

THE THOMPSON SUBMACHINEGUN  
 MODEL M1A1  
 MACHINIST'S WORKING DRAWINGS  
 IN FOUR PLATES

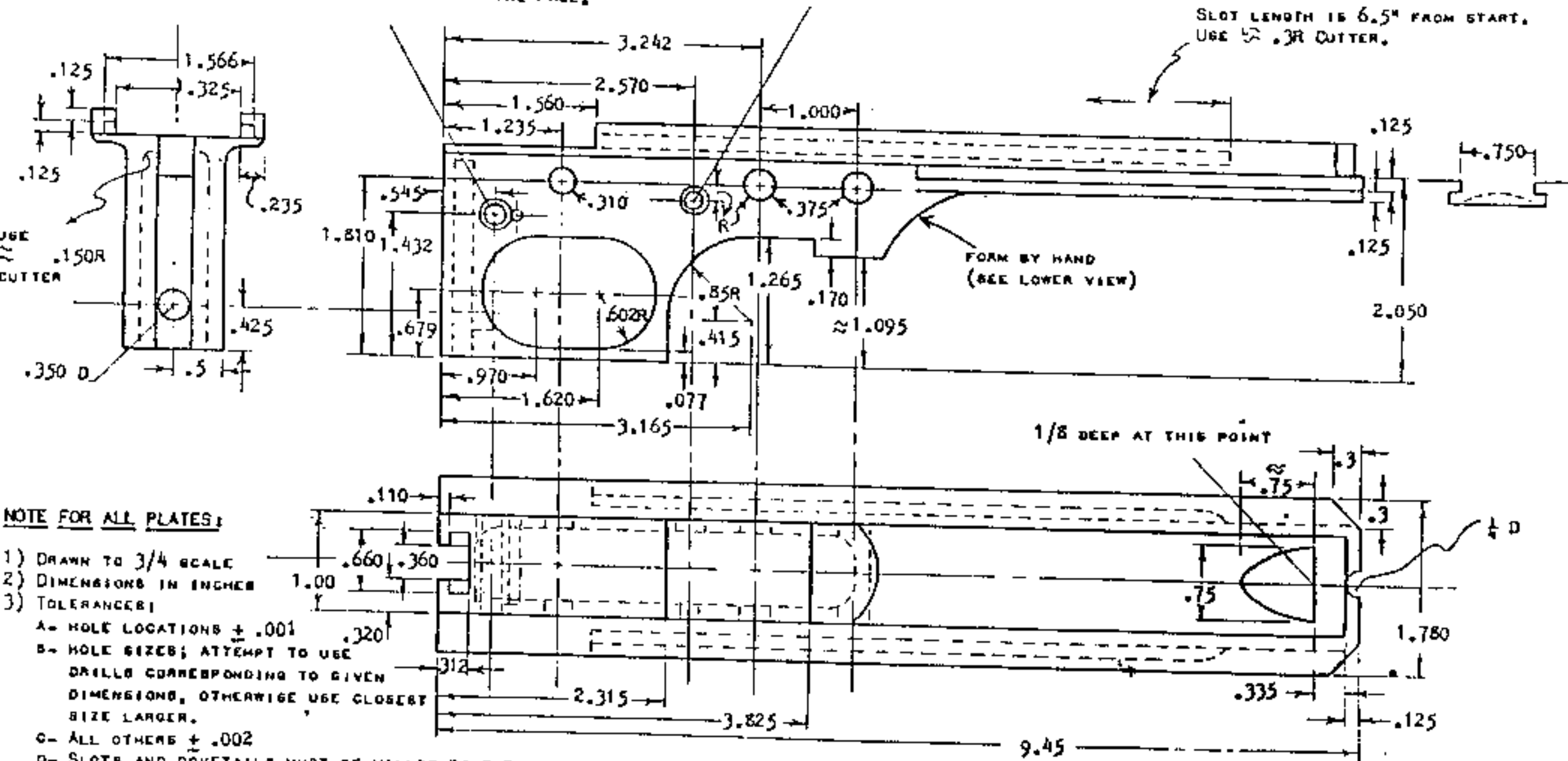
PLATE ONE

-TRIGGER HOUSING-

CENTER HOLE IS .250 D AND GOES ALL THE WAY THROUGH. LARGEST IS .380 D, SMALLEST IS .150 D; BOTH GO TO A DEPTH OF .675. SMALLEST INTERSECTS AS SHOWN AND LEAVES A SLOT BETWEEN  $\approx$  .075 WIDE. THE SMALLEST SHOULD BE LOCATED .610 FROM THE FACE.

