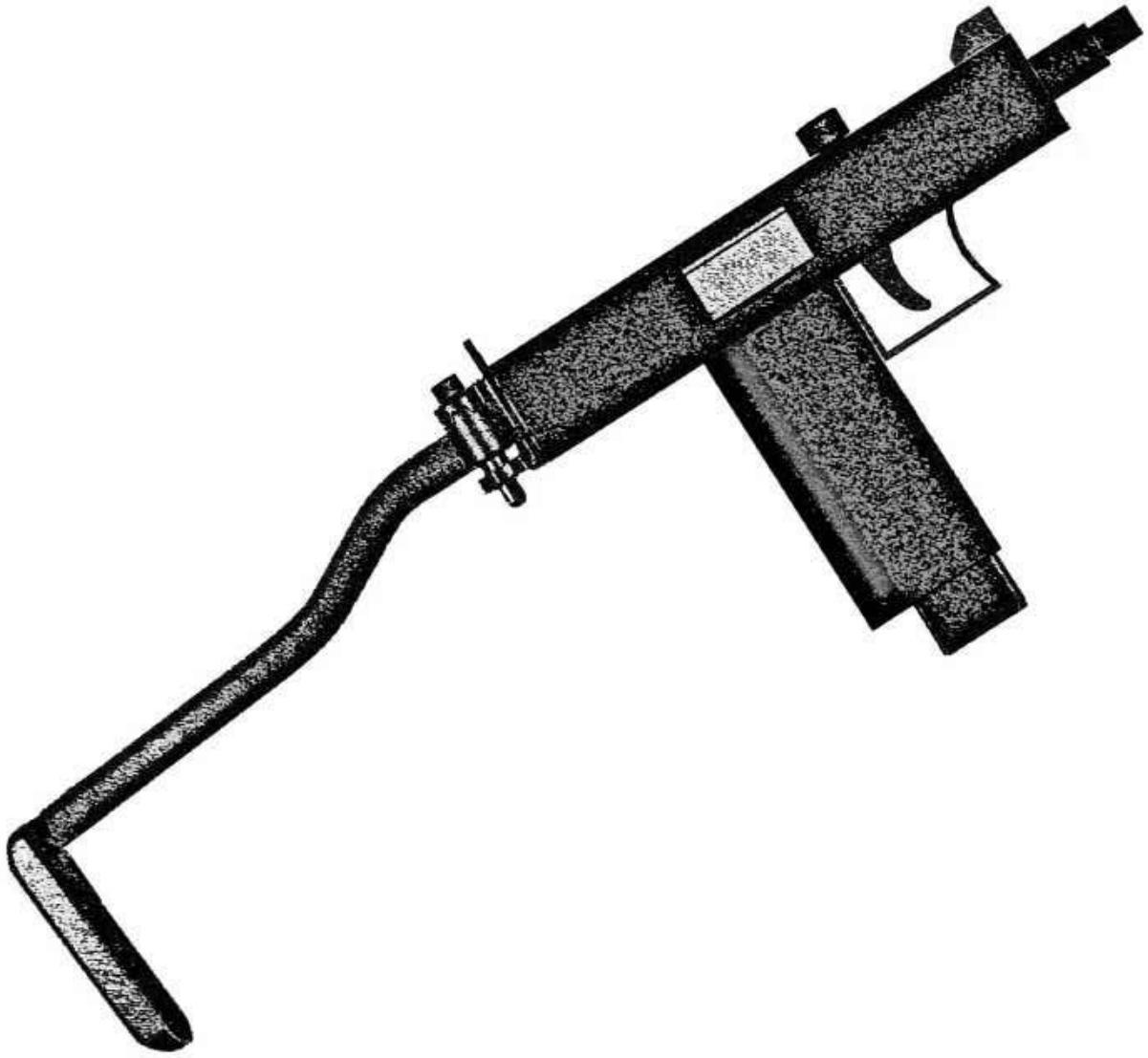
PANTHER-9 MACHINE PISTOL

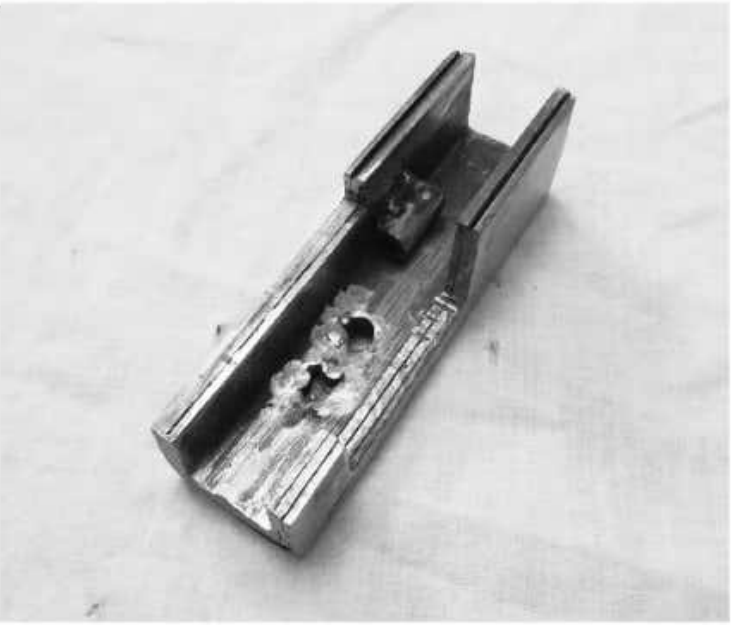


CONSTRUCTION PLANS

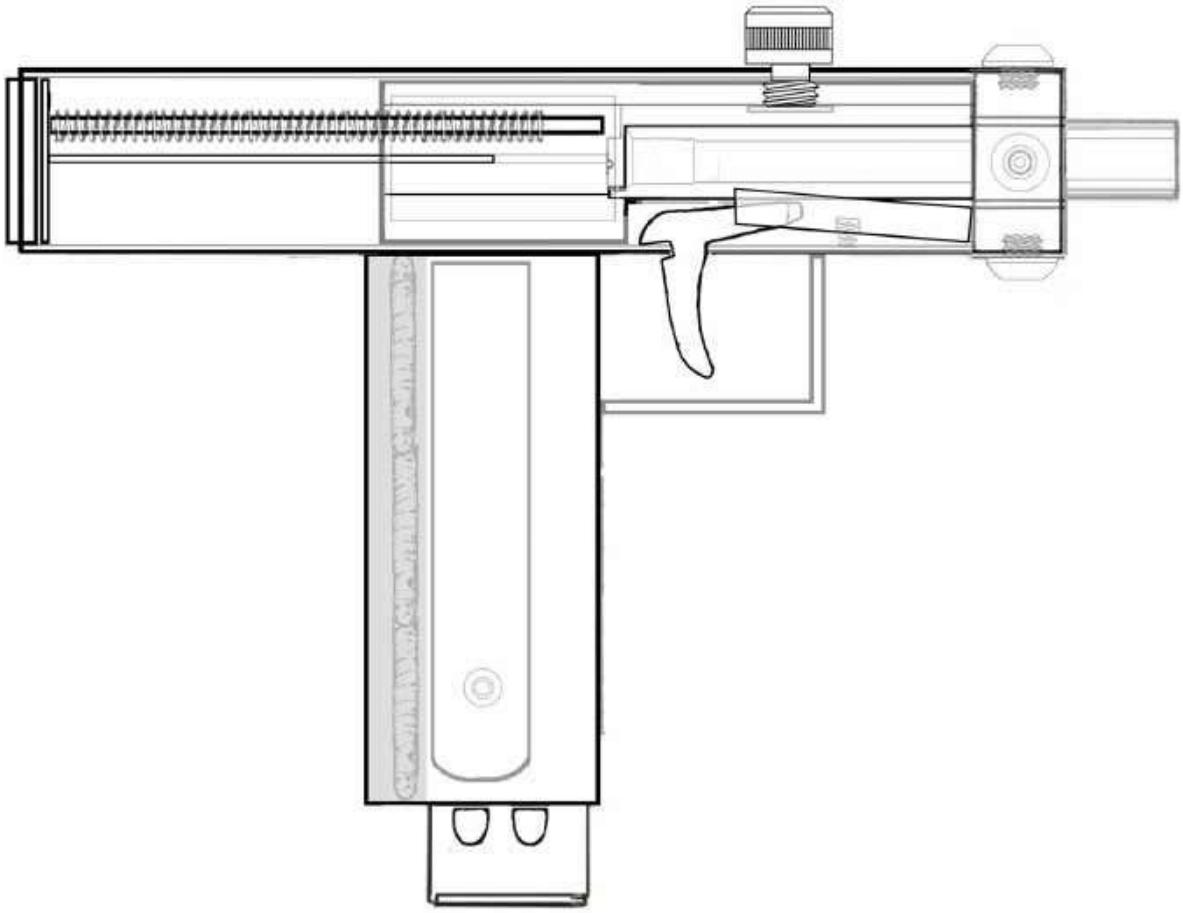
Panther-9 Machine Pistol (Prototype model)

