

# CANEGUN



*SILENCED .22 L.R. CAL. DEFENSE WEAPON*

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## GENERAL NOTES

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 class 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 to tie wire in the opposite direction. Do not use steel wool because it will burn nor 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

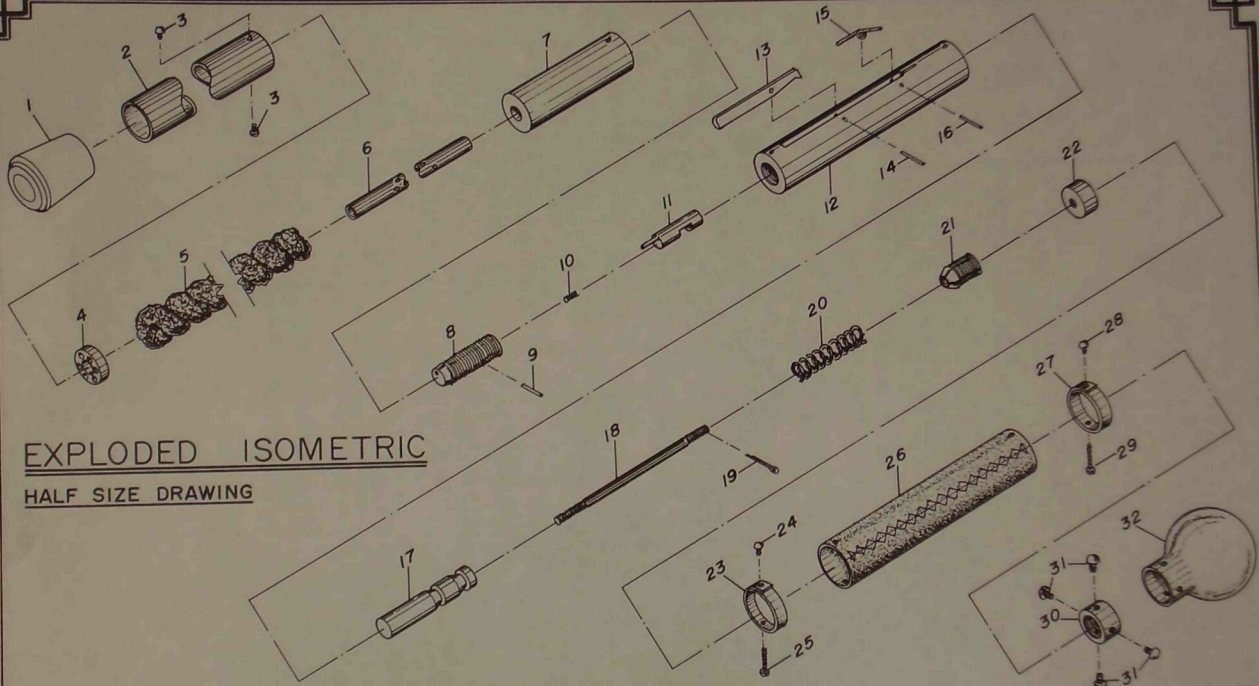
Drill bits: #1, #14, #36, #43, 29/64", 5/16", 13/64", 1/8",  
5/32", 7/64", 3/32", 1/16"  
Curved sewing needles and heavy waxed thread  
Thread taps: 1/2-20, 12-24, 6-32, 4-40  
Machinist's vise and/or "V" blocks  
Files: flat, round and triangular  
Dremel bits: #402, #409 & #932  
Razor knife and 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 SARDAUKAR ORIGINALS

ZAPPER -Cigarette lighter gun  
BUCKLER-Db1 bbl buckle gun  
BLITZER-High explosive bullet  
TATTLER-Trip wire alarm  
PENGUN -Writing pen gun  
ROCKER -AR7 full auto  
FOGGER -pen/smoke bomb

