

# FullAutoGlock

CONVERT YOUR GLOCK TO FULL-AUTO

CHOOSE YOUR FIREPOWER: SEMI OR FULL-AUTO

Please visit the bureau of Alcohol Tobacco and Firearms website at [www.atf.treas.gov](http://www.atf.treas.gov) and read the laws regarding the conversion of firearms to fully automatic fire: Translated loosely, the legal jargon says that unless the finished device is registered with the ATF, or you possess special exempting qualifications, it is illegal to possess the finished device or pieces whether or not it is installed on a Glock handgun.

Glock is a registered trademark of Glock Ges.m.b.H. and has no affiliation with this device.

# FullAutoGlock

Material to be C-1015 or C-1020 (standard mild steel) or equivalent. No special steel or exotic composite materials are required in the production of this device.

A finish of 150 microinches rms is standard.

The individual parts do not need to be Rockwell "C" scale heat treated.

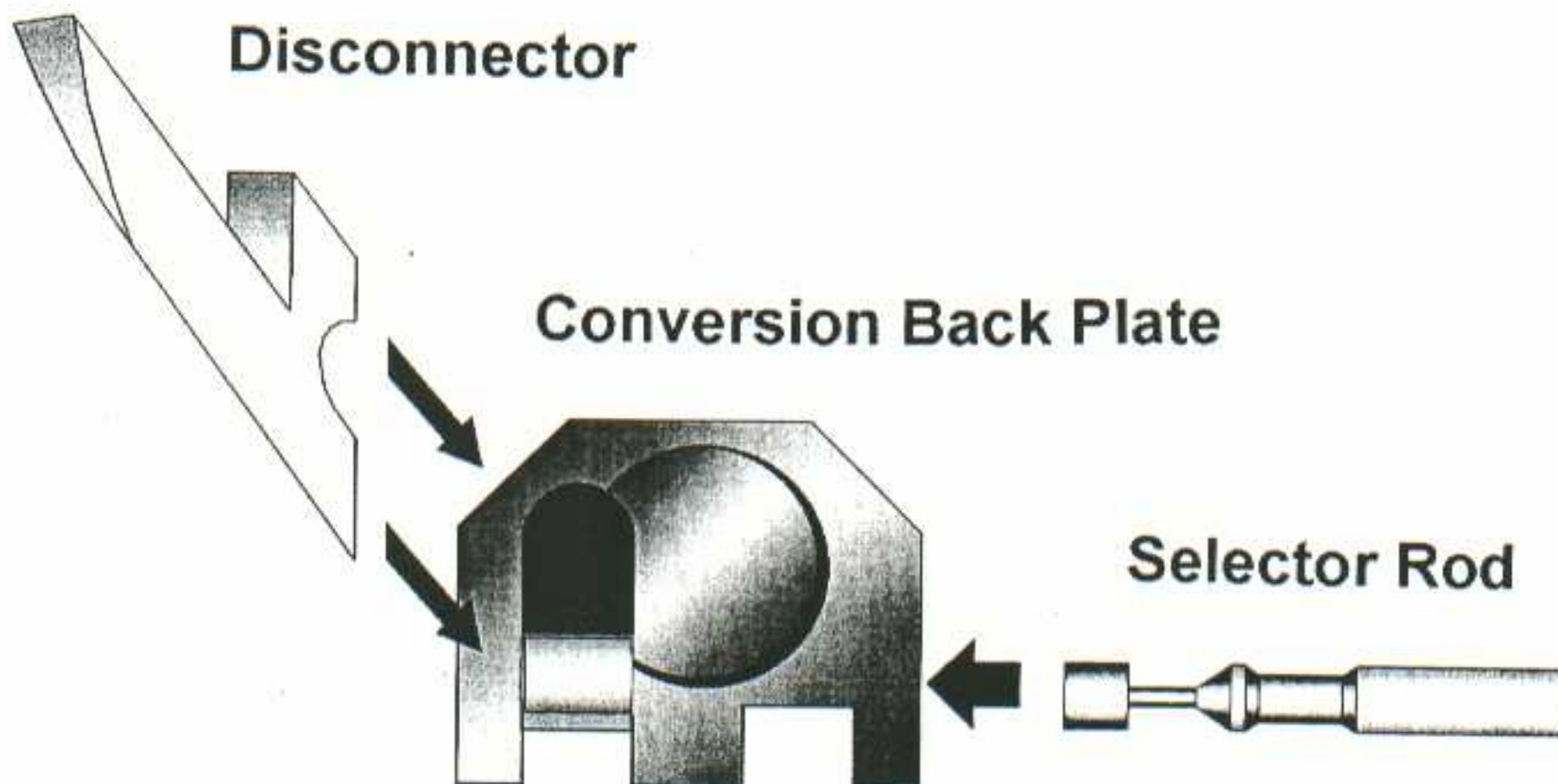
Break all sharp edges to R. 1/16 MAX with 1/32 ok.

All fillets to R. 1/16 MAX with 1/32 ok.

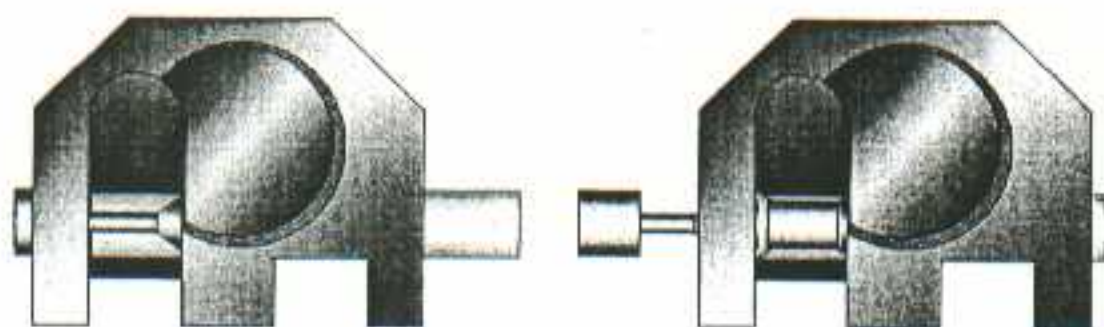
Painting of the end cap and selector switch may be desired to give the device an Original Equipment Manufacturer (OEM) look. It is not recommended to paint the sear.



Once you have ATF approval to own this device, please familiarize yourself with the names and functions of the three following pieces:



Your full-auto modification device consists of three parts: Selector Rod, Disconnecter, and Conversion Back Plate or End Cap. These three parts will replace the existing black plastic end cap located on the rear of your Glock slide. The following pictures show the assembled device and the two positions for the selector rod.



**Semi Auto**

**Full Auto**

### **Selection:**

- (1) Small post extended equals Full auto function
- (2) Small post hidden equals Semi auto function

When the selector rod is positioned for full auto firepower, you control how long your Glock fires through trigger action. A quick trigger pull will release a short burst and a trigger pull and hold will empty all the rounds in your Glock magazine.



## INSTALLATION PROCEDURE (providing you have ATF approval)

- 1) No one has ever been accidentally shot while servicing an unloaded firearm. Now, knowing and agreeing with this truth, please remove your Glock magazine AND the CHAMBER ROUND before beginning the assembly steps.
- 2) Pull back the slide of your Glock handgun and lock it open by applying upward pressure on the slide release. While you may prefer to, it is not necessary to remove the slide to install your full-auto modification device. A small screwdriver or pointed key is all that is needed to remove the black plastic end cap on the rear of your Glock slide.
- 3) Position the small screwdriver between the metal firing pin notch and the plastic firing pin jacket. Use the small screwdriver to lever the plastic firing pin jacket away from the metal firing pin notch. While your are holding back the firing pin jacket, remove the black plastic end cap by lifting it out or prying it out. Note the small spring loaded extractor plunger that is now exposed.
- 4) Assemble the full-auto device and set aside. Now use the small screwdriver to again lever the plastic firing pin jacket away from the metal firing pin notch. Slip the assembled device into the empty end cap slots. Now use the screwdriver to push back the small spring loaded extractor plunger to allow the fully assembled device to fully seat into the end cap slots.
- 5) The last step before test firing is to pull and release the slide ten to twenty times to create a small channel for the disconnecter in the frame. Refer to the previous photos for setting the selector switch to semi or full-auto fire. Once the positions have been committed to memory, it is time to test fire your new Glock handgun!



