

**INTERFOR**  
**USA GROUP INC.**  
D I L I G E   E T   Q U O D   V I S   F A C

OWNER'S MANUAL  
STEN and I-STEN rifle and pistol models



Thank you for your business.

This gun has been rebuilt starting from a WW2 Sten parts kit of the appropriate version (MK2 MK3 or MK5) and modified to semi automatic functioning using an Indianapolis Ordnance ATF approved system.

Right now your gun is classified and registered as a pistol but can be safely converted to a rifle using a separate parts kit of 16" barrel and stock (sold separately).

Buying and using this firearm implies acceptance of the following rules (from the site <https://gunsafetyrules.nra.org>) :

**1. ALWAYS KEEP THE GUN POINTED IN A SAFE DIRECTION**

This is the primary rule of gun safety. Common sense dictates the safest direction, depending on different circumstances.

**2. ALWAYS KEEP YOUR FINGER OFF THE TRIGGER UNTIL READY TO SHOOT**

When holding a gun, rest your finger alongside the frame and outside the trigger guard. Until you are actually ready to fire, do not touch the trigger.

**3. ALWAYS KEEP THE GUN UNLOADED UNTIL READY TO USE**

If you do not know how to open the action or inspect the chamber(s), leave the gun alone and get help from someone who does.

**4. KNOW YOUR TARGET AND WHAT IS BEYOND.**

**5. WEAR EYE AND EAR PROTECTION AS APPROPRIATE.**

Guns are loud and the noise can cause hearing damage. They can also emit debris and hot gasses that could cause eye injury. For these reasons, shooting glasses and hearing protection should be worn by shooters and spectators.

Ear and eye protection is specially important in case of a **slamfire or out of battery firing** (unexpected firing with the bolt not completely close) which can happen with any gun due to debris or dirt, malfunction of parts, dropping etc.

Not being completely close, a gun firing out of battery can eject debris or hot gases and only proper eye and hear protection can prevent injury.

**6. BE SURE THE GUN IS SAFE TO OPERATE.**

Just like other tools, guns need regular maintenance to remain operable. Regular cleaning and proper storage are a part of the gun's general upkeep.

Check proper gun functioning before shooting activities and consult a knowledgeable gunsmith in case of any doubt.

**7. Know how to use the gun safely.**

Before handling a gun, learn how it operates. Know its basic parts, how to safely open and close the action and remove any ammunition from the gun or magazine. Remember, a gun's mechanical safety device is never foolproof. Nothing can ever replace safe gun handling.

**8. DO NOT CARRY THE GUN WITH A ROUND IN THE CHAMBER**

Gun Safeties aren't necessarily 100% safe and should not be relied upon to carry, handle, or transport a gun with a round in the chamber.

This is particularly important for this type of firearms (STEN family) whose original WWII design had no safety provision ; the safety button you find on the gun only blocks the trigger mechanism but cannot intercept the bolt or the or the striker in the cocked (armed) position).

A round must be inserted in the chamber only immediately prior to firing and the chamber must be emptied at the end of shooting activities..

FOR THIS REASON IT IS MANDATORY THAT THE GUN IS CARRIED UNLOADED AND CHAMBER EMPTY, and a bullet be loaded only when in pointing in direction of target just ahead of firing.

**If you do not want to abide to these rules please DO NOT USE THE GUN.**

## Firearm specific instructions:

1. If you disassemble this firearm, take care of proper reassembly. In particular, take care that the striker has sear engagement protrusion pointed towards the rear of the gun. Check gun proper functioning of the gun and the striker – sear engagement properly before loading the gun with live fire ammo. If the firearm is assembled with striker in the wrong position it may fire when loading the first round.

Assemble the gun with the parts positioned as in the following picture:



After assembling, point the gun in a safe direction and cock the gun ensuring that the that the striker engages and is properly kept back by the sear (the striker is locked back and is released only when trigger is pulled). If the striker is not kept back by the sear/trigger system do not load the gun with live ammo, disassemble and check correct assembly of parts

2. During disassembly take note of the proper positioning of parts. Before reassembly properly clean the gun and clean and check the proper floating of the firing pin. If the firing pin is not freely floating (moving back and forth) **do not reassemble the gun** and refer to a trained gunsmith for checking. Always point the gun in a safe direction when assembling disassembling or otherwise using the firearm.
3. Do not use this firearm for other uses than collecting or target shooting. This gun is a remodeling of the original Sten design which is almost 80 years old and cannot have the safeties of a modern firearm.

