BOLTGUN

.22 L.R. CAL. DEFENSE WEAPON

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WARNING: IT IS A VIOLATION OF FEDERAL LAW SUBJECT TO FINE AND/OR IMPRISONMENT TO MANUFACTURE THIS OR ANY FIREARM WITHOUT A LICENSE.
GENERAL NOTES

The BOLTGUN is a single shot, .22 long rifle caliber personal defense weapon disguised as a common 7/8" diameter, 8 inch long, galvanized bolt. Most of the components of the BOLTGUN are off the shelf items which can be found in any good hardware store. The only essential power tools are a drill press and a Dremel hand grinder. The usual assortment of hand tools and a modicum of skill are also needed.

Undoubtedly, the hardest task is drilling the 29/64" hole down the center of part #8. "V" Blocks or a machinist's vise are helpful. Even so, it may take more than one try. Centering the hole is crucial to the effort. The 5/16" hole through part #2 is easier only because the piece is shorter. It is advisable to use the drill press chuck as the tap holder when cutting internal threads. If the tool is not perpendicular to the work, another piece of scrap is created.

The alternate design which eliminates one set of internal threads as well as part #12 is not recommended because of the difficulty of drilling the 29/64" hole entirely free of one end. Although it is easier to drill the hole half way from either end, another threaded part is required.

Part #9 is turned down from 1/2" to 29/64" by chucking a piece of 1/2" bolt in the drill press and reducing the diameter with a file or grinder. Likewise, the 9/16" drill bit may be held in a machinist's vise while part #9 is checked in the drill press to assure a centered hole. Part #9 may be fashioned entirely in the drill press and cut to length with a hacksaw while being turned to assure a square cut.

INSTRUCTIONS

1. Cut bolt into three sections; threads, shaft and head to use for parts #6, #8 and #13 respectively.

2. Drill 5/16" hole through #1. Drill 29/64" hole to indicated depth and cut threads with 1/2-20 tap.

3. Drill 29/64" holes through #8 just drill hole half way from each end. Cut threads with 1/2-20 tap.

4. Drill hole in #13 and cut threads with 12-24 tap.

5. Cut 3" section from 1/2" bolt for #4. Cut 1/2-20 threads for 2". Drill 5/16" hole as shown. Cut #4 to length and square face. Drill 3/32" firing pin hole. Taper end to slot against bottom of hole in #2.

6. Grind #4 using Dremel hand grinder and #599 cutting wheel. Use #11 to locate 3/32" hole through side of #4 and drill size. Cut spring #7 and pin #7 to fit.

7. Cut 3" section from 1/2" bolt for #12. Cut 1/2-20 threads for 1". Drill 13/64 hole. Cut to length.

8. Drill 29/64" hole in scrap metal for gauge. Cut 3" section from 1/2" bolt for #5 and chuck in drill press. Reduce diameter of #5 until it will pass through gauge. Drill hole and tap 12-24 threads. Cut to length.

9. Cut #10 to length and tap both ends as shown.

10. Cut #1 to length. Drill chamber with #1 (wire size) bit using .22 l.r. round to gauge proper depth. Screw #4 tightly into #2. Place .22 round into #1 and insert into #2 (to see headspacing). Blue #1 into #2 using rear view mirror adhesive or Loctite and allow to set overnight. Grind end of #1 flush with #2.

11. After #1/7 have set, screw #6/45°/#41/4 into #2 with .22 round in chamber. Put drop of Loctite on exposed threads and screw on #6.

12. Assemble #5/#10/#13 and slide into #6. Adjust threads until #5 contacts #4 at the same time #13 contacts #8. Loctite #9 to #10.

13. Remove #13 from #10. Insert #5/#10/#13 into #6. Screw in #12 and screw on #13. The work is now finished.

14. To complete the camouflage, press a small piece of paraffin into the barrel and touch up with Testors #1146 gloss enamel silver paint.

TOOLS AND EQUIPMENT NEEDED

Drill bits: #14, 29/64", 5/16", 13/64", & 3/32" machining's vise and/or "V" Blocks.
Dremel electric hand grinder.
Dremel bits: #402 & #409
.22 l.r. bullets.
Center punch.
Drill press.
Cutting oil.
Hack saw.
Hammer.
Pencil.
Ruler.