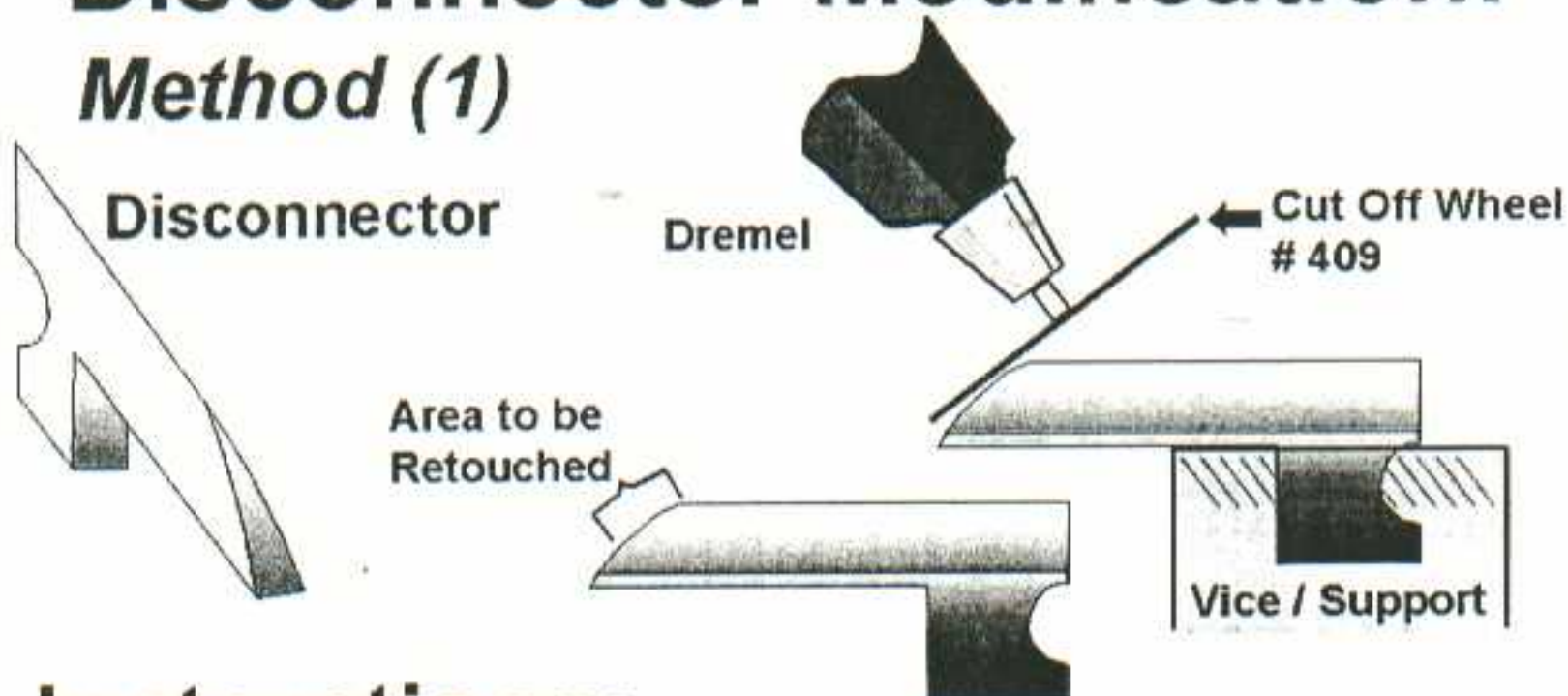
## TROUBLESHOOTING

If your Glock slide does not close fully: First check to make sure you do not have extra parts left over! Only the black plastic end cap should be extra. Then check to see that the device is FULLY seated in the end cap slots. If the device is unseated even a fraction of an inch, it will cause your slide to not close all the way. If this is still not the cause, please repeat step 5. The disconnecter must create a small channel in the frame to allow the slide to operate freely.

If your Glock handgun fires full auto in BOTH selector rod positions, disassemble the device and follow the instructions on the modification page. Due to the fact that all Glock handguns have slightly different tolerances, the disconnecter measurements compensate for this fact. You will need to shorten the disconnecter by following the instructions on the following page. Remove extremely small amounts and test after each small modification until the problem no longer persists. It is vitally important that you remove only small portions between testings because if your Glock fires semi-auto in both selector rod positions after filing, you have removed too much and will need to get a new disconnecter machined.



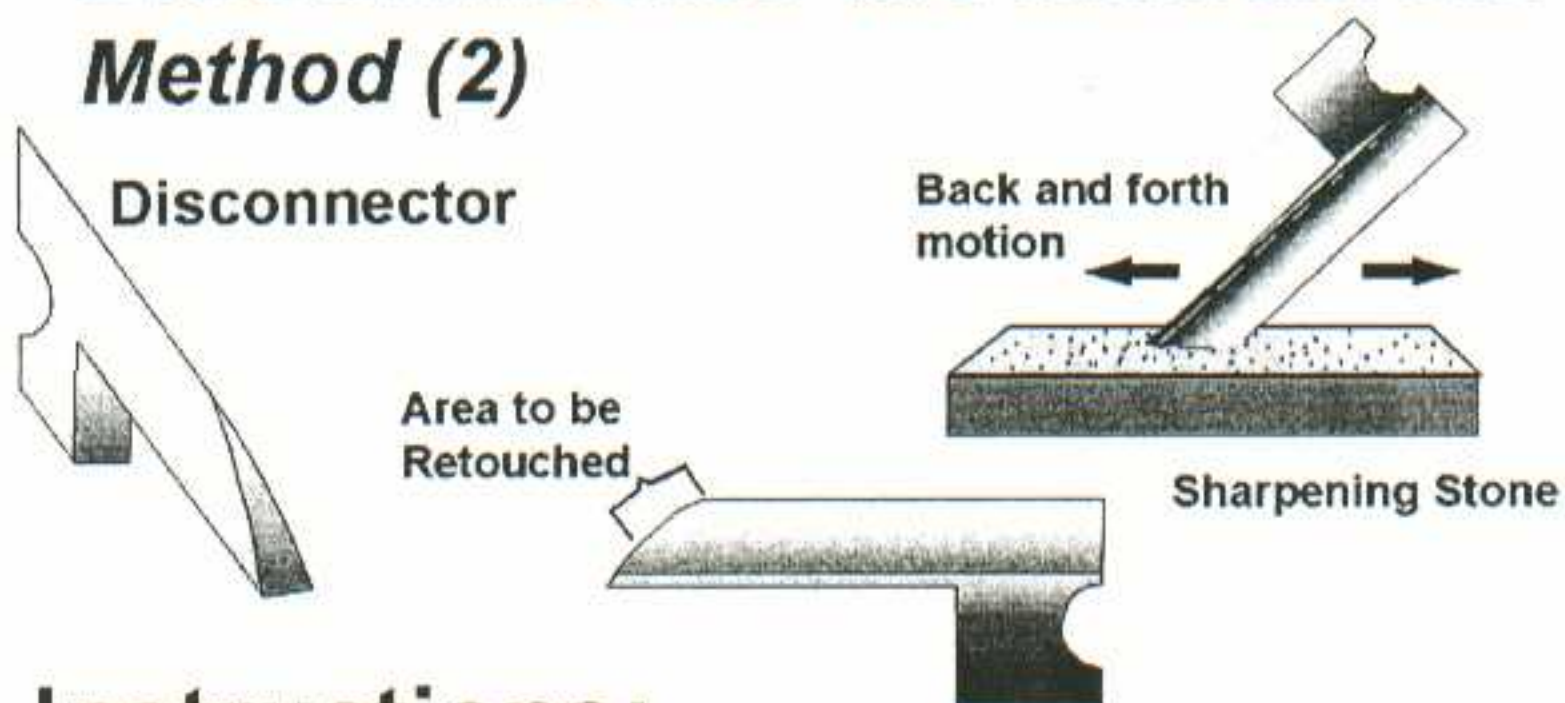
## Disconnecter Modification: *Method (1)*



### Instructions:

- (1) Use a Dremel™ tool and a # 409 cut off wheel for use in disconnector modification
- (2) Carefully secure the disconnector in a vice
- (3) Modify ONLY the area specified
- (4) Remove extremely small amounts each time