This gun is not suitable for self defense or to be carried loaded with live ammunition in the chamber.

## OPERATING INSTRUCTIONS

This gun is not designed or intended for the use of beginner shooters, as it requires particular competence on firearms use. If you do not know how to use this gun or its functioning is not clear leave it alone and consult an expert.

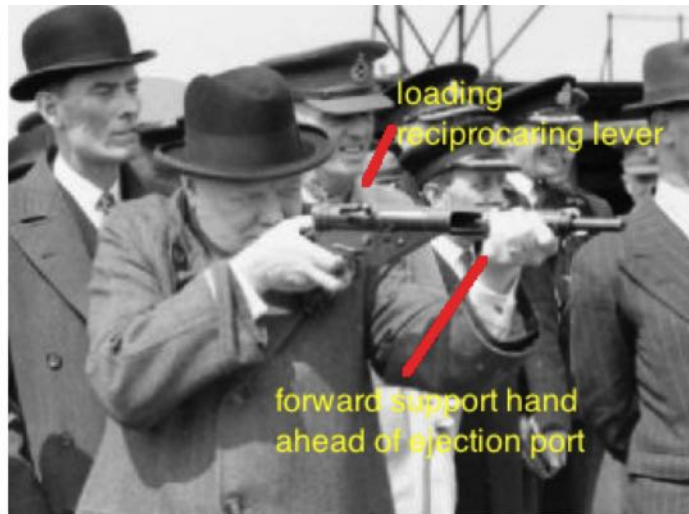
### LOADING

1. Choose a safe place for gun handling ; your bedroom or home are NOT safe places for gun handling. Only appropriate areas of gun ranges are.
2. Extract the gun from the box or bag, always keeping the finger OFF the trigger and the gun pointed in a safe direction (a backstop or target area).
3. Pull the cocking lever (on the right of the gun) check the chamber is empty (no bullet inside the chamber)
4. Pull and release the lever more times to check that everything is working and the gun is not dirty or the barrel obstructed.
5. With gun pointed in safe direction, finger still off trigger, load a loaded magazine in the magazine well.
6. Always pointing in a safe direction and with finger off trigger, pull the loading lever all the way and load the first round.
7. Ensure that the striker has positively engaged the sear.

If you haven't a full comprehension of how the gun operates, always keeping off the trigger and gun pointed in a safe direction, extract the magazine, pull the lever to clean the chamber from a bullet, check the chamber is empty, put down gun in a safe position and look for competent help in the form of an instructor.

Like the original STEN this gun has a reciprocating charging handle (the handle travels back and forth solid to the bolt during fire) and a big ejection port on the right. Keep your hand away from these Areas during firing or loading unloading as you can be hurt. Again, this is a gun for expert shooters so look for appropriate teachings if not competent in the use of this gun.

In general **never hold the gun with the forward hand on the magazine or in correspondence of the ejection port on the right.** The correct position for fire is depicted in the following image:



**Winston Churchill correctly bracing a STEN. Note the forward hand in front (well clear) of the ejection port and the trigger hand thumb, well clear of the reciprocating loading lever.**

8. With the gun still in a safe direction, put your finger on the trigger and pull once. The gun will fire its first round. Check gun pointing and surrounding area and shoot more rounds if necessary, in a slow deliberate manner. Once all rounds are fired or if you decide to stop shooting take your finger off the trigger, keep the gun in a safe direction, engage safety and extract magazine. It is not finished yet: pull the lever and free the chamber from the eventual live round, check the chamber, close the bolt and dry fire in a safe direction. Install a chamber flag (a plastic flag which prevents the accidental chambering of a round – put the gun down in a safe position and always pointed in a safe direction.

ALWAYS FIRE IN A SLOW DELIBERATE MANNER, TAKING CARE THAT YOUR FORWARD HAND DOES NOT SLIDE IN FRONT OF THE BARREL DUE TO RECOIL OR A TOO HIGH RATE OF FIRE.