CENTER HOLE IS .185 D AND IS DRILLED FIRST, ALL THE WAY THROUGH. SECOND HOLE IS .300 D, AND IS DRILLED ONLY THROUGH THE FIRST WALL.

SLOT LENGTH IS 6.5" FROM START. USE  $\frac{1}{2}$  .3R CUTTER.

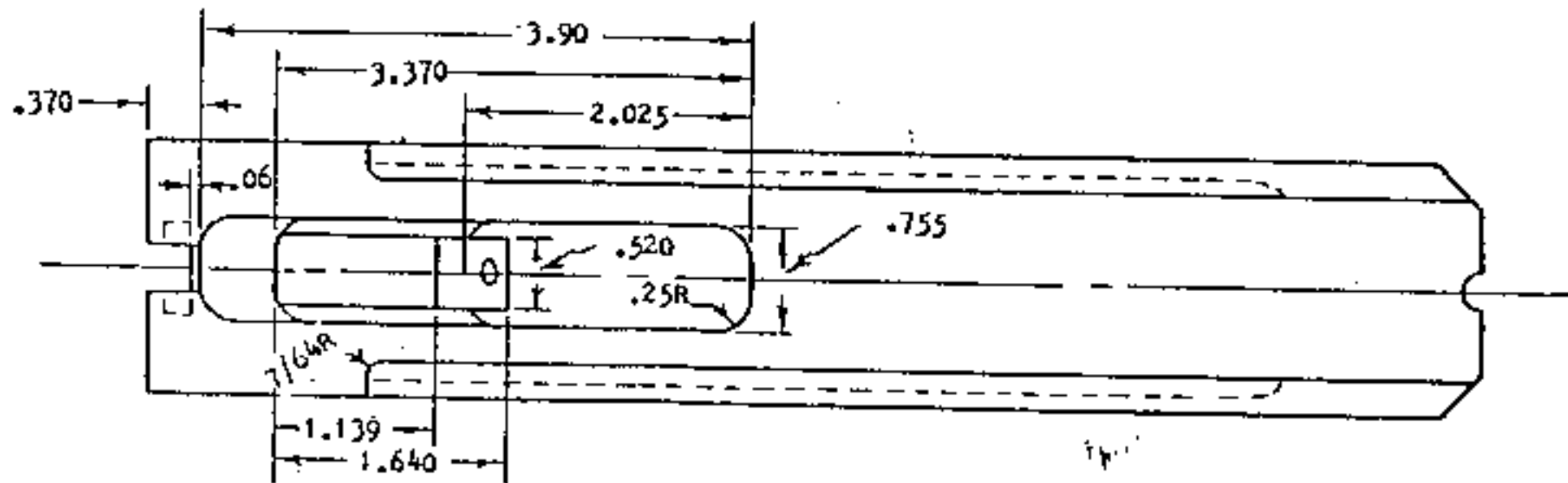
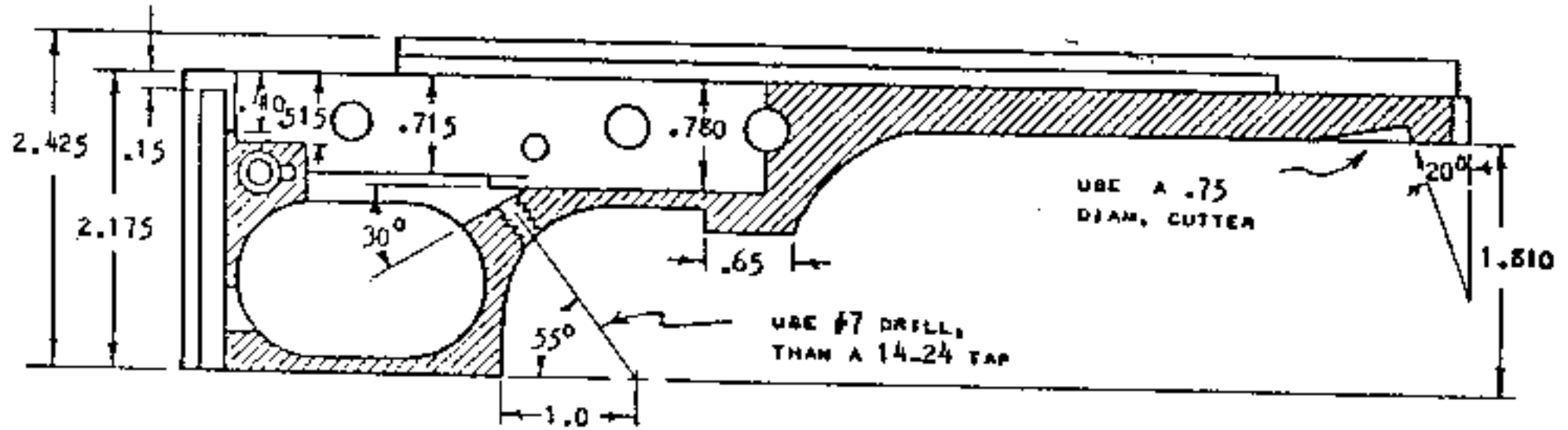