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

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



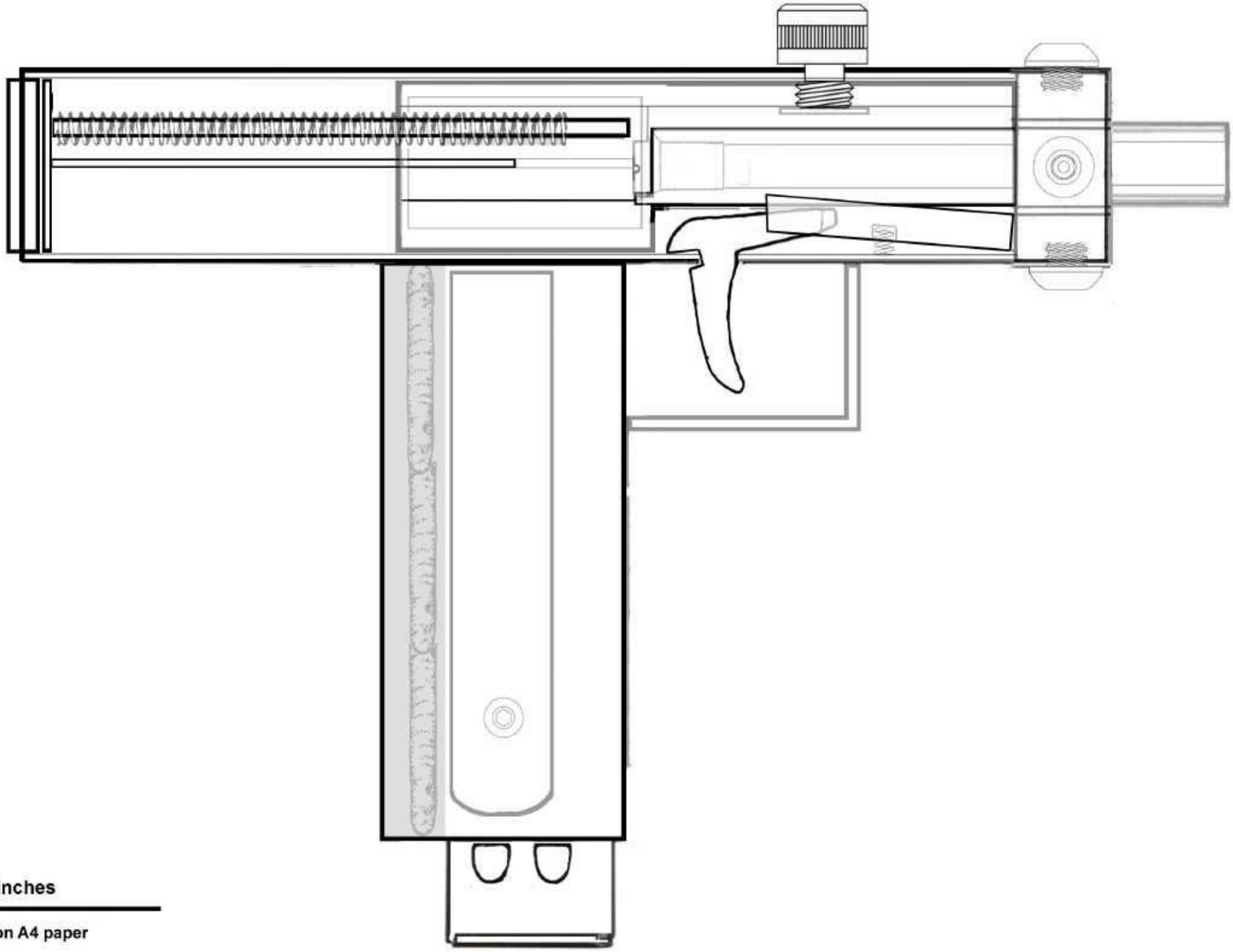
The information contained herein is presented purely for academic study purposes only.



Materials

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

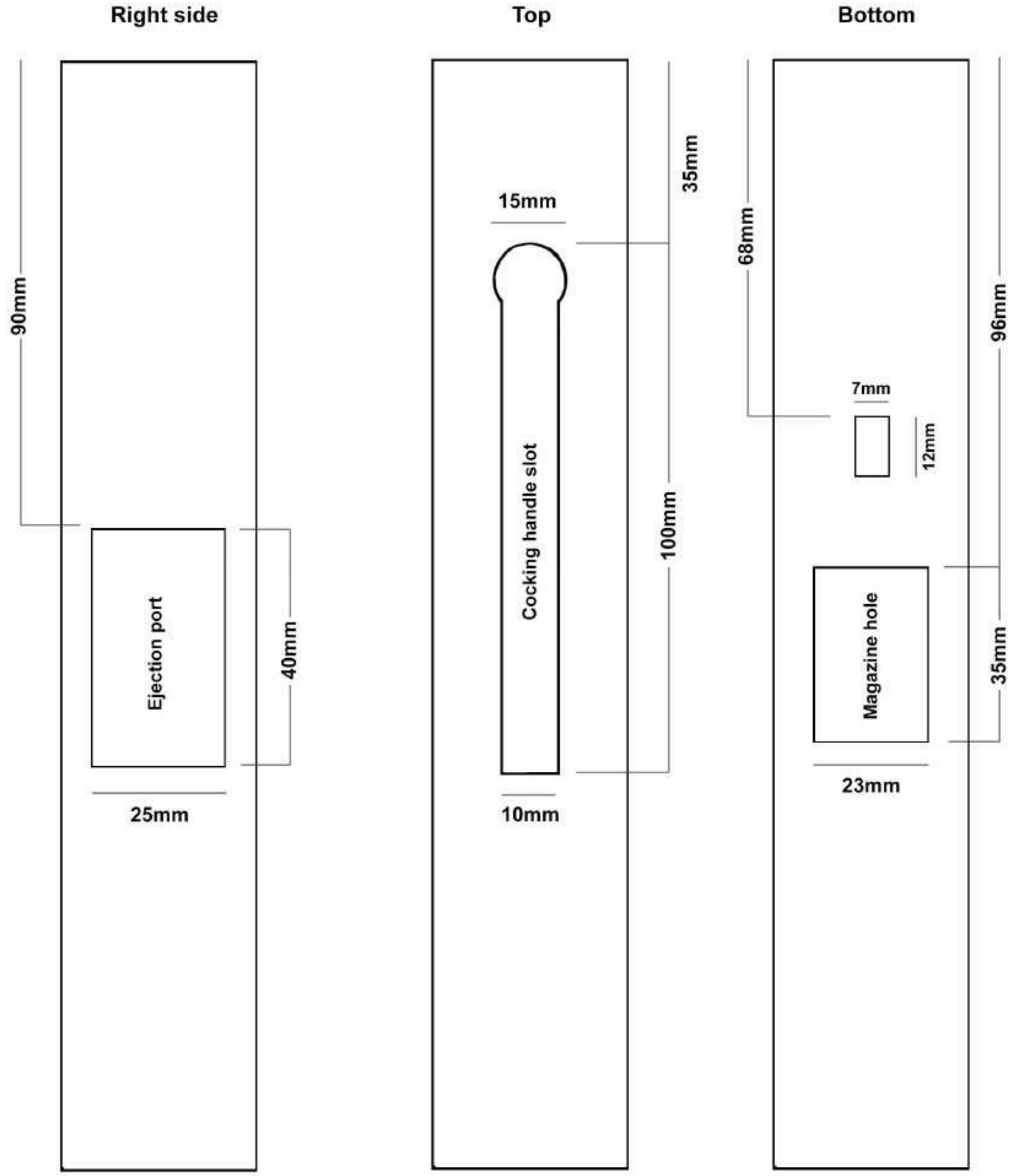
The Panther-9 uses standard 9mm Uzi magazines