OTHER SARDAUKAR ORIGINALS
ZAPPER - Cigarette lighter gun
BUCKLER - Bol bol belt buckle.
BLITZER - High explosive bullets
TATTLESS - Trip wire sentry alarm
PENGUN - Writing/firing pen gun
ROCKER - MR7 full auto conversion
POGGER - Pen/pistol book.
CANEGUN - Silenced walking stick gun.

SARDAUKAR PRESS
P.O. Box 36531-O
Germantown, TN 38138

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# Parts Schedule

<table>
<thead>
<tr>
<th>No.</th>
<th>Nomenclature</th>
<th>Material</th>
<th>Source</th>
<th>MFGR</th>
<th>MFGR No.</th>
<th>Comments</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Barrel (Rifled)</td>
<td>Steel</td>
<td></td>
<td>1</td>
<td>51-12R46</td>
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<td>Threads</td>
<td>Steel</td>
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<td>5</td>
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<td></td>
<td></td>
<td>From Retractable Ball Point Pen</td>
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<td>6</td>
<td>Firing Pin</td>
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<td>5/16&quot; Drill Bit</td>
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<td>Firing Pin Retaining Pin</td>
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<td>506</td>
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<td>mainspring</td>
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<td>32</td>
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<td>12</td>
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<td>13</td>
<td>Head</td>
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<td>2</td>
<td>P2144-900B</td>
<td>7/8&quot; x 8&quot; Grade 2 Bolt</td>
<td></td>
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</tbody>
</table>

## Parts No. 1

- **Dimensions:** 1" = 1"
- **Note:**
  - 2.50" x 1.65" x 0.85"
  - 5/16" x 29/64" Drill
  - 1/2" - 20 Tap
  - 1/16" x 1/16"

## Parts No. 2

- **Dimensions:** 1" = 1"
- **Note:**
  - 7/8" x 0.85"
  - 5/16" x 29/64" Drill
  - 1/2" - 20 Tap

## Parts No. 13

- **Dimensions:** 1" = 1"
- **Note:**
  - 7/16" x 0.85"
  - 5/16" x 29/64" Drill
  - 1/2" - 20 Tap

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**Manufacturers Listing**

1. Brownell's Inc.
   - Route 2, Box 1
   - Montzuma, IA 50171
2. Rockford Products
   - P.O. Box 6306
   - Rockford, IL 61125-1306
   - 6917 West 59th St
   - Chicago, IL 60638
4. Medalist
   - 9375 West Chestnut
   - Franklin Park, IL 60131
5. Servalite Products
   - East Moline, IL 61244

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The ZAPPER
ULTIMATE CONCEALABLE WEAPON
A functional lighter
A deadly derringer

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WARNING: IT IS A FELONY VIOLATION OF FEDERAL LAW SUBJECT TO FINE AND / OR IMPRISONMENT TO MANUFACTURE THIS OR ANY FIREARM WITHOUT A LICENSE.
REMOVE FLOOR OF LIGHTER TOP.

HEAVY DUTY HAMMER SPRING:

1/8" SPRING STEEL TRIGGER ROD SOLDERED TO LID.

3/8" HOLE IN LID & LIGHTER CASE.

ROTATE LID AGAINST LIGHTER BASE TO FIRE.

DRILL SAFETY PIN HOLE THRU FRAME & ONE SIDE OF LIGHTER CASE ONLY.

FLINT

COTTON & WICK

SHORTEN FLINT TUBE & SPRING, RETAP W/ 6X32 THREAD.

SAW AWAY FLUID & COTTON HOUSING TO FIT CONTOURS OF FRAME.

ROUND OFF OUTSIDE CORNERS OF BREECH BLOCK & FRAME TO FIT LIGHTER CASE.

SECTION

SCALE: 3" = 1"
MODIFIED LIGHTER TOP

CLEAR PIN DT PIN

FRAME

BREECH BLOCK

HAMMER SPRING

HAMMER PIN

FIRING PIN PIVOT

BREECH PIVOT PIN

BREECH SCREW

LIGHTER CASE

SAFETY PIN

TRIGGER ROD

EXPLODED ISOMETRIC

FULL SIZE
NOTES:
1. ALL PARTS TO BE MADE OF STEEL.
2. ENLARGE CHAMBER W/ EMERY CLOTH ON GROTTED MANDREL USING DRILL.
3. GEAR & FIRING PIN BEST MADE BY GRINDING SHAPES FROM STD. HALF MOON KEYS.