NOTE FOR ALL PLATES:

- 1) DRAWN TO 3/4 SCALE
- 2) DIMENSIONS IN INCHES
- 3) TOLERANCES:
  - A- HOLE LOCATIONS  $\pm$  .001
  - B- HOLE SIZES; ATTEMPT TO USE DRILLS CORRESPONDING TO GIVEN DIMENSIONS, OTHERWISE USE CLOSEST SIZE LARGER.
  - C- ALL OTHERS  $\pm$  .002
  - D- SLOTS AND DOVETAILS MUST BE MILLED TO FIT.
- 4) FILLETS AND ROUNDS 1/8R UNLESS INDICATED.

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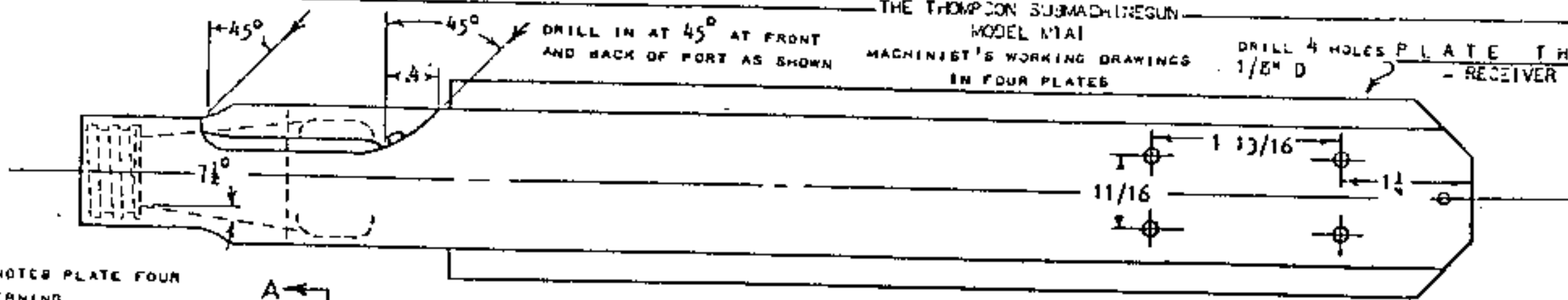
PLATE TWO  
-TRIGGER HOUSING-  
(ALTERED TO TAKE  
M1928 BUTT-STOCK)



