. I will be happy to return any loaned items, or purchase any reasonably priced pieces.

Mystery photo: Last month we published a photo of some destroyed firearms...still no guesses or wisecracks on what they are, so I'll let it sit for another month and see who answers. This month's mystery photo gave me a severe case of brainlock. I just couldn't remember what gun it went to when Vida showed it to me at Knob Creek. She showed it to Bob Landies, who immediately said "———," because, of course, he knew what it was.



Mystery Photo. Photo by Dolf Goldsmith.

Same with Dolf Goldsmith. I was so embarrassed. (Not.) Anyway, those were the only two that got it, so, if you want to take a stab at it, write in to *MGN*...

Q I have an M16 carbine with the M4, 14.5 inch barrel. I know it's hard to find Colt barrels these days, but do you know of any sources which might be able to sell me an extra Colt barrel in the M4 configuration?

SRB

A Quality Parts in Windham, Maine, (207) 892-8068 had a supply of their own M4 barrels. The M4 barrel is a 14.5" shorty barrel that is heavier than normal and has a relieved section to allow for the mounting of the M203 40mm grenade launcher. If any of the parts suppliers out there have some Colt originals to offer, send a note in and I will mention it here.

Q I have been looking for 20-mmd TSMG magazines for some time now. A few weeks ago at a gun show, I saw some. The blue finish was almost gone and they were pitted and scratched. The springs felt weak. Many were wrapped in a greasy brown paper. Some were marked "Patented—Aug. 20, 1920" and below this was "Aug. 24, 1920—Jan. 11, 1921." Inside stamped "MSCO." Others were only stamped on the outside with "SWC." The four-round (as in bullet) indicator holes were all soldered closed. Why would someone go to this trouble? It was not even neatly done. The solder had run along the side of the mag in a lump. These magazines were \$20 apiece. Are they worth going back to buy?

Yours very truly,
Robin H. O.

A Your call on if they are worth going back for. Are you set up to blue them? I don't think that I would go \$20 each on them. Any conjecture on the soldering from the Rafficarians out there—was that one of your projects that went bad? Write in to us...

Q I have a question about the two types of AK muzzle brakes. One is for the AK-74 and the other is for the AKMS (short barreled AK, "Krinkov" etc.). It seems to me no one in the U.S. offers original ones for sale. Could this be due to the fact they might actually reduce the sound level by 10 decibel or two and are thus classified as "silencers" by the BATF? From looking at pictures, I find it hard to believe

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Reising 50	\$750
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Erma Emp	\$1750
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AR18	\$1900
MG34's	CALL
MG42's	CALL
Marlin MKV Aircraft	\$2000
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1927AC Colt Thompson semi-all orig.	CALL
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1928 Thompson (several)	\$3500
Marlin BAR	\$5000
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AOW - Any other weapon

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TRANSFERABLES

1919A4's in .308, last of the A4's—Chrome Trunnion	\$2500
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45 Uzi reg. bolt	\$500
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SAR 48 Ballistics with L1A1 lower	\$2950
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25mm Hotchkiss or Petaux with ammo	CALL
(Several \$3500-5500)	

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55 Boys	\$2500
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Solothurn S18-1000 Beautiful	\$7500
50mm Russian Mortar	\$750

FIREARMS

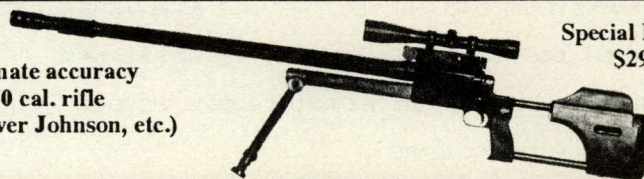
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the AK-74 brake reduces the sound level at all, in fact, the opposite probably happens. On the other hand, the "Krinkov" might play a similar role to the "moderator" on the CAR-15. The CAR-15 moderator was designed to reduce the sound level to that created by the M193 cartridge fired through a regular 20-inch long M16 barrel. What do you know about these brakes and can you print "section" views of them in *MGN*?

JR

A ATF considers the reduction of two decibels or more to make a device into a "Sound Suppressor" or "Silencer," requiring taxation and registration under the National Firearms Act. I do not believe that the "Krinkov" reducer does that. As far as the marketing of these muzzle brakes, there are a number of advertisers who claim to have copies, but I haven't seen the originals marketed yet. If any of you have the information on where these are being sold, send it in. I do not have any cross sections either.

Q I am a Class 3 dealer and MG "tinkerer" in Athens, GA. Regarding the letter in March 1995 *MGN* from Robert J.N. re-

questing information on a scope mount for his 1919A4. I am in the prototype stage of developing a mount for this application. I have fabricated a bracket out of 1/4" steel plate with three mounting holes. The plate curves over the top of the receiver and provides a mounting point for a Weaver, Redfield, or Leupold type scope base. To save time so I can test fire, I have painted the unit black, but we plan to offer the unit parkerized to match the weapon.

I am installing a one power red dot-type scope to provide a large range of eye relief so that the unit can be used with my spades or shoulder stock. I am installing my prototype on my 1919A4 tonight and plan to test it at a local "Knob Creek Warmup Shoot" we're having on March 25th. I may have units in stock for sale by the time I get to KC. I'll be on Lamar Cheatham's position to the right of John's mini-gun setup.

The other items I'm working on are custom fit, military type, pine carry boxes for our belt feds. I got tired of carrying my expensive weapons wrapped in an old blanket. I should have them available for 1919s, 1917s, M2 .50s, and M60s. (By the way, I just received my first "pig" last Friday, and

I love it!) We can stencil weapon and owner ID on the carry crates. They are big enough for the weapon, tripod, T&E, spare barrel, and a few parts. They should retail for \$125 to \$200 for a .50 crate. I won't have these ready for Knob Creek, but wanted to let you know about them. I think they would be a good add-on sale item for anyone who spends three to five thousand on a belt-fed.

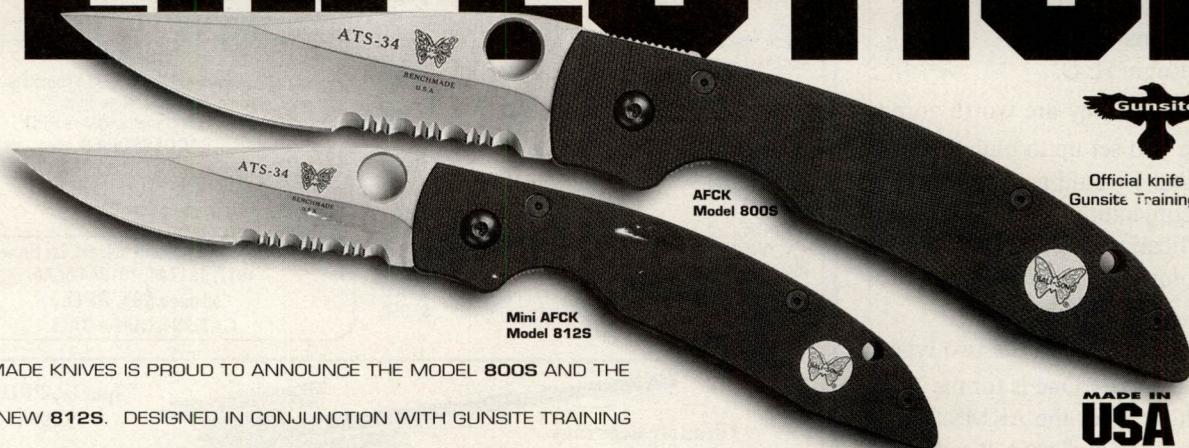
Call me if you want more info or have any suggestions. I enjoy your writing in *MGN* and constantly refer to the *MGDB* for reference. Hope to see you in April.

Dudley Calfee
259 Wynburn Ave.
Athens, GA 30601

A I examined the 1919 scope mount at Knob Creek, and it looks good. I plan to purchase some and see how they market to my regular customers. Any interested parties can contact Dudley at (706) 549-0381 or fax at (706) 549-0381.

It's a good business shot for you dealers, and I like the idea of someone marketing carrying boxes for the odd shaped belt feds. Good luck with it. And thanks for the blatant plug for the *Machine Gun Dealers Bible*; the 1995 updated version is now

PERFECTION



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being shipped. (Dan, was that necessary?
—Vida) (Vida, I think so. —Dan)

Q In your March, 1995 Raffica column,
a Robert J.N. inquired about optical
mounts for the 1919A4 BMG. Dan, I have
been making and marketing (in a small
way) those mounts for two years now.
Our mount is extruded, using metal ex-
trusion techniques, machined and hard
anodized coated. The "key," that fits into
the slot on the side of the receiver, is made
of hardened steel. The "key" is held in
place by small Allen bolts and can be re-
versed to allow the mount to place the op-
tical sight either over the receiver or on
the left side (left side plate) of the BMG.

The mount is made of one piece of
aircraft-grade aluminum and has Weaver-
type slots cut on the top.

Although any optical device can be
used that has Weaver-type "rings," we
suggest the 50mm (2 inch format) red dot
optical sights that allow the red dot to in-
crease or decrease in intensity. For true
exotics, two mounts can be placed to-
gether allowing a night vision device on
the side and a red dot optical sight over
the receiver.

Mounts are in shrink wrap on cards.
Let your readers know.

Sincerely
Don Austin Wagenknecht
D.A.W., Class II MFG.
300 Ford Center
420 N. 5th Street
Minneapolis, MN 55401
(612) 860-3435

P.S. Photos & promotional literature
available upon request.

A Seems like this is the month for 1919
scope mounts...I suggest to the dealers
that they look at both of the above offer-
ings and try them for marketing. I have
had a number of dealings with Don, and
don't hesitate to recommend trying his
products.

Q What's wrong with the Ruger AC556?
They advertise at not a great deal more
than a Mini-14/30! This amazes me. I'd
like an MP5 with Navy configuration. My
limited research indicates that I could
have five Rugers for the same cost!?!
Mike L.

A Sigh. What's wrong with the AC556?
Other than it being made by Bill Ruger,
who is an apologist for the anti-Second
Amendment crowd, any analysis is go-
ing to be pretty subjective.

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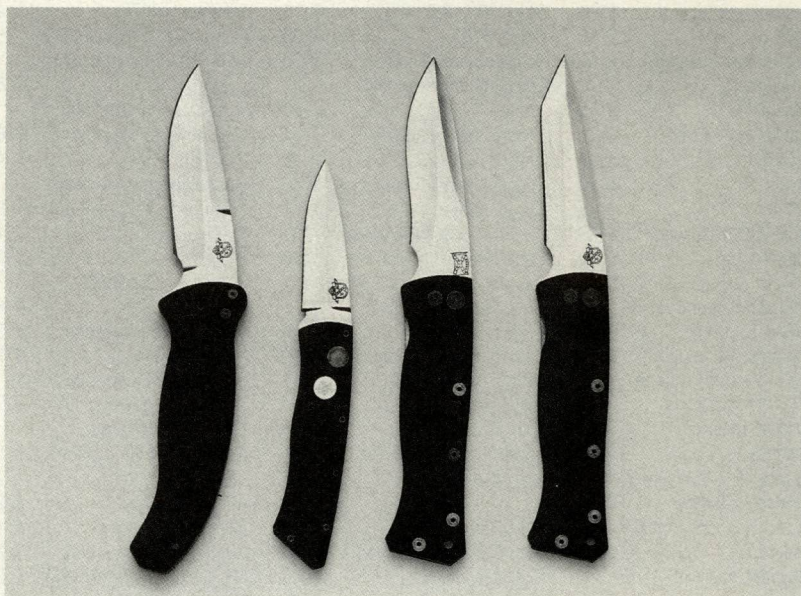
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(C)

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Barrel Assy 20" A-2, 1 in 7, chromed, new G.I. . . . \$165.	Bolt, stripped, S.A. . . . \$ 40.	Barrel extension \$ 40.
Barrelled upper assy. above barrel on complete G.I. A	Bolt, stripped, Winchester . . \$ 55.	Bolt, .30-06 or .308, new, stripped \$ 85.
2 upper with handguards, flash hider, gas tube . . . \$390.	Front handguard, new birch . . \$ 18.	Bolt, M-37, new, stripped . . \$ 60.
Bolt, new complete \$ 50.	Hammer, Winchester \$ 20.	Driving spring \$ 10.
Bolt carrier, new stripped . . \$ 60.	Op-rod spring, new \$ 6.	Extractor, new \$ 45.
Bolt carrier assy. unassembled \$115.	Safety, G.I., S.A. \$ 15.	Flash hider, M-7, for 1919 A-6, internally chromed, .308 \$ 85.
Bolt carrier assy. factory assembled \$130.	Safety, WRA \$ 30.	Front & rear spacer, .308, G.I. new (for pair) \$ 60.
Buffer, G.I. \$ 20.	Scope mount, M-1 D \$ 75.	Lock frame \$ 45.
Buffer tube \$ 20.	Trigger guard, Winchester, milled \$ 30.	Muzzle bearing, internally chromed, .308 or .30-06 . . \$ 50.
Buttstock A-2, (w/spacer) . . \$ 45.	Trigger guard, unmarked, milled \$ 20.	Spacer, 8mm \$ 45.
Charging handle \$ 20.	Trigger housing, comp., S.A. \$ 55.	Trigger \$ 25.
Flash hider, A-2 \$ 8.	Trigger, winter \$ 7.	.50 B.M.G.
Forward assist, round or teardrop, complete . . . \$ 16.	M-1 Carbine	Bolt, stripped \$ 85.
Handguards, A-2 (round) . . \$ 25.	Barrel, Rock-Ola, exc. + . \$120.	Carry handle excellent . . \$ 35.
Lower kit (every replacement part to complete your lower receiver) . . \$ 60.	Barrel, non-import, Inland or B.A., stripped, original finish \$ 90.	Rear sight, exc. \$ 75.
Pistol grip A-2 \$ 8.	Bolt, round or flat, comp. . . \$ 60.	Ruptured cartridge extractor \$ 8.
Upper receiver A-2, stripped \$105.	Disconnect block \$ 15.	Spade grips, used complete \$175.
Upper receiver flat top . . \$140.	Push safety, unmarked . . \$ 10.	Magazines
Upper receiver early Colt A-1 (without F.A.) \$ 90.	Slide M-2, G.I., new \$ 75.	AK-47 Soviet 40-rd., new . . \$ 50.
M-7 bayonet, new (w/o scabbard) \$ 30.	Trigger housing M-2, G.I. stripped \$ 85.	AK-47, 75-rd. drum \$ 95.
M-14	M-60	AR-15, 30-rd., new \$ 20.
Buttplate assy. new \$ 45.	Assault pack, 100-rd . . . \$ 22.	AR-15, 30-rd., used \$ 15.
Buttplate assy. used \$ 25.	Barrel, complete w/bipod . \$245.	AR-15 Colt, 20-rd., used . . \$ 20.
Flash hider, G.I. \$ 55.	Bolt, stripped, new \$ 45.	AR-15, 120-rd. drum metal \$120.
Front sight, N.M. \$ 12.	Bolt, complete, new \$ 85.	H&K 91, used, 20-rd. steel . \$ 35.
Gas cylinder, new \$ 37.	Feed tray hanger \$ 35.	H&K 91, new, 20-rd. alum. . \$ 45.
Hammer, H&R \$ 25.	Hanger, E-3 \$ 65.	H&K 91, new, 30-rd \$ 60.
Hammer, TRW \$ 25.	Op-rod, new standard . . . \$ 50.	H&K 93 .223, 40-rd., new . \$ 70.
Rear sight base, N.M. . . . \$ 40.	Op-rod, new E-3 \$ 80.	M-1 carbine, 15-rd. new G.I. \$ 10.
Rear sight aperture, N.M. . \$ 25.	Pintle, platform or gooseneck \$ 60.	M-1 carbine, 15-rd. Winchester \$ 12.
Trigger guard \$ 16.	Sear, new \$ 12.	M-1 carbine, 15-rd Rock-Ola \$ 15.
M-6 bayonet, new (w/o scabbard) \$ 60.	Top cover, M-60 E-3, new, stripped \$180.	M-1 carbine, 30-rd. new . . \$ 30.
M-203	M-79	M-14, 20-rd. commercial . . \$ 25.
Barrel, new, stripped . . . \$110.	Bore brush, new, 40mm . . \$ 10.	Mini 14, 30-rd., blue \$ 30.
Extractor, new \$ 15.	Buttstock, new, walnut . . \$ 50.	SKS, 30-rd. metal \$ 30.
Forearm, new \$ 25.	Extractor, new \$ 50.	Sten, 9mm, 30-rd. \$ 9.
Front sight, new complete . \$ 45.	Firing pin, new \$ 8.	Thompson, 30-rd., new G.I. \$ 11.
Quadrant sight, new \$ 30.	Forearm bracket, new . . . \$ 40.	Valmet, .223, 40-rd. new . . \$ 75.
Safety, new \$ 25.	Rear sight, complete, new . \$250.	
Sear, new \$ 25.	Rear sight, demilled, cut one time in frame. All other parts ok \$125.	
	Safety actuator \$ 35.	
	Safety spring, new \$ 7.	
	Trigger, new \$ 30.	

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1. The AC556 is an "assault rifle," while the MP5 is a "submachine gun." They fulfill entirely different tasks in the military or law enforcement requirements. There is no valid comparison on this level. The Ruger would more aptly be compared to the M16, FNC, AK-47, HK33 and Beretta AR-70, all "assault rifles" that are in the same class. This comparison would fill several books.

2. As an all-around select-fire rifle for the shooting enthusiast, it's not a bad choice. In .223 caliber, with safe-semi-3 shot and full-auto selections, it can be a pleasant gun to shoot. They are ammo friendly, easy to clean (not quite as easy as an M16) and lightweight. The lines of the AC556 are slim and very conventional, allowing easy storage and carrying. There are a number of variations, with folding stocks, stainless or blue finish, and bayonet lug as being the defining characteristics.

Q When is somebody going to start making a .22 cal. and 9mm conversion kit for all of our grease guns? I would love to find a low cyclic rate .22 cal subgun.

J.W.

A Medea Corporation, listed in previous Raffica notes, made the M3A1 in 9mm .45 and .22. I do not know their volume of production, and have never seen the .22. Remember that the manufacturers are motivated by sales ability. How many grease guns are there out there, anyway? Are there enough to entice a manufacturer to market a subcal kit? I am sure that there are enough in the world market, but would it sell, and would there be enough demand on the U.S. market to pay the prototype work and tooling costs? I think this is going to be a tinker's toy. And, yes, I would probably buy one.

Q As we say in "Aussie" G'day Dan. You're absolutely right in your Feb. '95 column that the AR-10 info. We are getting "Raffica at its best." You see I am an AR-10 owner and fan (Ser. No. 000832) fully licensed and that's no mean feat here these days, and have been looking for parts for some time. I have contacted both Mr. Martinez and Mr. Pikula and am looking forward to some good results.

I will be in the USA in May for the "Bianchi Cup" and hope to bring back some "goodies" with me.

Anyway, thanks for a good mag and

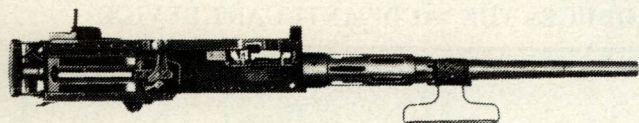
Continued on page 57

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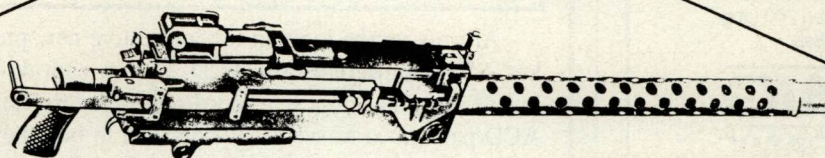
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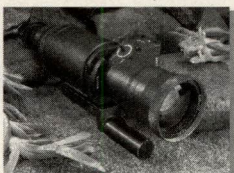
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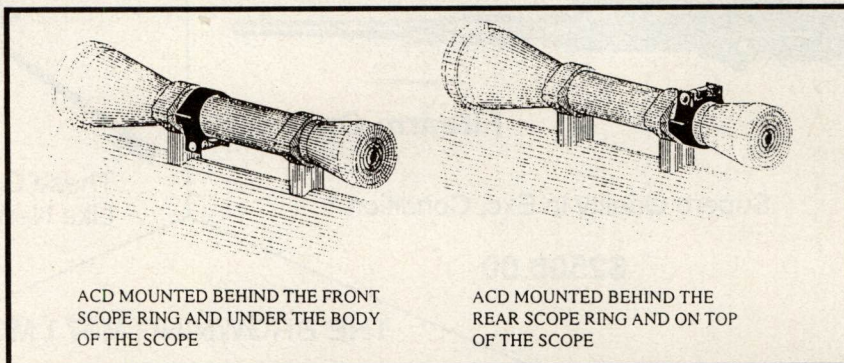
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What's New

by CHRIS A. CHOAT

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Always on the lookout for innovative new products for the shooting market, MWG introduces the ACD, an anti-cant device that is simple in design but deadly in accuracy. According to Ned Scheer, Operating Manager, "The ACD performed so well that I decided to buy the company that made it!" His enthusiasm for the ACD has been echoed by outdoor writers evaluating its performance as well as competitive shooters who attribute their success in a large part to it. The ACD is a simple, carpenter grade bubble level mounted in an aircraft-quality, two-piece anodized aluminum scope ring that mounts in minutes without special tools. The 1/2 oz. device, when properly installed, on a rifle, shotgun or pistol will not shift under recoil. It allows the shooter to visualize and make adjustments for cant (rotation of a scope's crosshairs off a true vertical/horizontal plane). This is critical for long distance accuracy. At 1000 yards, 6 degrees of cant (visualized as 1 minute on the face of a clock) moves the bullet impact 55 inches from point of aim. Installed on a properly mounted rifle or pistol scope, the ACD is sensitive to canting of only 1/8th degree! The ACD mounts in minutes, using only an Allen wrench and can be placed behind the front ring and under the body of the scope or behind the rear scope ring and on top of the scope. It is available in matte black or silver in 3/4", 1", 26mm or 30mm sizes. For more information contact: Ned Scheer at MWG Company, P.O. Box 971202, Miami, FL 33197. Phone: 1 (305) 253-8393. Fax: 1 (305) 232-1247.

G&L "HOT STUFF" 9MM AMMO

G&L Arms of Williamsburg, VA, has just introduced a new 9mm ammo that they will be distributing. The new ammo is called G&L "HOT STUFF." The ammo is 9mm loaded with 124 grain FMJ bullets at +P velocities. They feel that this will be "THE" 9mm ammo for competitors and other serious users. The new ammo will be sold in 150 round boxes for \$29.00, or a 900 round case (6 boxes) for \$165.00. Both prices are plus shipping. (Ed. Note: I have tried this ammo and it is exceptional, just as all the G&L Arms ammunition.) For more information contact: George or Laurie at G&L Arms, 6064 Mooretown Road, Williamsburg, VA 23188. Phone: 1 (804) 565-2820.