## Disconnecter Modification: *Method (2)*



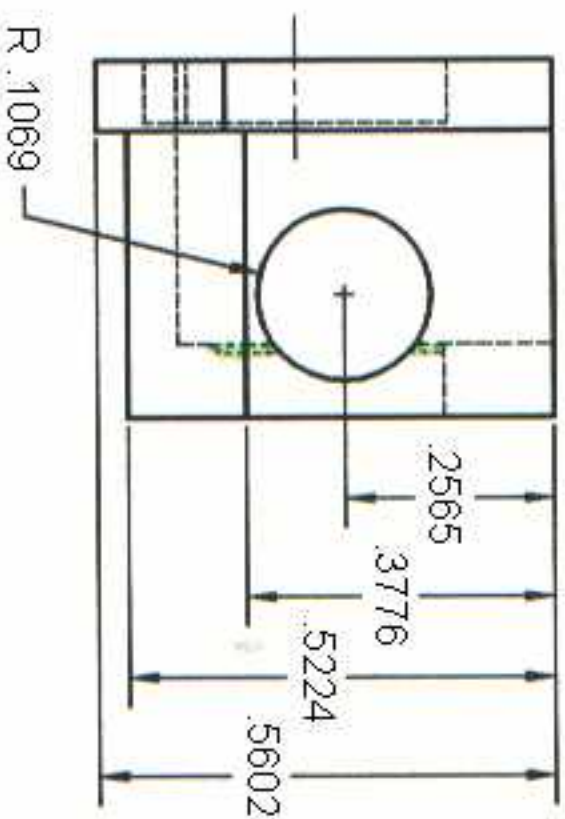
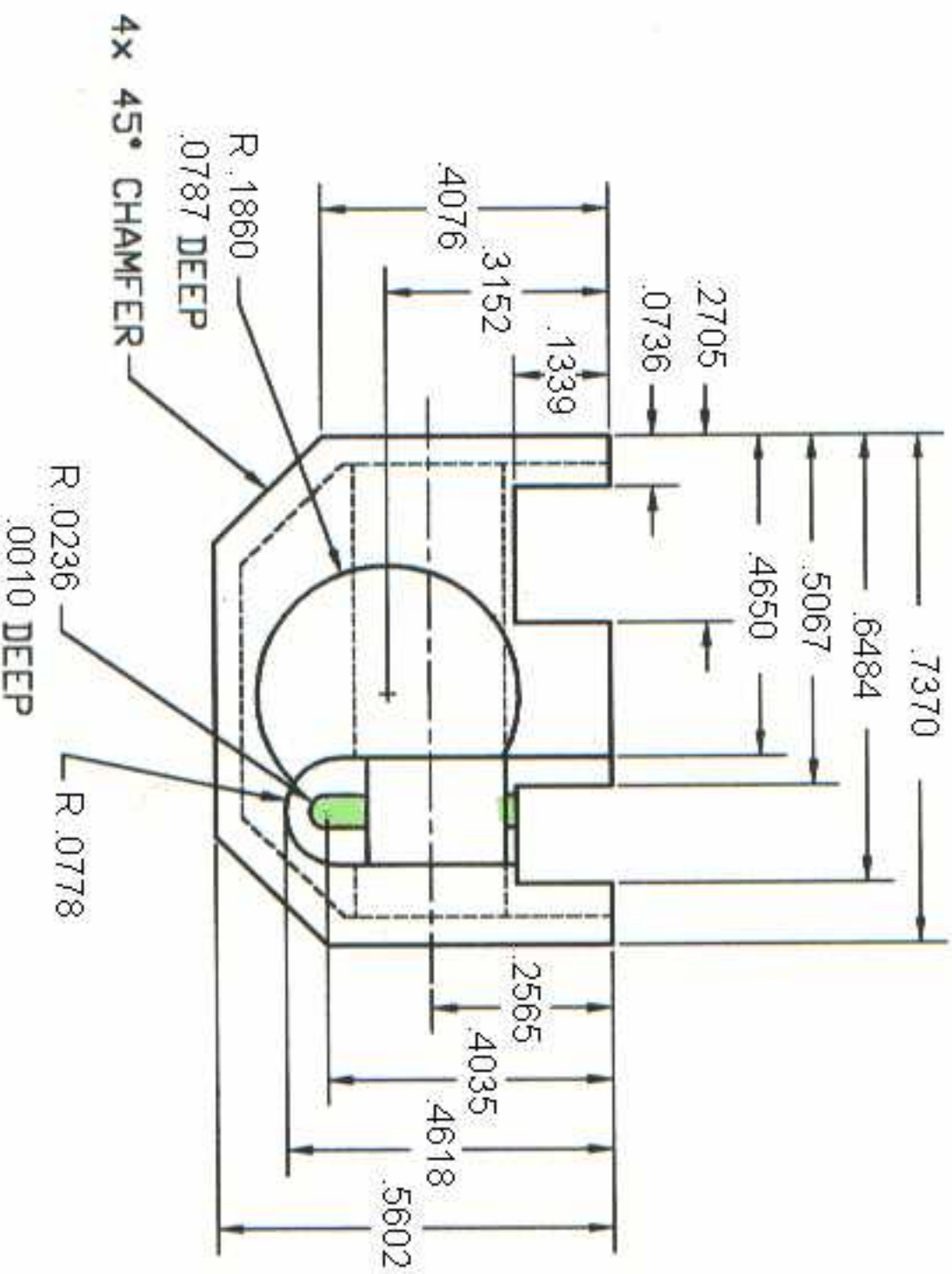
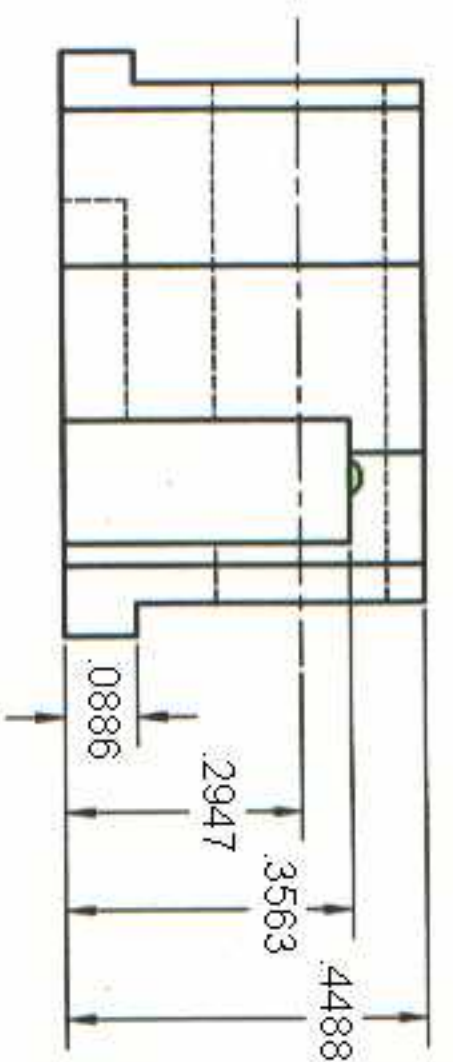
### Instructions:

- (1) Move the disconnector back and forth on the sharpening stone
- (2) Modify ONLY the area specified
- (3) Remove extremely SMALL amounts each time
- (4) Test device after each SMALL modification





REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPVD.



NOTES  
ALL DIMENSIONS ARE IN INCHES  
IT IS RECOMMENDED THAT YOU PAINT THE ENDCAP FOR A FACTORY LIKE FINISH AND APPEARANCE