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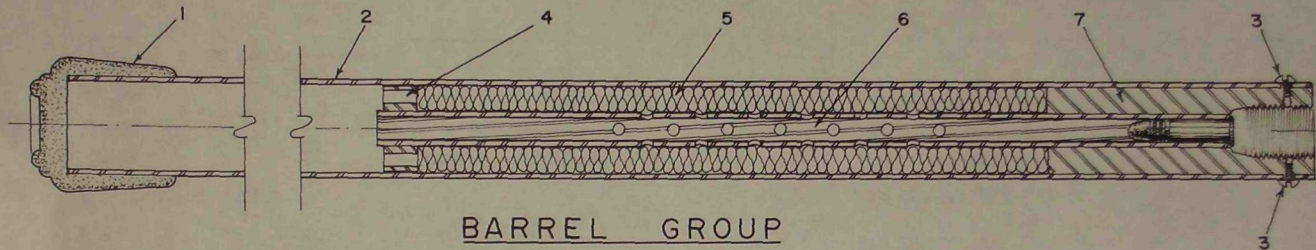
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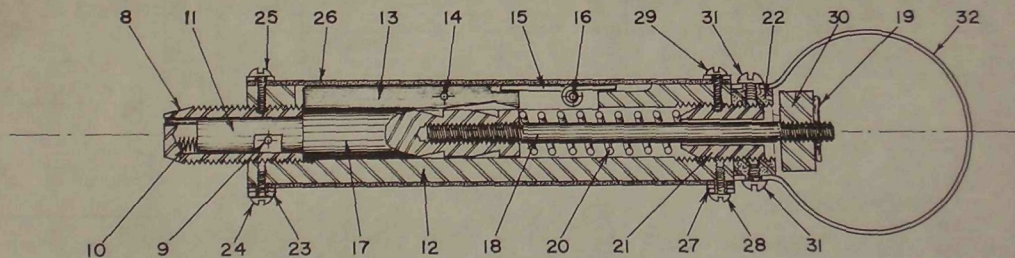
EXPLODED ISOMETRIC  
 HALF SIZE DRAWING

## INSTRUCTIONS

- Cut 12 to length. Tap threads in both ends. Cut slot, groove and drill 1/16" dia. holes for 14 & 16.
- Cut 3" section from 1/2" bolt for 8. Cut 1/2-20 threads for 2". Drill 5/16" hole (hint: chuck 8 in drill press and secure 5/16" bit in machinists vise). Cut 8 to length and square face. Drill 3/32" firing pin hole. Bevel end.
- Grind 11 using Dremel hand grinder and #409 cutting wheel. Use 11 to locate 3/32" hole in 8 and drill same. Cut pin 9 and spring 10 to fit.
- 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.
- Cut 6 to length. Drill 7/64" gas holes (hint: "V" blocks are helpful). Cut chamber with wire size drill #1 (.228" dia) using .22 long rifle bullet to confire depth. The first round fired will remove all internal burrs.
- 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.
- Screw 8 into 7. Put .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.
- Cut 3" piece from 1/2" bolt for 17. Drill 29/64" hole in scrap metal for gauge. Chuck into drill press and reduce the diameter until it will pass through gauge. Drill hole as shown using #14 wire size drill (hint: hold bit in machinist's vise keeping 17 in chuck). Shape grooves in 17 using hacksaw, Dremel grinder and file. Tap 12-24 threads and cut to length using hacksaw (hint: spin 17 in chuck for square cut). Bevel end slightly.
- Drill
- Cut 18 to length. Drill 1/16" dia. hole and cut threads.
- Cut 22 to length, drill and tap 12-24 threads as shown. Chuck 18 in drill press, screw on 30 and reduce diameter.
- Remove escutcheon plate from 32 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 indentions (hint: lay shaft of knob on piece of wood, insert 1/2" rod over indentions and hit rod with hammer) and grind smooth from inside with Dremel and #932 bit. Drill 1/8" dia. holes 90 degrees apart centered 5/64" from the edge. Grind off any burrs.
- Cut 2" piece from 1/2" bolt for 21. Thread for 1". Drill 13/64" hole and bevel end. Cut 30 to length, drill and tap. Screw onto 21 and reduce diameter as in step 4 for tight fit into 31. Remove 30 and cut 21 to length.
- Mark holes for 22 with holes in 31. Drill and tap.
- Assemble 4/6/7, 8/9/10/11, 12, 17, 21, 22 & 30. Cut out 13 and trial fit. Cut pins 14 & 16 to length. Bend spring 15 around nail in vise. Cut ends to proper length after trial fit.
- Cut spring 20 to have slight pressure when uncocked. Test fire on empty .22 case, make adjustments as needed. Set 18 in 17 using adhesive as in step 7.
- Cut out 26 to fit 12. Mark holes 1/4" apart 1/8" on either side of seam. Sew together in "shoelace" stitch with heavy waxed thread using two curved needles (Item 01025, The Singer Co., Edison, NJ 08637).
- Wrap 23 & 27 around 26/12, cut to length and drill #43 holes (hint: secure 23 & 27 in position with tie wire or small hose clamp prior to drilling). Mark all parts for proper relationship and disassemble. Tap 4-40 threads in 12.
- Reassemble 4/6/7, 8/9/10/11 (using empty .22 case to set headspace) into 12. Mark and drill set screw indentation. Repeat procedure for 21. Cut screws 25 & 29 to length.
- Cut 2 to length. Install over 4/6/7, drill holes for 3 and tap threads in 7. Paint 2 (Black) enamel recommended).
- Remove 5 from handle, unwind and twist into "rope". Rewind around 6 and secure with tie wire.
- Assemble all parts and the work is finished.
- To load: unscrew barrel group from breech group, drop .22 long rifle bullet into chamber and screw pieces together.
- To cock: unscrew knob and pull rearward. Two clicks will be heard as the trigger engages the half cock then full cock notches on the hammer. The bulge of the trigger can be felt under the leather grip. Screw knob back into place.
- To fire: press trigger bulge in leather with thumb.