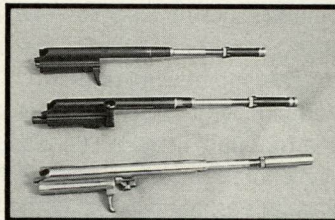
H&K NEWS RELEASE: FBI ADOPTS MP5 10MM SUBMACHINE GUN

On September 30, 1994 Heckler & Koch, Inc., of Sterling, VA, was awarded a 1.92 million dollar contract to deliver 1,636 MP5/10 10mm submachine guns to the U.S. Federal Bureau of Investigation. Heckler & Koch, Inc., is the U.S. affiliate of the German firearms manufacturer Heckler & Koch GmbH, owned by Royal Ordnance plc., a division of British Aerospace Defense. The MP5/10 submachine gun is a product-improved variation of the famous 9mm MP5 submachine gun and was developed especially for American law enforcement users. The FBI conducted extensive and rigorous testing of the MP5/10 for over two years before selecting it as their new submachine gun. They have used the 9mm MP5 since the early 1980's. The MP5/10 submachine gun provides increased range, accuracy and terminal ballistics compared to submachine guns in other pistol calibers. The MP5/10 was designed to meet the requirements of U.S. law enforcement users for a compact, accurate and reliable firearm capable of firing the highly effective 10mm auto cartridge. The new submachine guns are chambered for the 10mm auto cartridge and feature a number of user-inspired improvements, including a bolt catch that holds the bolt rearward when the magazine is empty. A threaded muzzle for the attachment of a screw-on sound suppressor and high strength synthetic magazines are also standard on the new MP5/10 submachine guns. The guns will be equipped with "0,1,2,S" trigger groups allowing safe, single shot, two-round burst and full-auto modes of fire. For more information contact: Jim Schatz, Heckler & Koch Federal Operations Department, 21480 Pacific Blvd., Sterling, VA 20166. Phone: (703) 450-1900. Fax: (703) 450-8160.



NEW PRODUCTS FROM M.A.D.I. ADJUSTABLE CYCLIC RATES FOR THE AK, VALMET AND GALIL

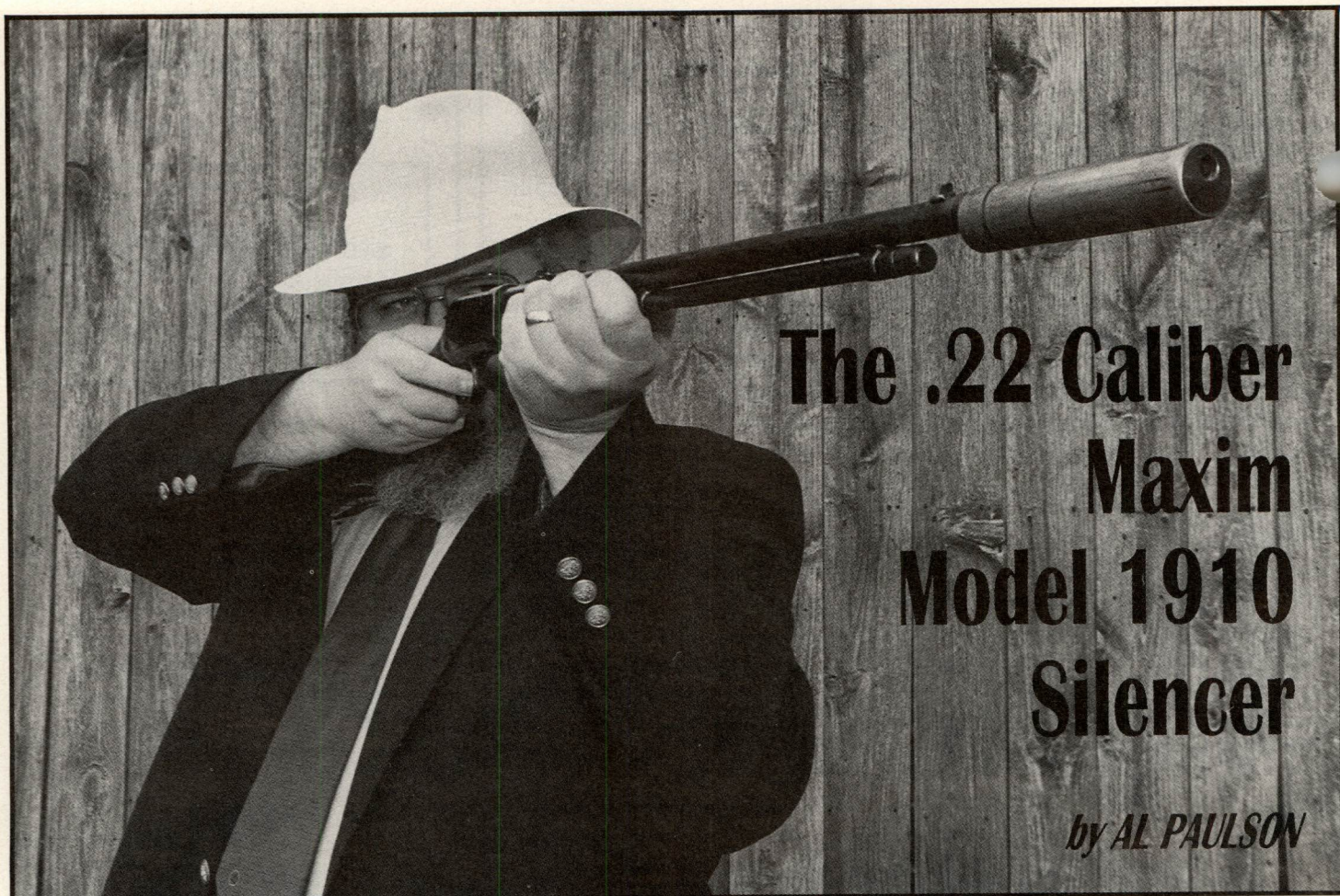
A new product from M.A.D.I. will be of benefit to AK, VALMET and GALIL owners. The new product is an adjustable bolt carrier/op rod assembly that allows the shooter to tailor the cyclic rate of his or her gun to different ammo and shooting conditions. The system can be adjusted from the normal cyclic rate down to where the gun has to be manually cycled. The benefits of this system are in being able to have a controllable cyclic rate with all types of ammo, as well as, when set to the lower rates, the guns internal components don't receive the intense impact that the higher rates of fire induce. Also, reloadable brass is virtually undamaged by extraction and ejection and the cases are only thrown 5-6 feet from the shooter instead of the usual 15-20 feet. For more information on all of the above products contact: Lee Hudson at Military Arms Depot International (M.A.D.I.), P.O. Box 41324, Phoenix, AZ 85080. Phone: 1 (602) 581-2484.



NEW PRODUCTS FROM M.A.D.I. MAC-TAC/COMP KIT



The new MAC-TAC/COMP KIT from Military Arms Depot International offers several add-on items that will make the MAC M-11/9 submachine gun more "competitor friendly." First is a muzzle brake that is threaded to mate to the small buzz-gun. The muzzle brake is of a dual sloped chamber design, to provide downward thrust from the first chamber and twist-and-swing stabilization from the second chamber. Next in the kit is a semivertical foregrip that is designed to be comfortable and quickly accessible. Placement of the foregrip was designed so that the left hand doesn't need to be removed from the grip to operate the selector lever. The foregrip is hollow with a threaded bottom cap which provides a handy compartment for the storage of papers, parts or a cleaning kit. Another feature of the kit is adjustable front and rear sights. The new sights slide on to the upper receiver of the gun and are held tight with set screws. Both the front and rear sights are fully adjustable for windage and elevation. The rear sight is the peep type and has a Weaver style base built in for the mounting of other optics. Both the front and rear sights have built-in catches for a quick release brass catcher also available from M.A.D.I.. Last, but not least, is a redesigned charging handle that is easier to grasp and at the same time is lighter in weight. All of the above items can be purchased as a kit or individually from: Lee Hudson at Military Arms Depot International (M.A.D.I.), P.O. Box 41324, Phoenix, AZ 85080. Phone: 1 (602) 581-2484.



The .22 Caliber Maxim Model 1910 Silencer

by AL PAULSON

The Maxim Model 1910 was the first commercially successful silencer. The Maxim provided a lot of innocent fun to sport shooters and their families (photo by Polly Walter).

The dawn of the 20th century was also the dawn of the silencer. Noted firearms authority of the period W.W. Greener claimed to have developed a silencer long before the turn of the century, but he didn't seek patent protection, since there was "no clear need (for silencers) at that time." Unfortunately, no Greener silencer or even sketch of his design survives. The first patent to clearly lay out the principle of baffles and expansion chambers was issued to J. Borrensens and S. Sigbjornsen in 1899. While a number of silencer patents were issued in the following decade, the first commercially successful silencer was designed by Hiram Percy Maxim.

Born on September 2, 1869, Hiram P. Maxim was the son of Sir Hiram Stevens Maxim (the inventor of the first practical machine gun) and the nephew of Hudson Maxim (the inventor of smokeless powder and the self-propelled torpedo). A mechanical engineer by training and a prolific writer by inclination, Hiram P. wrote a weekly column on "Science for the Layman" for the King newspaper syndicate,

an eclectic array of magazine articles, a book published in 1915 entitled *Defenseless America*, and two books published in 1936 entitled *A Genius in the Family* and *Horseless Carriage Days*. While his writings are largely forgotten, Maxim is well remembered by ham radio operators as the founder of the American Radio Relay League and the creator of a code of ethics for amateur radio operators. Many decades later, another silencer designer—Dr. Phillip H. Dater—would make his own contributions to ham radio technology.

While amateur radio operators still remember Maxim's work in that field, historians generally remember Hiram P. Maxim for his genius as an inventor. While he was a pioneer in the technology of such diverse fields as electrically powered vehicles, aviation and motion pictures—it was Maxim's engineering in the realm sound suppression that seems to attract the most interest today.

Maxim began his engineering career in 1886, when he graduated from MIT (the Massachusetts Institute of Technology) at the remarkable age of 17. Not surprising-

ly, this *Wunderkind* was the youngest graduate in his class. After working a total of 20 years for several pioneering companies in the electrical industry and several companies in the electric motorcar industry, his interest in the internal combustion engine eventually convinced Maxim that he had a limited future as the designer of electrically powered vehicles. Maxim concluded that he needed to take control of his destiny by forming his own company. He founded the Maxim Silent Firearms Company and received his first silencer patent in 1908.

EARLY MAXIM SILENCERS

The Maxim Model 1908 silencer, from a distance, looked something like a soup can stuck perpendicular to the underside of a rifle barrel. Closer inspection revealed a wide piston valve system extending from the right of the can, and a smaller escape valve with vent ports extending from the left side of the can. The design was intended to briefly trap high-pressure combustion gases near the muzzle of the firearm and then gradually vent low-pressure gas from the silencer. The design was complicated, expensive, and not particularly ef-

fective. Maxim developed a simplified variant of this design, but it also provided disappointing performance. Study of early patents suggests that attempting to mechanically trap combustion gases using spring-powered valves was a common theme in early silencer design. Maxim quickly abandoned this approach in favor of a different principle.

The following year, Maxim received a patent (see Figure 1) for a silencer designed to swirl the gases entering the rear of the silencer, causing the gases to expand and lose energy before exiting the front of the silencer. This Model 1909 silencer apparently sold in limited numbers, but its concentric design (relative to the bore of the

firearm) occluded the gun's front sight. This aspect of the can's design required either mounting front sight on the silencer itself or using a telescopic sight. Furthermore, Maxim believed that the Model 1909 allowed a pencil-shaped gas jet to exit the front of the silencer, thus significantly reducing the Model 1909's performance. Solving these two problems led to Maxim's most successful silencer: the Model 1910 (see Figures 2 and 3).

MAXIM MODEL 1910

The Maxim Model 1910 was not only quieter than the Model 1909, its eccentric design permitted employing a firearm's regular front sight. According to a long-since retired Colt employee, the Colt plant in Hartford, Connecticut, actually manufactured the Model 1910 silencer for the Maxim Silent Firearms Company, which was initially based out of New York and then moved to Hartford.

Another interesting feature of the Model 1910 was the use of interrupted threads, which permitted mounting the silencer by simply slipping the silencer over a barrel with interrupted threads, and then simply twisting the silencer clockwise 90 degrees. This permitted almost instantaneous mounting and dismounting, which greatly facilitated reloading rifles with tubular magazines.

Made of soft, malleable steel, the silencer tube is press-fitted into a rear end cap that features interrupted threads for mounting on a barrel. A primary expansion chamber forward of the rear end cap is separated from the stamped baffles by a ring-shaped ridge pressed into the tube (seen as a circular groove around the outside of the tube). In variants designed for centerfire cartridges, the rearmost baffles are stamped

from thicker material than the forward baffles to withstand the higher pressures generated by the muzzle blast in the primary expansion chamber. While the thicker baffles function as blast baffles, they retain the sculptured design of all the baffles in the baffle stack. When the thicker baffles are present in the Model 1910, they are individually held in place by a series of ring-shaped ridges pressed into the tube. A single pressed ridge (seen as a straight groove running lengthwise along the bottom of the can) keeps the eccentric baffles properly aligned with the bore.

The .22 rimfire variant of the Maxim Model 1910 tested in this study features 13 baffles (not counting the front end cap) in a tube measuring 4.5 inches (113.6 mm) long and 1.0 inch (25.4 mm) in diameter. The eccentric mount extending from the rear end cap is 0.4 inch (11 mm) long and 0.6 inch (16 mm) in diameter.

It's an ingenious design even by modern standards, and the eccentric Model 1910 quickly became relatively common among sport shooters, especially in the northeastern United States. Over the years, I have seen photographs of people quietly target practicing in the yards of beautiful Victorian homes. Silencers provided an innocent and inexpensive source of family fun. The Model 10 cost an affordable \$5.00 for the .22 rimfire version and \$7.00 for the centerfire version. A subsequent variant called the Model 15, which was designed for the Springfield rifle, sold for \$8.50 including a quick-couple device that wrapped around the Springfield's front sight.

While the movies show silencers being used by villains of the period, I have found only a single documented case of a crime committed with a silencer prior to the Gun

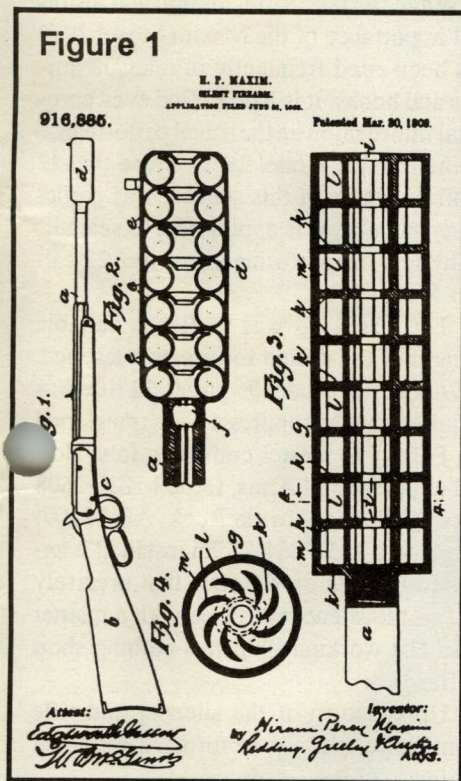


Figure 2

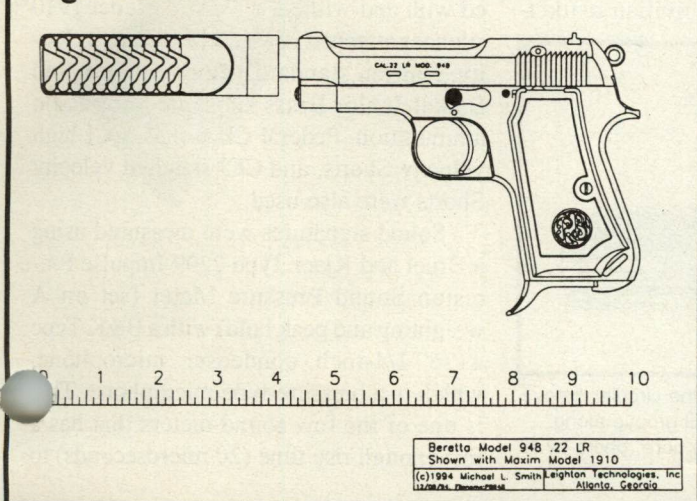
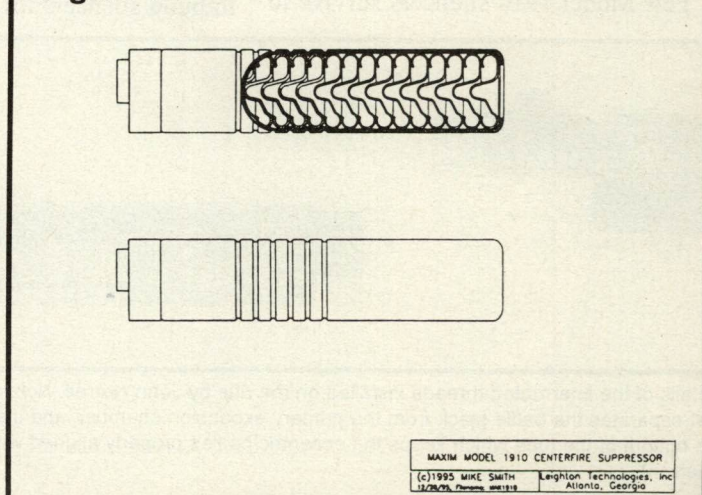


Figure 3

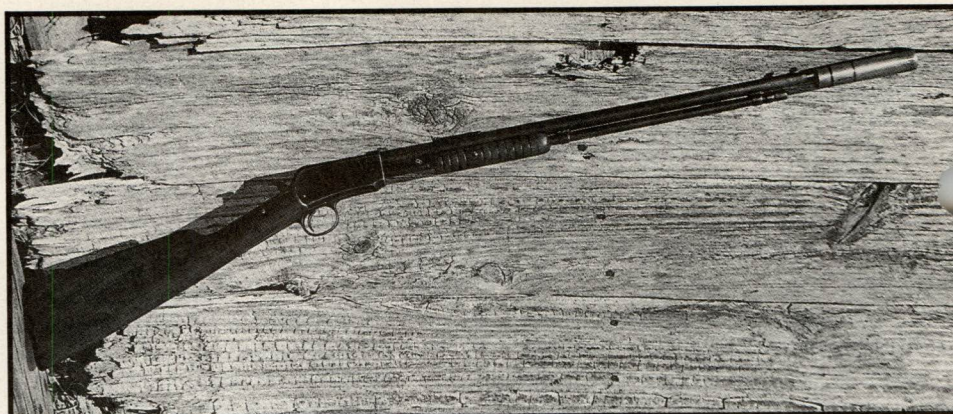


Control Act of 1934. Two men used silenced rifles to kill six horses on a New Jersey farm, and then they attempted to extort \$800 from the farmer so the brigands would spare the rest of his livestock. While the scoundrels were caught, the salient point is that one misuse of a technology does not constitute a crime wave. Apparently, silencers were subjected to the same controls as machine guns in 1934 because the Great Depression created a lot of hungry people. Few of us today understand the depth and breadth of hunger in America during the Depression. William Manchester writes in his book *Goodbye, Darkness* that "in 1940 two out of every five draftees had been rejected, most of them victims of malnutrition." That suggests that 40 percent of the adult population was not getting enough food during the Depression.

Thus, it is at least understandable that the pandemic hunger in the United States of the early 1930s led game managers to fear that silencers might be used by poachers. It seems to be this fear that led to the heavy restrictions that were placed upon silencers in 1934.

Even though legal silencers are once again becoming commonplace, not one registered silencer in the hands of a *civilian* has ever been used for poaching or any other illegal act since 1934, according to federal government records. The only two illegal acts I've documented involving registered silencers or machine guns since 1934 involved *law enforcement officers* who ran amok, not civilians. Thus, one could argue that the civilian owners of registered silencers and machine guns have a better track record as law-abiding citizens than the law-enforcement community, the United States Congress, and even the Presidency itself. This observation will come as no surprise to readers of *MGN*.

Few Model 1910 silencers survive to



The Maxim Model 1910 silencer mounted on a Winchester Model 06 pump rifle. The performance of the Maxim Model 1910 compares favorably with a number of modern silencers and integrally suppressed firearms (photo by Polly Walter).

the modern day. Combining corrosive ammunition of the period with a sealed silencer constructed of mild steel made cleaning difficult and corrosion a serious problem. Yet it was the Gun Control Act of 1934 that made most of the Model 1910s disappear.

The Gun Control Act of 1934 forced people to destroy their silencers or register them. The original owner had a brief amnesty period in which to register the silencer without cost. If not registered within that period, the silencer became unregistrable contraband which could subject the owner to a big fine and jail sentence. Most owners never got the word in time. Others decided it was too much trouble since each time a registered silencer was sold, the new owner had to pay a \$200 transfer tax. That was an incredible amount of money in the depths of the Great Depression. Therefore, few Maxim silencers survive to this day, and these tend to be expensive.

The Maxim Model 1910 silencer achieved greater commercial success in the States than any design until Jonathan Arthur Ciener, Dr. Phillip Dater and others began to build silencers for the civilian market-

place nearly three-quarters of a century later. While the fascinating design and historical importance of the Maxim Model 1910 has been cited frequently in relevant articles and books, it is hard to find even anecdotal information on the actual performance of the Maxim Model 1910. Since the .22 rimfire version of this silencer was particularly popular, it is appropriate to scientifically test the performance of the .22 caliber Model 1910.

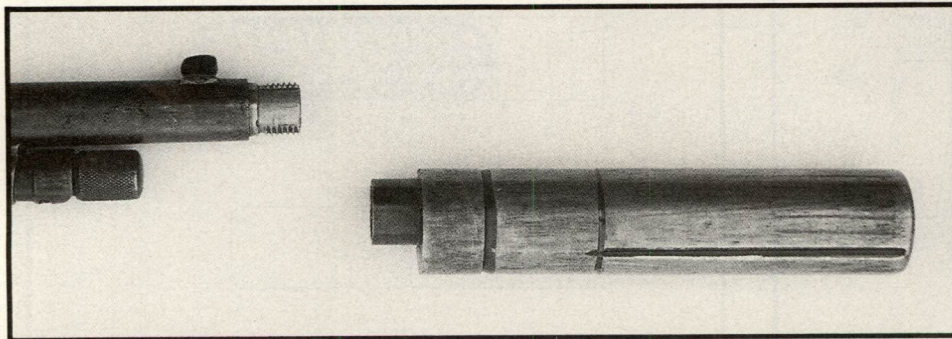
The first step was to find a suitable firearm of the period for use as a test bed. A Winchester Model 06 pump .22 rifle was acquired and the suppressor was transferred via Form 5 to master craftsman John Norrell (John Norrell Arms, Dept. MGN, 2608 Grist Mill Road, Little Rock, AR 72207; phone 501-225-7864). John installed interrupted threads on the rifle that precisely locked the silencer in place with a quarter turn. His workmanship was nothing short of flawless.

Upon return of the silencer and rifle from Norrell Arms, the formal T&E could begin.

TESTING METHODOLOGY

A Winchester Model 06 rifle was tested with and without a Maxim Model 1910 silencer attached using Federal high velocity, Hansen standard velocity target, and Baikal Junior Brass subsonic Long Rifle ammunition. Federal CB Longs, CCI high velocity Shorts, and CCI standard velocity Shorts were also used.

Sound signatures were measured using a Bruel and Kjaer Type 2209 Impulse Precision Sound Pressure Meter (set on A weighting and peak hold) with a B&K Type 4136 1/4-inch condenser microphone, which is a pressure-type microphone. This is one of the few sound meters that has a fast enough rise time (20 microseconds) to



Details of the interrupted threads installed on the rifle by John Norrell. Note also the circular groove that separates the baffle stack from the primary expansion chamber, and the strait groove along the bottom of the tube which keeps the eccentric baffles properly aligned with the bore (photo by Al Paulson).

accurately record very brief sound impulses such as gunshots. The microphone was placed 1.00 meter away from the front of the suppressor or muzzle, at a 90 degree angle from the bullet flight path, to the front of the muzzle. The pressure microphone was pointed straight up toward the sky so that the plane of the diaphragm intersected the suppressor or muzzle. (A free field microphone such as the B&K 4135 is oriented 0 degrees to the sound source, so it points directly at the suppressor or muzzle. A random incidence microphone such as the Larson-Davis 2530-1133 is oriented 80 degrees to the sound source.) The meter was calibrated just before and just after the tests with a B&K 4230 calibrator. No instrument drift was observed.