UNLESS OTHERWISE SPECIFIED:  
DIMENSIONS AND TOLERANCES  
ARE IN INCHES AND ARE PER  
ANSI Y14.5M-1994

TOLERANCES:	
DECIMALS	ANGLES
.X = ±.030	±2°
.XX = ±.010	
.XXX = ±.005	

END CAP

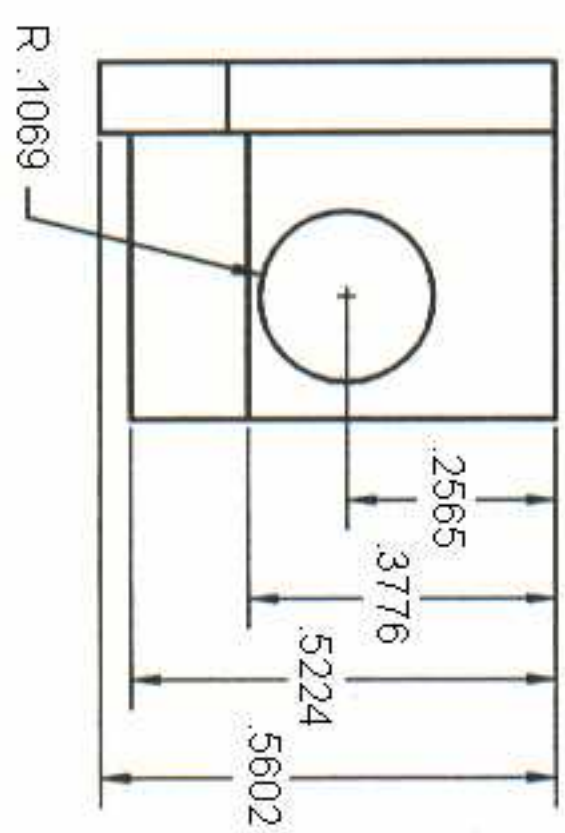
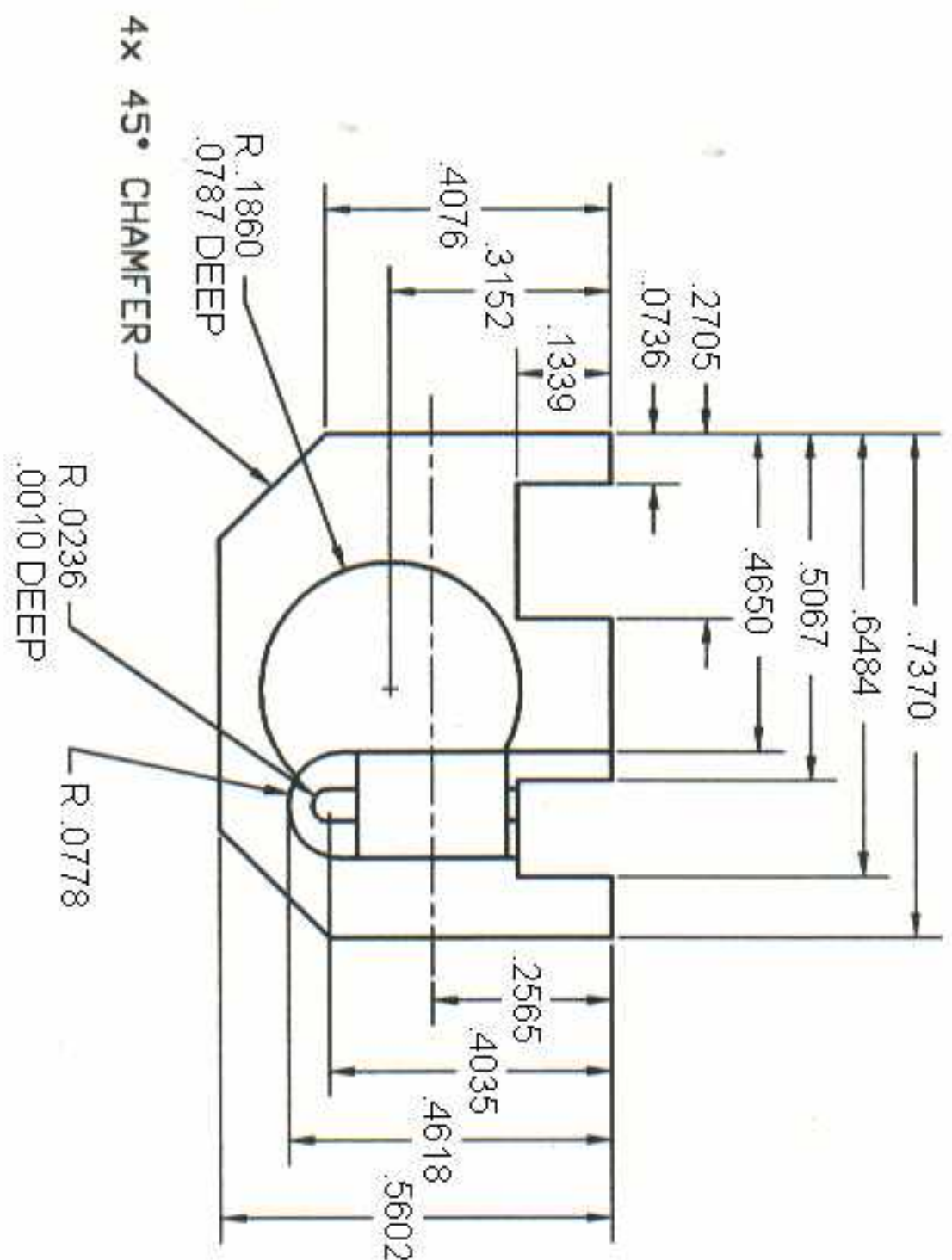
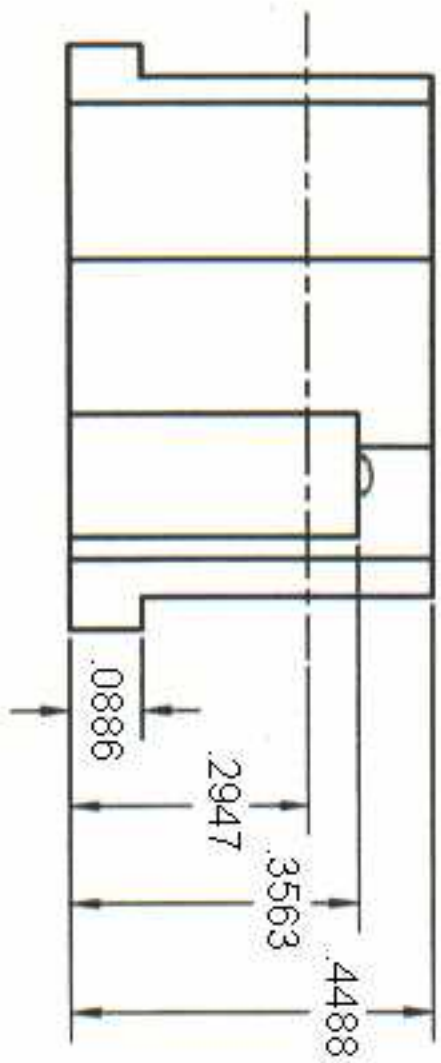
FULL-AUTO GLOCK

KEY	QTY	DESCRIPTION
-----	-----	-------------

SIZE: A	SCALE: 3:1	SHEET#: 1 OF 3
---------	------------	----------------



REVISIONS			
ZONE	REV	DESCRIPTION	DATE
			APPROV.