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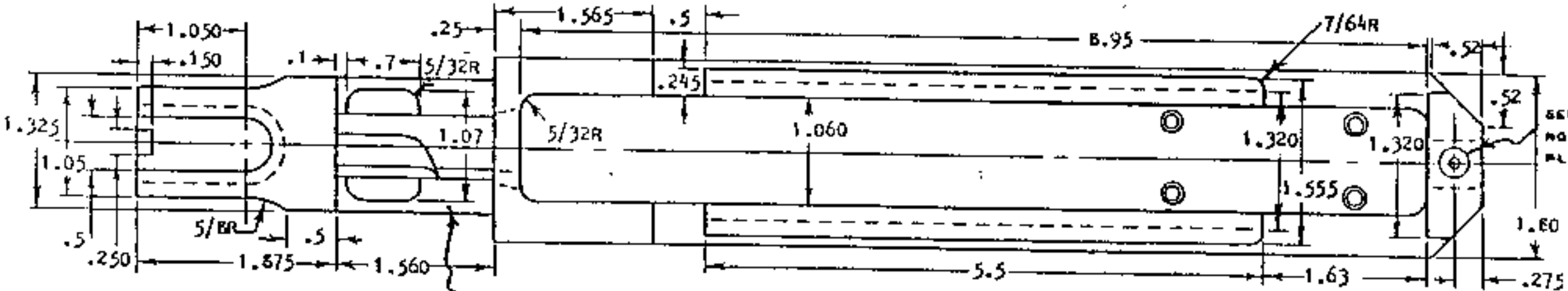
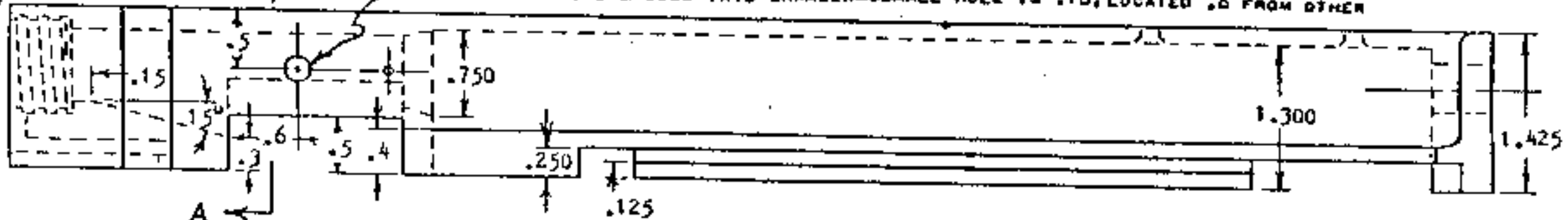
DRILL 4 HOLES PLATE THREE  
 1/8" D  
 - RECEIVER -

DRILL IN AT 45° AT FRONT  
 AND BACK OF PORT AS SHOWN



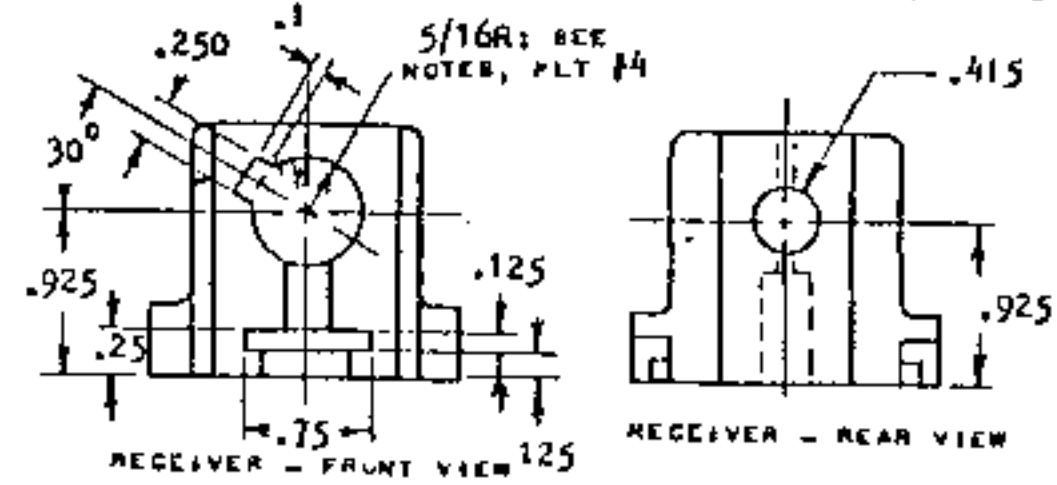
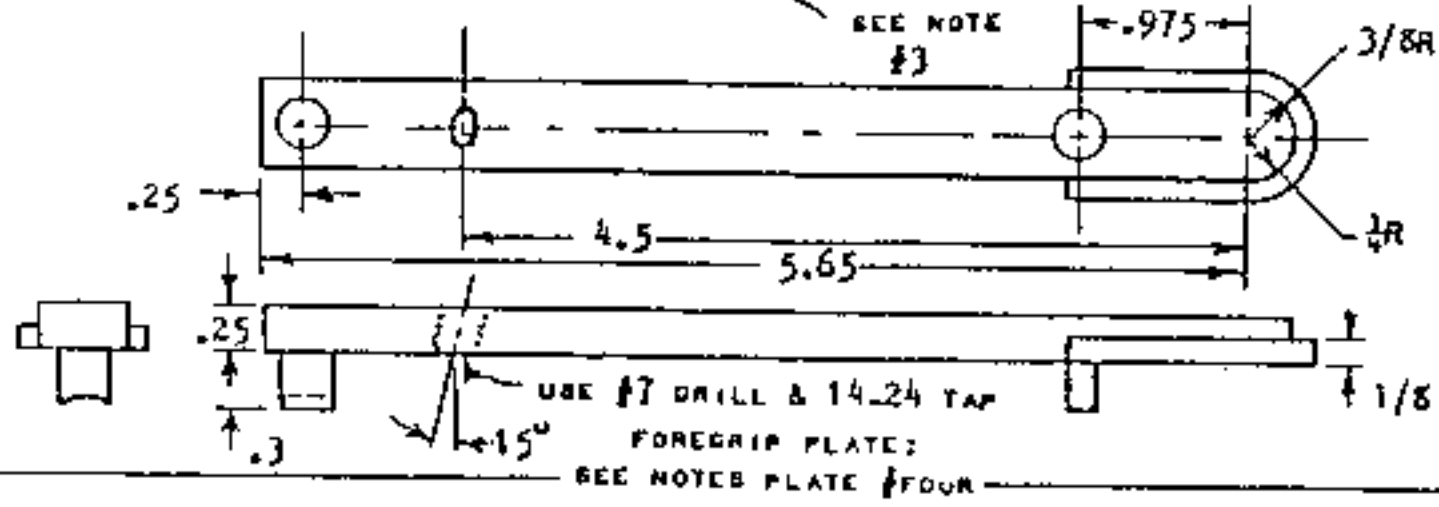
SEE NOTES PLATE FOUR  
 CONCERNING  
 THREADS AND  
 ANGLES OF  
 FEED RAMP