The ambient temperature during each test is always given. Velocities were measured in feet using a P.A.C.T. MKIII timer/chronograph with MKV skyscreens set 24.0 inches apart and the start screen 8.0 feet from the muzzle (P.A.C.T., Dept. MGN, P.O. Box 531525, Grand Prairie, TX 75053, 214-641-0049). At least 10 rounds were fired to obtain an average sound signature or muzzle velocity. Computer analyses of external ballistics were conducted using Ballistic Explorer Version 4.02a (Oehler Research, Dept. MGN, P.O. Box 9135, Austin, TX 78766, 512-327-6900).

UNDERSTANDING SOUND DATA

Since few people have an intuitive grasp of decibels, a few comments will help put these data into perspective. Decibels are a logarithmic rather than a linear scale that approximates the response of the human ear much more closely than raw sound pressure levels. The threshold of human hearing is 0 decibel, a quiet conversation is about 56 dB, an IBM Selectric II typewriter is 84 dB, a Daisy Red Ryder BB Gun is 101 dB, a .22 CB is about 131 dB and a standard velocity Long Rifle is about 137 dB when shot from a bolt-action rifle. Hearing damage begins at about 140 decibels, the pain threshold is about 141 dB, an MP5 is about 157 dB, a .45 pistol is about 162 dB, an M16 is about 165 dB, and a 122mm howitzer is about 183 dB. Death of the observer can occur in the neighborhood of 220 dB. Most adults can distinguish a 1 decibel difference between impulse sounds such as gunshots, while most people need a 3 dB difference to distinguish between continuous (RMS) sounds.

Note, however, that the unsuppressed sound signatures can differ from test to

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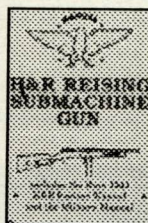
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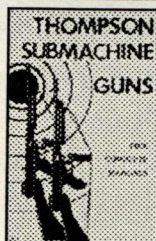
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test. This is because different atmospheric conditions (such as temperature, humidity and altitude) affect the burning characteristics of gunpowder. Even the speed of sound changes with the temperature. Therefore, the unsuppressed weapon signature were remeasured each day of testing, as a control or benchmark.

The best way to compare suppressors tested under different conditions is to subtract the suppressed sound signature from the unsuppressed sound signature, to get the AMOUNT of suppression. This more useful number is called the net sound reduction, which provides a better yardstick for comparing similar systems, such as suppressed .22 caliber Ruger pistols. The suppressed sound signature remains useful for comparing different systems, such as suppressed .22 pistols versus suppressed .22 rifles or suppressed 9mm pistols (which have different unsuppressed sound signatures).

PERFORMANCE

From a historical point of view, the most appropriate rounds to use with the Maxim Model 1910 silencer are standard velocity Long Rifles and standard velocity Shorts, for these are essentially the rounds that were available when H.P. Maxim designed the Model 1910 silencer.

The .22 Short was the first metallic cartridge to be commercially produced in the United States. As hard as it is to imagine today, the .22 Short was originally developed for self-defense. The earliest firearm chambered for the round was the First Model revolver produced by Smith & Wesson in 1857. Many wealthy officers carried this pistol during the Civil War. The original load was 4 grains of black powder driving a 29 grain bullet. Remington introduced the first noncorrosive .22 Shorts in 1927, and the first high velocity Shorts in 1930, about the time that H.P. Maxim turned his attention from firearm to industrial silencers.

The .22 Long Rifle was originally developed in 1887 by the J. Stevens Arms & Tool Company. The Long Rifle featured a 40 grain bullet and 5 grains of black powder. The cartridge proved much more accurate than the Longs and Extra Longs of the day, as well as being more effective against game, so the popularity of the Long Rifle spread like wildfire. Soon available with semismokeless and then smokeless powder, ammunition manufacturers started crimping the case in 1900. But the high velocity Long Rifle cartridge was not in-

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Using standard velocity Short and Long Rifle rounds is appropriate to test what the Maxim silencer sounded like when it appeared in the marketplace. Testing the Maxim with the more modern high velocity and new subsonic ammunition provides a useful benchmark for comparing the Maxim's performance against modern muzzle suppressors and integrally suppressed firearms.

The performance of the Maxim Model 1910 silencer was compared to Vaime A8 and AWC Archangel I muzzle cans mounted on a Ruger 77, as well as a Ciener integral suppressor on a Marlin Model 780 rifle. The suppressed and unsuppressed sound signatures appear in Table 1, net sound reductions appear in Table 2, and muzzle velocities appear in Table 3. Note that the peak sound pressure level created by cycling the pump action of the Winchester Model 06 is 105 decibels, while the external hammer creates a 106 dB sound signature when the trigger is pulled on an

empty chamber.

It quickly becomes obvious that from the data in Tables 1 and 2 that the Maxim Model 10 performs very well even by modern standards. Using high velocity ammunition, the Maxim delivers more sound reduction than either muzzle can and even the integral suppressor. A loud ballistic crack does occur, however, with every system using a muzzle can. There is no ballistic crack with the integral system since its ported barrel drops high velocity projectiles to subsonic speeds.

Using standard velocity target ammunition, the Maxim also outperforms all of the other suppressed systems tested in this study. Note from Table 3 that the standard velocity ammunition remained subsonic in the Winchester 06. But the same lot of ammunition produced supersonic velocities in the Ruger 77/22, so there was a loud ballistic crack that no suppressor can mask.

The Maxim was much more effective than all of the other muzzle cans with sub-

sonic ammunition. The Ciener integrally suppressed rifle was barely quieter with subsonic ammunition, but the integral system only produced 84 percent of the velocity delivered by the Winchester/Maxim system.

The Maxim delivered disappointing performance with high-velocity shorts. Not only was the net sound reduction the poorest in this study, the high velocity Shorts produced a ballistic crack, since they exceeded the speed of sound on this day by 25 fps (8 mps).

The Maxim did, however, produce a significantly better net sound reduction with standard velocity Shorts. The actual suppressed sound signature using SV Shorts was a mere 112 decibels, which is within 6 decibels of the sound generated by the rifle's hammer fall. Most observers are astonished by this level of performance. They typically think suppressed gunshot using the Maxim with SV Shorts sounds like a BB gun, although the Daisy Red Ry-

Table 1. Sound signatures in decibels of suppressor tests.

Gun	Suppressor	Federal HV	Hansen SV LR	Baikal JB SS LR	CCI HV Shorts	CCI SV Shorts	Federal CB Longs	Temperature F (C)
Winchester 06	None	142	138	138	136b	130	129	78 (26)
Winchester 06	Maxim 1910	119	115	114	122b	112	107	78 (26)
Ruger 77/22	None	141	139	137a	—	—	131	64 (18)
Ruger 77/22	AWC Archangel I	123	121	115a	—	—	106	64 (18)
Ruger 77/22	None	141	138	138a	—	—	132	50 (10)
Ruger 77/22	Vaime A8	121	118	117a	—	—	106	50 (10)
Marlin 780	None	143	140	140a	—	—	134	83 (28)
Marlin 780	Ciener integral	124	121	115a	—	—	111	83 (28)
a RWS subsonic LR								
b ambient temperature = 77F (25C)								

Table 2. Net sound reductions.

Gun	Suppressor	Federal HV LR	Hansen SV LR	Baikal JB SS LR	CCI HV Shorts	CCI SV Shorts	Federal CB Longs	Temperature F (C)
Winchester 06	Maxim 1910	23	23	24	14b	18	22	78 (26)
Ruger 77/22	AWC Archangel I	18	18	22a	—	—	25	64 (18)
Ruger 77/22	Vaime A8	20	20	21a	—	—	26	50 (10)
Marlin 780	Ciener integral	19	19	25a	—	—	23	83 (28)
a RWS subsonic LR								
b ambient temperature = 77F (25C)								

Table 3. Muzzle velocities of suppressed and unsuppressed rifles.

Gun	Suppressor	Federal HV	Hansen SV LR	Baikal JB SS LR	CCI HV Shorts	CCI SV Shorts	Federal CB Longs	Temperature, F (C)	Speed of Sound, fps/mps
Winchester 06	Maxim 1910	1,236	1,120	1,018	1,162b	872	668	78 (26)	1,137 (347)
Ruger 77/22	AWC Archangel I	1,272	1,133	982a	—	—	644	64 (18)	1,122 (342)
Marlin 780	Ciener integral	1,065	986	851a	—	—	568	83 (28)	1,142 (348)
a RWS subsonic LR									
b ambient temperature = 77F (25C)									

der actually produces a sound signature of 101 dB. The Maxim's report with SV Shorts does not sound like a gunshot, and the dominant event is the sound of the bullet striking the target. The old rifle is quite accurate with these standard velocity Shorts, and they have become my favorite load for the Winchester/Maxim system.

For short-range target shooting or potting squirrels pilfering the insulation from my attic, I use CB Longs. The muzzle signature with the Winchester/Maxim system is just 1 decibel louder than the rifle's hammer fall. Since the hammer is closer to the shooter's ear than the front of the Maxim silencer, the shooter only hears the hammer fall and bullet impact. The shooter hears no muzzle signature at all with the Winchester/Maxim system and CB Longs. That's a heady and rather addictive experience. The CB Longs are not as accurate as the SV Shorts in this rifle, but the CB Longs do provide enough accuracy for reliable

head shots on meddlesome squirrels at typical engagement distances.

The data in Table 3 demonstrate that a muzzle can like the Maxim provides significantly more velocity than an integrally suppressed rifle (which vents combustion cases into the suppressor through ports drilled in the rifle barrel). This increased velocity translates into both a flatter trajectory (i.e., superior shot placement) and more velocity for penetration in live targets (i.e., superior terminal ballistics). Figures 4 and 5 compare the velocities and trajectories produced by several kinds of ammunition fired in the Winchester 06 rifle with Maxim Model 1910 silencer. Subsonic Long Rifle ammunition clearly offers the flattest trajectory and the most velocity for penetration of the three rounds compared in Figures 4 and 5, making subsonic ammunition the preferred round of these three for hunting small game. Figures 6 and 7 compare the performance of the Winches-

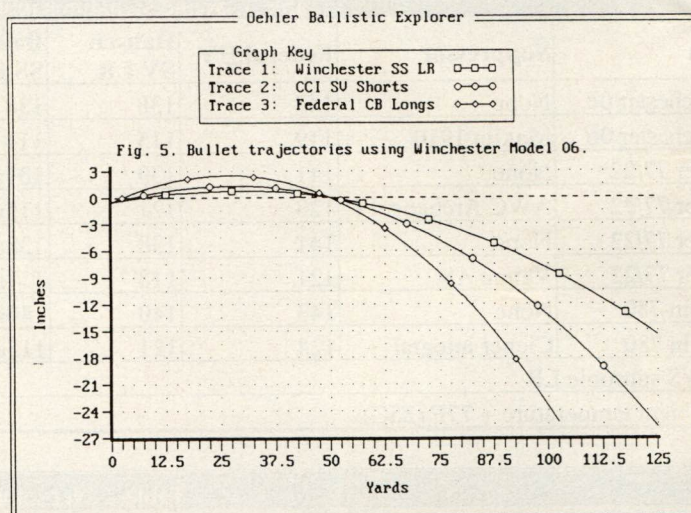
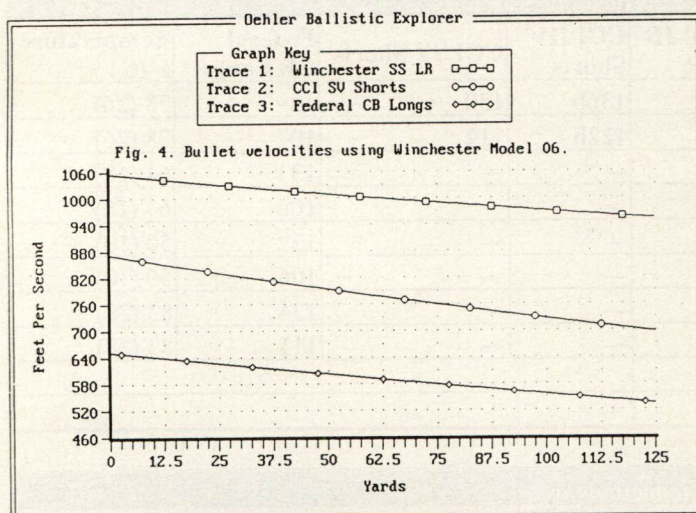
ter/Maxim system with a Ruger 77/22 and AWC Archangel I suppressor, and the Marlin 780 rifle with integral Ciener suppressor (all using Hansen standard velocity ammunition).

While Hiram Percy Maxim certainly showed great promise when he graduated from MIT in 1886 at the age of 17, the excellent performance of his Model 1910 silencer demonstrates that his engineering prowess fulfilled that expectation. Like his contemporary, John Moses Browning, Hiram P. Maxim's technology is still quite relevant today.

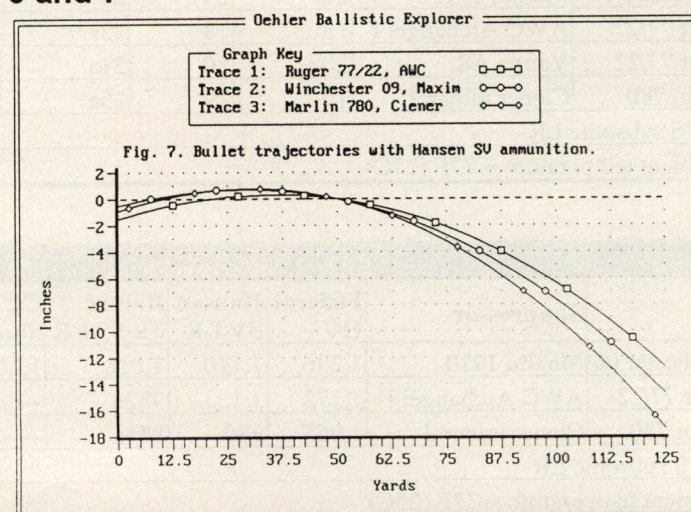
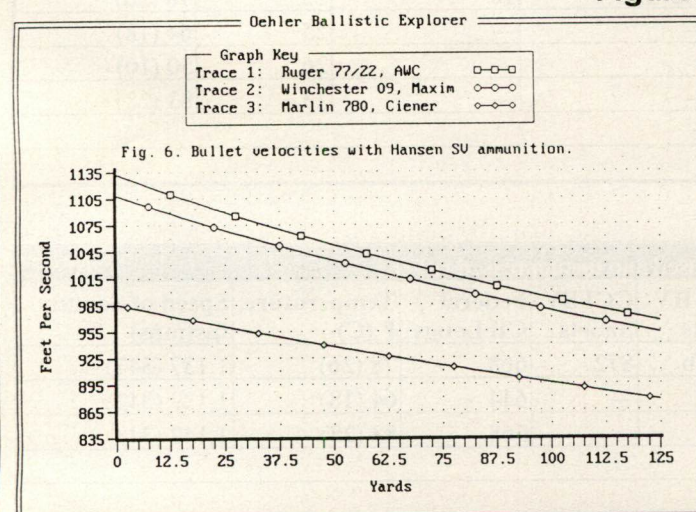
Maxim did not, however, rest on his laurels after developing the Model 1910 silencer. He continued to design and market new suppressors for nearly two more decades. We'll continue the Maxim story when we examine the design and performance of the Maxim Model 1921 silencer in a future issue of *Machine Gun News*.

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Figures 4 and 5



Figures 6 and 7



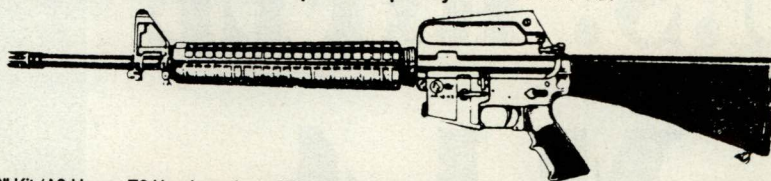
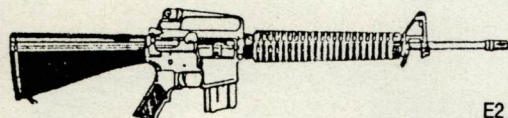
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U.S. RIFLE M14

BY FRANK IANNAMICO

Ask any U.S. Military Veteran from the 1960's to the early 1970's what their weapon of choice would be, chances are you will hear a resounding "M14." Especially if the vet you ask was a Marine. The M1 Garand is also a favorite of many ex G.I.s. It must be the combination of power, accuracy and reliability that makes these weapons so popular.

HISTORY

The M14 came to be after many years of development and controversy. One world class weapon that competed against the M14 for U.S. adoption and lost was the FN FAL. The reasons for the military choosing the M14 over the FN FAL were, that due to the similarities of the M1 Garand and the new M14, training and manufacture would be easier. The M14 was a pound lighter than the FAL, and the United States was not about to adopt a FOREIGN weapon for the U.S. Army. Ironically the FN Corporation would eventually produce the M16A2 for the U.S., and the armed services would eventually replace their 1911A1s with the Italian-designed M9 Beretta.

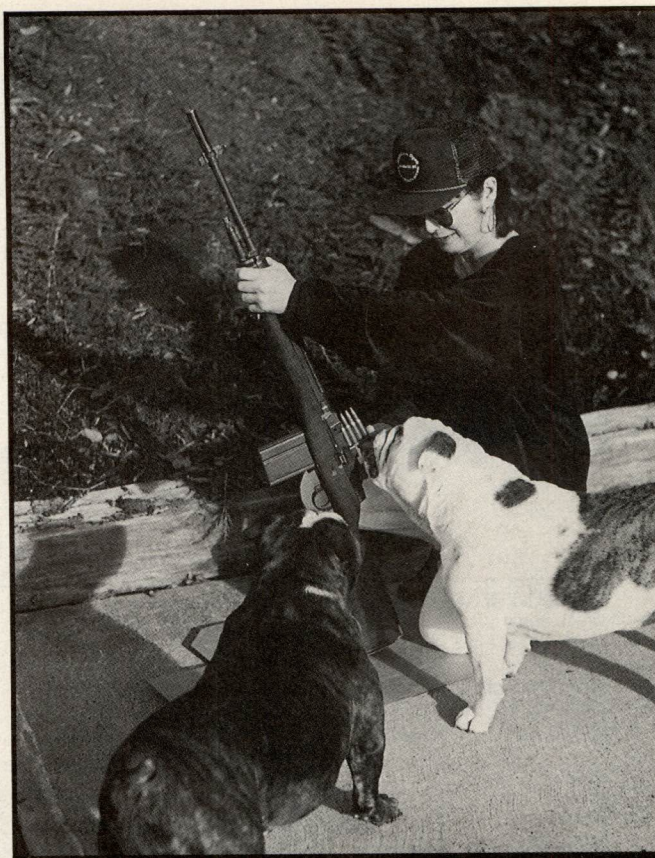
The cartridge the M14 was to use generated as much controversy as the weapon itself. The problem was that the military wanted a full power .30 caliber round in a light weight weapon that would have full automatic capability. It just was not possible. The M14, at 750 rounds per minute in the full-auto mode, is very hard to control.

In the early 1950's some countries were

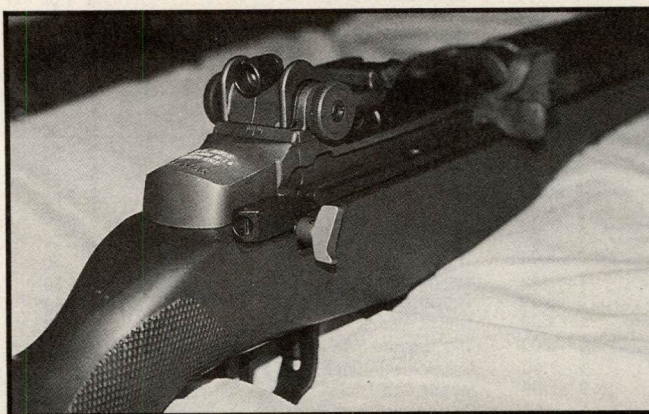
interested in developing a mid-range cartridge from combat lessons learned in WWII. It was concluded that a select fire weapon, firing a mid-range round could replace the submachine gun and the full power battle rifle. The Germans had developed their own mid-range cartridge: the 8mm Kurz that was utilized in their highly advanced (for the time) Sturmgewehrs MP 43, MP 44, and StG 44 in the closing months of the WWII. The Soviets developed their infamous 7.62x39 mid-range round and the SKS rifle which was succeeded shortly after by the AK-47. Great Britain was working on their .280 intermediate round for use in their version of the FN FAL. To the United States Military way of thinking the 7.62 x 51 was an intermediate round; after all,

it was 12mm shorter than the .30-06 cartridge. At the period that the M14 was being developed, the NATO countries were trying to adopt a standard NATO cartridge. The reason was simple. In the event of another war, supplying allied armies would be much easier if they used the same ammunition. The United States insisted on, and got the 7.62x51 (.308) cartridge standardized as the NATO round. Ironically, many of the NATO nations adopted the FN FAL making it the most prolific rifle in the world chambered for 7.62 NATO ammunition.

The M14 was originally produced for the U.S. military by four manufacturers: TRW, Springfield Armory, Winchester, and Harrington and Richardson (H&R). The weapon was produced from 1957 until 1964 when the AR-15 (M16) was being considered and eventually adopted. Approximately 1,400,000 M14s were manufactured.



Sandra Iannamico loads M14 through receiver stripper clip guide, as two USMC Reps observe.



The M14 selector for semi or full-auto operation, NM rear sight, fiberglass stock.

VARIATIONS

The M14 is basically a product-improved M1 Garand. The M14 cured the short comings of the 1930's-developed Garand. Briefly, these improvements were a detachable 20-round capacity magazine, a floating gas piston, the gas port on the barrel located closer to the receiver, a roller on the bolt to reduce friction, full-auto capability, a flash suppressor, chrome lined barrel, and a "smaller" round: the 7.62 NATO or as civilians were to know it, the .308.

The M14 was produced in several configurations. The M14A1 (E2) was developed to help control the weapon while firing in the full-auto mode. Some of the modifications made were a straight line stock with a pistol grip and a retractable fore grip, a muzzle brake, recoil pad, and a bipod. These improvements also added additional heft to an already heavy weapon. The standard M14 weighs in at 8.7 pounds empty and 12.75 pounds for the A1 version. A heavy-barreled version was contemplated as a possible Squad Automatic Weapon (SAW): it was to be the M15. After extensive testing it was concluded the M14 was not well suited to the SAW role, and the M15 was not adopted. Many standard M14s were issued with a selector lock that prevented the user from switching to the full-auto position. These locks could be removed if the situation warranted.

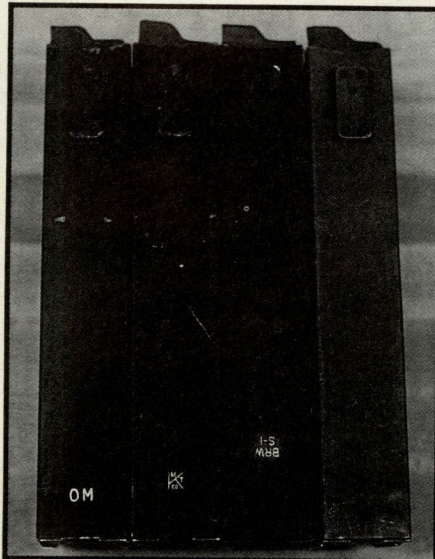
Another configuration of the M14 was the excellent M21 sniper version. This was probably the area for which the M14 was best suited. One version of the M21 used a Leatherwood ART scope (Auto Ranging Telescope). Earlier versions were equipped

with the same M84 scope the M1 Garand snipers used. A few M21s were equipped with a Sionics sound suppressor. Although the 7.62 round is supersonic and not easily suppressed, it made the location of the shooter difficult to detect.