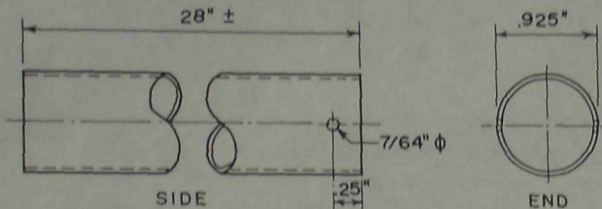
BARREL GROUP



BREECH GROUP

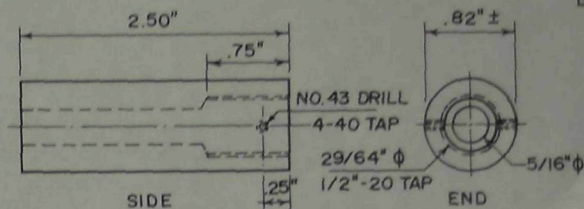
LONGITUDINAL SECTION

FULL SIZE DRAWING



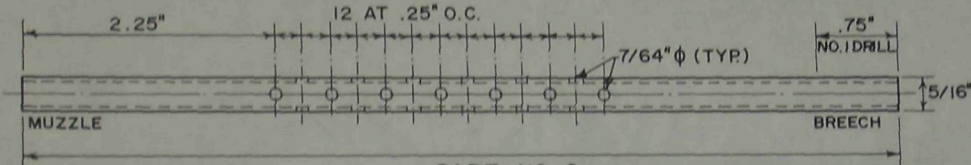
**PART NO. 2**

1" = 1"



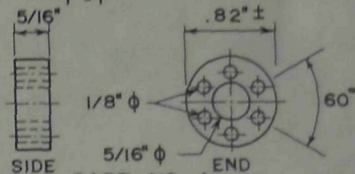
**PART NO. 7**

1" = 1"



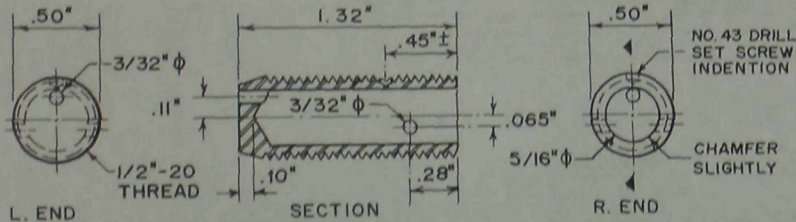
**PART NO. 6**

1" = 1"