NOTES  
ALL DIMENSIONS ARE IN INCHES

IT IS RECOMMENDED THAT YOU PAINT THE ENDCAP FOR A FACTORY LIKE FINISH AND APPEARANCE

HIDDEN LINES OMITTED FOR CLARITY

UNLESS OTHERWISE SPECIFIED:  
DIMENSIONS AND TOLERANCES  
ARE IN INCHES AND ARE PER  
ANSI Y14.5M-1984

TOLERANCES:  
DECIMALS ANGLES  
.X = ±.030 ±2°  
.XX = ±.010  
.XXX = ±.005

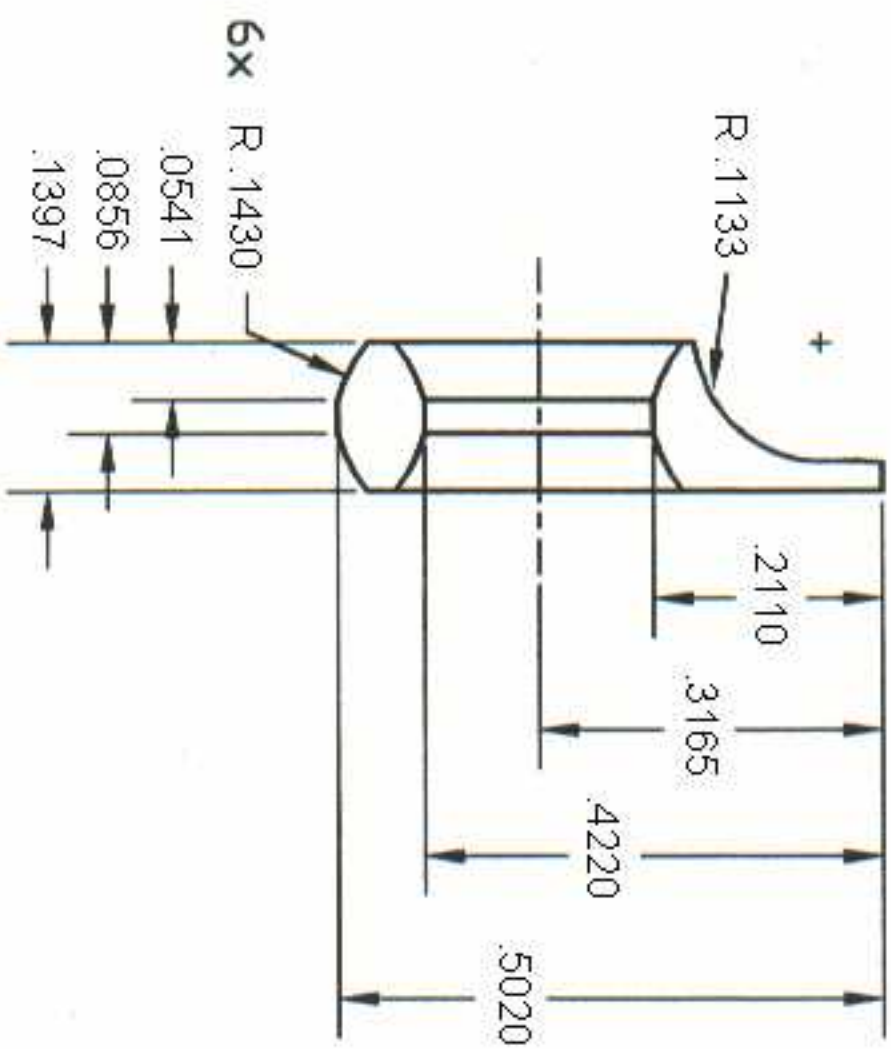
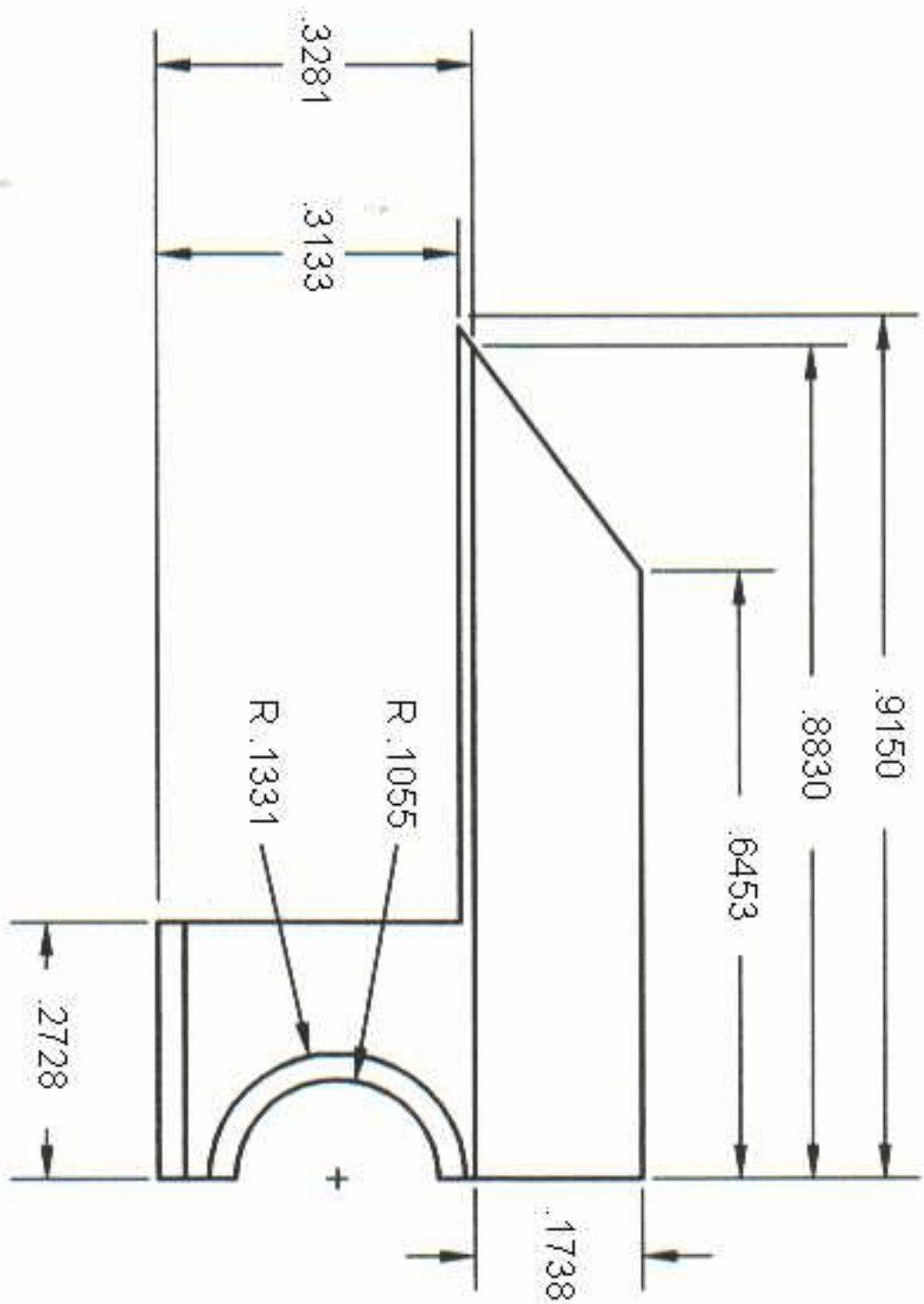
END CAP

FULL-AUTO GLOCK

SIZE: A SCALE: 3:1 SHEET#: 1 OF 3

KEY	QTY	DESCRIPTION
-----	-----	-------------

REVISIONS			
ZONE	REV	DESCRIPTION	DATE APPVD.



NOTES

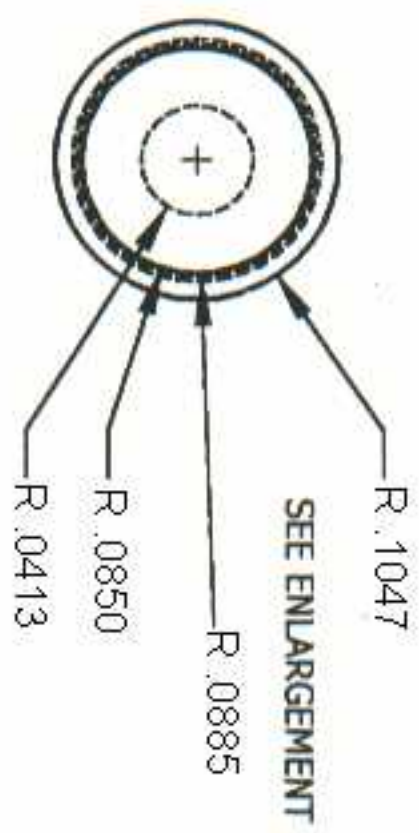
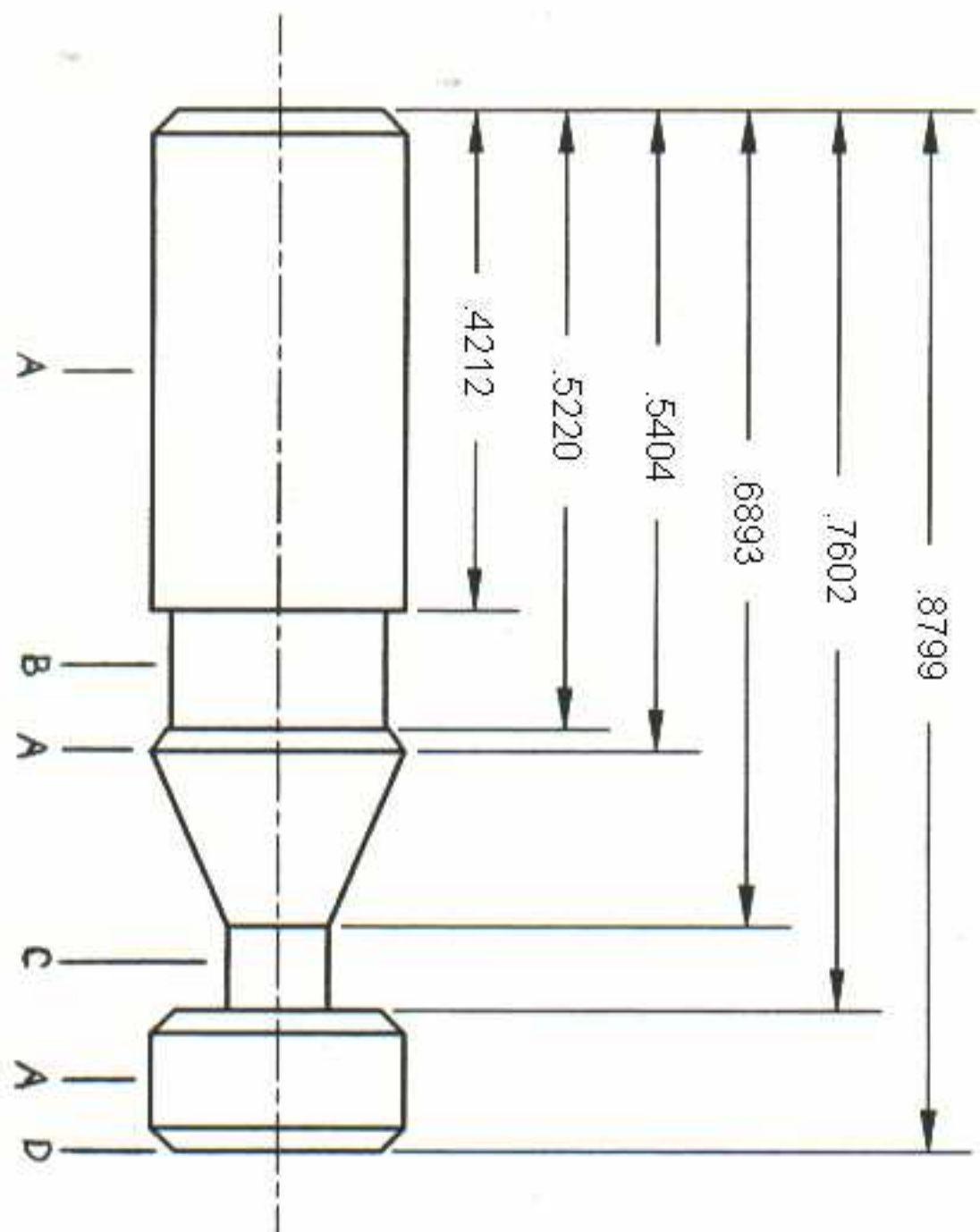
ALL DIMENSIONS ARE IN INCHES