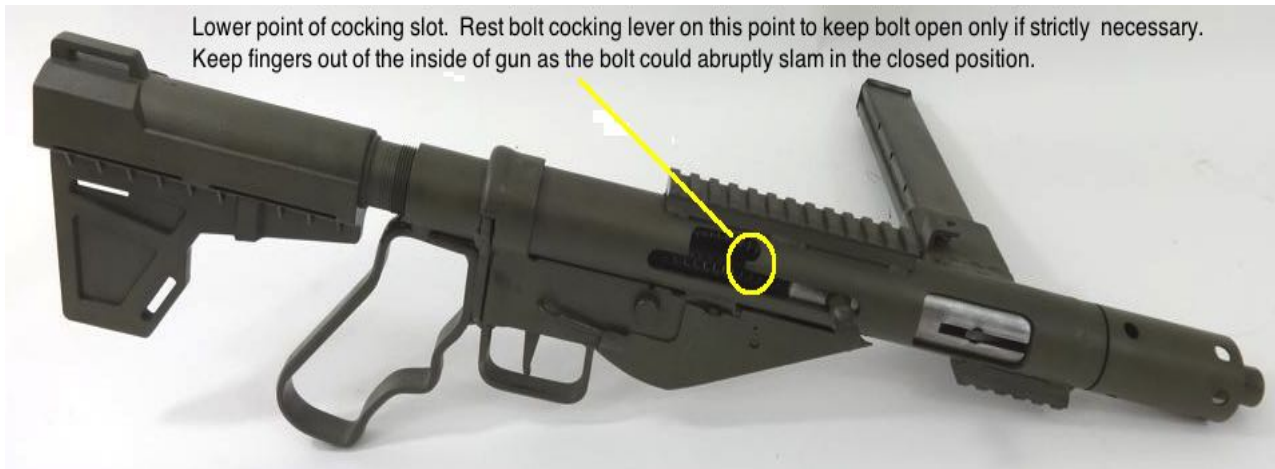
MAKE EXPERIENCE ON THE GUN WORKING BEFORE FAST FIRING, IN CASE CONSULT AN APPROPRIATE INSTRUCTOR.

**IMPORTANT NOTE: this gun has been modified from its original configuration as by ATF guidance. For this reason it is strongly advised to not engage the arming/cocking lever into the hold open slot, as this could bend the recoil rod and the striker rod located inside the receiver.**

**If holding the bolt back in the open position is utterly necessary, please rest the lever on the lower part of the hold open. Refer to following image for position identification.**

**Never insert your finger inside the gun as the bolt could slam abruptly in the closed**

**position, with a sever injury possibility.**



## **PARTS AND OPERATING COMMON TO ALL FIREARM MODELS**

### **CLEANING AND MAINTENANCE**

Periodic cleaning of a firearm is paramount for its correct functioning.

#### **Cleaning operations:**

**THE GUN CONTAINS SPRINGS UNDER LOAD SO ALWAYS WEAR GOGGLES (YOU AND BYSTANDERS) AND CHECK THE GUN IS UNLOADED BEFORE DISASSEMBLING**

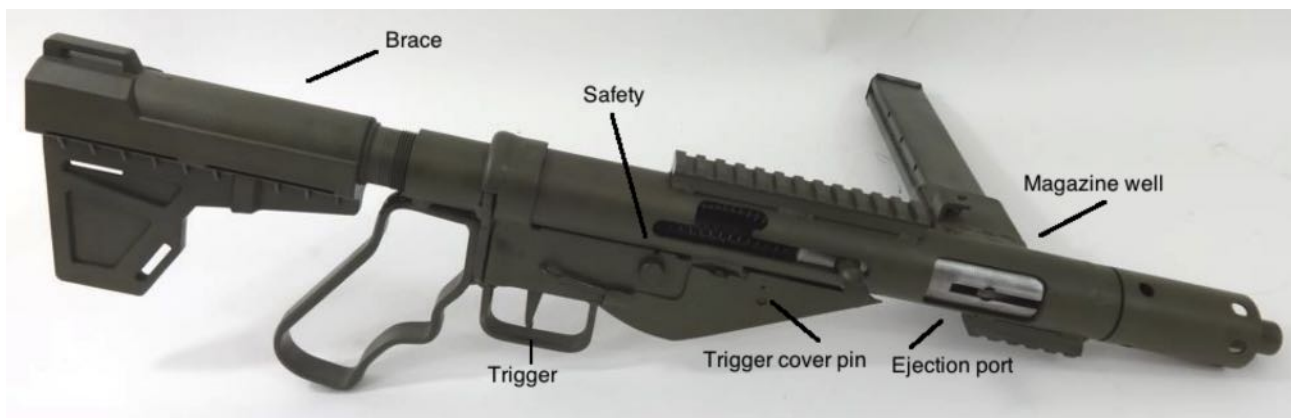
Always keep the gun pointed in a safe direction and keep finger off the trigger.  
Check the chamber is empty pulling the loading lever ; if it is not unload it.  
Remove the small pin in the middle of the trigger body. The pin will be partly green and golden (inside the body) for easy recognition.