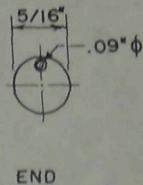
**PART NO. 4**

1" = 1"



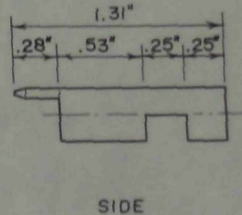
**PART NO. 8**

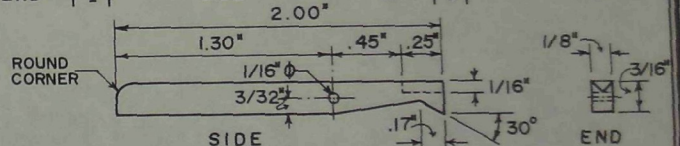
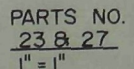
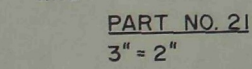
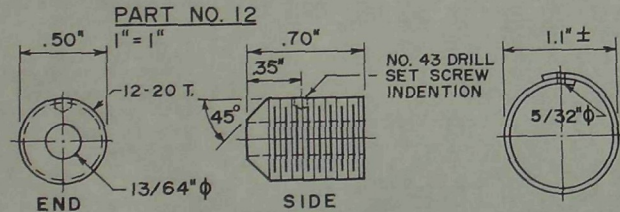
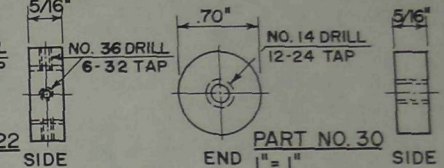
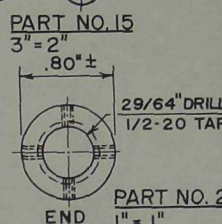
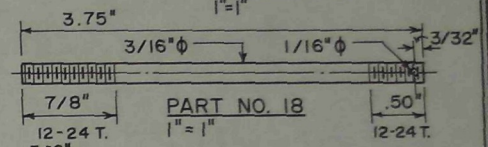
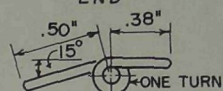
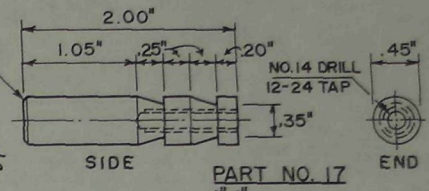
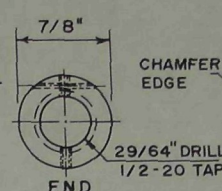
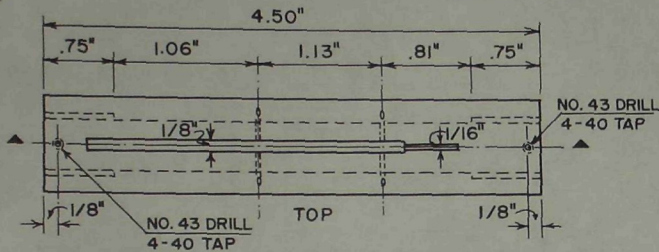
3" = 2"



**PART NO. 11**

3" = 2"