2 inches

Print on A4 paper

Receiver



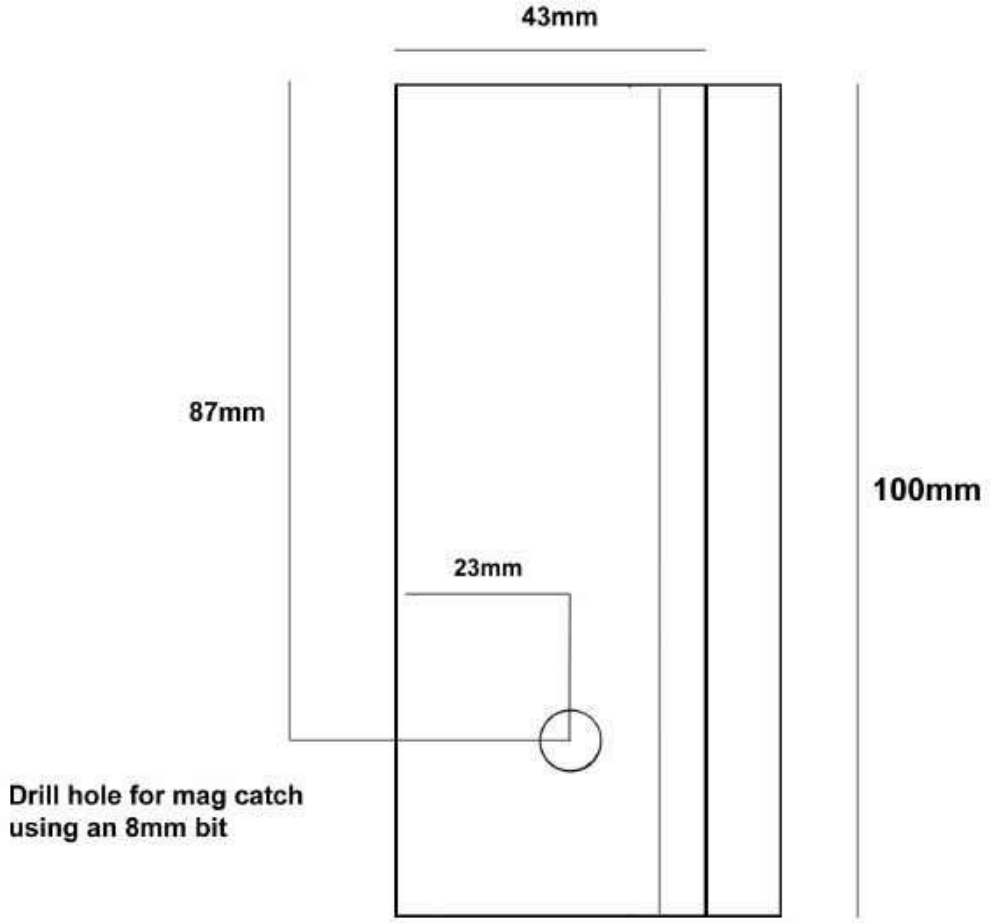
210mm long length of 38mm (1.5") square mild steel box section
(1.6mm (16 gauge) wall thickness)