NOTE:
IF HAMMER SPRING CANNOT BE FOUND W/ SUFFICIENT FORCE TO DETONATE PRIMER, NEST TWO OR THREE SPRINGS WITHIN EACH OTHER.
**BR EEC H P O V E T P I V O T**: \( \frac{3}{32}'' \phi \times 0.44'' \\
**F I R I N G P H N P O V E T**: \( \frac{1}{6}'' \phi \times 0.44'' \\
**G E A R P O V E T P I V O T**: \( \frac{1}{16}'' \phi \times 0.44'' \\
**S I D E**
PENGUN

DUAL FUNCTION .22 CAL. DEFENSE WEAPON

A PEN THAT SHOOTS / A GUN THAT WRITES

"THE PEN IS MIGHTIER THAN THE SWORD"

BARON LyTTON

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GENERAL NOTES

This PENGUN is designed to be built without exotic tools or special skills. All critical dimensions are accommodated by utilizing a rifled barrel liner and five sizes of readily available brass tubes which fit snugly inside each other. All other dimensions, which are shown to the nearest hundredth of an inch, are approximate. For instance, part 23, which plugs into part 22, is turned down until it fits snugly inside. No precise measurement is necessary. This "test to fit" method is used throughout.

The technique employed to join the various pieces is known as "sweating" and widely used by plumbers. The pieces are cleaned with steel wool, coated with soldering flux paste, fitted together, heated with a small torch (alcohol lamp, kitchen range, etc.) and acid core solder is applied to the joint. If there is sufficient heat, the lead solder will be drawn into the joint by capillary action making a very strong connection. A trip to the library or a talk with your plumber about sweating is strongly advised. A little practice is also very helpful.

The technique for "turning down" parts 8, 10, 14 and 23 is quite simple. A suitable brass rod or bolt is selected and placed in a drill which is clamped (or other held firmly) in a vise. A file is then used to reduce the diameter of the spinning rod to fit snugly in its proper tube. The piece is then cut to length with a hacksaw and sanded smooth to remove the teeth marks.

There is an alternative to "turning down" a brass rod. Purchase 
RGS parts 166, 130 & 131 (3/16" solid rod and 7/32" and 1/4" tubes, respectively) and sweat them together with other tubes on hand to form solid pieces needed for 8, 10, 14 and 23.

The brass tubing is cut and slotted with a Dremel hand grinder with no. 402 mandrel and no. 409 cutting wheel. Buy, borrow or rent this tool because it is essential. The PENGUN is designed for one handed firing by the right hand. The angled cocking slot in the housing would be on the opposite side for left handed operation.

Test fire the PENGUN starting with empty .22 cases and progress to blanks, C.B. caps and finally .22 shorts. A more powerful bullet will likely blow up the PENGUN and cause serious personal injury.

TOOLS AND EQUIPMENT NEEDED

Hoppe's gun blue solution (item # 1702).
Dremel grinder bits # 402, 404 & 945.
Fine sandpaper or emery cloth.
Dremel electric hand grinder.
Vise (to hold drill).
Soldering flux paste.
Acid core solder.
Small round file.
Fine steel wool.
Small flat file.
Hackamore & blade.
Hand torch.
Superglue.
Pencil.

OTHER SARDAUKAR ORIGINALS

ZAPPER - Cigarette Lighter Derringer
BUCKLER - Belt buckle Buckle Gun
BLITZER - High Explosive Bullets
TATTLER - Trip Wire Prowler Alarm

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GERMAN TOWN, TN 38138

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INSTRUCTIONS

1. Cut 18 to length. Cut out middle section as indicated.

2. Cut 17 to length. Place in vise and ream chamber with "number size" drill bit 1 (0.2320" diameter). Test correct depth with 5. Do not over drill to avoid possibility of chambering a larger bullet. Sweat 17 to 18.


5. Cut 11 to length as indicated.

6. Place brass rod or bolt in drill. Turn down parts 6, 10, 14 and 23 for snug fits in there respective tubes. Cut to lengths as shown with hacksaw.


8. Use assembled 9/10/11 to determine slot size in 6. Make slot "V" shaped to allow for firing pin play. Sweat 6 to 7 using assembled 9/10/11/temperate 12 to determine proper position.

9. Place 5 in 17/18 and grind (pinned) end of 7 for snug fit.


11. Place 13 in 11, 11 in 7, 14 in 7 and crosspin with 8. Start with 13 too long and gradually shorten so firing pin travels maximum distance from spring at full compression.