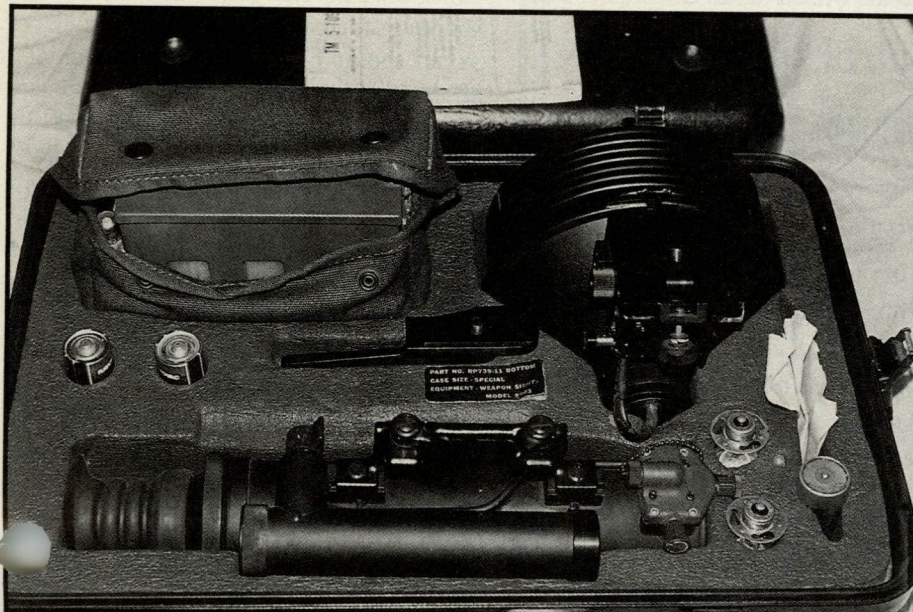
Yet, another version of the M14 was the National Match M14. These were hand assembled by military armorers using selected parts. The NM versions also utilized special sights, glass bedded stocks and other parts that had to meet very strict tolerances. The NM M14 is primarily for shooting competitions.

CARTRIDGES

The standard 7.62 NATO cartridge was the M80. It featured a 150 grain bullet that had a velocity of 2800 fps. This combination yielded 2,611 foot pounds of energy



Original GI-marked magazines, Chinese mag (no markings) far right.



Infrared night vision scope for M14 in storage case.

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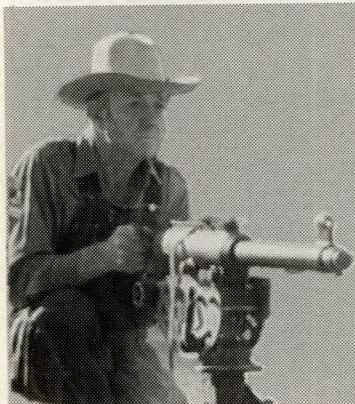
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at the muzzle. The current NATO round, the 5.56, yields 1,290 foot pounds of energy at the muzzle.

The armor piercing round is the M61. It is for penetrating lightly armored vehicles. It can be identified by a painted black tip. Armor piercing 7.62 NATO ammunition is not legal to possess by civilians.

A tracer round is known as the M62. It is used for directing fire especially at night. It can be identified by its painted orange tip. This ammunition is normally issued for use in the M60 general-purpose machine gun.

The M64 Grenade launching round is used to launch grenades from the end of the rifle's barrel using an M76 grenade launcher attachment. There is a spindle valve located on the side of the M14's gas tube that must be turned when launching grenades. This directs all the gases to the launcher. The rifle will not cycle when the spindle is in the launch position.

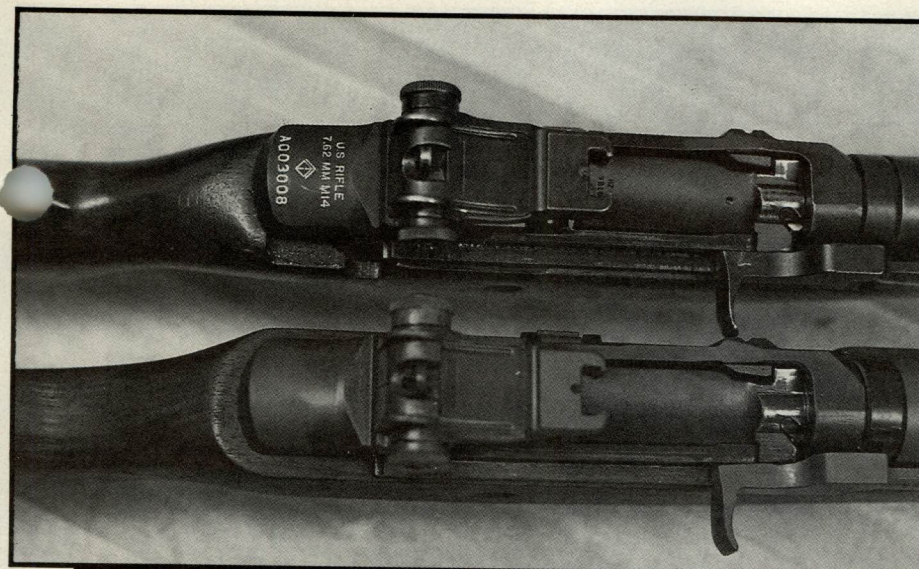
The M198 duplex load was not widely used. It contained two projectiles. It is identified by its green painted tip.

M14 NATO ammunition normally came on 5-round stripper clips, 12 clips to a bandoleer. The M14 can be loaded without removing the magazine by inserting a stripper clip into the grooved insert on the top of the receiver. 20-round magazines were standard for the M14. There is an adapter for using the stripper clips to fill the magazine when it is removed from the rifle.

PARTS AND ACCESSORIES

Accessories for the M14 are readily available and relatively inexpensive. One advantage to U.S. military arms and their clones are parts cost and availability. When shopping for parts for the M14, the consumer should be aware there are a lot of aftermarket parts out there for sale, including magazines. All original military M14 parts will be marked by the manufacturer i.e. SA, HRA, TRW, WRA, W, OM or NM on national match parts. Parts and accessories that are available are slings, mag pouches, M6 bayonets, winter triggers, M12 blank adapters, M76 grenade launchers, M15 grenade sights, M2 bipods and muzzle brake (stabilizer).

Original stocks come in two styles and several materials: the straight line M14A1 pistol grip stock, and the standard stock that comes in birch, walnut, and fiberglass. A few years ago M14 complete parts kits were available and inexpensive, although current laws have raised the price and lowered availability.



Armscorp M14 (top) and Chinese M14.

TOOLS

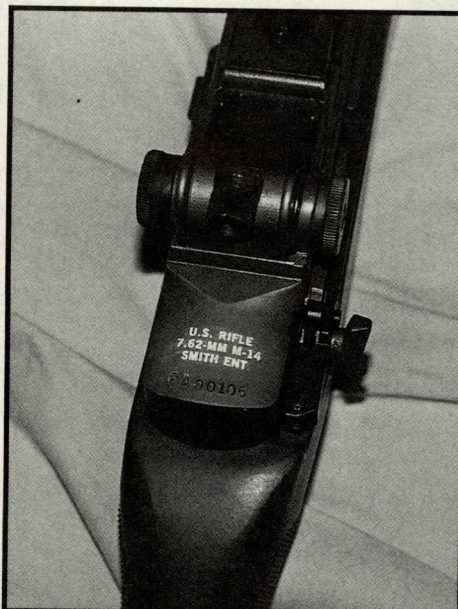
For the collector who needs everything, there are several tools for field maintenance on the M14. The combination tool that is stored in the buttstock is used as a cleaning rod handle, a gas plug wrench, and a screw driver for adjusting the sights, etc. There is also a cleaning kit that includes a ratcheting chamber brush along with a cleaning rod, bore brush and patch holder. A small plastic container with LSA and applicator are also included in the cleaning kit. This kit is also stored in the buttstock.

Other low level maintenance tools available are flash suppressor locknut pliers, alignment tool for the flash suppressor, ruptured case extractor, several GI field and technical manuals.

THE M14 TODAY

The M14, as known to collectors and shooters today, comes from one of several places: rare original uncut amnesty guns, demilled and rewelded original receiver guns, aftermarket manufacturers such as Armscorp, Smith and Federal Ordnance (receivers), the modern commercial Springfield Armory who produces the M1A, and the Chinese M14's. The full-auto aftermarket versions are usually Springfield Armory or Smith manufacture.

The original uncut guns are the most desirable, and of course the most expensive. The rewelded guns are as good as the person who remanufactured it. Properly done, a rewelded receiver would be as reliable as an original and, of course, retaining all the original markings. In most cases of rewelded M14s, the welded areas would be visible upon close inspection. All



Smith Manufacture M14 receiver.

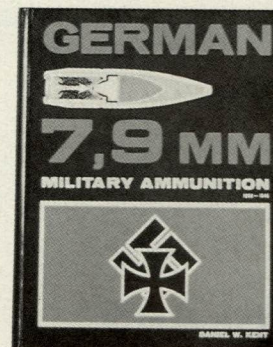
the aftermarket guns, except the Chinese versions, have cast receivers. Springfield Armory also manufactures many of the M14 components used in their rifles.

The Chinese M14 rifles have been the subject of much controversy lately. Two separate tests performed recently came up with two different conclusions about this rifle—one positive, the other negative. Most Chinese parts will not interchange with U.S. GI parts. The Chinese versions are the most economically priced M14s.

The M14s role has changed from warrior to a collector's prize and shooter's delight. It also brings back memories for many from days long past when they, as young soldiers, entrusted their lives to its reliability and firepower.

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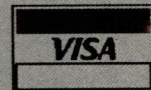
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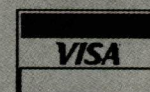
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MK19 MOD 3 40MM GRENADE MACHINE GUN

During the Vietnam War, there were many new weapons ideas tested. The advent of the individual soldier carrying a grenade launcher (M79 40mm) was modified by trying to make every rifleman into a grenadier with the M203 40mm. Many of the military planners tried to find a method of utilizing the massive antipersonnel firepower of the 40mm grenade in a full-auto mode. Helicopters were armed with pods that had miniguns and 40mm launchers that utilized higher pressure rounds than the M79 ammo.

Chinook helicopters and PBR's (Patrol Boat, River) were armed with a crank-fired, cloth belt-fed unit that fired the low pressure M79 ammo. (I have located one of these and I am trying to get it so I can do an article on it.) For ground use, Colonel George Chinn (author of the five-part book, *The Machine Gun*) started work on the MK19 Mod 0 at Naval Ordnance in Louisville, Ky. in 1966. By 1968, there were test models in use. There were a lot of parts to the Mod 0 as it was originally fielded, and the reports came back that it was a "low reliability-high maintenance" unit.

Between 1971 and 1974, after a design to reduce parts and increase reliability, a small quantity of the Mod 1 were issued to riverboat operations in Vietnam. Being a mobile unit, with the firearm mounted and ammunition available, the project met with more success. It was once again dropped as the war in Vietnam ended.

In 1979, American undercover agents' reports came back from Afghanistan on the devastating effect that the Soviet AGS-17 30mm had on the rebel forces. The AGS-17 utilized "burst only" charges (antipersonnel), not "shaped" (anti-armor). General Barry McCaffery, at the Infantry School in Ft. Benning Georgia, received this intel and immediately started on a project to upgrade the MK19 and bring it into inventory. Gen. McCaffery was an advocate of burst mechanism munitions — it is well documented that a greater number of soldiers are wounded or killed in battle by shrapnel than by bullets. It is largely through his diligence that the current MK19 Mod 3 is used by today's forces. In 1982 the Navy lab called for the bidding for contract. Saco Defense, Royal Ordnance, Ramo, and FN com-

Karachi, Pakistan;

_____1979:

Report of Agent _____:

Attn. — General _____:

Sir,

I have just returned to "base," fresh from the Afghani-Soviet front. The Mujahideen are fierce fighters and are holding their own when not outright advancing against the Soviet forces. Our small arms packages have helped them very much — these are a tough bunch of warriors. They "improvise, overcome, and adapt" in even the most adversarial conditions. The Soviet weaponry that they are having the most trouble against are the Hind helicopters, which we anticipated. (The few surface-to-air units that "accidentally" made their way to the Mujahideen are causing the Hind pilots to hold back a little — they quickly learned that these mountain tribesmen may ride horses, but they can effectively use any modern technology that is weapons related!)

On a more disturbing note — reports that the new Soviet AGS-17 30mm is being used to a devastating effect against the Mujahideen are true....The fully automatic grenade launcher is firing antipersonnel burst rounds, and it rules the battlefield wherever it is used. We have been unable to advise an effective defense against the AGS-17 and would consider it a priority to get any input from the Infantry School or other sources on how to counter this weapon.

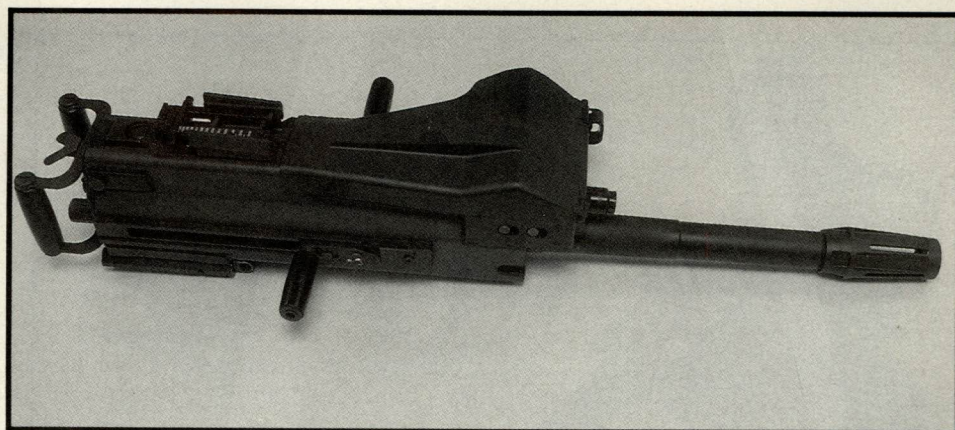
Sincerely,

peted. Saco Defense won the contract and by 1985 they were in production. (Export was restricted until 1991.)

The original U.S. users were the Marine Corps and the Navy SEALs. The Marines started with mounts for the M151 and now have them on the Humvee. For the AVV7, the 40/50 turret was made — either a .50 cal. M2-HB or the MK19 Mod 3 can be used on it. Between 1988-90, the U.S. Army adopted the MK19 Mod 3, and Saco Defense is the sole source for procurement.

The final Mod 3 has seen its parts reduced to a minimum...with that reduction, reliability has gone way up. Many consider the MK19 Mod 3 to be the most reliable firearm in the U.S. inventory. There are five major assemblies: receiver assembly, feed slide assembly and tray, top cover assembly, sear assembly, and the bolt and backplate assembly. When I did the field strip and reassembly at Saco, I was amazed at how easily everything went together. The various groups, once subassembled, snapped back into position very quickly. That counts in a combat weapon. (There are some good assembly/field strip hints in the tech section of this article.)

There have been problems in the MK19 design that required the manufacture of the receiver to be excruciatingly accurate. Military use requires that there be parts interchangeability and ease of field maintenance. Saco utilizes the Zeiss MC850 measuring device that compares over 160 characteristics on the MK19. The MK19 receiver is the most complex component that the Zeiss company has ever tested. Saco has two of these Zeiss MC850 measuring devices, in order to meet government orders. The receiver is welded out of forgings and stampings, and every measurement must be precise. Like most govern-



SPECIFICATIONS MK19 SYSTEM

Caliber	40mm
Maximum effective range	1,500 meters (1650 yds)
Maximum range	2,200 meters (2400 yds)
Muzzle velocity	241 m/s (790 fps)
Rate of fire	325-385 rounds per minute
Weight	33.0 kg (72.5 lbs)
Length	1095mm (43.1 in.)
Width	340mm (13.4 in.)

ment-contracted items, there is a very precise requirement description. Saco Defense's MK19 meets or exceeds the following as described in the MK19 catalog:

TEST HISTORY

The MK19 Mod 3 grenade machine gun has an extensive test history. Developmental testing was conducted in the early 1980s. Saco Defense and the United States Government, beginning in 1983, has conducted extensive joint testing of the MK19 Mod 3.

1983 PREPRODUCTION TEST

Ambient firing of two guns 20,000 rounds. Testing demonstrated 5,000 MRBS and 10,000+ MRBF. (MRBS—Mean Rounds Between Stoppages) (MRBF—Mean Rounds Between Failures.)

1986 FIRST ARTICLE TEST

Ambient test of three guns firing 7,300 rounds. Demonstrated MRBS exceeded 5,300 rounds. MRBF exceeded 7,300 rounds

1988 INITIAL PRODUCTION TESTS

Guns successfully subjected to extreme environmental testing (sand, dust, mud, icing and rain tests)

in accordance with U.S. Department of Defense Test Operating Procedure (TOP) 3-2-045 "U.S. Army Test & Evaluation Command Test Operating Procedures for Automatic Weapons, Machine Guns and Hand-Held Shoulder Weapons."

Hot Testing at 68 degrees C, 10,000 rounds fired exhibiting MRBS of 1,100 and MRBF of 10,000.

Cold Testing at -45 degrees C, 10,000 rounds fired demonstrating MRBS of 2,475 and MRBF exceeding 10,000.

In 1988, Saco Defense was contracted to improve the reliability and maintainability of a new generation of the MK19 Mod 3. The improved MK19 currently in production remains fully interchangeable with the older version of the MK19 Mod 3. Engineering improvements succeeded in improving the reliability and performance of the gun.

1990 PREPRODUCTION TEST

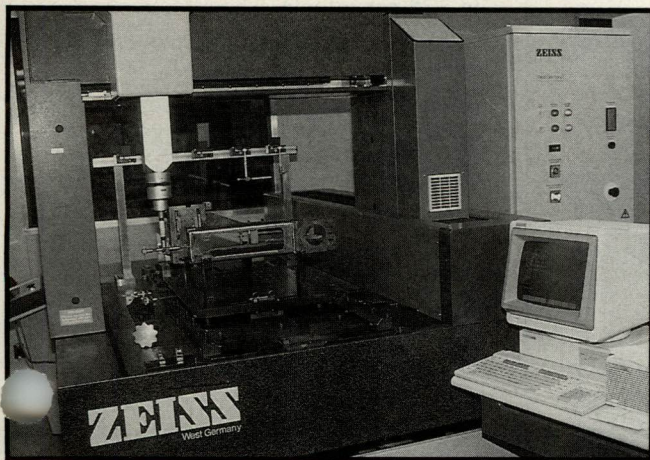
Ambient Firing of 20,000 rounds exhibiting an MRBS of 12,000 and MRBF of 12,000.

1991 FIRST ARTICLE TESTS

Ambient Firing of 50,000 rounds with MRBS of 8,350 and MRBF of 20,000+.

PERFORMANCE SPECIFICATIONS

The MK19 Mod 3 was developed and tested to meet the U.S. Government's stringent operational performance requirements. These requirements provide the



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users with a weapon that works consistently and reliably in demanding combat environments.

MK19 MOD 3 PERFORMANCE

All MK19 Mod 3s are thoroughly tested at Saco Defense's modern test facility. Saco Defense conducts testing that insures all MK19s meet stringent U.S. Government performance requirements of MIL-G-70790C.

RATE OF FIRE

325 rounds/minute minimum. All guns are measured during production acceptance testing.

TARGETING AND ACCURACY

3-round burst must strike a 14-meter square target at 1,000 meters. Production acceptance based on all rounds striking 84-cm square target at a distance of 60 meters.

BELT PULL

MK19 must function with a 28-round hanging belt. Production acceptance based on firing a 3-round belt with an equivalent 25-round weight hanging from the belt.

REMOTE FIRING

Must operate with solenoid-controlled triggering.

MK19 MOD 3 RELIABILITY

Saco Defense and the U.S. Government conduct reliability tests of the MK19 Mod 3. These tests insure that Saco production meets all reliability requirements. Reliability requirements are:

Barrel Life—10,000 rounds minimum
Receiver Life—25,000 rounds minimum
Stoppages—1,000 Mean Rounds Between Stoppages (MRBS) minimum
Failures—3,300 Mean Rounds Between Failures (MRBF) minimum

DESCRIPTION

Basically, the MK19 Mod 3 40mm grenade launcher is a blowback-operated, air-cooled, 40mm fully-automatic machine gun, firing 40mm grenades at a rate of 325 to 375 per minute. The effective range is 1500 meters with an extended range out to 2500 meters. The firing system is "advance primer ignition," meaning that the firing pin will activate the primer 3/8" out of battery before the round is fully chambered.

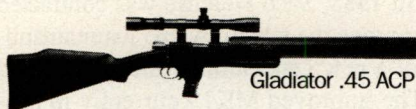
To operate, first point the weapon down-range. Then the feed box with belt is placed in position on the mount, or next to it if you are using the M3 ground mount (same as the M2-HB uses, with a different cradle). Make sure the bolt is forward — don't slam fire it — ease it forward. With the cover open, lay the first round in the belt in the feed tray, female side of the link first — push it across the first pawl — do not

R.A.S.E.