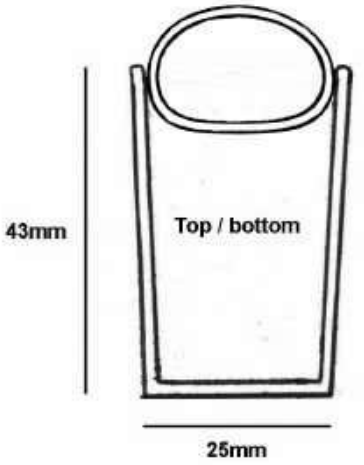
2 inches

Print on A4 paper

Magazine well

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



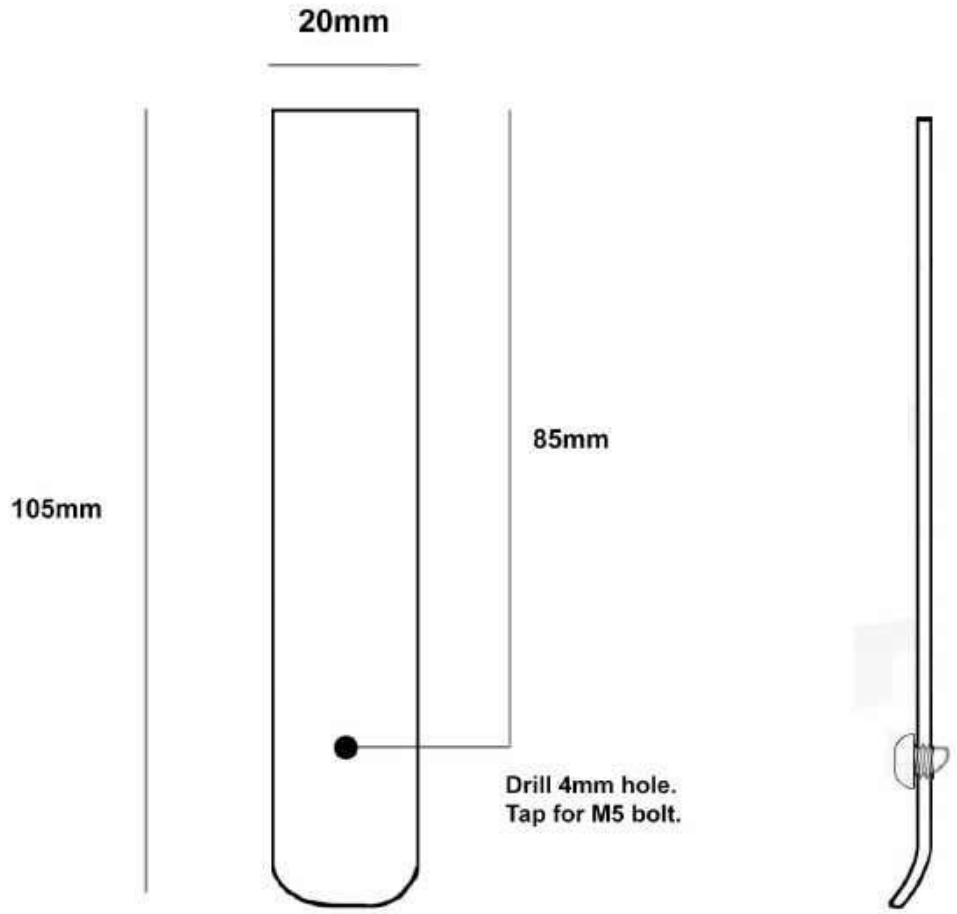


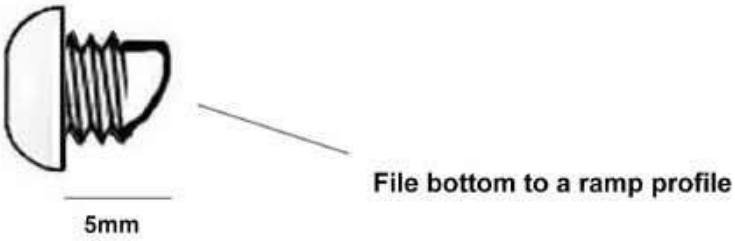
2 inches

Print on A4 paper

Magazine catch strip

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

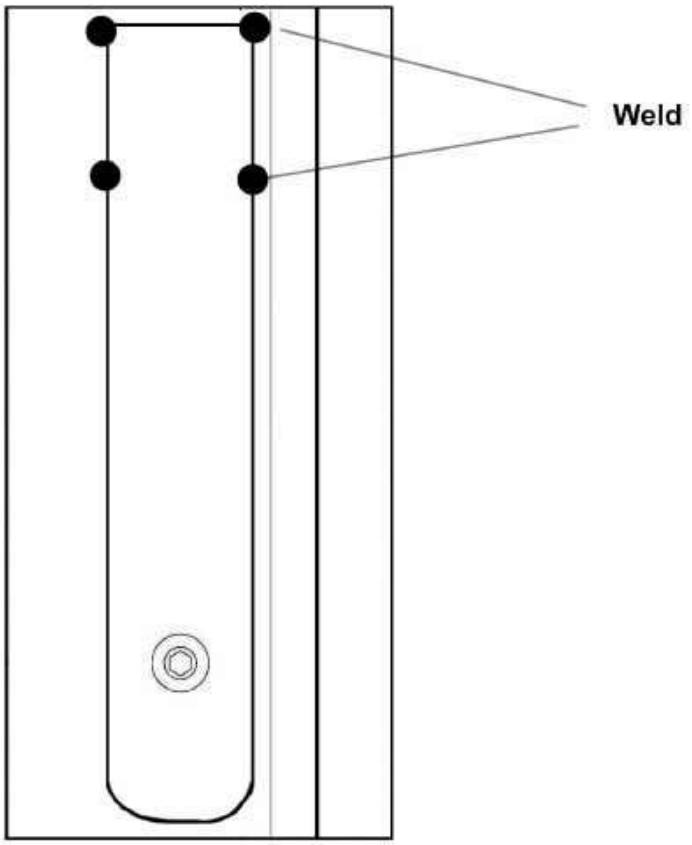


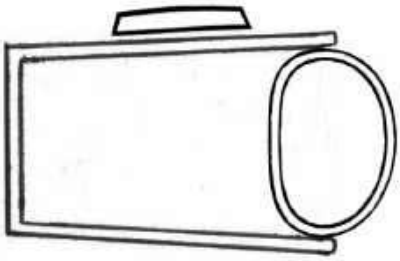


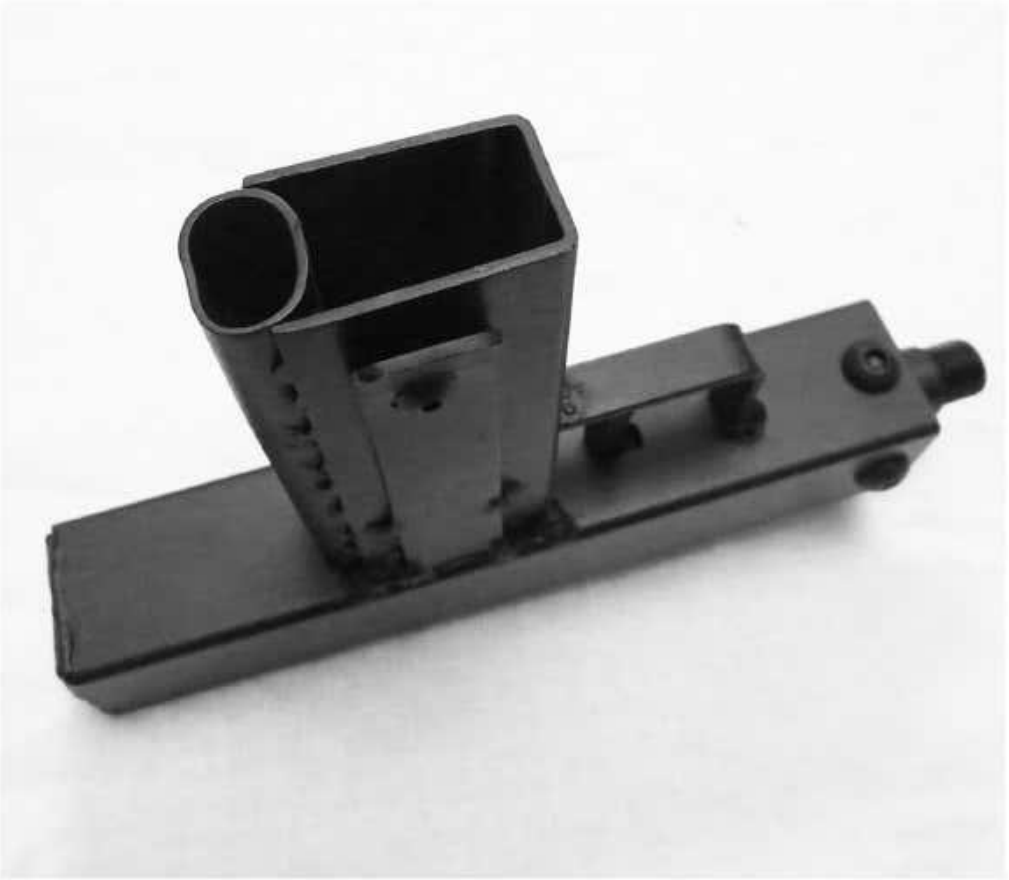
Insert magazine into magazine-well and align catch strip in the correct position before welding in place