Remove the pin on the safety and push it all the way  
You can remove the trigger group cover  
Spray a cleaning product inside the barrel and drive it from muzzle to breech. Repeat as necessary.  
Spray a cleaning product over the trigger system and swipe with a clean rag.

***NO FURTHER DISASSEMBLY IS NECESSARY OR ADVISED.***

Reassemble the gun in the opposite sequence. Check all functions, store the gun

unloaded and with an empty chamber.



I-Sten semiauto pistol

## **WARRANTY**

Interfor USA Group Inc. Will warranty this product against defects of materials and workmanship for one year since the original date of sale.

If return to Interfor USA Group Inc. should be necessary for warranty or repairs, please contact us via [www.interfor.us](http://www.interfor.us) site or call us at 832.542.1587, or write to Interfor USA Group Inc. 12515 Maxim Drive 77065 Houston, Texas, USA.

If the manual for this gun is missing or damaged please download a new copy from [www.interfor.us](http://www.interfor.us) Internet site.

**ALL RIGHTS RESERVED**



## Addendum I

### special instructions for the Sten MK3 takedown model

Our Sten MK3 takedown has been built to resemble a Sten MK3 maintaining the takedown capability of the Sten MK2.

For this reason the gun has been built with 2 piece rib which gets in line when the front sleeve is completely screwed in position.

#### Takedown operations:

1. Point the gun in a safe directions, remove magazine (If inserted) and check the gun is unloaded. If the gun is loaded, unload it.



2. Untighten the front barrel sleeve; if it is tightened you can use a big wood block and hammer it in the clockwise direction (looking from the rear)

3. The following image depicts use of a wood block and hammer:

If the barrel sleeve is stuck can use Liquid Wrench oil or even heat the sleeve with a propane torch to let Liquid wrench get into the parts.

4. Once the sleeve is unscrewed can remove the barrel like on the Sten MK2.

5. Reassemble following direction in the opposite sense. Hammer the wood block till the sleeve is tightened and the sleeve rib is aligned with the rear rib.

Before reassembly always use Anti Seize paste (found in auto stores) on the threads to prevent lockup (the sleeve must be very tight to have the ribs in a straight line).



# HAMMER STEN ASSEMBLY REASSEMBLY (ONLY FOR HAMMER VERSION)

1) REMOVE COCKING HANDLE PULLING BACK BOLT TILL HANDLE REACHES SLOT



2) THE BOLT GOES IN/OUT ONLY IF ROTATED 1/4 COUNTER CLOCKWISE WHILE PUSHING THE BOLT IN/OUT THE HAMMER MUST BE PUSHED DOWN FURTHER INTO THE RECEIVER TO GET OUT OF THE WAY OF THE BOLT.



BOLT ROTATED 1/4  
COUNTER  
CLOCKWISE

SCREWDRIVER  
PUSHING  
HAMMER  
DOWN

**3) ONCE THE HAMMER HAS BEEN PASSED YOU CAN LET IT GO AND PUSH THE BOLT IN OUT USING A RUBBER Mallet**



**ONCE THE BOLT IS REINSERTED PULL IT TO THE RIGHT HEIGHT AND INSERT THE HANDLE**