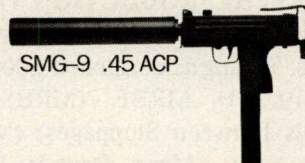
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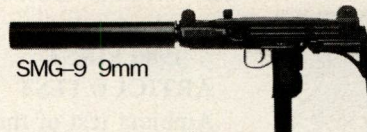
Gladiator .45 ACP



SMG-9 .45 ACP



M-22RF



SMG-9 9mm



I-22RF



CAR-9SD



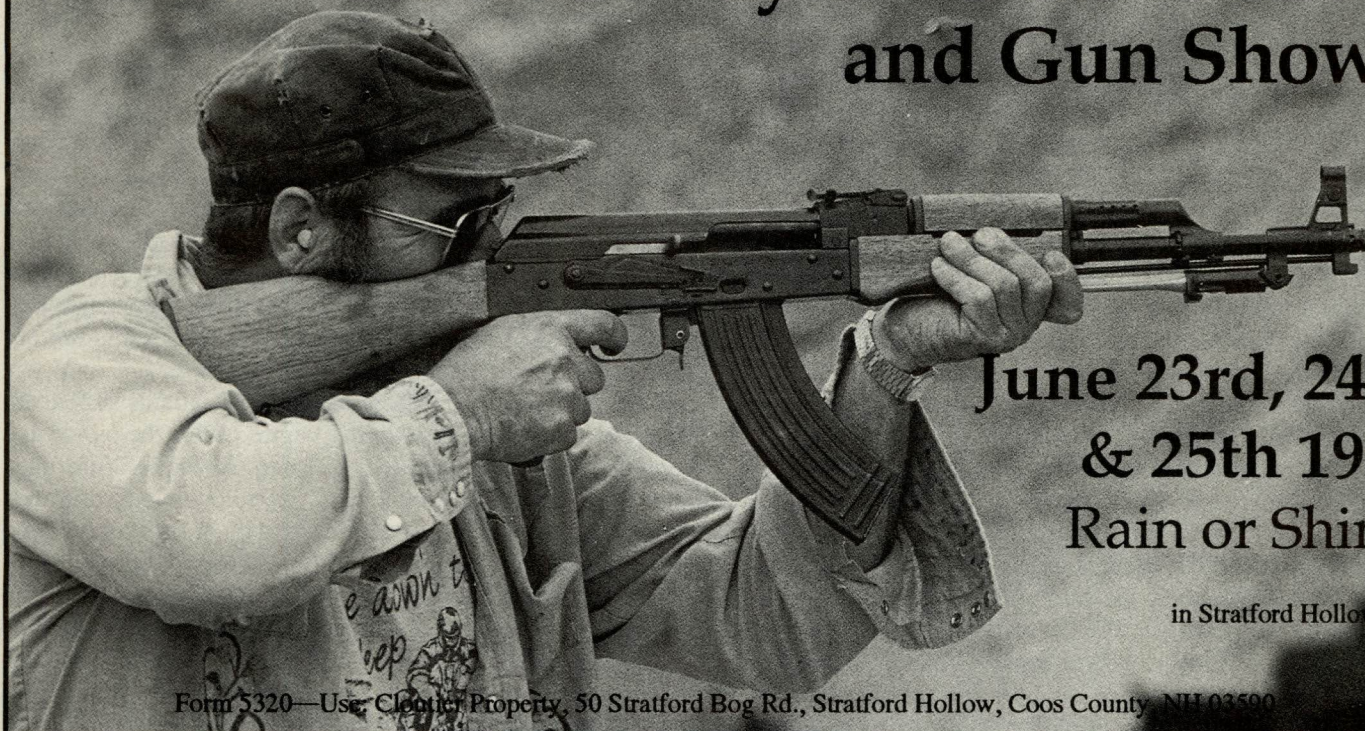
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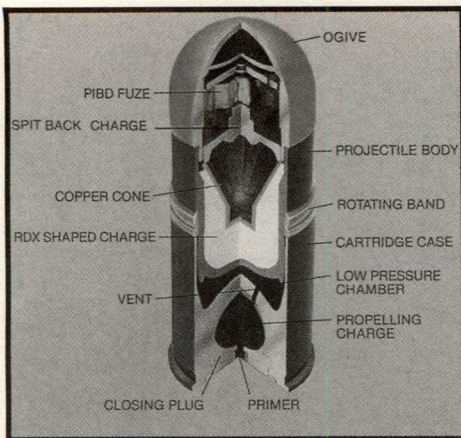
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The M430 round's unique high-low propulsion design reduces peak recoil and barrel erosion.

"roll" it, the pawl won't do its job. This leaves the round between the first and second pawl. Make sure that the rounds are straight and firmly seated. Move the feed slide assembly to the left, then CLOSE THE TOP COVER. Grab the handles (palm down), rotate them to horizontal, then pull the chargers sharply to the rear. Push them to forward, and rotate the handles up. To load your first round, place the safety in the "fire" position, and press the trigger. The bolt will spring forward — you have now loaded the first round onto the bolt face. Pull the chargers sharply to the rear (Yes, you need to charge twice). You now have a live round on the bolt face, to the rear, ready to fire. Push the charger handles forward and rotate up, the MK19 will not fire if the charging handles are not in the "up" position. Now, place the safety on "safe" until ready to fire.

Ammunition for the MK19 is different

from that for the M79/M203. Most soldiers refer to the M79 ammunition as "low pressure" and the MK19 as "high-pressure." This is incorrect — they are both "low-pressure." The MK19 round is longer, and develops more pressure than the M79 type, but it is still a low pressure round. These rounds are two distinct types of ammunition- they ARE NOT INTERCHANGEABLE BETWEEN THE M79/203, OR THE MK19! Low pressure 40mm functioning is described quite well in the following ammunition specification from Saco:

40MM, M430 HEDP (HIGH EXPLOSIVE, DUAL PURPOSE) AMMUNITION

The M430 cartridge is a fixed round of ammunition designed for use against personnel and lightly armored vehicles. The round consists of an internally embossed one-piece steel projectile body which is press-fitted into an aluminum bi-chambered cartridge case assembly. The projectile body is fitted with a metal rotating band. A PIBD fuze assembly with a Composition "B" spitback charge and copper core liner is threaded into the open end of the projectile cavity. The fuze assembly seals the front end of the projectile cavity which contains the high-explosive shaped-charge.

The propelling charge is contained in a spherical high-pressure propellant chamber with vent holes in the top sealed with a copper closing cup. The chamber is sealed at the bottom with an aluminum base plug which is crimped into the base of the cartridge case. There is a hollow chamber in

the case between the high-pressure chamber and the projectile base which acts as a low-pressure chamber. A percussion primer is crimped into the center of the case closing base plug.

The ammunition is loaded, assembled and packed in accordance with MIL-48684 (AR).

FUNCTIONING

The weapon firing pin strikes the percussion primer igniting the propelling charge. Pressure, generated by the burning propellant in the high-pressure chamber forces the expanding gases through the vent holes into the low pressure chamber, and propels the projectile forward. The rotating band around the projectile engages the barrel rifling which imparts a spin rate of 12,000 rpm to the projectile.

When the projectile attains sufficient spin, arming begins. After the projectile has traveled 18 to 30 meters from the launcher tube, the rotor is locked in the armed position, and the fuze is armed. Upon impact with the target, the firing pin is driven into the detonator, which, in turn, initiates the spitback charge, producing a jet which initiates the RDX explosive charge. Concurrently, the RDX filler detonates, producing an armor-piercing jet of molten metal and fragmentation of the projectile body.

The M430 ammunition is linked together with M16A2 links and packaged either in the 48-round M548 container or the 32-round PA 120 container. The ammunition should be ordered in multiples of full pallets to realize the most cost effective shipping charges."

Note that the factory description includes the description of an explosive jet in the charge — this is considered a "shaped charge," capable of penetrating 2" of armor.

There are other ammunition types available:

M-430 described above (yellow ogive, band is olive drab with yellow markings, base is olive drab)

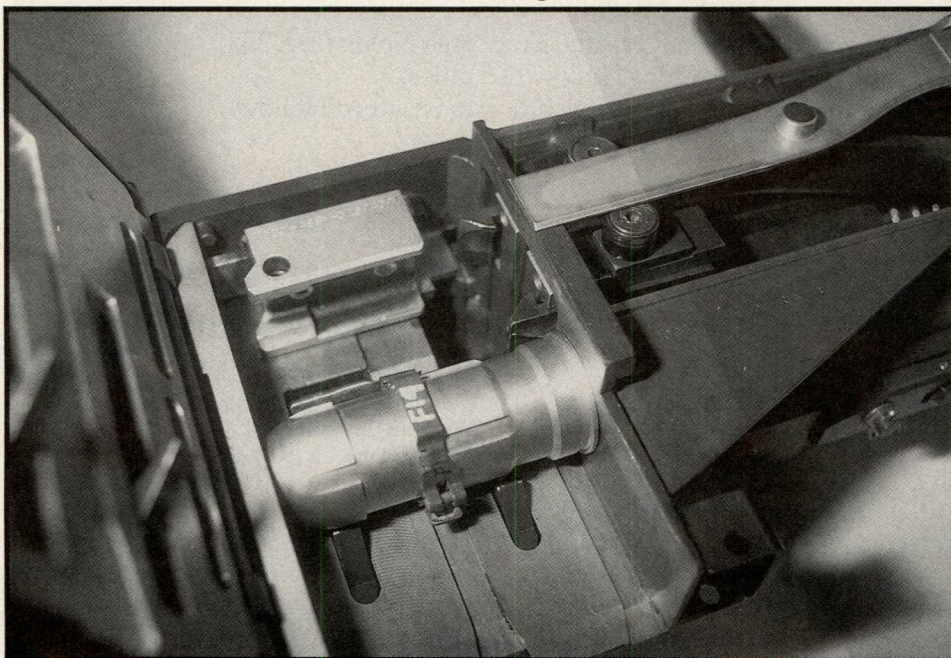
M-383 HE High Explosive (yellow ogive, band is olive drab with white markings, base is olive drab)

M-385 TP target practice with inert projectile (blue ogive, band is blue with white markings, base is blue)

M-918 TP target practice with 1 gram flash marking projectile

Dummy rounds — totally inert as well as a new tear gas round by Nico Pyrotechnik.

In recent years, fire control has been



Dummy round in feed tray positioned for first charging.

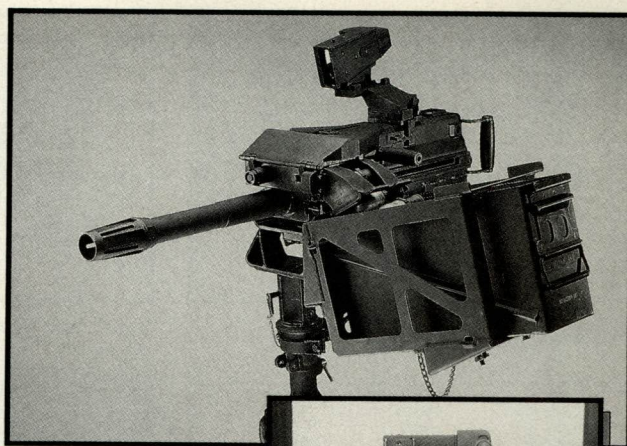
the focal point of the Saco Team headed by Kevin Sullivan. The original sighting system on the MK19 was essentially the same ladder type sight as is on the M79. This system leaves a lot to be desired. Saco focused on three basic problems: ability to mount an optical sight, projectile drift, and use of the modern night vision devices, lasers and range finders. The solution that they arrived at was a sight base that was mounted off to the top right of the receiver, allowing for 30 degrees of elevation with a full field of view. This also reduces "blooming" problems with night vision, as well as heat rise off the barrel when using thermal sighting devices. (The new flash suppressor had virtually eliminated the blooming problem.)

The base has an iron sight built in, and has a triangular base that allows for a repeatable bore sight. The ring sight WC-30, which is the recommended system for the MK19, is an optical day sight with graduations from 200 to 2000 meters. Illumination is by natural light or an attachable LED. It mounts on the Saco sight base. Drift is compensated for in the WC-30 system — this is critical considering that the 40mm round has a 60-meter drift to the right at 2000 meters! Up until the WC-30 system,

the gunner had to use "Kentucky windage." This sight base will accept the TVS-13 laser, TVS-5 MILES, PAC4-B Laser pointer, Aimpoint and F/C devices. The military required that the new sighting system would accept and use current sighting devices. The U.S. Army Battle Lab did extensive testing on the WC-30 system, and has endorsed it. The retrofit is drilling four non threaded holes in the receiver.

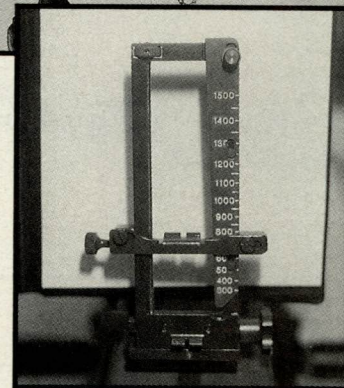
Your faithful correspondent was invited by Saco Defense to go fire 25 cases of HE at a demo in the United Arab Republic. Unfortunately, due to a conflict in schedule, I was unable to attend. (Let's not forget budget restraints.) Later this year I will be accompanying them to another demo, and will brief you on the live fire.

Government purchasers may contact:
Kevin Sullivan, Program Manager MK19
Saco Defense Inc.
291 North St.
Saco, ME 04072-0890 USA
Fax (207) 283-1395



Top: Daylight Optic and adjustable sight bracket.

Right: Rear sight ladder.



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MK19 Field Strip Instructions next page.

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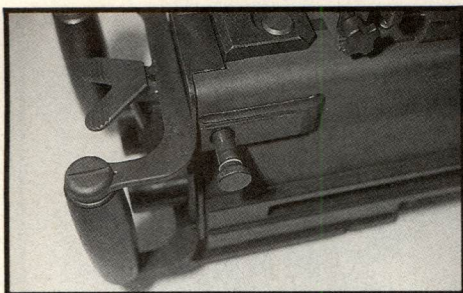
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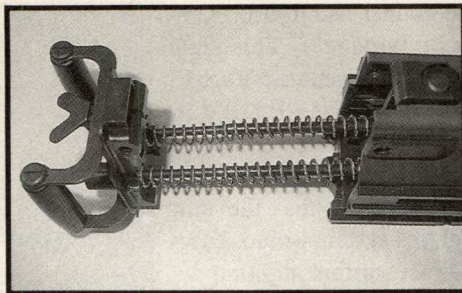
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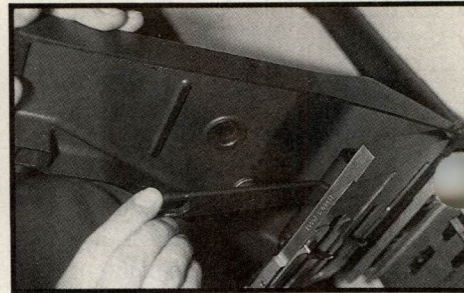
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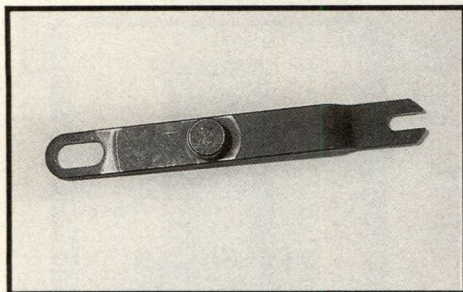
A. Backplate pin being removed.



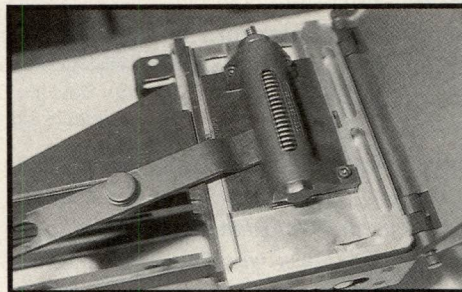
B. Bolt and Backplate assembly being removed.



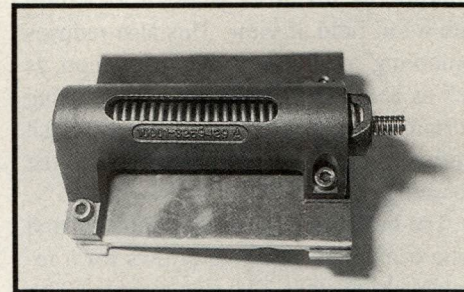
C. Removing secondary drive lever.



D. Secondary drive lever.



E. Secondary drive lever and feed slide assembly lowered out of top cover, showing how feed mechanism functions.



F. Feed slide assembly.

MK19 **FIELD STRIP**

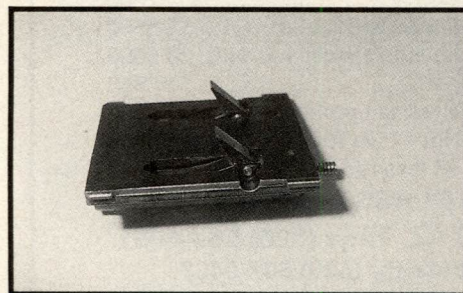
- A. Point weapon in safe direction.
- B. Clear gun of ammo.
- C. Put BOLT in FORWARD position.
- D. Rest gun on mount or flat surface.

1. Remove BOLT AND BACKPLATE ASSEMBLY.

WARNING

Be sure bolt is forward before removing backplate pin! Serious injury could result!

- A. Pull straight out on backplate pin. Use rim of a spent case.
 - B. Lift up slightly on backplate assembly. Pull it to the rear, until it "clicks."
 - C. Pull the safety on FIRE.
 - D. Support assembly with both hands and pull rearward. (Lift the bolt up slightly to remove it.)
- 2. Remove SECONDARY DRIVE LEVER.**
- A. Raise top cover.
 - B. Push down on pivot post (from outside top cover). This releases the secondary drive lever.
 - C. Lift out secondary drive lever.



G. Feed slide assembly.

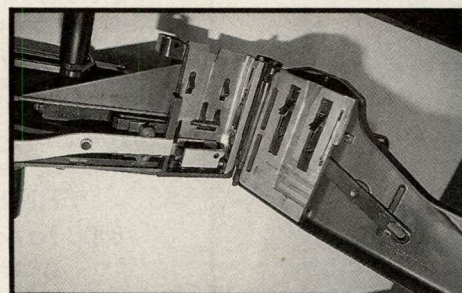
3. Remove FEED SLIDE ASSEMBLY.

- A. Fold down tray with feed slide assembly.
 - B. Move feed slide assembly to line up tabs with slots in tray.
 - C. Lift upward on feed slide assembly.
- 4. Remove TOP COVER ASSEMBLY.**
- A. Hold top cover STRAIGHT UP.
 - B. Pull straight out on pins twisting as you pull.
 - C. Lift off top cover.
- 5. Remove FEED TRAY.**

NOTE:

Feed tray must be down to remove top cover pins.

- A. Top cover assembly must be removed first.
 - B. Lift tray out of feeder.
- 6. Remove PRIMARY DRIVE LEVER, and 7. Remove VERTICAL CAM ASSEMBLY.**
- A. Reach under top of receiver to locate the drive lever lock (on the vertical cam assembly). Slide the lock rearward (about 1/4 inch).
 - B. Press down on the primary drive lever's pivot post. This releases both the primary



H. MK19 with top cover open, showing feed mechanism.

drive lever and vertical cam.

- C. Pull out the lever and cam from the receiver (either end).

8. Remove ALIGNMENT GUIDE ASSEMBLY.

- A. Depress the flat leaf spring by using a cartridge link or small tool.
- B. Slide alignment guide toward feeder mouth.
- C. Pull rearward on alignment guide, and lift it out.

9. Remove OGIVE PLUNGER.

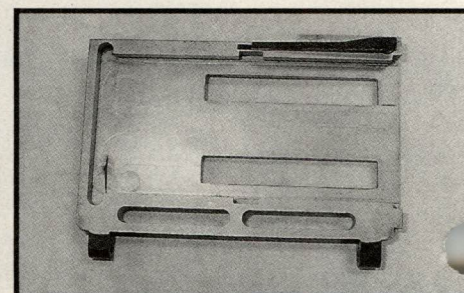
- A. Alignment guide must be removed first.
- B. Pull out ogive plunger.

10. Remove ROUND POSITIONING BLOCK.

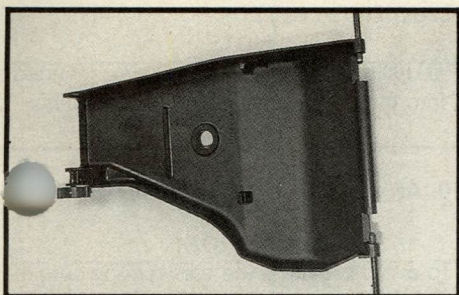
- A. First remove ALIGNMENT GUIDE.
- B. Slide round positioning block toward muzzle-end of gun.
- C. Pull round positioning block away from wall of receiver.

11. Remove CHARGER ASSEMBLIES (both sides).

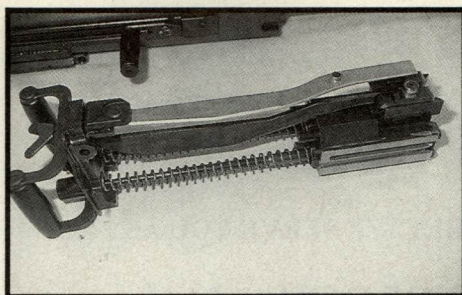
- A. Rotate charger handle up.
- B. Hook the rim of a spent case under the lip of the lock plunger.
- C. Lift up on lock plunger to retract it, and slide charger assembly all the way rearward.



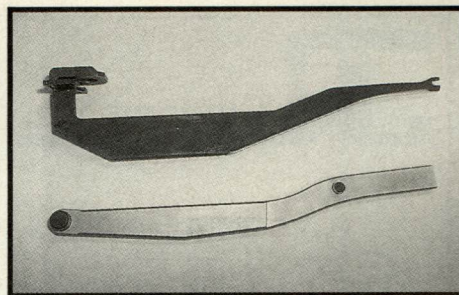
I. Stripped feed slide.



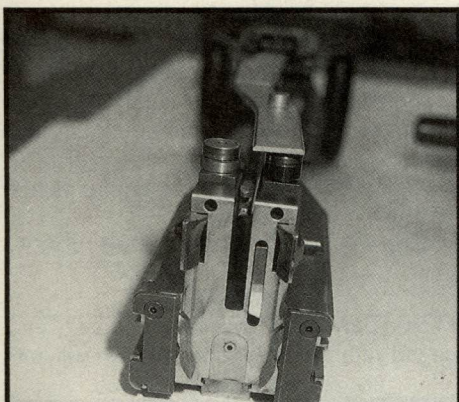
J. Top cover, with pins.



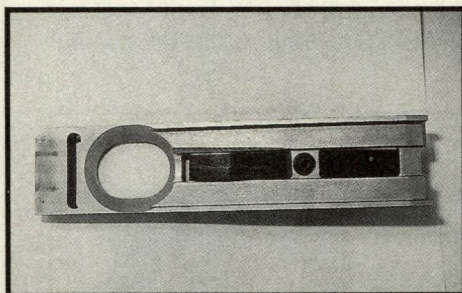
K. Bolt and backplate with vertical cam assembly and primary drive lever in position.



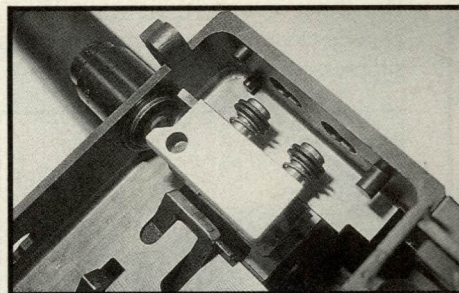
L. Vertical cam assembly and primary drive lever.



M. Bolt face showing dual extractors, top rollers, vertical cam lever in center slot, and primary drive lever on top.



N. Alignment guide assembly.



O. Round positioning block and ogive plunger in position.

D. Pull charger assembly away from receiver.

12. Remove SEAR HOUSING ASSEMBLY.

A. Turn receiver on its side. Put safety in FIRE position.

B. Lift up slightly on lockpin with cartridge link.

C. Squeeze receiver sear (underneath safety) and safety together. Rotate sear housing assembly 90 degrees in either direction (see note below).

D. Press tip of sear down while you put safety on SAFE. This locks the sear in "down" position.

E. Lift out sear housing assembly.

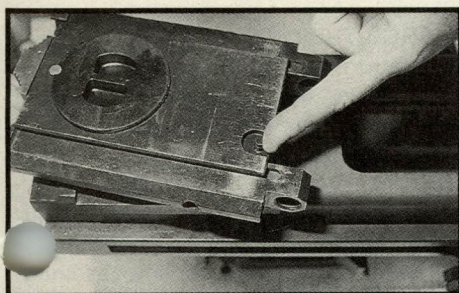
NOTE:

Continue to depress the safety while rotating the housing. It makes the job easier.

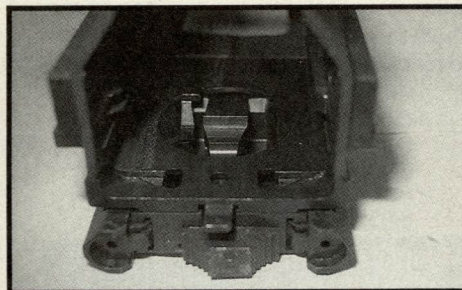
ASSEMBLY

1. Attach SEAR HOUSING ASSEMBLY

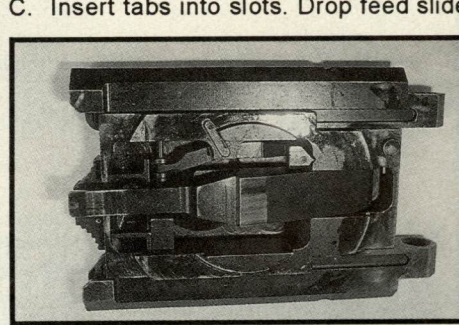
A. Put safety in FIRE position. Squeeze



P. Sear housing assembly (detent).



Q. Inside the MK19. Safety at bottom, sear housing removal lever, the sear is in the center of the photo.



R. Sear housing assembly.

sear and safety together while installing assembly.