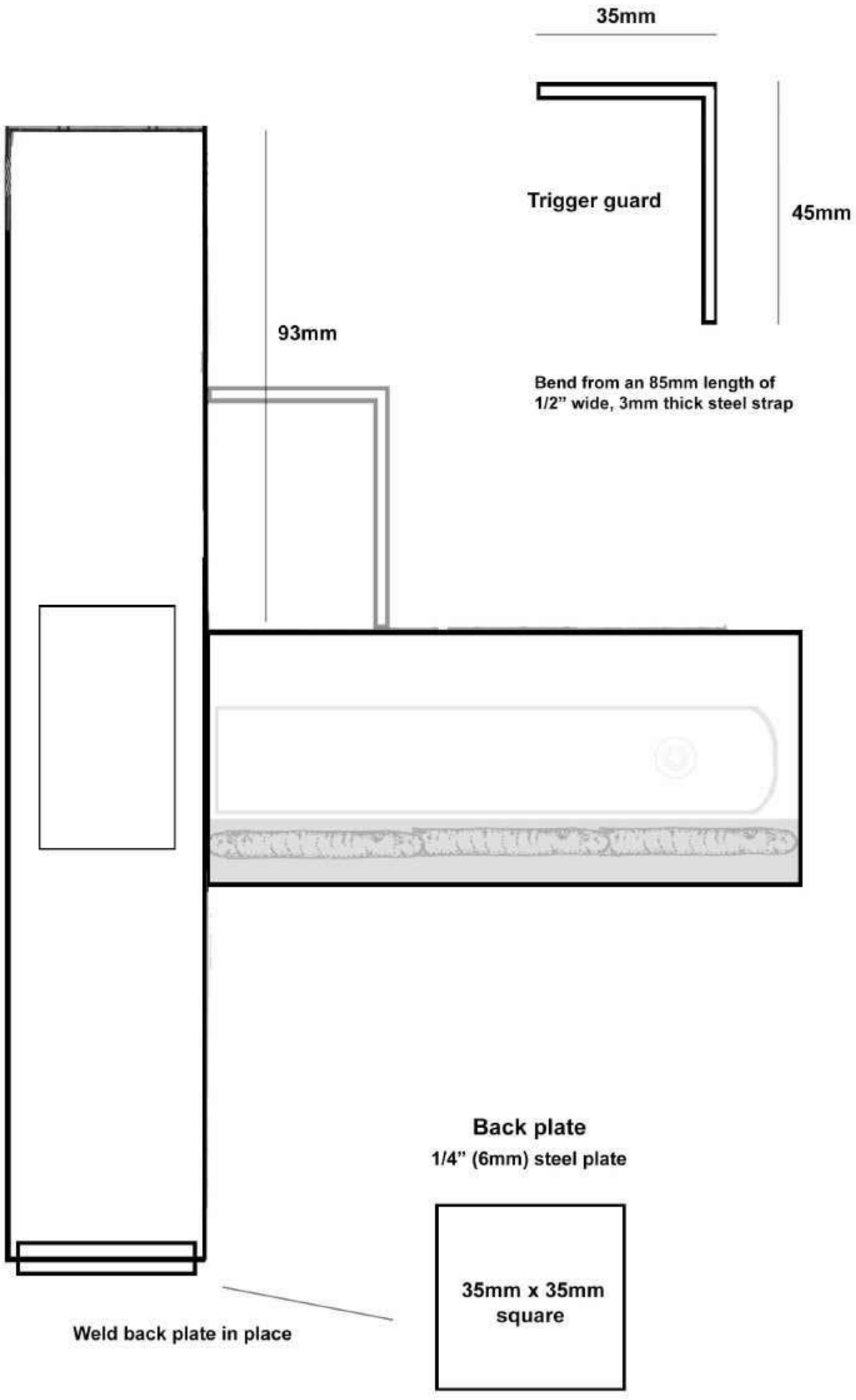
2 inches

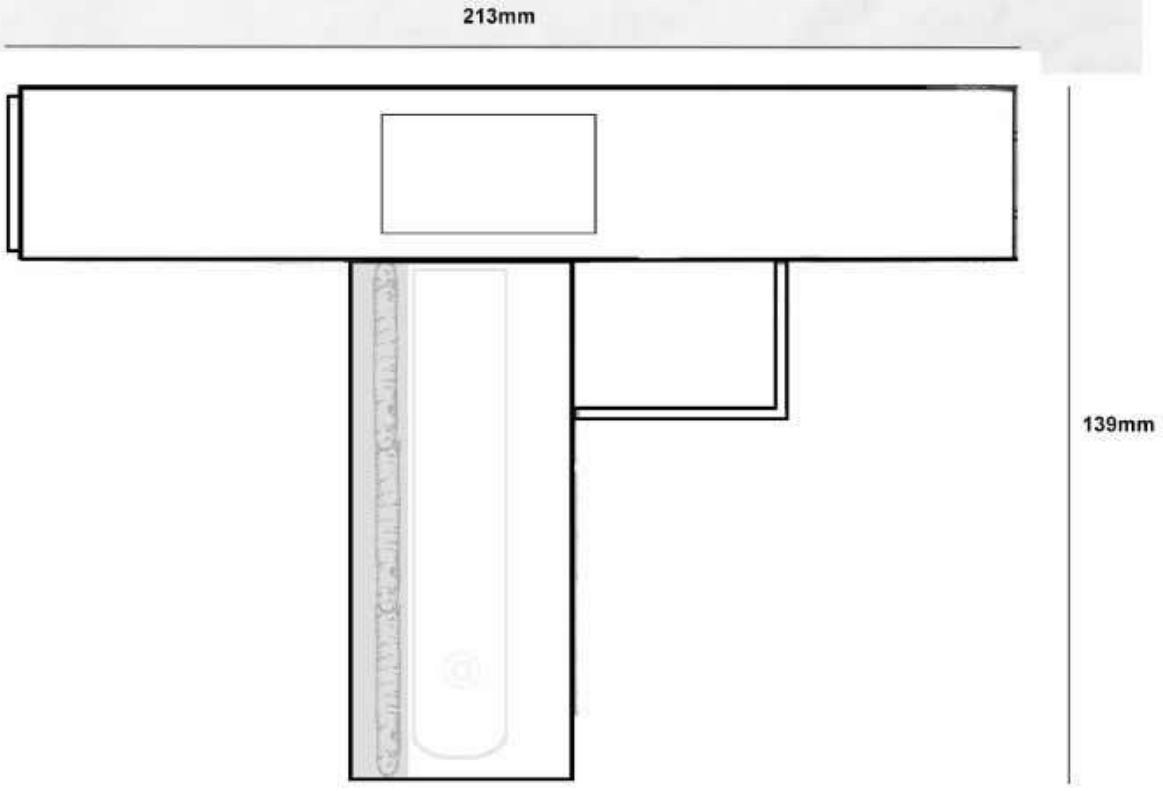
Print on A4 paper


Weld

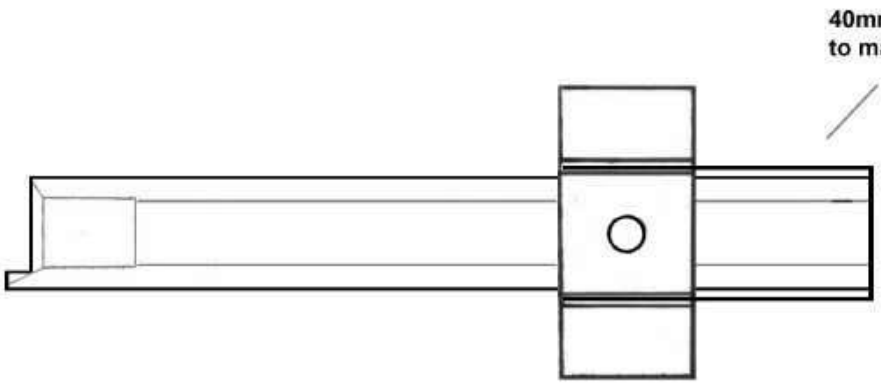




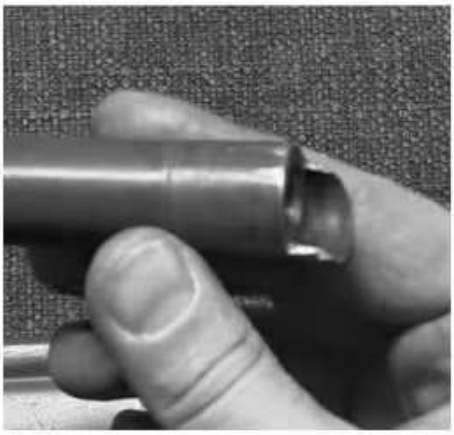

35mm
Trigger guard
45mm
93mm
Bend from an 85mm length of
1/2" wide, 3mm thick steel strap
Back plate
1/4" (6mm) steel plate
35mm x 35mm
square
Weld back plate in place
2 inches