16. Slide 2/3/4 over 16/17/18/19. Slide 15 over 15 until 15 begins to turn. Stop when pocket clip is perpendicular to 12 (so 12 will not show a bump in the pocket or poke the chest). Glue 15 into place.


18. Place 5/32" bit in drill and shape 12 from shank and using Dremel and #409 disc. Test fit often. Cut off 12 only when fit and function are satisfactory. Cut all helps.

19. Load with .22 primed case (bullet and powder removed). Test for reliable ignition. Shape tip of firing pin or use heavier spring(s) as necessary.

20. Load with .22 short round. Clamp 17 in vise with non-marving jaws, set up backstrap, cock pen, cover whole assembly with a heavy blanket and fire remotely using string. Disassemble and inspect for signs of failure. Repeat procedure five times.

21. Polish all exposed metal with steel wool and apply Hoppe's gun blue in accordance with the instructions on bottle.

22. When firing by hand keep fingers away from muzzle and maintain good grip. Do not attempt to fire a larger bullet.
RUB CAP WITH STEEL WOOL TO REMOVE SHINE.

1.00"

PART NO. 1
1" = 1"

CUT

UNSCREW

PART NO. 4
1" = 1"

PART NO. 16
3" = 1"

PART NO. 21
3" = 1"

MAKE PARTS 16 & 21 AT THE SAME TIME BY CUTTING ONE FROM THE OTHER. ANGLE IS NOT CRITICAL AS LONG AS PARTS MATE TOGETHER.

SLOT PATTERN
2" = 1"

0.19" DIA.

0.1"

0.2"

0.57" 1.1"

0.1"

0.20"

0.075"

90°

0.15"

PART NO. 22
3" = 1"

PART NO. 23
3" = 1"

PART NO. 21 (INSIDE)
1" = 1"

PART NO. 23 (INSIDE)
1" = 1"

SECURE WITH SUPER GLUE

SEAL CUT END WITH SPOT OF GLUE.

PART NO. 3
1" = 1"

PART NO. 2
1" = 1"

PART NO. 15
1" = 1"

PART NO. 1
1" = 1"

PEN GROUP
2" = 1"

HOUSING GROUP
1" = 1"
# Parts Schedule

<table>
<thead>
<tr>
<th>No.</th>
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<th>MFGR</th>
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<th>Comments</th>
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<tbody>
<tr>
<td>1</td>
<td>Pen Cap</td>
<td>Plastic</td>
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<td>1</td>
<td>70000</td>
<td>No Nonsense Ballpoint Pen</td>
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<td>70000</td>
<td>&quot;&quot;</td>
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<td>.22 Cal. Short</td>
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<td>162 1/16</td>
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<td>15210</td>
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## Local Source Listing

1. Supermarket
2. Hobby Shop
3. Sporting Goods Store
4. Hardware Store
5. Brownell's Catalog
6. Scrap Pile

## Manufacturers Listing

1. Sheaffer Eaton, Inc.
   Lincoln, RI 02865
   6917 West 59th St.
   Chicago, IL 60638
3. Winchester
   East Alton, IL 62024
4. Black & Decker
   P.O. Box 21030-0798
   Hunt Valley, MD 21030
5. Brownell's, Inc.
   Route 2, Box 1
   Montezuma, Iowa 50171

See Sheet 6 for Parts No. 15 & 16.
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CANEGUN

SILENCED .22 L.R. CAL. DEFENSE WEAPON

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WARNING: IT IS A VIOLATION OF FEDERAL LAW SUBJECT TO FINE AND/ OR IMPRISONMENT TO MANUFACTURE THIS OR ANY FIREARM OR SILENCER WITHOUT A LICENSE.
The CANEGUN is a .22 long rifle caliber, camouflaged urban defense weapon designed to be built without exotic tools, complex parts or special skills. The weapon is disguised by sight and sound having the appearance of a classy walking stick and incorporating an ultra efficient internal silencer. All components of the CANEGUN are off the shelf items most of which can be found at any good hardware store. The only essential power tools are a drill press and Dremel hand grinder. The usual assortment of hand tools and a modicum of skill are also needed.

Undoubtedly the hardest task is drilling the 29/64" hole down the center of part #12. V blocks or a machinist vise are helpful. Even so, it may take more than one try. Centering the hole is crucial to the effort. The 5/16" hole through part #7 is easier only because the piece is shorter. It is also advisable to use the drill press chuck as the tap holder when cutting internal threads. If the tool is not perpendicular to the work another piece of scrap is created.