IT IS NOT RECOMMENDED TO PUNT THIS PART

KEY		QTY	DESCRIPTION
SEAR			
FULL-AUTO GLOCK			
UNLESS OTHERWISE SPECIFIED: DIMENSIONS AND TOLERANCES ARE IN INCHES AND ARE PER ANSI Y14.5M-1994			
TOLERANCES: DECIMALS ANGLES .X = ±.030 ±2° .XX = ±.010 .XXX = ±.005			
SIZE: A	SCALE: 4:1	SHEET#: 2 OF 3	



REVISIONS			
ZONE	REV	DESCRIPTION	DATE
			APPROV.



NOTES

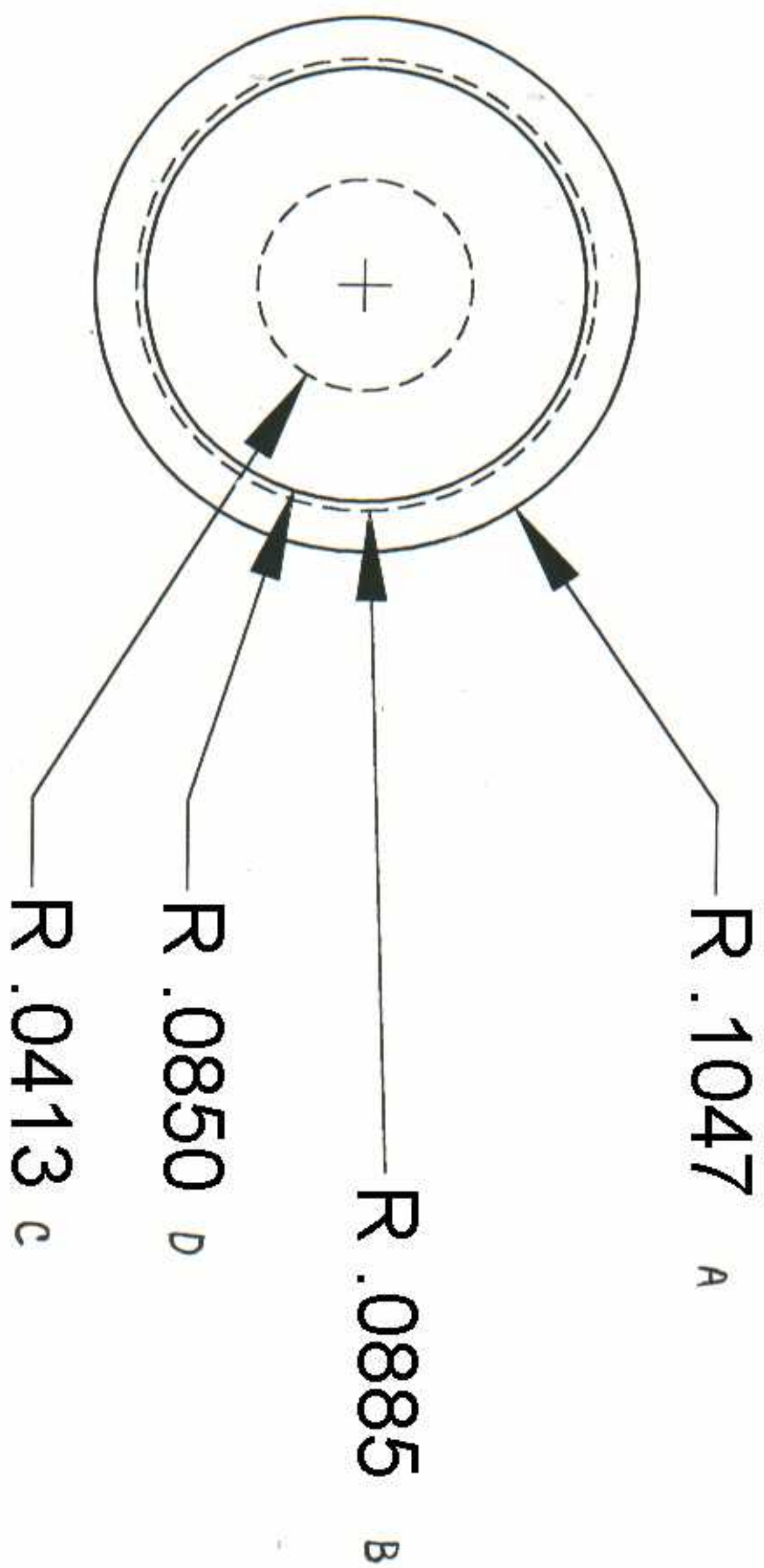
ALL CHAMFERS ARE .0197 @45°

PAINING OF THE SELECTOR SWITCH IS OPTIONAL. A PAINTED FINISH WILL "BLEND" IN THE SELECTOR SWITCH WITH THE END CAP FOR A FACTORY LIKE APPEARANCE.

KEY	QTY	DESCRIPTION
SELECTOR SWITCH		
FULL-AUTO GLOCK		
SIZE: A	SCALE: 5:1	SHEET#: 3 OF 3

UNLESS OTHERWISE SPECIFIED:  
DIMENSIONS AND TOLERANCES  
ARE IN INCHES AND ARE PER  
ANSI Y14.5M-1994

TOLERANCES:	
DECIMALS	ANGLES
.X = ±.030	±2°
.XX = ±.010	
.XXX = ±.005	





The material for the auto connector is simple 7/32" box tubing. Its available in brass, steel, or stainless steel. The stainless steel gives a life of about 7000 to 12000 rounds. and is the same material as a number of the parts in your weapon. the steel will give about the same life but is prone to rust. the brass while easy to work and more commonly available will only last about 400 to 1000 rounds. You will find a supplier who carrys box tubing in the back of these instructions in case you can't find it locally. If you don't have measuring tools, a set of calipers in thousandths, don't sweat it. With a little care and some patience you can make a connector without them. The original auto connector that these plans grew out of was made with nothing more than a dremel type tool with a cutoff wheel, and a rubberized polishing wheel, a small hammer 4 oz. and a cold chisel. presto full auto glock.

#### HOW IT WORKS

As you pull the trigger the trigger bar pulls back the firing pin to full cock. the trigger bar makes contact with the connector which cams the rear of the trigger bar down and releases the firing pin. The cartridge fires, the slide moves to the rear unlocking the barrel and tripping the connector which releases the trigger bar allowing it to rise. as the slide moves forward, the trigger bar catches the firing pin and fully cocks it but dosnt release it until you release the trigger bar to reset the connector. The auto connector bypasses the connector by camming the trigger bar down as the slide finishes its forward movement (the barrel must be locked before the firing pin is released) The auto connector will continue to fire the weapon until you release the trigger or the weapon runs out of ammo.