213mm
139mm

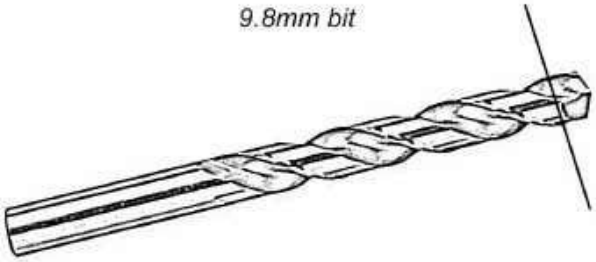
Barrel



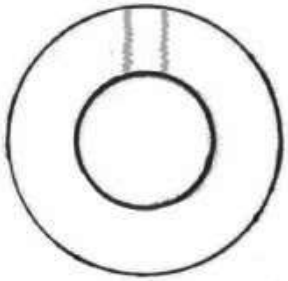
- Drill all the way through a 115mm length of 16mm (5/8") steel bar stock using an 8.5mm drill bit.
- Ream the bore to size using an 8.8mm Valve Guide Reamer.
  (Alternatively use a length of 15mm x 3mm or 16mm x 3.5mm wall seamless steel tube.)
- Either push through a 9mm Lugar rifling button using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



Intergrated feed ramp (Paramax Type)



Improvised chamber reamer



3/4" shaft lock collar

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

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

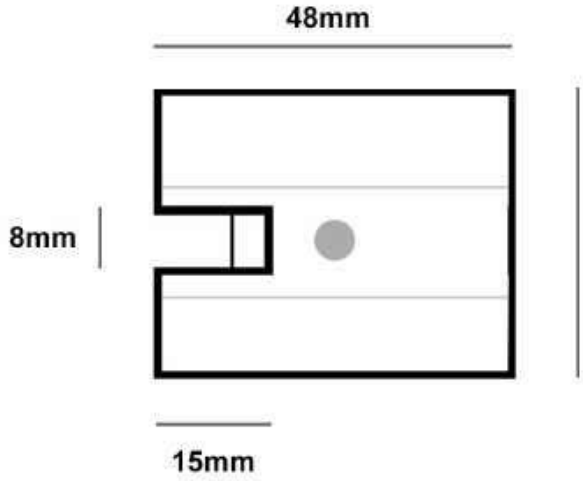
Retain collar in front of receiver via four M8 x 5mm bolts (Top bolt passing through front sight).

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

Trigger & sear

1/4" (6mm) thick steel plate

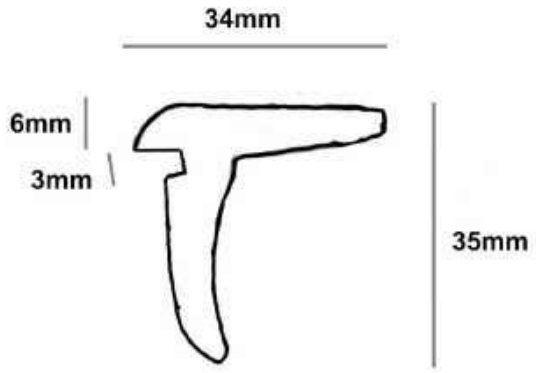
Sear plate



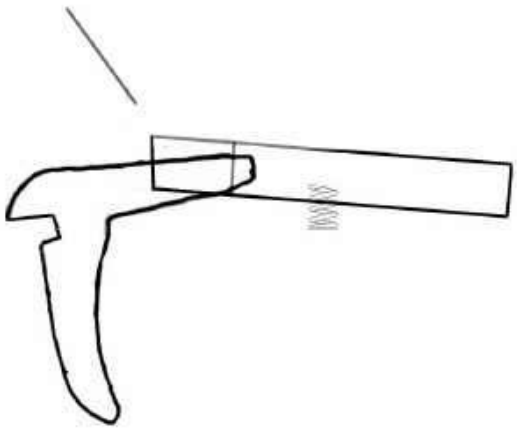
Use angle grinder to scallop bevel into top surface to match profile of barrel.

Weld a piece of thin steel plate to bottom creating an overlapping 'lip' for trigger to contact. Drill a blind hole to house small spring.

Trigger template



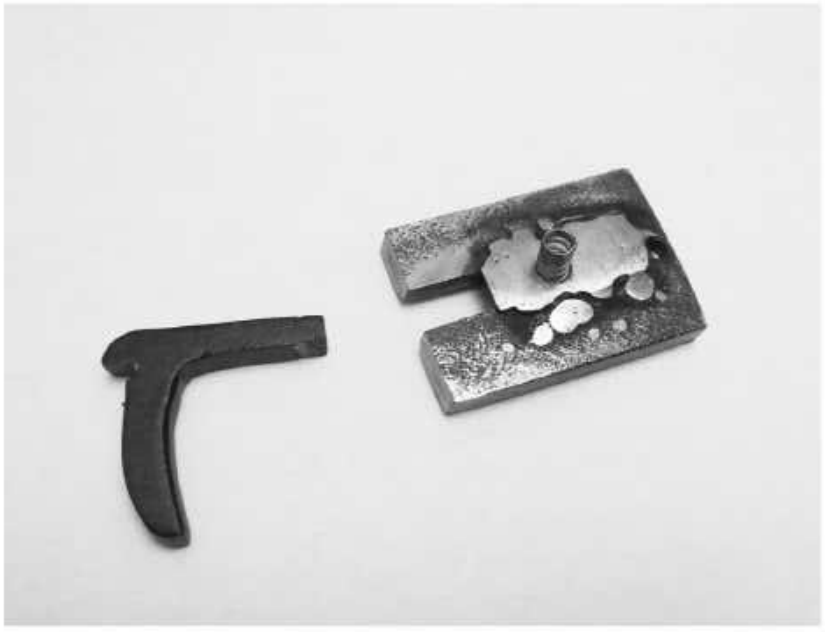
File sear to a sharp angled edge



2 inches

Print on A4 paper

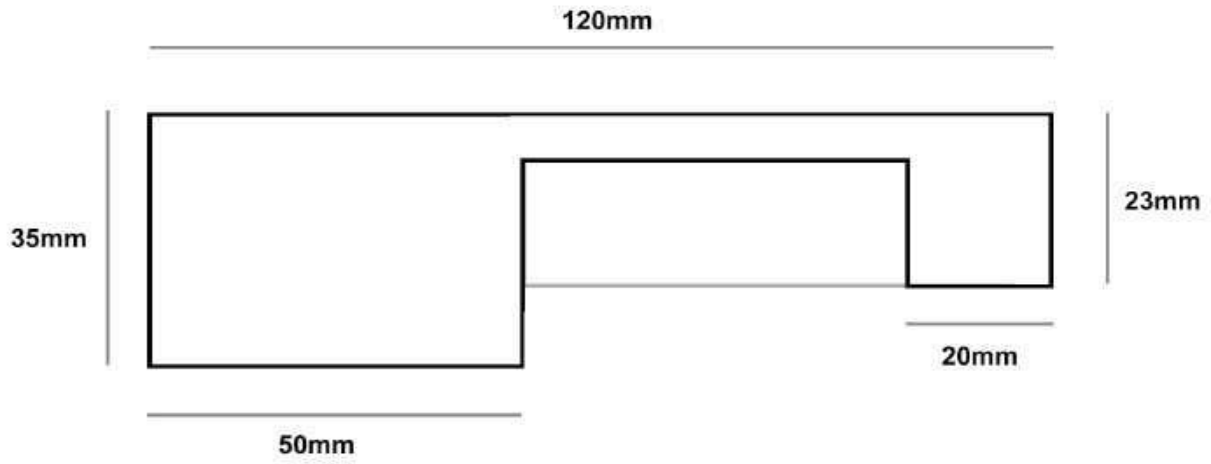
Trigger & sear (Top view)