Part #7 is turned down to fit snugly inside part #2 by inserting a 5/16" threaded rod through the hole, securing with two nuts, and turning in the drill press against a hand held file. Likewise, parts #4, #22 and #30 are reduced but #17 is placed directly in the chuck and shaped in its entirety before sawing it from the bolt stock.

The leather which conceals the trigger mechanism was selected from the scrap bin at Tandy Leather. This could also be denim, canvas, plastic, etc. If a suitable piece of leather can not be found.

Part #5 is a copper clad, steel fiber scouring pad stretched out, twisted into a rope and wound around the outside of the perforated, rifled barrel liner. It is held in place by wrapping a piece of tie wire in the opposite direction. Do not use steel wool because it will burn or string because it will break.

While most dimensions are shown to two decimal places the implied degree of accuracy is not really necessary. Test fitting is used throughout the manufacturing process whereby the dimensions of one part determine the size of the next.

The most delicate art is tapping the small threads. Patience, plenty of cutting oil and a gentle touch is required. The amount of patience used is inversely proportional to the amount of scrap generated.

TOOLS AND EQUIPMENT NEEDED

Drill bits: #1, #14, #36, #43, 29/64", 5/16", 13/64", 1/8", 5/32", 7/64", 3/32", 1/16"
Curved sawing needles and heavy waxed thread
Thread tapers: 1/2-20, 12-24, 6-32, 4-40
Machinist's vise and/or "V" blocks
Files: flat, round and triangular
Dremel bits: #402, #409 & #932
Razor knife and straight edge
Dremel electric hand grinder 5/16" threaded rod and nuts
Thread dies: 1/2-20, 12-24
Screwdriver, flat blade .22 l.r. bullets .05" tie wire
Center punch
Drill press
Cutting oil
Hacksaw
Pencil
Hammer
Ruler

OTHER SARDRAKAR ORIGINALS
ZAPPER -Cigarette lighter gun
BUCKLER-Dbl bbl buckle gun
BLITZER-High explosive bullet
TATTLER-Trip wire alarm
PENGUN -Writing pen gun
ROCKER -AR7 full auto
FOGGER -pen/smoke bomb

SARDRAKAR PRESS
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Germantown, TN 38138

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INSTRUCTIONS

1. Cut 12 to length. Tap threads in both ends. Cut slot, groove and drill 1/16" dia. holes for 14 & 16.


4. Cut 7 to length. Chuck in drill press and reduce diameter until 7 will fit snugly in 2. Drill 29/64" to depth as shown and tap 1/2-20 threads.

5. Cut 6 to length. Drill 7/64" gas holes (hint: "V" blocks are helpful). Cut chamber with wire size drill 91 (.220" dia) using .22 long rifle bullet to confine depth. The first round fired will remove all internal burrs.

6. Cut 4 to length and drill 5/16" hole in center. Using step 4 technique reduce diameter to fit loosely into 2. Drill 6 gas vent holes as shown.

7. Screw B into 7. Cut .22 round into 6. Coat end of 6 with glue (use auto rear view mirror adhesive or Loctite) and insert into 7 being careful to keep glue off bullet. Set 4 on 6 in same manner. Allow to set over night.


10. Cut 18 to length. Drill 1/16" dia. hole and cut threads.

11. Cut 22 to length, drill and tap 12-24 threads as shown. Chuck 18 in drill press, screw on 30 and reduce diameter.

12. Remove escutcheon plate from 12 by grinding off rolled lip of metal insert. Remove insert by placing hacksaw blade inside square hole and cut through in two places. Hammer out four indentations (hint: lay shaft of bond on piece of wood, insert 1/12" rod over indentations and hit rod with hammer) and grind smooth from inside with Dremel and 9/32 bit. Drill 1/8" dia. holes 90 degrees apart centered 5/64" from the edge. Grind off any burrs.

13. Cut 2 piece from 1/2" bolt for 11. Drill 10/64" hole and bevel end. Cut 30 to length, drill and tap. Screw into 21 and reduce diameter as in step 4 for tight fit into 31. Remove 30 and cut 21 to length.


16. Cut spring 20 to have slight pressure when uncocked.


18. Wrap 27 & 28 around 26/12, cut to length and drill #43 holes (hint: secure 27 & 28 in position with tie wire or small nose clamp prior to drilling). Mark all parts for proper relationship and disassemble. Tap 4-40 threads in 12.
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