B. Line up sear housing assembly at right-angle to barrel centerline.

C. Twist the housing 90 degrees until assembly locks in place.

NOTE:

Continue to depress the safety while rotating the housing, until it locks in place.

2. Attach CHARGER ASSEMBLIES (both sides).

A. Rotate charger handle to straight-up position.

B. Line up lugs on charger with slots in receiver rail. Insert charger lugs into slots.

C. Hold charger tightly against rail. Slide charger forward until it locks in place.

3. Attach ROUND POSITIONING BLOCK.

A. Insert block into slots, with the tang-end forward.

B. Push against block and slide it toward the rear until block locks in place.

4. Insert OGIVE PLUNGER ASSEMBLY.

A. Insert ogive plunger assembly.

5. Insert ALIGNMENT GUIDE ASSEMBLY.

A. Position the alignment guide assembly so that the pin is lined up with slot in feeder wall.

B. Depress leaf spring as you slide the alignment guide all the way into the feeder, until it "clicks."

6. Engage VERTICAL CAM ASSEMBLY.

A. Slide vertical cam assembly through rear of receiver. Raised portion should slide over hole in receiver. Drive lever lock should be underneath.

B. Engage forked end in the notch.

C. Hold vertical cam in place while you insert primary drive lever (step 7.)

7. Engage PRIMARY DRIVE LEVER.

A. While holding vertical cam assembly.

B. Slide primary drive lever into receiver.

C. Engage pivot post of lever through holes in receiver and vertical cam.

D. Slide drive lever lock (on the vertical cam just beneath top of receiver) forward.

8. Attach FEED TRAY and 9. Feed SLIDE ASSEMBLY.

A. Drop tray into top of feeder, recessed side up. Pinholes on tray should line up with lugs on receiver.

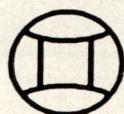
B. Position feed slide assembly so that tabs are lined up with slots in tray.

C. Insert tabs into slots. Drop feed slide



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assembly into tray.

NOTE:

Feed slide assembly may also be inserted into tray before the tray is placed in the feeder.

10. Attach TOP COVER ASSEMBLY

CAUTION:

To avoid breaking the crosspin be sure it is fully inserted into the receiver before closing the top cover.

- Feedtray should be in place.
- Line up pinholes in feed tray, pinholes in top cover, and receiver lugs.
- Hold top covers STRAIGHT UP. Insert top cover pins, on both sides. Insure that the crosspin enters the receiver.
- Close cover, and insure both pins are flush.

11. Engage SECONDARY DRIVE LEVER.

WARNING

If secondary drive lever is not properly engaged with the feed slide pin, gun will not fire and may be dangerous.

- Lift the feed slide assembly and tray.
- Engage forked end of secondary drive lever with the feed slide pin.
- Press raised pivot post through hole in top cover.
- Press tray firmly against top cover.

12. Insert BOLT AND BACKPLATE ASSEMBLY.

CAUTION:

Before inserting assembly, put cocking lever in forward position.

- Make sure cocking lever is cocked and forward.
- Place safety in FIRE position. Insert bolt and backplate assembly into the receiver. When it stops, press receiver sear and slide bolt and backplate assembly all the way forward. **WATCH YOUR THUMBS!**
- Insert backplate pin to lock the assembly in place.

AFTER ASSEMBLY CHECK

CHARGE THE GUN

If bolt jams midway, hold the bolt back while opening top cover. Ride the bolt forward slowly. Clear the jam (see facing page). Close top cover.

TEST SAFE AND FIRE POSITIONS

After FIRE, open top cover. Make sure firing pin is forward. If firing pin is not forward, remove the bolt and backplate assembly. Be sure the cocking lever is forward. Reinstall the bolt and backplate assembly. MGN



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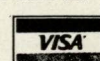
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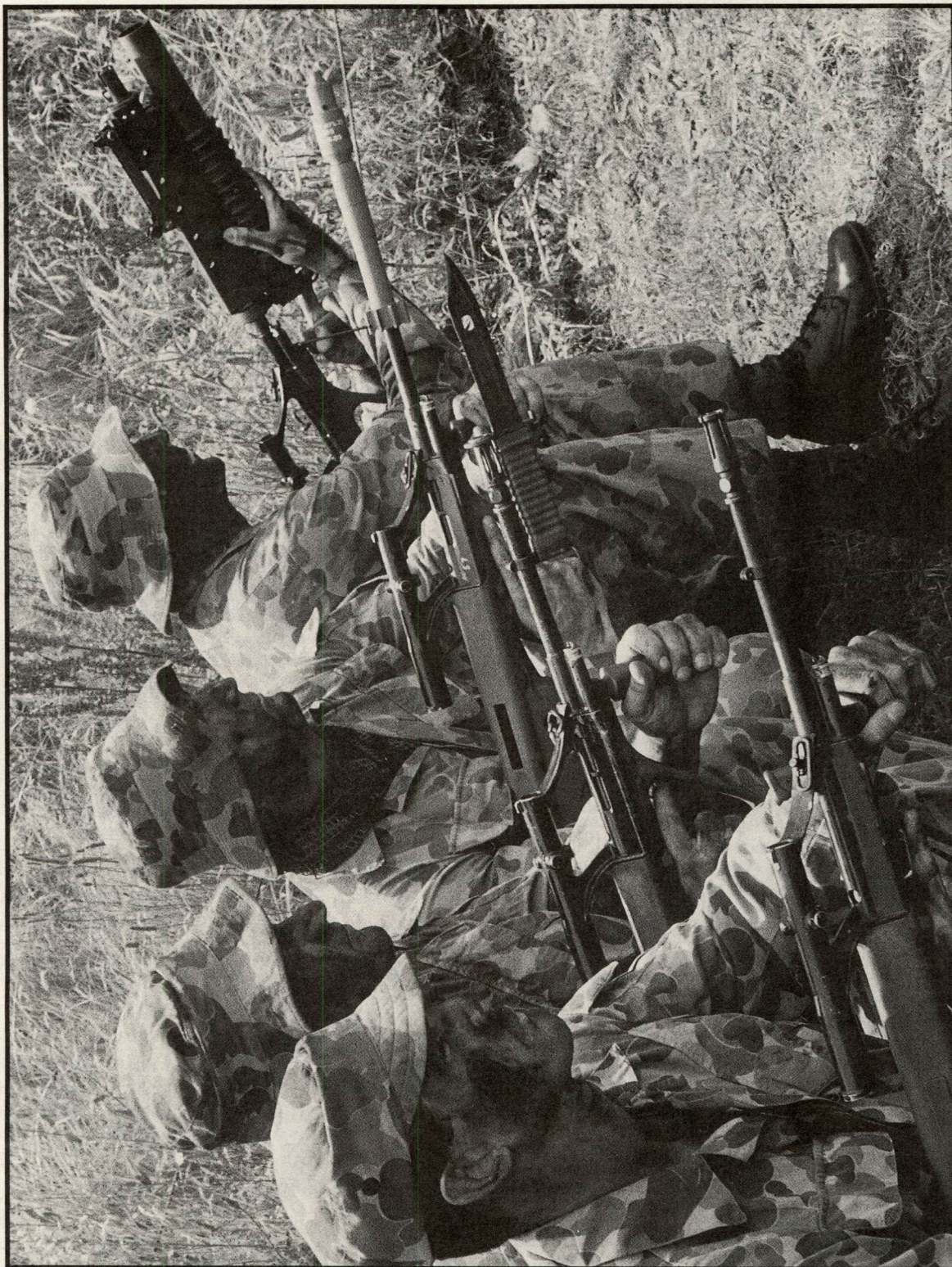
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Archive Photo of the Month

From the Robert Bruce Collection



AUSTRALIA, 1985. Aussie Special Forces troopers show off some well-used STEYR AUG assault rifles in a publicity photo taken during a series of trials of this and other prominent candidate weapons. This eventually resulted in adoption of the 5.56mm AUG as a replacement for the 7.62mm L1A1, a version of the venerable Belgian FAL as manufactured by the national arsenal at Lithgow. Note the bayonet, rifle grenade, and M203 grenade launcher. Credit: Embassy of Australia/Army Publicity Release. Copyright © 1995 ROBERT BRUCE PHOTOGRAPHY. Editor's Note: Robert regrets that he cannot handle individual requests for photographs. However, publishers and documentary filmmakers, etc., are encouraged to contact him for information on use of archive images. Send a self-addressed stamped envelope and details on intended use to ROBERT BRUCE PHOTO, P.O. 482 MGN, SAN ANTONIO, TX 78215.

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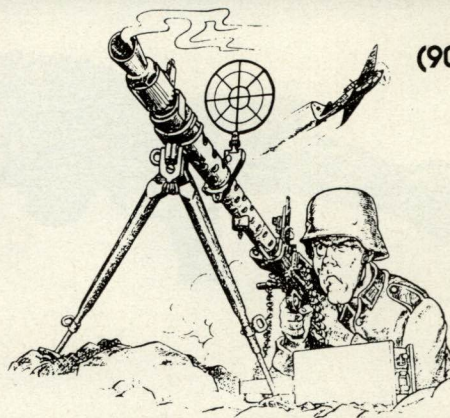
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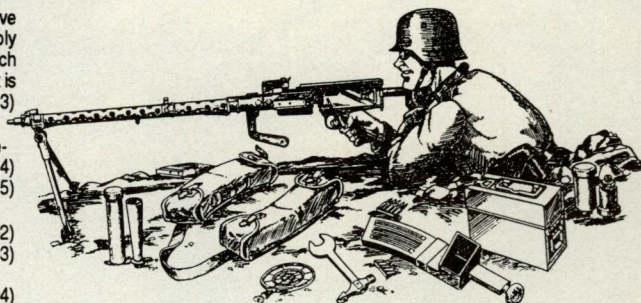
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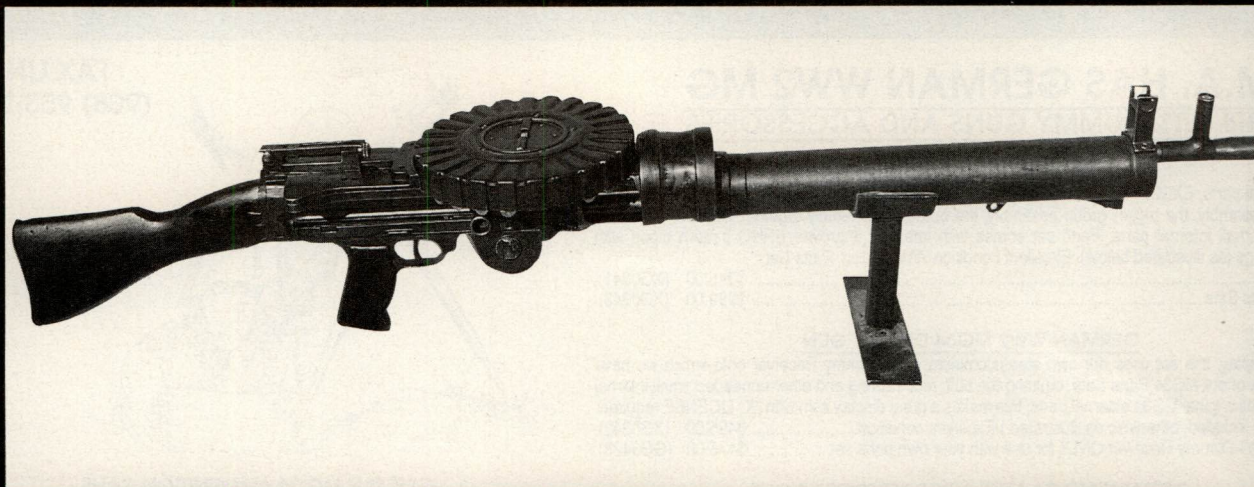
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The weight saved by lightening the ground gun into this model allowed extra loaded magazines to be carried as well as making the gun faster for the gunner to handle in aerial combat.

The Aircraft Lewis

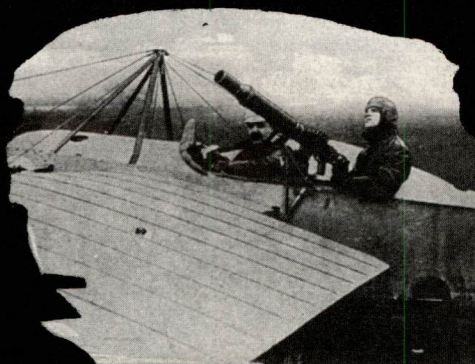
by JOHN HIPWELL

I find it rather surprising that today the venerable Lewis gun is not more popular with machine gun enthusiasts than it is. There are probably only a handful in private ownership in Canada today; the vast majority of them naturally being 1917 .303 ground guns.

By 1914 the Lewis gun was rapidly gaining popularity. It was in production at Leige, Belgium and Birmingham Small Arms Co., who produced it in .303 for the British and Canadian forces as well as in .30-06 for the U.S. The Lewis was copied and manufactured by many others in several different calibres, including the Japanese who had her in production well into WWII. During WWI it was probably the best and most popular light machine gun despite the fact it did not have a quick-change barrel.

For the first time, advancing troops had a machine gun that was truly man-portable enabling them to have real fire power with them instead of having to rely on covering fire from their Maxims and Vickers (the U. S. BAR was not available to Allied troops). Due to her light weight of 27 pounds, it was a favorite to mount on early motorcycles and vehicles.

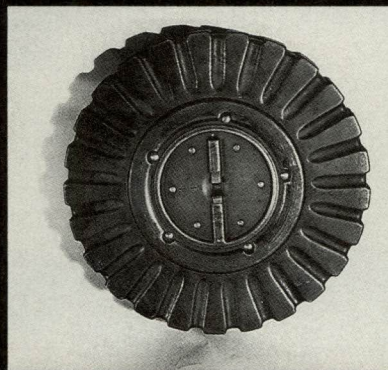
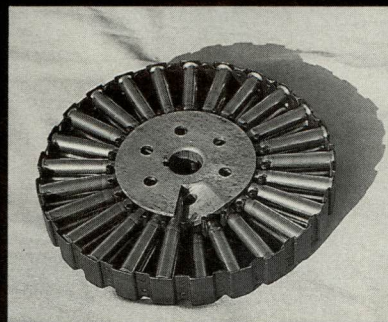
When the need arose to arm the RFC's (Royal Flying Corps) planes with a gun, the Lewis was the obvious choice. The early aerial "duels" had been fought with service revolvers and semiauto handguns which had escalated into the use of rifles and shotguns. The Germans even used a Maxim-designed semiauto rifle and the RFC acquired .30-30 Winchester 94 lever action carbine!



The first aerial use of the Lewis was with the standard ground gun. It was quickly realized that the large barrel jacket and aluminum fins were not necessary. Imagine an observer/gunner in a two-seat biplane trying to align a fast moving enemy scout in his sights whilst swinging a Lewis on an improved pintle mount, and fighting gravity, slipstream and centrifugal forces in a rapidly moving plane.

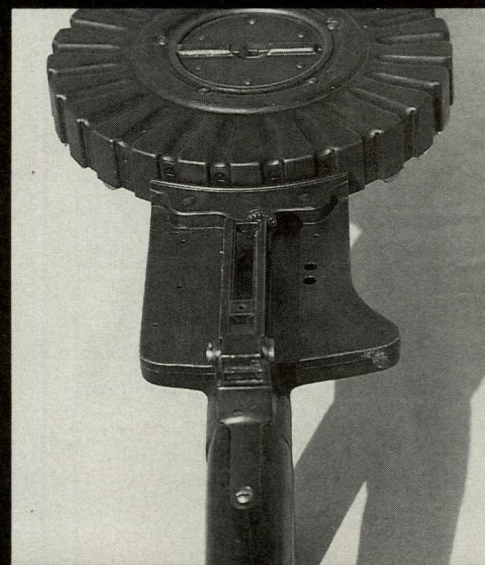
The Aircraft Lewis, which is the subject of this article, was developed from the ground gun specifically for aircraft use; this example weighs in at only 18 pounds empty. The large jacket and aluminum fins have been completely removed and a small, shorter, light-weight jacket installed. Even this jacket was subsequently discarded on most aircraft guns. This Lewis, with the small jacket, has a very elegant look compared to the long, fat ground gun.

The second obvious difference on this gun is the addition of a vertical tube between the foresight and muzzle nut. This was for the Norman wind vane sight. This was an attempt to automatically compen-



Above: Top view of the distinctive 47rd Lewis magazine. Loaded magazine weighs 4 1/2 lbs. Photo: Ed James.

Left: A fully loaded 47rd magazine showing the central spiral track holding the cartridge nose, the double row of cartridges held by their rims. A highly successful design for reliably feeding rimmed cartridges in an automatic arms. No "rim over rim" malfunctioning with this one.



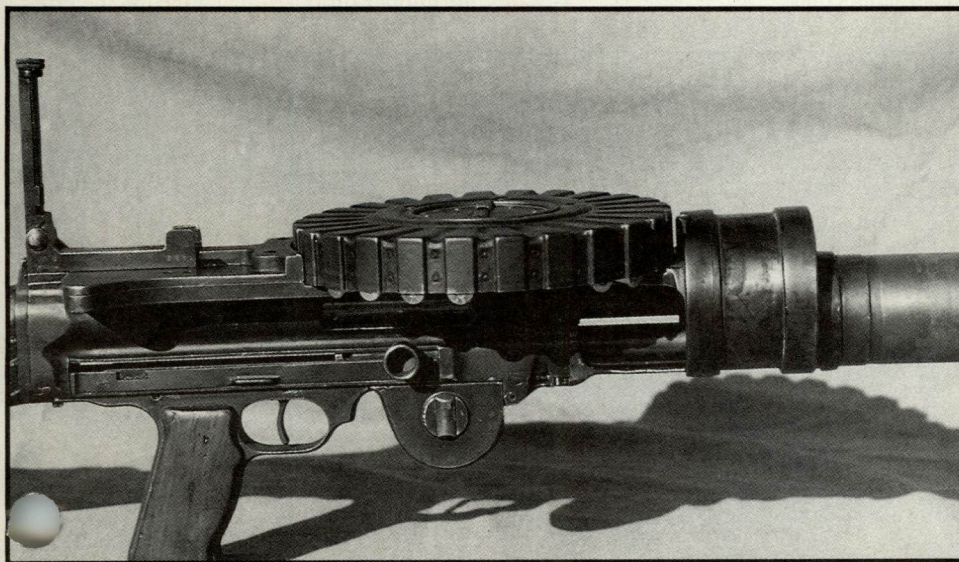
Above: Top view of the Lewis, the two mystery holes are visible here to the right of the folded down rear sight.

Lewis (Aircraft)

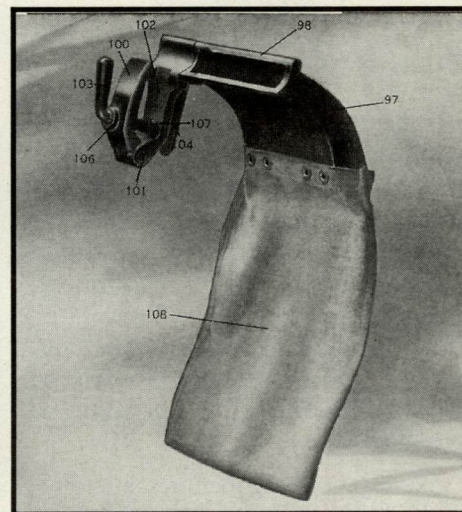
Manufactured BSA	(Birmingham Small Arms, UK)
Calibre	.303
System	Gas Automatic only
Cyclic rate	550 rpm
Feed device	47- or 97- rd. drums
Weight	18 lbs.
Barrel length	26.5"
Overall length	47.5"

sate for the aircraft speed. This pivoting foresight was often removed and regular sights utilized. Its value, fine in theory, was probably limited in practice due to the short ranges of early aerial combat, and it would obviously mislead the gunner when

affected by any eddies caused by the numerous struts and wires on early planes. Normally a large ring rear sight was used with either the vane foresight or regular foresight. On this example the aerial ring rear sight would have a base clamped around the large diameter rear barrel jacket. These aerial gun sights raised the sight



The unusual bulge forward of the trigger guard houses the unique clockwork spring which operates the action.



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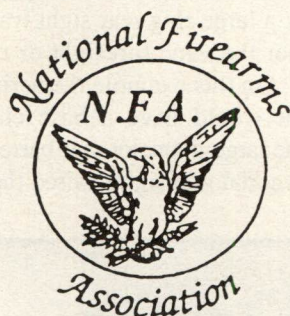
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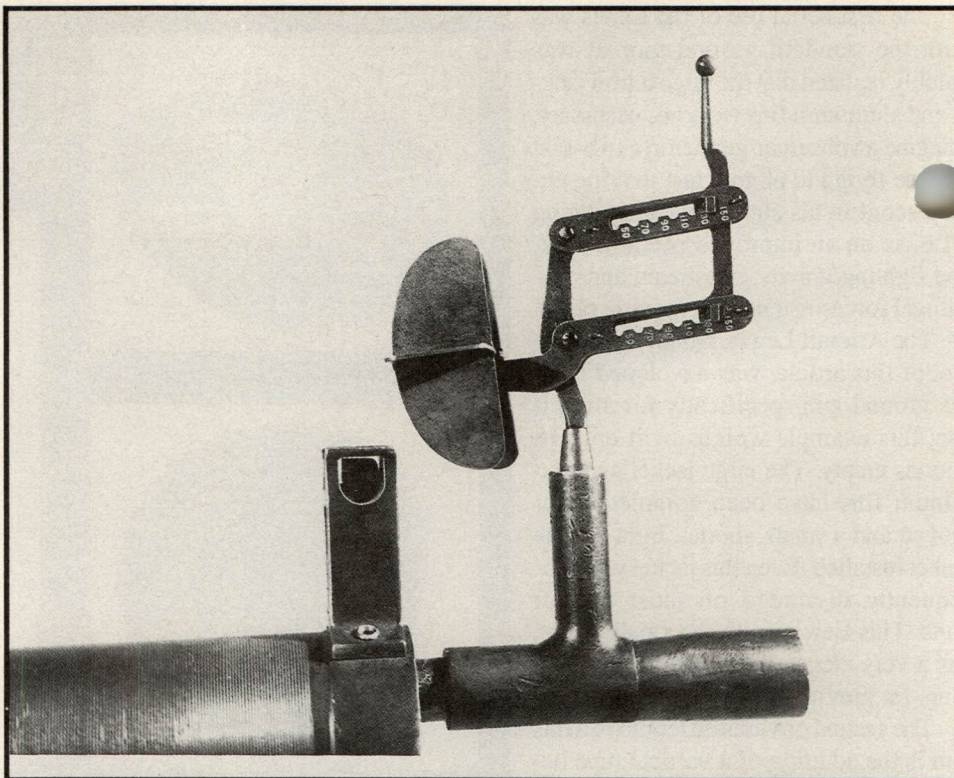
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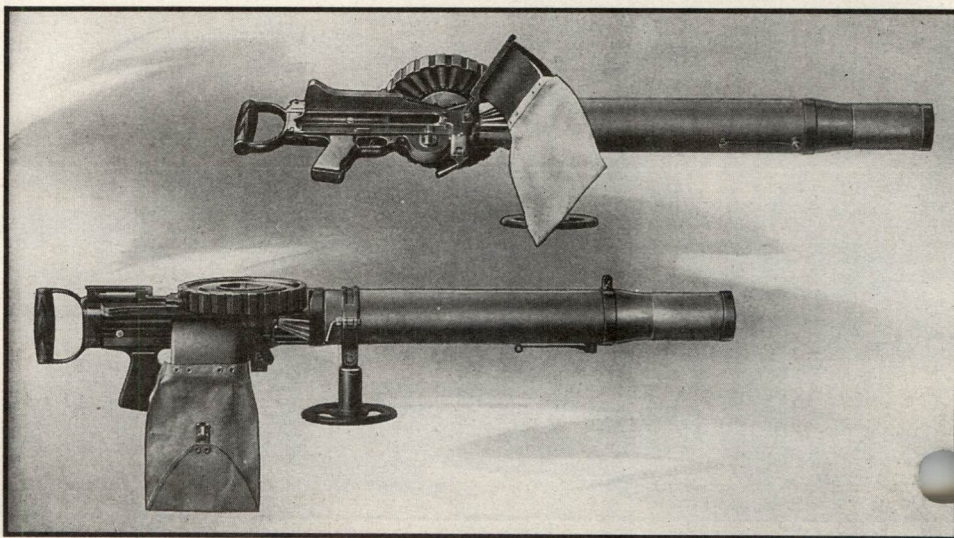
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Norman Vane front sight, air movement over the vanes caused the front sight bead to rise and fall and swing left to right, it was an attempt to simplify aerial gunning. Photo: Ed James.

line several inches above that used on the ground, thus enabling the use of a higher capacity magazine. This "aircraft" magazine was twice as thick as the ground magazine and held 97 rounds instead of the normal 47. Both magazines could be used on either model assuming high line sights were utilized. Alternatively, when mounted in pairs, a sight was often used between the guns. Interestingly, if early photos of combat aircraft are studied, it will often be noticed that when pairs of Lewis guns are used, one gun has a regular foresight and one a vane sight.