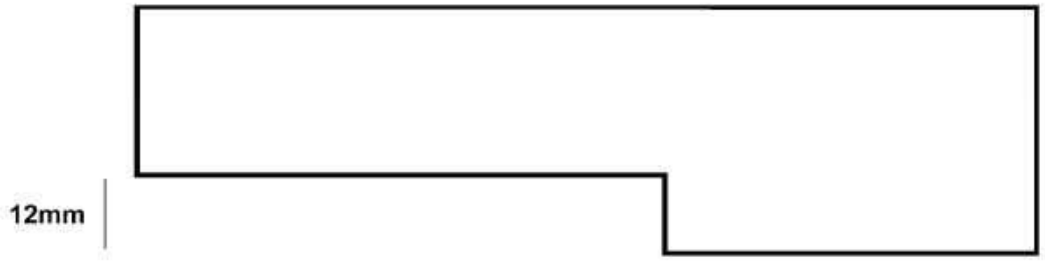


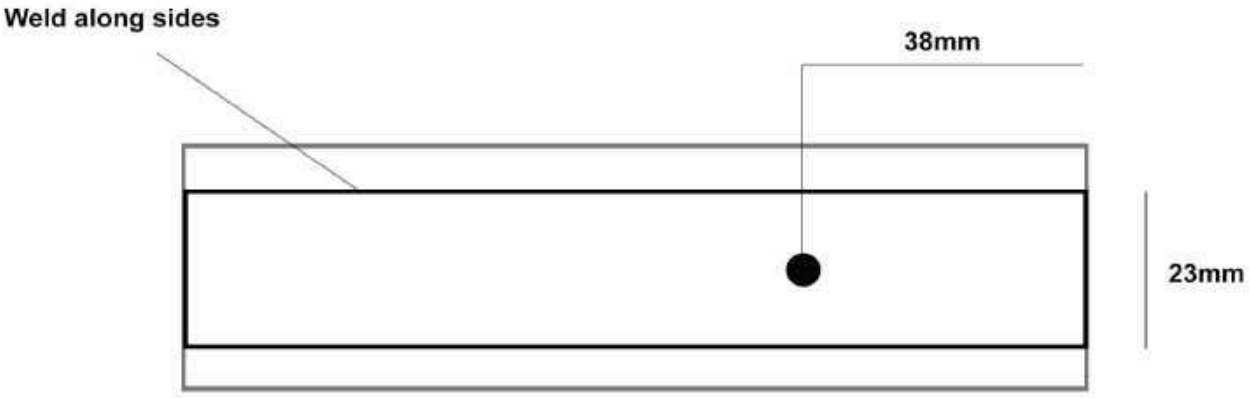
Sear (Bottom view)

Bolt body

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







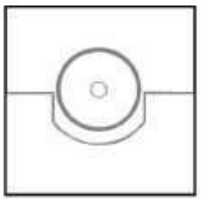
2 inches

Print on A4 paper

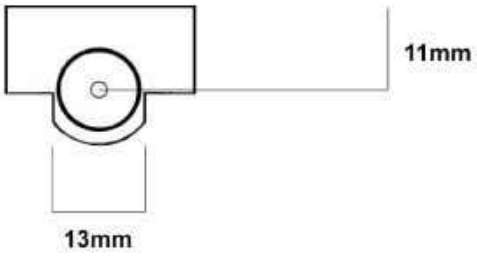
Bolt Breech Insert

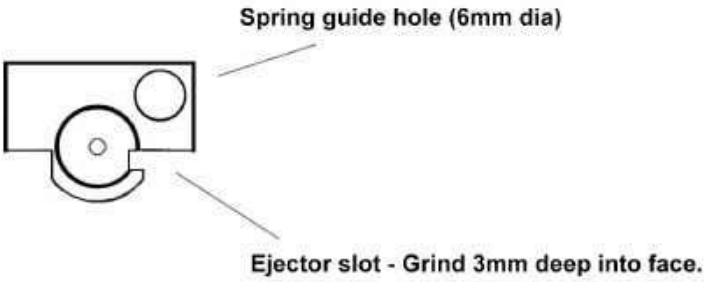
Cut to shape from a length of 1" (25mm) dia square steel bar.

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



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





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

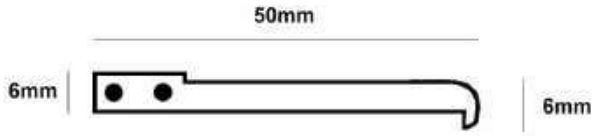
Using a belt sander, reduce overall width of bolt piece to 23mm.

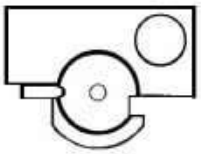
2 inches

Print on A4 paper

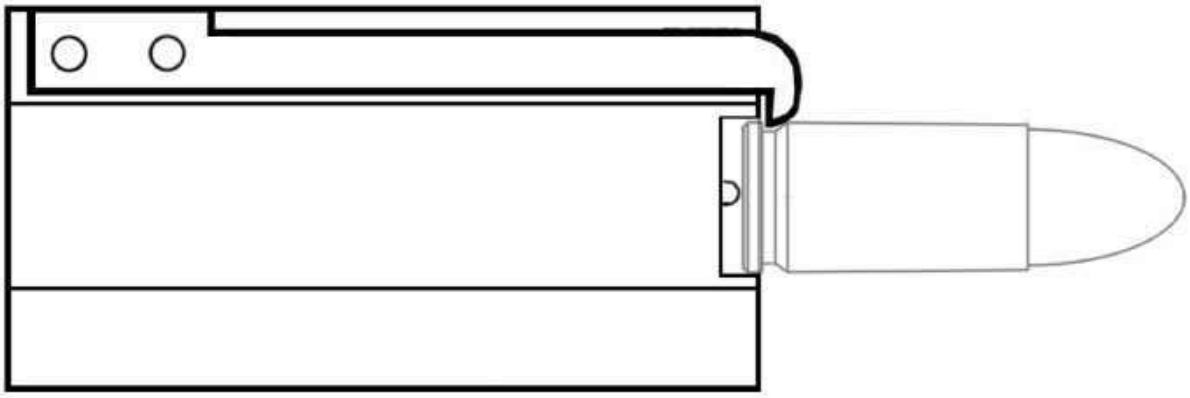
Extractor (Optional)