## TIMING

Looking at the top of an "empty" weapon, no ammo, no magazine, finger off the trigger. Pull the slide back about 1/2" you will notice the chamber end of the barrel drop down in the ejection port. The weapon is now unlocked. As you let the slide move forward the barrel rises and locks into the slide.

Now lock the slide open on an empty weapon no ammo no magazine. insert the auto connector as shown, no ammo no magazine, finger off the trigger. release the slide if the firing pin drops, your auto connectors cam surface is to far forward and must be cut/polished back. If the firing pin dosnt drop, good so far. Now pull the trigger on the empty weapon, no ammo no magazine. hold the trigger back and pull back the slide fully to the rear ease the slide forward no ammo no magazine watch the barrel and ejection port lockup it must be at least 2/3rds locked before you hear the firing pin drop. you may have to push the slide fully forward this is normal. if the firing pin dosnt drop you took off to much of the auto connectors cam surface, or forgot to polish the .015" off the firing pin.

The box tubing used for the construction of an auto connector can be found in most quality hobby shops. some hardware stores and is used in modling . if you can not find it locally the following is some companys that sell small metal parts and supplys

Small Parts Inc.  
13980 N.W. 58th Court  
P.O. Box 4650  
Miami Lakes, Fl. 33014-0650

K&S engineering company  
Chicago Ill. 60638



The Glock autoconnector is designed for low cost easy manufacture. It will only produce full auto fire but it can be installed and removed in seconds without disassembling the weapon. Since the glock family of weapons has identical measurements in the firing pin cutout, the cartridge rail area, this device can be used on any model except the model 18, and the model 25. These two weapons will not accept the auto connector. The model 18 is a select fire weapon and the model 25 is a blowback operated .380 not generally available in the United States.

#### TIME YOUR WEAPON

A full auto weapon with improper timing will rupture cases, damage the handgun, and could injure or kill anyone near the weapon.

**DO NOT FIRE THE WEAPON UNTIL THE TIMING IS CORRECT!**

A few words on full auto fire. The glock handgun is a tough weapon not prone to failure. it's light weight, and it's center of bore is close to the hand, reducing muzzle rise. It also has a very high rate of fire (cyclic rate) in full auto it will fire aproximatly 1000 to 1200 rounds per minute depending on ammo and caliber of the weapon. At this rate of fire muzzle climb is guarenteed and is increased in the 10mm and .45 caliber models. Any compact model will also show a greater tendancy to climb. You must be aware of your target and any thing around it, above it and beyond it. Keeping your fire in smaller bursts will help you keep your rounds on or near your target. keep in mind that near dosnt count.

two modifications must be made to the host weapon. First the cartridge rail must have a very small indentation at its rear where it meets the slide. Properly done this cannot be seen by eye. Second the firing pin Must have .015" polished off its bottom where it engages the trigger bar (not the auto connector) see the drawings. one aditional modification will increase the life of the auto connector and that is the polishing of the ears of the trigger bar.

Photo 1 Everything but ammo. Nothing more is needed and with patience the calipers are'nt even needed.

Photo 2 The auto connector installed.  
Note; The weapon dos'nt need to be disassembled to install the auto connector.

Photo 3 The black line shows the point of the cartridge rail that needs to be indented. Lay your cold chisle on the flat surface of the slide, The cutting edge of the cold chisle should touch the base of the cartridge rail where it blends into the slide. LIGHTLY ding the cartridge rail not enough to see but enough to feel with a finger nail. This will keep the front of the auto connector from dropping out of the weapon.

The metal pointer shows the suface of the firing pin that needs about .015" (fifteen thousanths of an inch) polished off. The photo sheet in these instructions is about .005" thick Try to keep the original contour of the firing pin.

Photo 4 SEE INSTRUCTIONS ON TIMMING.  
IF YOUR WEAPON IS NOT TIMED IT IS DANGEROUS!

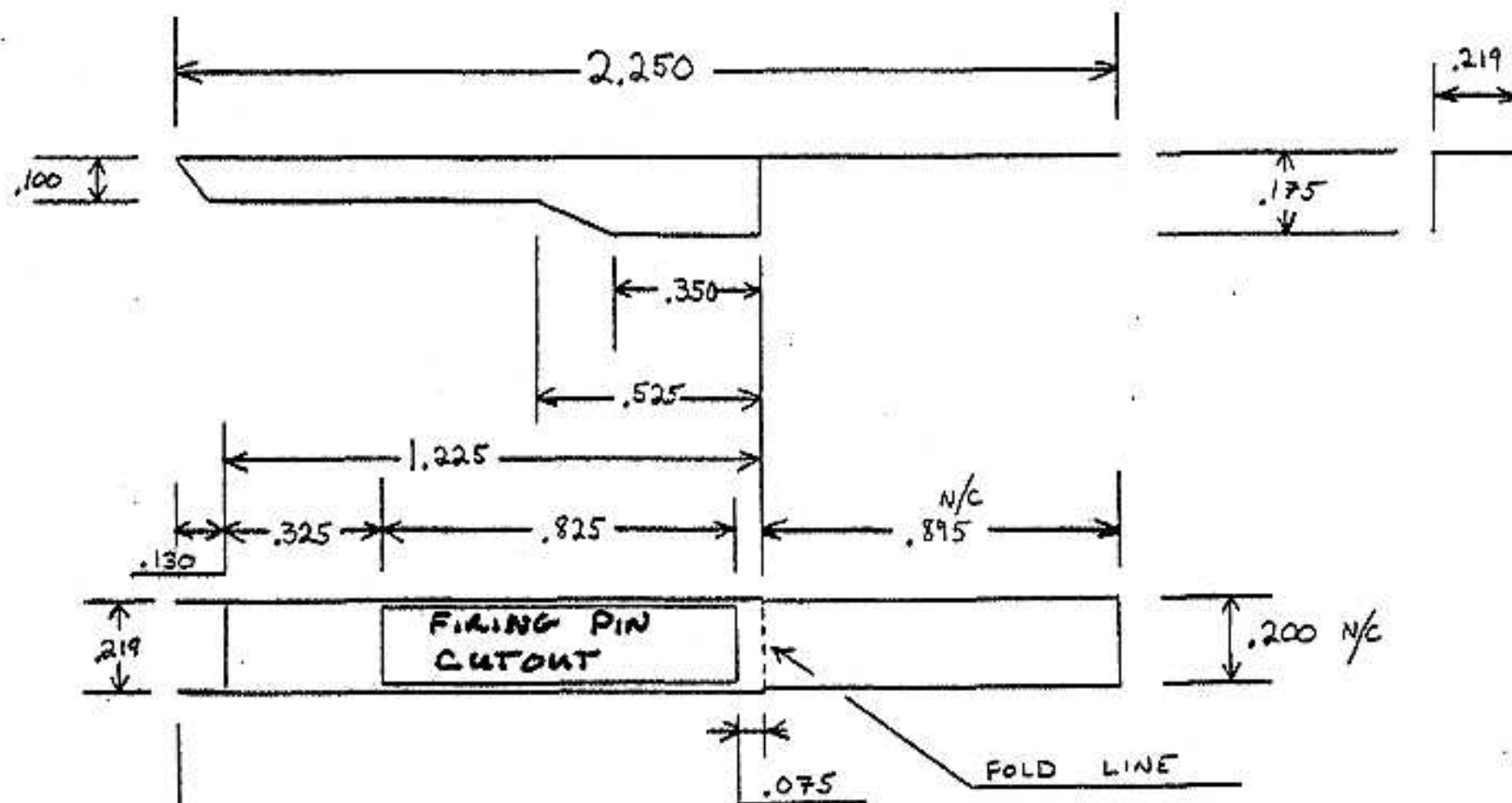
Line A is a weapon with a fully locked slide  
Line B is a weapon with a 2/3rd locked slide  
Line C is a weapon with an unlocked slide

Photo 5 The metal pionter shows the trigger bar ears that Should be polished to increase the life of the auto connector. DO NOT POLISH THE FIRING PIN ENGAGEMENT SURFACE. note it has been pointed out to the author that some trigger bars have sharp edges on the ears from the factory, this will dig into the cam suface of the auto connector and cause it to malfunction or rapidly wear out the auto connector. The trigger bar ears should be polished because of this. The polishing will give a smother and more dependable weapon.