The Lewis magazine is interesting: a pan type holding 47 or 97 rounds. It gave super reliable feeding of a rimmed cartridge if clean and undamaged, but in all fairness what magazine will give reliable feed if dirty or damaged. The open bottom of the magazine was probably a real pain in that it allowed the easy access of dirt when carried by an infantryman, but I doubt this ever bothered an air gunner. Likewise, a loaded magazine is heavy, and if dropped on a hard surface, it would undoubtedly be bent out of true and then fail to feed. If an air gunner dropped his magazine, he prob-



Earlier model of the aircraft Lewis complete as mounted on aeroplane.

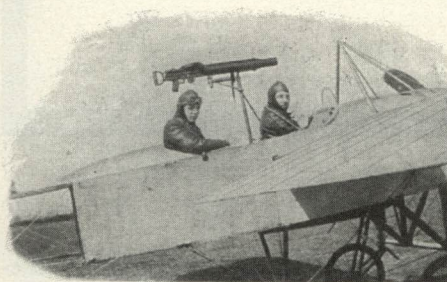
ably never saw it again! The Lewis magazine requires the use of a loading tool to turn the center boss whilst cartridges are carefully inserted, but aircraft gunners never carried loose rounds to reload—all their ammunition being in ready-loaded magazines.

Our example is B.S.A. manufactured, serial #40481. Originally this gun was registered in Canada as a restricted full auto. When the owner died, the gun was deactivated so his heir could inherit it. Under Canadian law, no individual can own a fully automatic arm if they failed to possess a registered one before 1978 when Bill C 51 was enacted. Subsequently this gun came up for sale in an auction, and I acquired her. When I realized she was indeed an unusual if not rare variant, I transferred her to the Curahee Military Museum so she could be restored into her working condition and safeguard her future survival as fits a true historically significant article.

Several minor parts were missing and I am grateful to O.G.T., Ontario and Sarco

Inc., New Jersey for their assistance in supplying the missing parts. Now rebuilt, this old girl functions well. The finish is very good apart from where, at some time in the past, the receiver was clamped in a large vise. I suspect this occurred when she was deactivated by our authorities as no careful owner would have wished to scar such a beautiful lady, but now these scars just attest to one period of her life.

This gun has the regular buttstock and from the metal finish, which is a perfect



match to the receiver, I assume it was original. Normally a spade grip was used in-

stead of the buttstock for aircraft use. I wonder if maybe this was a very early gun and used a simple pintle mount (instead of the later Scarff mount). Assuming the gunners cockpit was big enough, a regular buttstock would have been a big advantage over a spade grip. The spade grip would however make this lightweight even lighter—probably by another 1 1/2 pounds.

The rear top cover on this gun has a pair of 1/4" diameter holes drilled in it and several other smaller holes (see photo). In David Truby's excellent book *The Lewis Gun* on page 48, a top cover with similar holes (but drilled on the left side of the sight base) is shown. I would be grateful if anybody can give me a reason for these holes. I would also like to track down and acquire a 97-round drum, rear aircraft sights and a mounting pintle.

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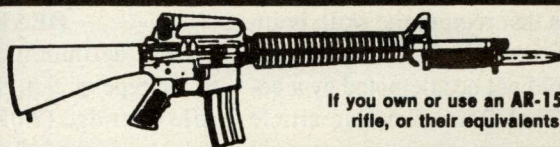
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FOCUS ON:

Basic Training: Gunsmithing Tools & Techniques Part 3: More Tools, Gauges & Tips

by CARL SILVER

Welcome back to *Focus On*: As I mentioned previously, one of the results of the reader's survey was the requests for both beginners and advanced technical articles on machine gun design and repair. The objective of the **Basic Training** articles is to explain the basics of firearm maintenance and repair. There are many tasks that require the skill, training and experience of a professional gunsmith and should not be attempted by a beginner. This **final Basic Training** article will cover measuring tools, headspace testing, a review of checking and setting the headspace and timing on the 1919A4/A6 Brownings, range "crash" kits, and (for you *M60 fans*) safety-wiring.

MEASURING TOOLS

Screw pitch gauges (leaf style) are made up of a number of thin blades. Each blade has V-shaped teeth cut along one edge that equals standard thread shapes. By matching one of the blades against the machine screw, the number of threads-per-inch (or threads-per-millimeter) can be determined. You will need two sets: English and Metric. **Steel Rules** are useful for both measuring and layout work. Get yourself a 6 and 12 inch rule with a satin finish (they are easier to read). An inexpensive steel **Protractor** is useful for measuring magazine feed angles.

The handiest measuring tool for general gunsmithing is the 6 or 8 inch **Dial Caliper**. It can be used to make inside, outside, depth and step measurements. The modern replacement for the dial caliper is the **Electronic Digital Caliper**. The primary advantage it has over the dial caliper is the ability to switch from English to Metric units at the push of a button. The more

expensive models have SPC (Statistical Process Control) outputs for production gauging.

Feeler (or thickness) Gauges are useful for measuring clearances between parts. They can also be used for setting the timing on the 1919A4/A6 Browning (see below).

HEADSPACE

The definition of headspace varies as to the type of cartridge. With a bottle-neck rifle cartridge (7.62 NATO for example), it is the distance between the shoulder of the cartridge and the boltface. With a rimmed cartridge (.303 British or .357 Magnum for examples) it is the distance between the front of the rim and the boltface. With a straight walled cartridge (.45 acp for example), it is the distance between the mouth of the case and the boltface.

This measurement is made with the cartridge fully seated in the chamber and the bolt in its locked (fully forward) position. If there is not enough headspace (too tight), the gun will run sluggishly or not at all. If you are **really** unlucky, it may break the barrel extension (1919A4/A6).

If there is excessive headspace (too loose), the gun will tear the base off of the cartridge case leaving the rest of the case stuck in the chamber (did you remember to bring your broken case extractor?). Running the gun with excessive headspace can also cause chipping of the bolt at the T-slot (1919A4/A6).

ADJUSTING THE HEADSPACE ON THE 1919A4/A6 BROWNING

The most important adjustment on the 1919A4/A6 Browning is the headspace. The manuals describe a technique for setting the headspace that worked when all of

the military barrels were manufactured with the same chamber depth. Today, with all of the different caliber conversions and nonmilitary specification barrels in use, the following method is more reliable.

Clear the gun of any ammunition, c the top cover, capture the recoil spring, remove the backplate (buffer) assembly, the bolt assembly and the trigger group. Slide the barrel and barrel extension about halfway out of the receiver. Screw the barrel into the barrel extension until the rear of the barrel is flush with the inside of the barrel extension.

Remove the extractor from the bolt. Place the bolt into the bolt guides in the barrel extension and push the bolt fully forward. Rotate the assembly so the bolt is facing downwards.

Lock the bolt to the barrel extension by pushing the breech lock fully into its seat in the bolt. Hold it firmly in position with your thumb. Screw the barrel into the barrel extension until it is stopped by contact with the forward face of the bolt. Make sure that the barrel does not force the breech lock out of its fully locked position. Rotate the assembly so that the bolt is facing upwards.

Unscrew the barrel from the barrel extension just enough to cause the breech lock to fall from its recess in the bolt. Unscrew the barrel two or three notches more. This will set the proper headspace. Remove the bolt and reassemble the gun.

This procedure takes longer to explain than to do. Once you have the correct setting, punch or grind a small reference mark into the barrel. This will aid in reassembly.

Some batches of imported ammunition do not meet NATO (.308) or their own dimensional specifications (why do you think it's so cheap?). Examine your brass after firing several rounds. If you find a shiny ring 1/4 of an inch forward of the base, this means that you have too much headspace (the brass is stretching and you are on the verge of case separation). You may need to tighten the headspace one or two clicks.

Some folks like to adjust the headspace with a **LIVE ROUND** in the chamber. **DO NOT DO THIS UNLESS YOU HAVE REMOVED THE FIRING PIN ASSEMBLY FROM THE BOLT.** If the bolt assembly is jarred, the round could fire. This would definitely ruin your day. If the headspace is correct and the gun still doesn't run properly, check the timing.

CHECKING THE TIMING ON THE 1919A4/A6 BROWNING

The timing on a gun is similar to a gasoline engine. Neither runs very well when the timing is off. The timing refers to the point in the travel of the bolt, barrel and barrel extension at which the trigger releases the sear and fires the next round. If the timing is such that the gun fires very early, the extractor will not be far enough forward to strip a round out of the belt.

This is the bang, click, empty chamber syndrome. If it fires a little early, the gun may not transfer enough energy to the feed mechanism for it to work properly. This results in needing your assistant gunner to hang off of the empty belt. If the timing is too late, the firing pin may not release at all.

To check the timing, you can use Browning Field Timing Gauge (U.S. # 7319928) or a pair of thickness gauges 0.120" (no fire) and 0.030" (fire). Clear the gun of any ammunition. Open the top cover and pull the cocking handle all the way to the rear. Slowly let the bolt slide forward while holding the extractor out of the way and the "no fire" (0.120") timing gauge between the forward edge of the barrel extension and the trunion block. Let the bolt close on the timing gauge and pull the trigger.

The firing pin should not release. If it does, then the timing is too early. If the firing pin does not release, repeat this test with the "fire" (0.030") gauge. If the firing pin does not release, then the timing is too late.

SETTING THE TIMING ON THE 1919A4/A6 BROWNING

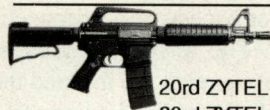
Adjusting the timing is a bit more difficult than checking it. This is a trial and error method that may require several repetitions. Disassemble the gun and remove the Lock Frame group. Using a small punch, push out the trigger pin and spring. This will allow you to remove the trigger. Hold the trigger as it would be positioned in the gun. If the timing is too early, the trigger bar must be bent between the pivot hole and the sear end to RAISE the tip of the bar. You only need to bend the bar a little bit. I use a pair of adjustable wrenches and check my progress with a straightedge.

Before you try to bend the trigger bar, check to see if it is cast steel or milled. The cast triggers have a small square block (casting riser) just above the finger groove. They tend to be brittle and will usually snap like a piece of glass when you try to bend

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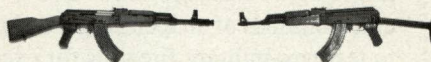
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one. The best bet is to replace a cast trigger with a milled one if the timing is off.

Reassemble the Lock Frame group and the gun, and retest the timing. If it is still off, bend the trigger bar a little more. Once the timing is set, it won't vary unless you change the trigger, sear, firing pin or have excessive wear on any of these components.

HEADSPACE GAUGES

O.K., enough of the Brownings. How do I check for excessive headspace in my other guns? The answer is **Headspace Gauges**. These gauges are inserted into the chamber and an attempt is made to close and lock the action. There are three different sized headspace gauges for each cartridge. They are **GO**, **NO-GO**, and **FIELD**. The **GO** gauge is the shortest length, and the action should fully lock-up with this gauge in the chamber. The **NO-GO** is several thousands of an inch longer and is used to test non-military firearms for excessive (dangerous!) headspace. If a nonmilitary action fully closes on the **NO-GO** gauge, it should not be fired until the headspace has been corrected.

The **FIELD** gauge was developed specifically for military firearms (which tend to be built a little heavier). It is several thousands of an inch longer than the **NO-GO** gauge. This is really the only gauge machine gunners need for testing their guns. If the action closes on the **FIELD** gauge—**DO NOT FIRE IT!**—It could **BLOW-UP** right under your nose.

RANGE "CRASH" KITS

You are probably asking yourself, "What the heck is a range crash kit?" A range crash kit contains the tools and spare parts necessary to fix any minor failures you may experience while at a machine gun "shoot." It is really depressing to have spent massive amounts of time and money to get to a shoot, only to have an extractor or firing pin failure leave you standing around swearing at your broken gun.

The contents of the crash kit vary but should include the following for each of the firearms that you bring with you:

1. **Assault Rifles & Submachine Guns:** extra firing pin, firing pin spring, extractor, extractor spring, extractor pin, ejector (if separate) recoil spring assembly, and a broken case extractor.

2. **Beltfeds:** complete spare bolt assembly with extractor assembly, extra barrel, any feed system parts that have a history of failures with your particular gun, and a broken case extractor. The reason for the complete bolt assembly is that it allows you

to put the gun "back into action" in a shorter time.

3. **Tools:** all handtools necessary to remove/replace the above parts, files and stones for fitting or deburring, plus any specialized gauges (headspace, timing, etc.)

4. **Cleaning Supplies:** cleaning rods, chamber brushes, your favorite toothbrush, etc.

SAFETY WIRING

Safety wiring originated in the aircraft industry where you need to be **absolutely sure** that fasteners will not loosen from vibration or the stress of temperature cycling. The second requirement was that the item could be disassembled on a regular basis for cleaning and inspection. Safety wire is 0.030" to 0.060" thick stainless steel wire that is used with drilled fasteners or special lock rings to prevent a fastener from loosening.

There are several details to good safety wiring technique. Always route the wire to maintain *positive tension* on the fastener in the direction necessary to **tighten** it. Keep the wiring as short as possible. Lastly, after the excess wire is cut off, bend the twisted tail out of the way.

Safety Wire Pliers are a specialized tool that clamp and twist the wire, then cut it. If you are an aircraft mechanic (or own an M60), then you need one. Figure 1 shows the proper wiring of the gas cylinder plug and gas cylinder extension washer on the M60.

MGN

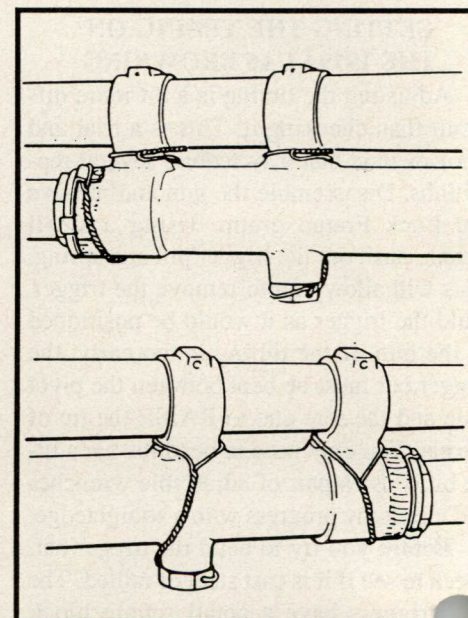
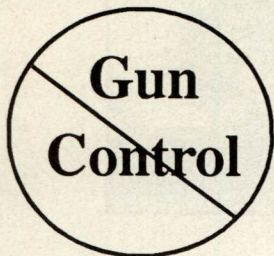


Figure 1: Safety wiring of the gas cylinder plug and gas cylinder extension washer on the M60.



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On June 4, 1995, the Committee of 1776, Inc., is sponsoring the National Rally for Firearms Rights, a pro-Second Amendment rally. The rally will be held at the Lincoln Memorial (Reflecting Pool steps) from 11 a.m. to 3 p.m.

We do not believe that the new Congress is acting quickly enough, or strongly enough, in our interests. We worked hard to elect them, and will not be forgotten. If you believe that the Federal Government has usurped your Constitutional Rights, and want them to back off and stay out of your life, then this is the Rally for you. We need to send a message to the bureaucracy that we will not tolerate any more loss of our Rights. In fact, it's time to start rolling back those losses—Revise and Rescind is the Rally theme.

The Committee of 1776 sponsored the Rally last year, and we had in excess of 15,000 people there. We sponsored the Rally at the state capitols on the July 4th weekend, and between 80 and 100,000 people were there! This year we will top that! The anti-Second Amendment fanatics are working hard against us, but we outnumber them 100 to 1. They seem to own the press. We need to get out together in a large enough group that they can't deny us any longer! When we get together as a group—you will know that you are not a minority—we will not be denied!

For more info write to: The Committee of 1776, Inc.
P.O. Box 558
Templeton, MA 01468

Organize charter bus trips and caravans from your state! Call in to talk radio shows! Go to gun shops and post this message. Put it on computer bulletin boards, fax it around, **GET THE WORD OUT THERE!** To be a state organizer, call (508) 939-4867 or fax the same number.

If you want your money to work for you, in a way that you can see, feel and hear, donate to the Rally fund—Checks should be made out to: "The Committee of 1776, Inc.-Rally Fund." We pledge that every penny will go to the Rally—we are all unpaid volunteers!

Invited speakers include:

G. Gordon Liddy
Sen. Phil Gramm
Roy Innis
Pat Buchanan
Alan Keyes

Larry Pratt
Joe Tartaro
Rep. Steve Stockman
John Snyder
Dr. Suzzanna Cratia

Rep. Bob Dornan
Sheriff Richard Mack
Ellen Saubrey
Stan Soloman
Kurt Lyons

and other local and national leaders in the fight for our Constitution.

BE THERE & BE HEARD!!

The Ammo Bunker

by guest columnist **FRANK IANNAMICO**
High Volume Reloading



It's hard for me to imagine a Class 3 enthusiast that doesn't reload. I guess the abundance and relatively cheap price of surplus ammunition has kept more than a few machine gunners away from the reloading presses—especially in the rifle calibers. Now, however, current political events are starting to change the surplus ammunition market. Many sources of ammo are disappearing, such as China, and what is available is very expensive. I suspect in the very near future, if you are going to shoot a lot of ammo, you are going to have to load it yourself. Even the reloading components are in short supply, although that is finally starting to stabilize now. The only problem that existed to cause the shortage was panic buying that was not based on any facts, just paranoia, which did nothing but drive up the prices of components.

A lot of the material contained in this article may be common knowledge for a lot of you RKI's out there. Please bear in mind a lot of MG shooters are new to the sport and may not have ever reloaded before. I'm sure, after they have had a few years of reloading experience, they may discover some shortcuts and tips contained herein. I'm just trying to save them time. This article is not a basic reloading course. It is about a few shortcuts and things I have discovered through the reloading of thousands of cartridges.

One of the key things of volume reloading is being organized. Even if you have a progressive press that can load 600-plus rounds an hour, you are constantly looking for things. How much time are you actually spending reloading? To be organized you need to keep all your dies, bullets, cases, etc., stored and marked neatly in separate containers or cabinets.

Another timesaver is to be sure every-

thing is clean and in good condition. After loading a couple thousand .45 cases, before storing the dies, shell holders, and other tools, take 10 minutes or so and clean everything. Use bore cleaner to clean up the dies (especially when using cast bullets). Wipe off the press and relube it. You will be amazed at how much easier your press will operate if you clean and relube the ram. Sweep off excess powder from around the press. Clean the primer cup and related parts. This information is especially true on a progressive press. If your loading a large amount of cartridges, a progressive is the only way to go. Once everything is cleaned, there is a lot less chance of your press jamming or causing problems once you start reloading your next run of cartridges.

BRASS

Now that you have everything organized, the first component is the brass case. I have read a lot of reloading data stating to keep the case length to a certain length. While this may be true of rifle cases, I've never had to trim a pistol case. Usually, pistol cases split long before they stretch enough to trim. Rifle cases—well that is a totally different story. A high pressure rifle case may be reloaded about five times before trimming is needed (this depends on loads, chamber, etc.). Trimming is usually .010" under the maximum length. Too long a case can cause many problems. For example, if a case is too long it will extend into the barrel rifling and pinch the bullet causing a high pressure condition. .30 carbine rounds are especially critical on length. These cases headspace on the case mouth. If the case is too short, it will cause a headspace problem and excess pressure. If the case is too long, the bolt will not fully close, and since the M1 Carbine has a floating firing pin, this could

cause the cartridge to fire with the bolt unlocked...a bad situation for the shooter and the weapon.

This rifle case length brings us back to organization. One way to track if cases are due to be trimmed is, trim a few hundred, assign them a batch number and keep track of how many times you have fired them. This will keep you from excess measuring and trimming.

The easiest way I have found to trim cases is by using Lee brand trimming tools and a drill press. The Lee system consists of several inexpensive parts: a cutter, a case length guide, and a shell holder. The length guide and shell holder are available for most calibers. You only need one cutting tool. The use of these tools is easy, fast and most importantly, accurate. Although they were made to be used manually, a drill press really speeds up the process. First, chuck the cutter into your drill press. Next, screw in the proper case-length tool into the cutting tool. Place the shell case into the case holder. Turn on the drill, and while holding the shell holder with your hand (keep your hand away from the cutting tool!), push it over the case length guide and apply slight pressure. The case length tool will keep it from trimming the case too short. As long as you keep your fingers away from the cutting tool, this a fast method for the tedious job of case trimming.

I have found that a drill press is a very valuable tool for case trimming. You can usually purchase them on sale at the larger variety stores for about the same price as an electric case trimmer. A drill press, set at a slow speed, can also expedite the deburring of cases. Chuck the deburring tool into the drill press (you can buy an adapter so it will fit in a 1/2" drill chuck) and while **CAREFULLY** holding the case

with your hand, deburr cases at a very fast pace. Several companies, such as Lyman and RCBS, make case holders for use on drill presses. These are valuable if you do not use the Lee method and set the drill up to cut your cases by adjusting the stops on the press. As a bonus you can use a drill press to drill holes when you are not using it to trim or deburr cases.

Dillon makes a very effective electric case trimmer, the 1200B. It is possible to size and trim a case at the same time! It mounts on the first stage of a progressive press, and the cutter is mounted on top of the sizing die. A vacuum cleaner is attached to suck away the cuttings. Dies are available to change calibers.

PRIMERS

Primers and primer pockets: If you are shooting a machine gun, chances are that you will sooner or later run into crimped primers. These can be difficult to decap at times and may break a few decapping pins. A Lee decapping tool is very handy for this task. It is simply a punch with a hardened steel tip, although you will be decapping one case at a time.

To remove the crimp from the primer pocket, there are several tools available. Dillon makes an excellent crimp removing device, the Dillon Super Swage 600. RCBS makes one that is used with a reloading press. Lyman makes a decrimping tool that is nothing more than a reamer with a handle. They come in large and small primer size. I keep one of each size in my tool box for any cases that I may have missed in the decrimping process or any cases picked up at the range that may have a crimp. Using one of these hand reamers for a case or two saves the setting-up process required by the other types of decrimpers. Open bolt guns have a tendency to pound the back of cartridge cases. Sometimes this will put a burr on the primer pocket making it difficult to insert a fresh primer. Lyman reaming tools are very handy for deburring cartridges.