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





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



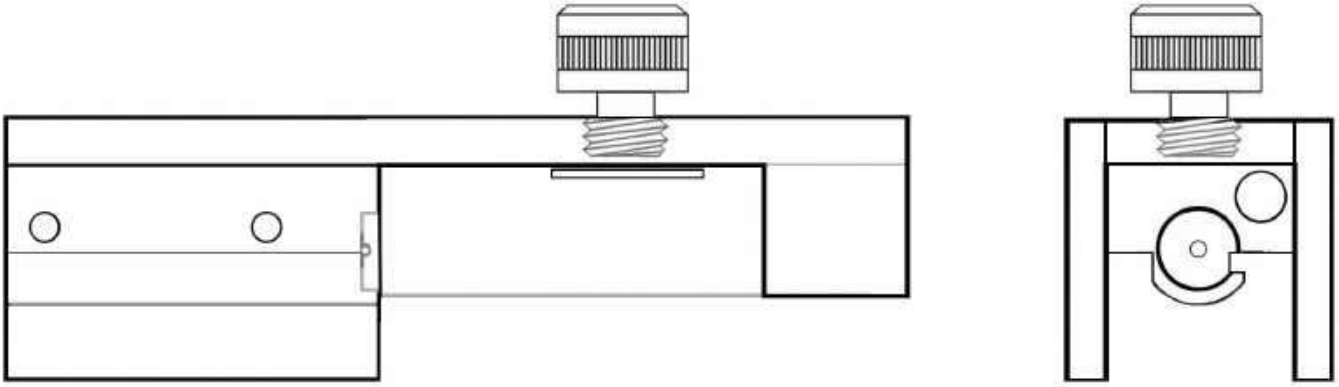
A 3mm deep recess to accommodate the extractor will need to be cut into the right side wall of the barrel's chamber end.

2 inches

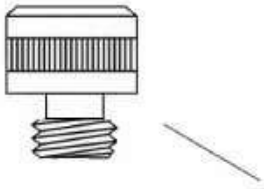
Print on A4 paper

Bolt (Assembled)

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



Cocking handle (M10 socket head bolt)

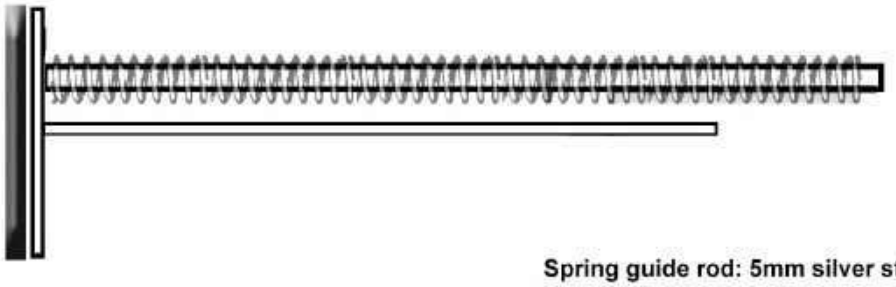


Create 'neck' using a drill press + file

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

Recoil spring / ejector assembly

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



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

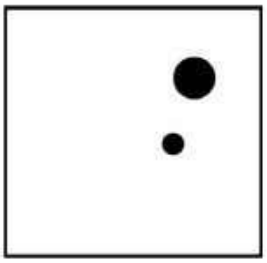
Ejector rod:3mm tool silver steel bar - 90mm long

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

Back plate

2mm thick steel plate. 35mm x 35mm

Template:



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

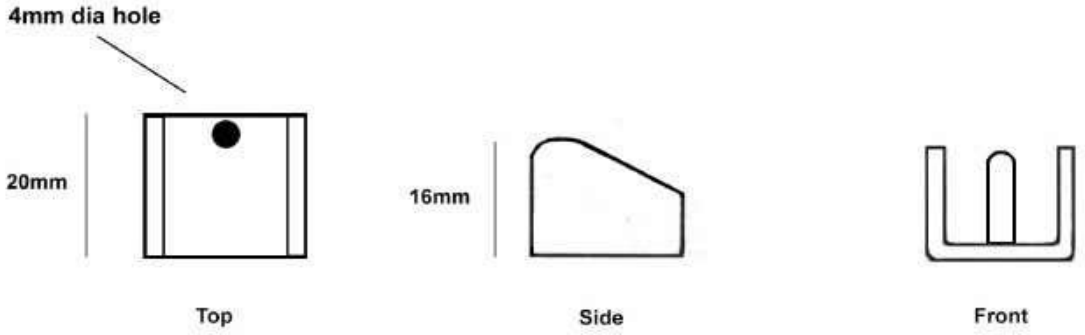
2 inches

Print on A4 paper

Sights

Front sight

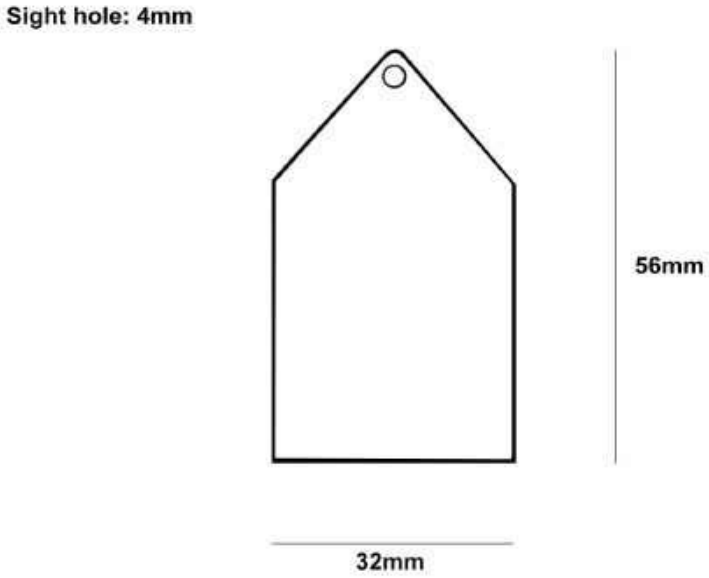
20mm x 20mm steel box section



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

Rear sight

2mm mild steel plate



Position flush with bottom of receiver and weld along sides.

2 inches

Print on A4 paper

2 inches

Print on A4 paper

Side folding stock

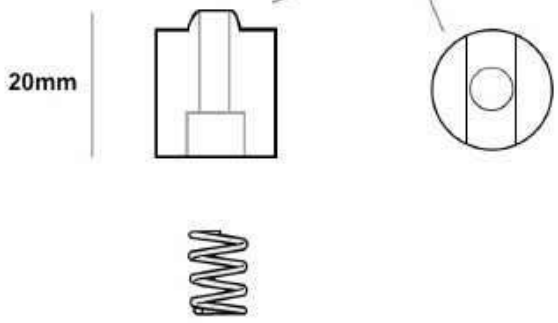
Weld stock tube to left side of drum

Heat and bend to profile

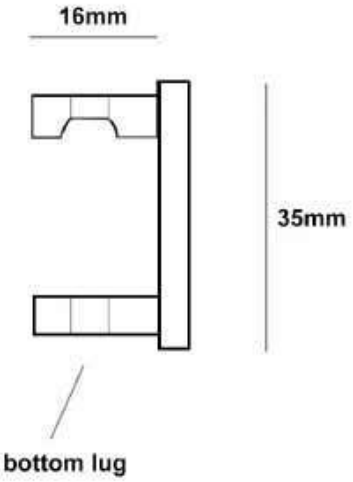
16mm OD steel tube, 8" long

20mm steel square box section

16mm dia steel round bar



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



Tap bottom lug

Additional Firepower...