# PARTS SCHEDULE

NO.	NOMENCLATURE	MATERIAL	SOURCE	MFGR	MFGR NO.	COMMENTS
1	CANE TIP	PLASTIC	1	1	ACE51241	7/8" $\phi$ FURNITURE TIP
2	BARREL SHROUD	STEEL	1		-	3/4" $\phi$ E.M.T. (THIN WALL) CONDUIT
3	BARREL SHROUD SCREWS(2)	BRASS	1	2	54060322	4-40 X 1/4" RD. HD. SCREW
4	GAS VENT	STEEL	1	3	P2144-903B	7/8" X 12" GRADE 2 BOLT
5	SILENCING MEDIA			2	44-1395	"ERGO" COPPER-CLAD SCOURING PAD
6	BARREL (RIFLED)		3	5	5L-12R46	MAIL ORDER ITEM
7	BARREL EXTENSION		1	3	P2144-903B	7/8" X 12" GRADE 2 BOLT
8	BREECH PLUG		1	3	P2144-744B	1/2" X 10" GRADE 2 BOLT
9	FIRING PIN RETAIN'G PIN		4	6	506	3/32" MUSIC WIRE
10	FIRING PIN SPRING		2	-	-	FROM RETRACTABLE BALL POINT PEN
11	FIRING PIN		1	-	-	5/16" DRILL BIT
12	FRAME		1	3	P2144-903B	7/8" X 12" GRADE 2 BOLT
13	TRIGGER		1	7	F37110	1/8" X 3/4" X 36" GALV. FLAT STOCK
14	TRIGGER PIVOT PIN		4	6	504	1/16" $\phi$ MUSIC WIRE
15	TRIGGER SPRING		4	6	503	.055" $\phi$ MUSIC WIRE
16	TRIGGER SPRING PIN		4	6	504	1/16" $\phi$ MUSIC WIRE
17	HAMMER		1	3	P2144-744B	1/2" X 10" GRADE 2 BOLT
18	COCKING ROD		1	7	R36103	3/16" $\phi$ X 36" GALV. ROD
19	COCKING NUT PIN		1	-	-	1/16" $\phi$ X 1" COTTER PIN
20	MAINSRING		1	8	32	SUPPLEMENT WITH NO. 76 X IF NEEDED
21	FRAME PLUG		1	3	P2144-744B	1/2" X 10" GRADE 2 BOLT
22	COCKING NUT		1	3	P2144-903B	7/8" X 12" GRADE 2 BOLT
23	LOWER FERRULE	BRASS	4	6	240	.032" X 12" BRASS STRIP
24	LOWER FERRULE SCREW		1	2	54060322	4-40 X 1/4" RD. HD. SCREW
25	BREECH PLUG SET SCREW		1	2	54060389	4-40 X 1" RD. HD. SCREW
26	GRIP	LEATHER	5	-	-	SOFT LEATHER
27	UPPER FERRULE	BRASS	4	6	240	.032" X 12" BRASS STRIP
28	UPPER FERRULE SCREW		1	2	54060322	4-40 X 1/4" RD. HD. SCREW
29	FRAME PLUG SET SCREW		1	2	54060389	4-40 X 1" RD. HD. SCREW
30	COCKING RING	STEEL	1	3	P2144-903B	7/8" X 12" GRADE 2 BOLT
31	COCKING RING SCREWS (4)	BRASS	1	2	54060405	6-32 X 1/4" RD. HD. SCREW
32	HANDLE	BRASS	1	9	488P	DUMMY DOOR KNOB, U.S.3 FINISH

## LOCAL SOURCE LISTING

1	HARDWARE STORE
2	SUPERMARKET
3	BROWNELL'S CATALOG
4	HOBBY SHOP
5	LEATHER SHOP

## MANUFACTURERS LISTING

- ACE HARDWARE  
2200 KENSINGTON CT.  
OAK BROOK, IL 60521
- CENTRAL HARDWARE  
111 BOULDER INDUSTRIAL DR.  
BRIDGETON, MO. 63044
- ROCKFORD PRODUCTS  
P.O. BOX 6306  
ROCKFORD, IL 61125-1306
- EMPIRE BRUSHES, INC.  
GREENVILLE, NC 27835
- BROWNELL'S, INC.  
ROUTE 2, BOX 1  
MONTZUMA, IOWA 50171
- K & S ENGINEERING CO.  
6917 WEST 59TH ST.  
CHICAGO, IL 60638
- MEDALIST  
9375 WEST CHESTNUT  
FRANKLIN PARK, IL 60131
- SERVALITE PRODUCTS  
EAST MOLINE, IL 61244
- KWIKSET CORP.  
ANAHEIM, CA.