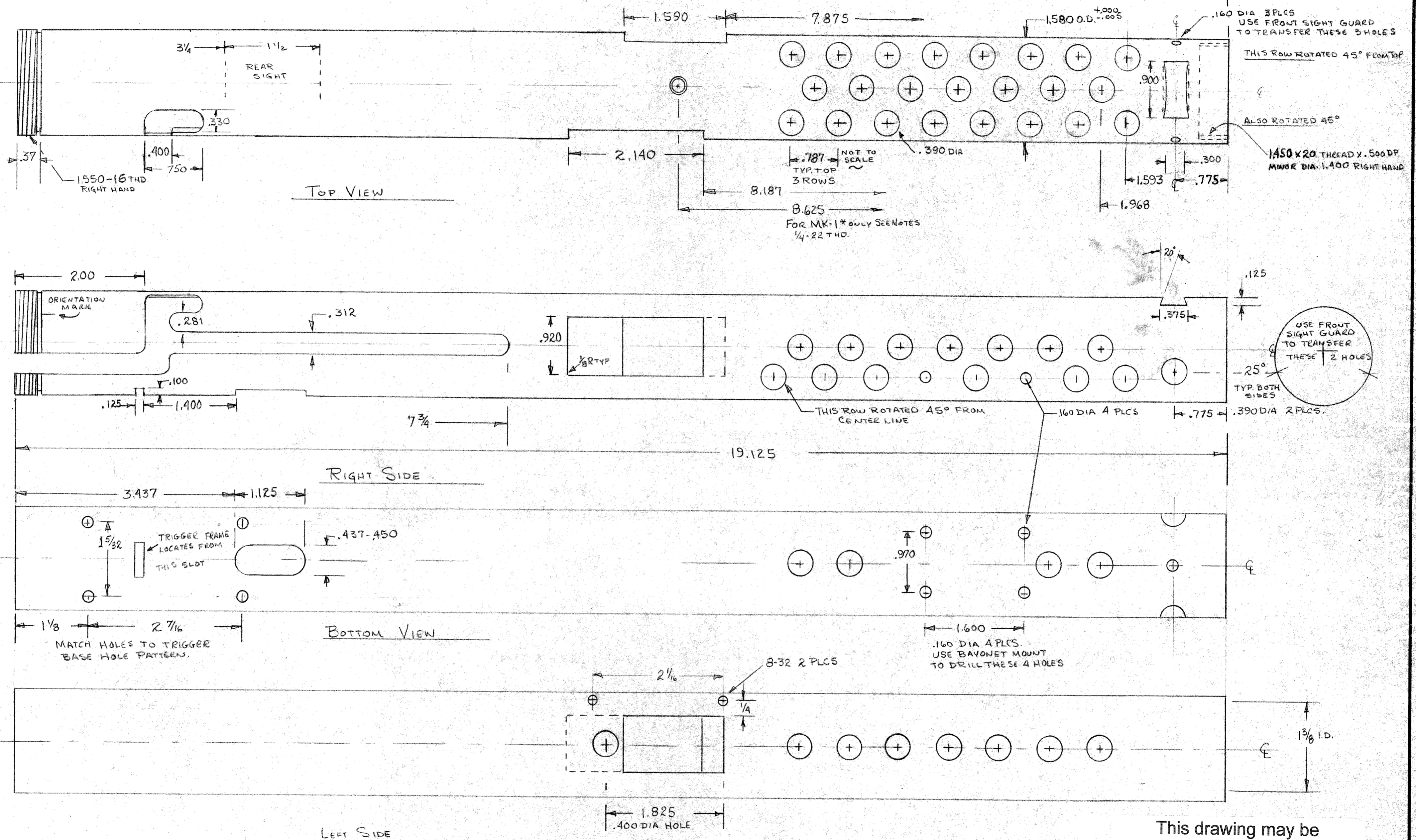


Lanchester Mk1 SMG





GENERAL NOTES AND SUGGESTIONS

1. TURN O.D. AND THREAD BOTH ENDS FIRST
2. MARK * IS THE LATER MODEL, FULL AUTO AND HAS 1/4-22 SCREW IN TOP OF MAG HOUSING THAT LOCKS BARREL IN PLACE. I TAP THIS HOLE & MAG HOUSING 1/4-20 AND USE ORIGINAL SCREW OR MAKE ONE.
3. ALL .160 HOLES WERE ORIGINALLY RIVET HOLES. I DRILL THESE HOLES #29(.136) AND TAP 8-32. USE 8-32 x 1/4 ROUND HEAD MACHINE SCREWS.
4. WITH END CAP IN PLACE TIGHT, BACK OFF 1/8 TURN AND MAKE A LINE-UP MARK ON BOTH PARTS. PLACE TUBE IN STOCK AND LOCK END CAP IN PLACE. SLIDE MAG HOUSING ON TUBE AND LOCATE IN STOCK AND INSTALL HINGE SCREW. SPOT DRILL THRU MAG HOUSING FOR 2 8-32 SCREWS. DRILL #29 AND TAP 8-32 AND INSTALL 2 8-32 SCREWS. THE ORIGINAL DOES FIT. THIS ESTABLISHES THE HOUSING TO THE END CAP. ALL OTHER HOLES ARE RELATIVE TO THE 2 PARTS.
5. LOCATE ALL OTHER HARDWARE BY SPOT DRILLING IN PLACE
6. MAIN PORTS CAN BE SCISED WHILE HOUSING IS IN PLACE. EXTRACTION PORT SIZE IS CORRECT, BUT MAG HOUSING HOLE IS LARGER.
7. THESE DIMENSIONS WERE COMPILED FROM 3 LANCHESTER RECEIVERS.
8. FRONT SIGHT DOVETAIL IS NOT A STANDARD TABLE. MACHINE A STRAIGHT SLOT AND TRIM FRONT SIGHT TO FIT AND SOLDER IN PLACE.
9. FINISH: BLUE ALL STEEL PARTS, BRASS SHOULD BE NATURAL, NOT PAINTED.
10. BAYONET: ENFIELD P1907 LONG OR P1907/4R

WARNING!!

COMPLETION OF THIS PART REQUIRES PRIOR BATE APPROVAL.

This drawing may be downloaded free of charge from <http://www.josreichert.com>. It is provided by Joseph Reichert, d/b/a/ Reichert Büchsenmacher (RB).

TOLERANCES (EXCEPT AS NOTED)	REVISIONS			LANCHESTER MK-1 & MK-1*		
	NO.	DATE	BY			
DECIMAL	1	11-20-88	S	DRAWN BY	SCALE FULL	MATERIAL 1 3/8 x 1 3/8 x 19 DOM 1020
±	2					
FRACTIONAL	3			CHK'D	DATE 7-3-1988	DRAWING NUMBER
±	4					
ANGULAR	5			TRACED	APP'D	SHEET 1 of 1
±	6					