Empty primer boxes are handy for keeping track of how many rounds you've loaded. By writing the caliber you loaded on the empty box, then at the end of the year or whenever you decide you want to know how many you have loaded, count the empty boxes.

RELOADING DIES

Dies: All the dies on the market today will do a satisfactory job. There are a couple of specialty dies that merit mention-

ing. One is a taper crimp die, a must on automatic pistol calibers, and I also like to use them on cartridges for my bolt action rifles because they are easier on the neck—they don't "work" the brass as much as a roll crimp does. The other die is a decapping die. The procedure I use to reload rifle caliber is to first lube and size the cases on a single stage press, trim as needed, and clean off the lube by tumbling. Then I run them as I normally would on my Dillon progressive, except I use a decapping die on the first stage rather than a sizing die. The decapping die will punch out any media left in the primer flash hole.

After tumbling brass, removing the media from the inside of the cases is sometimes difficult. I have found that the solution is to use a sifter on top of your tumbler. You will need a large container to empty the contents of your tumbler into. Place the sifter on top of your empty tumbler (see photo). Turn your tumbler on. Slowly pour the contents of the container, through the sifter, back into your tumbler. The media will go back into your tumbler, and the cases will have all the media shaken out of them, except for possibly the primer flash holes, and if you use a decapping die as previous paragraph suggests your media problems will be solved.

POWDER

I only use bulk surplus powders that I purchase through dealers like the ones that advertise in the classified ads in *Shotgun News*, *Machine Gun News*, or the *Gun List*. If you get together with a few other volume shooters and purchase a large quantity, you can usually make a better deal. There are bulk powders for just about any application you could think of, rifle or pistol. As a safety precaution, I always label the powder container on my press with what powder is in it—my memory is not what it used to be.

PROJECTILES

For pistol caliber applications many reloaders use cast lead bullets. Any leading problems can be controlled by using an Outers' FOUL OUT electronic bore cleaner that removes lead. A preventive step is to thoroughly clean the bore. Then using a proper size bronze bore brush, dipped in Break-Free lubricant, run the coated brush through the bore about ten times and let it sit for 24 hours. After it has had time to penetrate, take a clean patch, and remove the excess lube. You will find this helps to reduce leading substantially.

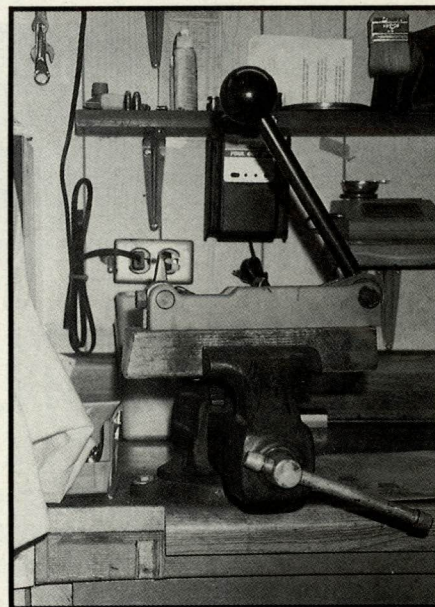
ACCESSORIES

If you are like most reloaders, you have all types of tools and accessories cluttering up your work area. I have my Dillon decrimping tool, my Forester deburring tool (it looks like a pencil sharpener), and various others mounted on a piece of 2"x4" wood block. When I want to use them, I clamp them in my vise. I have a single-stage reloading press that is mounted on a piece of 2"x6" wood block that I "C" clamp to my reloading bench. Using this method, I only have the tools on the bench when I'm actually using them.

If you have never reloaded before, you may be hesitant to start. The initial investment, although substantial, will pay for itself very quickly. Reloading can be very enjoyable. You may feel as though you do not have the time to invest in reloading. I personally am very busy during the week, so I make it a point to load 100 rounds each



By using a sifter with your tumbler you can shake the media out of the cases fast.



Mounting tools on wood blocks keeps them off your bench until you need them.

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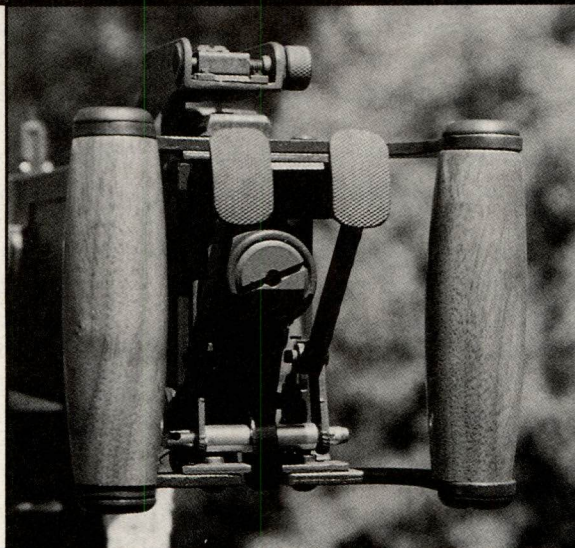
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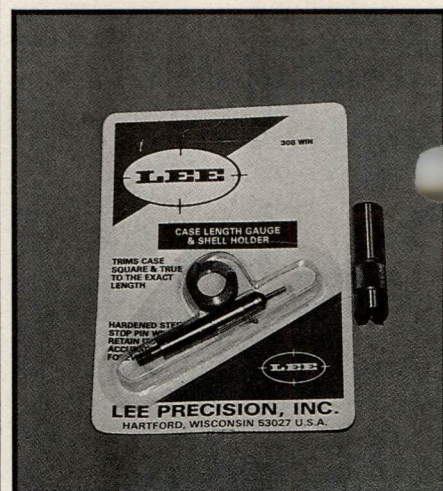
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Lee case trimming tools are inexpensive and accurate. Cutting tool is at left.

day while I'm making my morning coffee. It takes me 11 minutes to load 100 rounds and I'm reloading 700 rounds a week with no effort and little time each day.

Catalogs with reloading tools and supplies are available from all the major manufacturers like RCBS, Lyman, Lee, Forester, Dillon and others. You will find all types of tools and equipment to make reloading easier in these catalogs. Midway, a reloading supplier, offers a free three-month subscription to their monthly catalog—a dealers catalog is available to FFL holders. Dillon Precision will send you their monthly catalog as well; simply call them and ask them to put you on their mailing list.

I hope my past experience may save you some time, money or hopefully both. The more time and money you save, the more you can shoot! Above all, be careful any time you are reloading. Complacency can be very dangerous when your dealing with components like gunpowder and primers. Always consult a reliable reloading manual for proper, safe loads, and complete safety instructions. **MGN**

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The Forms

by **DAN SHEA**

I have finally gotten the word on the Examiner groups at NFA Branch. As many of you are aware, there have been many changes to the transfer procedures. Instead of there being one examiner handling a group of transfers according to a division of the alphabet that your company name is on, there are now three groups, each taking care of different forms. Each "Group" is composed of 3 examiners, and overseen by a specialist.

Group A:
Form 4's
Form 5's to individuals
Form 1's

Group B:
Form 2's
Form 2's with attached Form 3's
Form 3's
Form 4's to Dealers

Group C:
All other transfers
Law Enforcement Transfers

Accordingly, the new structure at NFA Branch, ATF, appears as follows (this is not an official release, merely my extrapolation from the data that I have gathered):

Chief, NFA Branch (Thomas Busey)
2 Technical Specialists
2 Archive Specialists
1 Quality Review Specialist and 1 Quality Review Examiner
1 Specialist and 1 Examiner on the Streetsweeper/USAS-12/Striker project
Supervisor of Examiners, (Sylvia Alexander)
Group "A": 3 Examiners
Group "B": 3 Examiners
Group "C": 3 Examiners
2 Detail Clerks
1 Secretary

In addition, each "Group" is supervised by one of the above listed specialists.

If I get more information, I will try to get it in the next issue.

Q I am a subscriber and I have some questions regarding registering a Streetsweeper on a Form 1 "Application to Make &

Register a Firearm." According to your April '94 article, corporations register Form 1's front only (no law enforcement signature required). The local ATF says otherwise. Also, how does one indicate on the form that no tax is required?

Marshall L.

A In the upper right hand corner of the form, check tax exempt, then type, "Per government order." Yes, a corporation can register the Streetsweeper, Striker, or USAS-12 without the law enforcement signature, photos, and fingerprints. Many local ATF offices are not aware of this procedure. When you sign at the bottom of the form, you are signing as an officer of the corporation. You can not use this as a way around the law enforcement signature, because on the dissolution of the corporation, the firearm must be transferred out. Remember that the possession of this firearm is retained by the corporation.

Q I bought an H&K "911" last year. I understand it to be basically an H&K 91 cosmetically doctored to comply with the import embargo. The extra "1" in "911" was definitely stamped separately from the "91." It has a thumbhole "sporter" stock, and a cover over what I guess is a threaded barrel, no bayonet lug. I want to convert it to full-auto with a drop-in sear. I have three questions:

1) The cover over the barrel has what looks like a spot weld a few inches from the muzzle. It might be a direct weld or it might be a set screw welded over to prevent removal. How do I get that cover off?

2) I was told that less than one thousand 91's configured this way were ever imported. Is the gun more valuable/collectible the way it is than it would be as a more conventionally outfitted full-auto?

3) This one's probably for the "Forms" column. Am I free to configure the rifle any way I choose, once I receive the tax stamp, even though it was shipped into the country in "sporter" style?

Any suggestions or opinions will be appreciated.

Chuck K.

A First, mill down on the weld to see if

it's a screw—I doubt it. Tread softly here—you may need to turn it off. I do not think that there were many of the 911 style that came in. As things are right now, they are not "collectible" because of the 911 configuration. That is a detriment. People want the HK-91 preban configuration.

When you get the registered HK sear, you can pretty much do what you want with the 911: shorter barrel, stock, etc. Once it's a machine gun, that takes precedence over the other categories. At least I haven't seen any negative rulings on any of the changes on the after-ban firearms if you have a registered sear.

Q Could you please help me out with a question I have. I own a Ruger AC556F folder with 13" barrel. I recently had a gunsmith install a 16" barrel and put this into a wood full stock. Should I write to NFA and advise them of this? If so, do I just tell them what I have done? What address should I send this to?

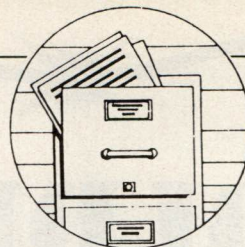
Mike T

A Once again, you should make a copy of your registration Form 1,3,4, or 5 with the new measurements. Write a letter to ATF explaining the changes in measurement and send it to them with a copy of the form. They will amend the registry to reflect the new dimensions.

Q I'm interested in obtaining a full-auto for my personal collection/fun. Does the fact of my holding a Class I FFL enhance my avenues for obtaining a weapon at less than retail cost? Can you advise what steps I need take as far as legal state/federal requirements? Does my license carry any weight or am I considered a typical purchaser? Can you advise to sources for full-auto?

Mike L

A First, for the sources for full-auto, check out the advertisers in *MGN*. Shop at Knob Creek and the other shoots. Get on the other Class 3's mailing lists. Mississippi allows the ownership of machine guns, so you should be in good shape. Your Type 01 FFL allows you to purchase NFA firearms interstate from individuals or interstate from individuals or Class 3 deal-



ers, using a tax paid Form 4. As far as a break from "retail" cost, that is going to depend on the dealers that you are talking with. Some have a retail structure, most do not. Since there is no real source of new inventory, many dealers consider all sales "retail."

Questions to:

Dan Shea, c/o MGN
P.O. Box 459
Lake Hamilton, AR 71951

Continued from page 14

an interesting and helpful column.
Neil

A I still think that there is a great story for MGN in Australia. Any of you Aussies up to writing about one of your shoots? How about an update on your laws. If I can talk Vida into footing the bill, I'll come to one of your shoots...(Nice try, but fat chance, Dan. —Vida)

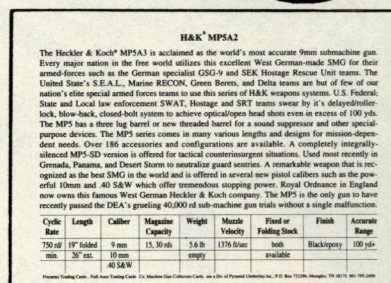
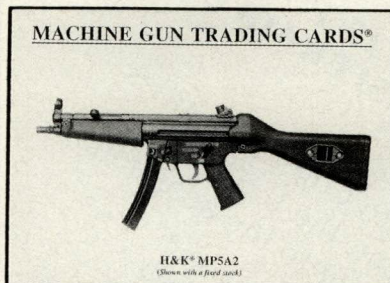
Q Did I miss something or did "the great one" misspeak? I'm referring to your response to G.K.M. in the March issue regarding his Mini-Uzi. With respect to the conversion, you ask, "Was the rail removed so that the gun will use an original MG bolt? Or was the bolt slotted for the rail?"

In 1991, I purchased a registered full-auto Uzi sear (Qualified Manufacturing) and a new-in-the-box, IMI Action Arms, Ltd. Mini-Uzi semiauto carbine. It had no receiver blocking rail and the conversion was extremely simple. I purchased a full-auto bolt and recoil spring assembly from Group Industries, Inc., and filed the rails on the front of the bolt so that they would slide past the barrel extension. I then removed the blocking bar in the front of the pistol grip so that the selector lever would move to the full-auto position and did some minor filing so that the lugs of the registered full-auto sear would fully engage both legs of the bolt. The removal of the rubber buffer in the rear of the receiver along with the addition of a ratcheting Mini-Uzi top cover, a 7 3/4 inch slotted SMG barrel, and a full-auto change (selector) lever completed the conversion.

I've seen several other similar full-auto conversions using Mini-Uzi semiauto guns and registered full-auto sears, and I've never seen a blocking bar in the lever which necessitated a slotted bolt. Additionally, unconverted Mini-Uzi semiauto carbines that I've looked at did

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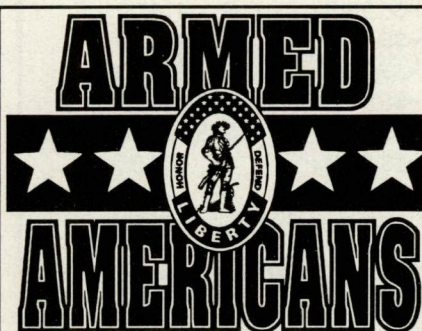
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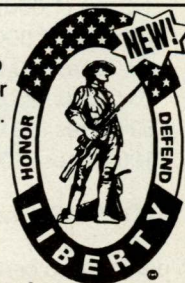
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not have blocking bars.

This brings me back to my original question—did I miss something or did you misspeak? Keep up the great work.

John

A Jackie Gleason was "The Great One" John. I'm just another guy with a word processing program and a few machine guns. I do have a lot of fun with this business, but I am not "Mr. Machine Gun."

You are correct. The sequence of events that I described are related to the original Uzi semiautomatic carbine. The Mini-Uzi did not have the rail installed.

I didn't put your full name in here because I want to make sure that you don't get into trouble... There is a question as to the validity of registered Uzi sears. I am not sure that ATF is allowing them if they were not already installed in a firearm by May 19, 1986. There are a number of manufacturers who had their inventories "disallowed." perhaps it is better to let sleeping dogs lie on this one...

Q I have a question that I hope you can help me with. I have an M11/9 and I have heard a rumor that a company named "Rhino" makes a conversion kit to adapt a Sten gun magazine to shoot in the M11/9. I have been unable to confirm this rumor. Do you know anything about this company or kit? If not, do you know a good gunsmith who would do the conversion for me? It makes a lot of sense to do this when you compare the cost of M11/9 magazines versus the cost of Sten magazines. Great magazine you guys print!

Keep up the good work.

Michael G. P.

A Rhino was superseded by Shooter's Equipment Company, Postal Slot 517, Richland, SC 29693. Phone: (800) 403-4008. I do not believe they manufactured the Sten conversion grip but sold the original SWD grips from the early 1980's first production of the M11/9mm. The original M11 by SWD used Sten magazines but had reliability problems. I have seen a few of these over the years and had three guns that Stan Andrews worked on. He had to tune them individually. It's not something that you can just "switch." I haven't seen any more of these on the market since then.

Speaking of Stan, refer back to question about the M3 grease gun in 9mm. I saw Stan at Knob Creek, huddled over

a small box that had a 9mm M3A1 bolt in it. There was no way anyone was getting that away from him. Bribes failed, offers of other exotic weapons parts, free dinners, and allusions to other worldly treasures in didn't move him. I did, however, sneak a peek when he was over talking to other customers (yes, the urge to switch it with a .45 bolt occurred to me, just to see his reaction, but I value my life and health). It was a genuine 9mm bolt. Stan's number is (603) 746-4387 if you want to sell him YOUR 9mm M3A1 parts...because he doesn't seem to want to give up HIS....

Q To echo your readers many accolades, thank you for an outstanding publication and very informative articles, especially the columns that you are responsible for.

In the March issue, more specifically the "Raffica" column, a question was asked regarding the barrel shroud removal of a Ramo 1919A4. You made reference to the point that you did not think that Ramo used silver solder in their manufacturing process. Does this mean that it is standard practice to "solder" the shrouds to the receiver?

I own a Saco Lowell M37, and after taking off the barrel bearing and removing the locking screw, I cannot remove, nor

can a gunsmith remove the shroud. Is the reason because it is in fact soldered?

If so, there is no mention of this fact in the manuals, and what is necessary to remove the shroud? I need your expert help in this matter as I am sure that many other people do, especially when I referred the matter to a Marine Gunnery Sergeant, and he could not help.

Leonard S.

A I had a conversation with Doug Oefinger of DLO Manufacturing, definitely a Reasonably Knowledgeable Individual, on the subject of these barrel jackets. His explanation was that, because the threads are very fine, there was a great deal of potential damage by field servicing; they were very easy to cross thread. The removal of barrel jackets was restricted to depot level maintenance, 4th or 5th echelon. In order to insure that it stayed that way, the threads were tinned, and the barrel jacket was installed with heat. I would strongly recommend that the barrel jacket work be kept to the Class 2 manufacturers and gunsmiths who are set up to do the work.

Questions to:

Dan Shea C/O MGN

P.O. Box 459

Lake Hamilton, AR 71951

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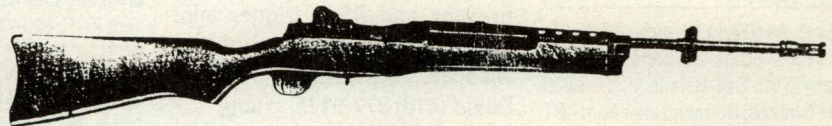
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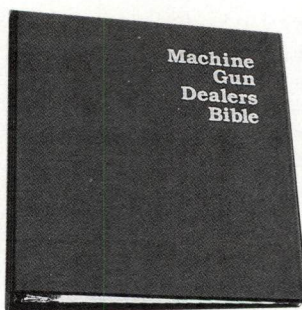
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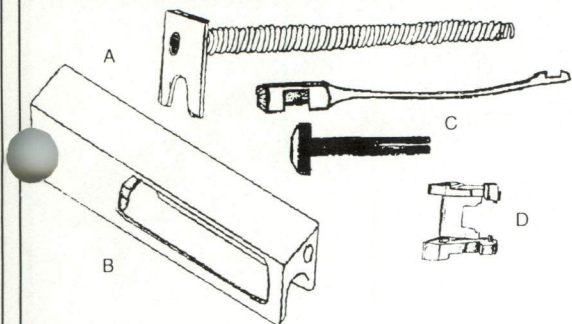
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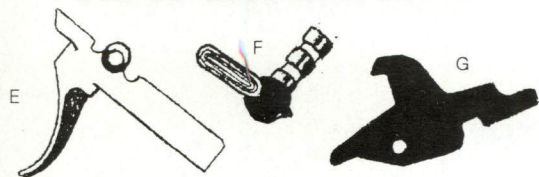
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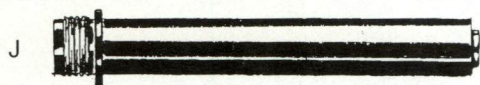


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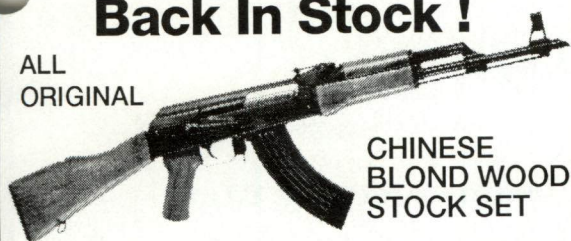
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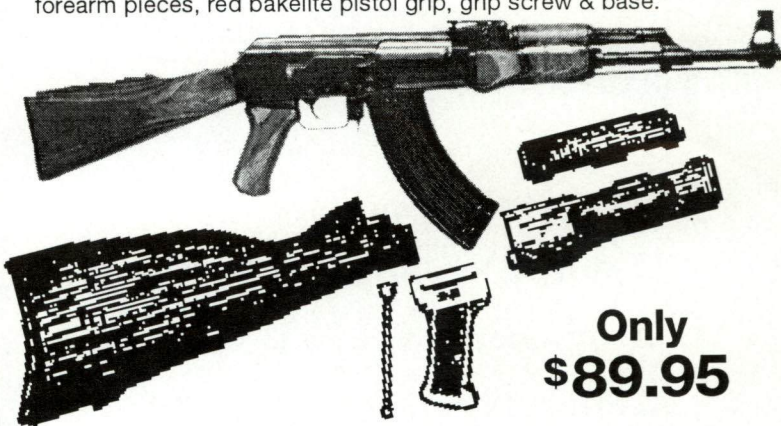


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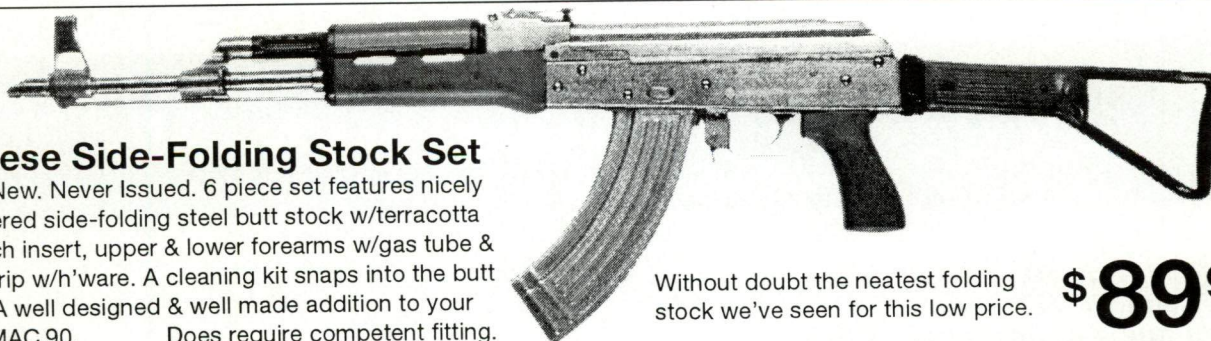
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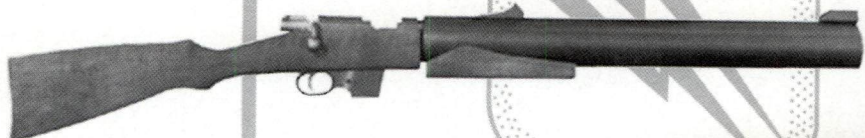


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