LARGE HOLE IS .20 & GOES INTO CHAMBER--SMALL HOLE IS .10; LOCATED .6 FROM OTHER



SEE NOTE #2  
 PLATE 4

SEE NOTE #3



RECEIVER - FRONT VIEW

RECEIVER - REAR VIEW

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PLATE FOUR

1. ON ALL PLATES: MANY HIDDEN LINES HAVE BEEN ELIMINATED TO SIMPLIFY VIEWS - ONLY NECESSARY HIDDEN LINES ARE SHOWN.

2. DRILL  $3/23$  LOCATING HOLE FROM TOP, THEN DRILL  $.300$  HOLE FROM BOTTOM TO A DEPTH OF  $.620$  (SEE REAR VIEW).

NOTES:

3. THESE TWO SURFACES ARE CUT AT  $45^\circ$  (SEE SEC. "A-A")

4. TWO  $.3$  DIAM. ROUND BARS ARE HEAT-FITTED INTO PLATE AND THEN CUT AS SHOWN, THE FRONT ONE CUT TO FIT BARREL - THE REAR ONE CUT TO FIT SLOT IN FRONT OF RECEIVER.

5. A  $5/8$  DIAM. HOLE AND SLOT ARE CUT INTO THE RECEIVER BEFORE THREADS ARE CUT (SEE FRONT VIEW), BOTH GO TO DEPTH OF  $3.685$ .

6. RECEIVER THREADS ARE SQUARE THREADS, 13 TPI,  $.850$  MD AND  $.750$  MIN D, DEPTH TO  $.55$ .

7. THE FLOOR OF THE FEED RAMP IS INCLINED  $15^\circ$  AND STARTS  $.15$  INCHES FROM CHAMBER. THE SIDES OF THE RAMP BEING  $7.5^\circ$  TO EITHER SIDE AND START FROM THE EDGE OF THE CHAMBER WHILE STILL AT  $15^\circ$  FROM THE HORIZONTAL. USE A  $1/2$ " DIAMETER CUTTER.

8. BARREL AND RECEIVER MUST BE HEAT-FITTED.

9. USE 4130 CHROME STEEL FOR RECEIVER