Photo 5 Optional. The silvered area shows where .025" can be removed from the frame of the weapon. If this is done the firing pin dos'nt need to be polished. However modifying the frame of the weapon will undoubtedly make it a machine gun in the eyes of the B.A.T.F. now and forever. If you dont modify the frame only the parts to make it full auto are considered the machine gun; with or without the weapon.

DO NOT TAKE CHANCES, GET YOUR LICENSE FIRST. OBEY THE LAW.  
YOU ARE RESPONSIBLE FOR YOUR OWN ACTIONS.





## GLOCK AUTO CONNECTOR

SCALE:

APPROVED BY

DRAWN BY

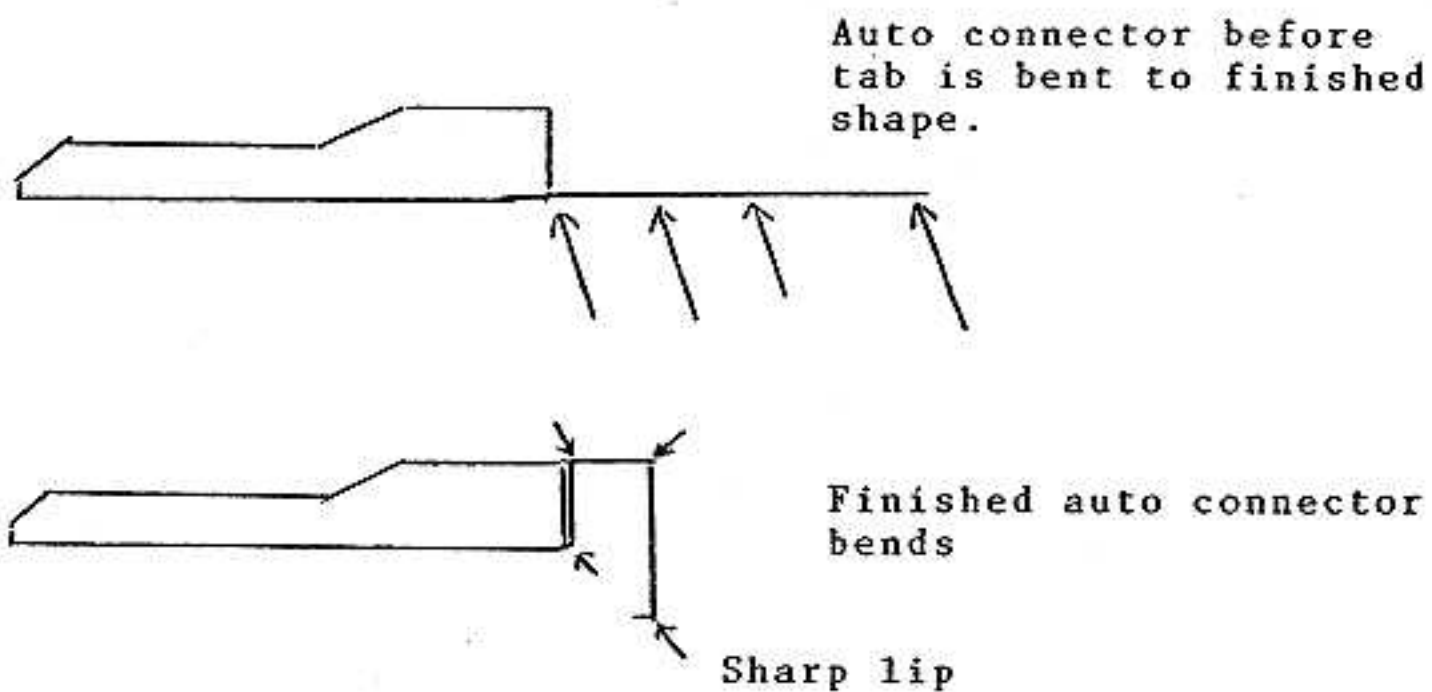
DATE:

TR.

MATERIAL 7/32 BOX TUBING

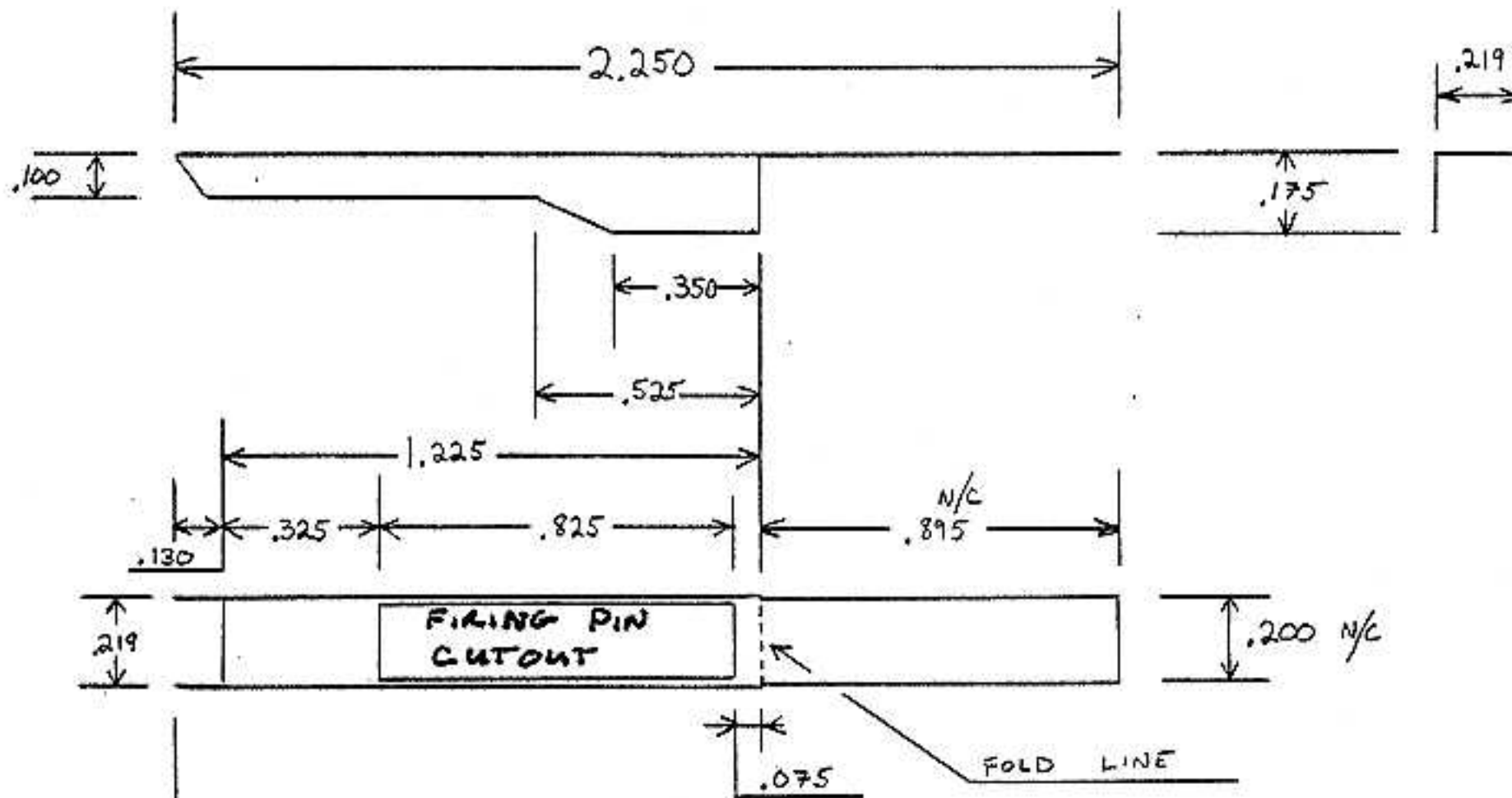
DRAWING NUMBER

1 of 1



When you finish cutting out your auto connector a locking tab must be bent out of the strip of metal protruding from the rear as shown. The sharp lip at the end of the strip holds this end of the auto connector in the slide. The indentation you made at the base of the cartridge rail holds the other end. Leave the lip sharp it holds better.





# GLOCK AUTO CONNECTOR

SCALE:

APPROVED BY

DRAWN BY

DATE:

TI

MATERIAL

7/32 BOX TUBING

DRAWING NUMBER

1 of 1



