



**\*\*\* MAIN MANUAL \*\*\***

# **The Underground Build Your Own Silencers System!**

**The Step-By-Step Guide For  
True Patriots Showing How To  
Build Your Own Military-Grade  
and SHTF Silencers!**

**The Underground Build-Your-Own Silencers System  
By Caleb Lee**

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## INTRO

Welcome fellow Patriot!

I'm extremely excited to introduce you to an exciting new opportunity to exercise your God given rights of self-defense ... and ... your Second Amendment rights by showing you how to build your own silencers!

This powerful guide and the video that goes with it will show you how to build two "types" of silencers:

1. A military-grade titanium silencer that should provide the same performance of today's best silencers that cost \$1,000 or more!
2. A SHTF silencer made out of a Maglite and common parts you should be able to find online and at almost any hardware or auto-parts store!

### Important Note About Laws:

This guide is for purely informational purposes only. I am not responsible for anything you do with this information. It is provided "as is". By reading this guide you agree to these terms.

Additionally, I am NOT a lawyer and in no way am I qualified to tell you what is legal Federally or on a state level as it pertains to you.

I am simply telling you "what I have heard" about the legality of all things I write about in this book and I'm exercising my First Amendment rights.

You are fully responsible to know the laws Federally and **Locally** as they pertain to you. **This is extremely important**, because if you live in the United States, you are subject not just to Federal laws but also your state laws, and sometimes even local laws such as city laws. Do your research!

Here are some links about building your own silencers pertaining to federal laws. If you are unsure about anything, I encourage you to do your own research before attempting anything in this guide.

# The Underground Build-Your-Own Silencers Manual

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The ATF.gov website is actually the source of all these laws. Because this guide is about silencers, you may want to start with understanding the NFA and go from there <https://www.atf.gov/qa-category/national-firearms-act-nfa>

There is also a wealth of information about silencers specifically online at reputable places such as <https://americansuppressorassociation.com/education/>.

If you need specific legal advice, I can personally recommend <https://www.arsenalattorneys.com/> because they set up my trust for me. They are lawyers, they do specialize in silencers and other NFA items and can answer any specific legal advice you have.

Now, with that disclaimer out of the way, **let's get into it!**

## WHAT IS A SILENCER?

Although it may seem basic, we're going to start at the beginning with a definition of what a silencer actually is...

I'm going to actually copy and paste right from the ATF.gov website, because, well, they are the ones that define and regulate these things...

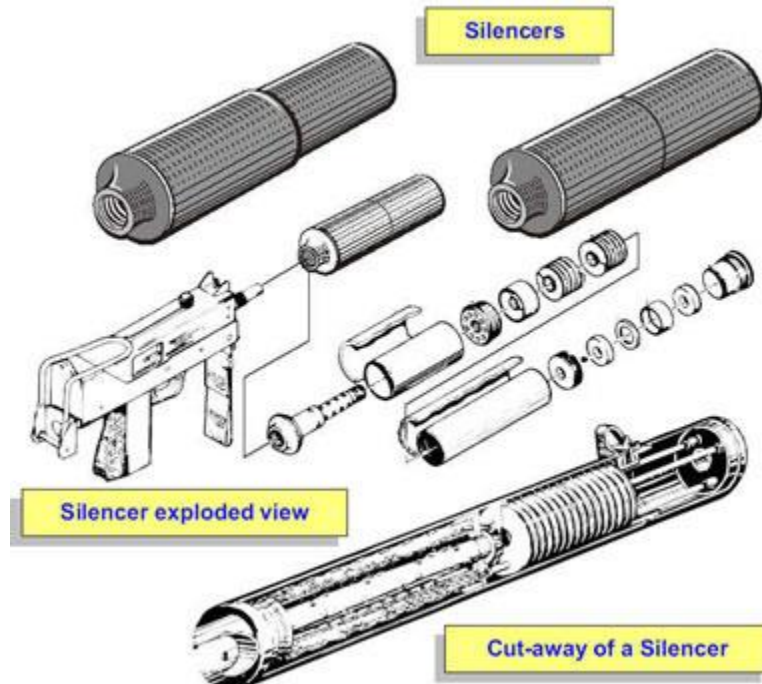
### *Firearms Verification*

#### *Gun Control Act Definitions*

##### *Silencer*

[18 U.S.C., § 921\(A\)\(24\)](#)

The term "**Firearm Silencer**" or "**Firearm Muffler**" means any device for silencing, muffling, or diminishing the report of a portable firearm, including any combination of parts, designed or redesigned, and intended for the use in assembling or fabricating a firearm silencer or firearm muffler, any part intended only for use in such assembly or fabrication.



# The Underground Build-Your-Own Silencers Manual

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**Note:** Any device that meets the definition as stipulated above in [18 U.S.C. § 921\(a\)\(24\)](#) is also subject to controls of the National Firearms Act [26 U.S.C., Chapter 53](#).<sup>1</sup>

This is a pretty good simple definition and lays the ground work for what we're talking about...

Of course, most of us have seen silencers in movies and throughout our lives in spy novels, etc ... so they're pretty easy to understand.

But let's bust some myths really quick, to make sure we're on the same page here...

## Top Silencer Myths And The TRUTH About Silencers.

### Myth: They are called "Suppressors"

While I understand the reasoning behind this, and I used to believe this myself, as a pro-gun guy, it's wrong.

The fact of the matter remains that when you fill out the ATF paperwork you will use the term "silencer" and only the word "Silencer" and people have reported having their paperwork rejected in the past for using terms like "suppressor".

Further, the guy who invented the darn things called it a "silencer". From Wikipedia (emphasis mine):

"American inventor Hiram Percy Maxim, son of Maxim gun inventor Hiram Stevens Maxim and co-founder of the ARRL, is usually credited with inventing and selling the first commercially successful silencer around 1902, receiving a patent for it on March 30, 1909.[2][3][4] **Maxim gave his device the popularly trademarked name "Maxim Silencer"**, [5] and they were regularly advertised in sporting goods magazines.[6] The muffler for internal combustion engines was developed in parallel with the firearm silencer by Maxim in the early 20th century, using many of the same techniques to provide

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<sup>1</sup> <https://www.atf.gov/firearms/firearms-guides-importation-verification-firearms-gun-control-act-definition-silencer>

# The Underground Build-Your-Own Silencers Manual

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quieter-running engines, and in many English-speaking countries automobile mufflers are called silencers.[7]

So, we are going to use the word “silencer”, even if we don’t like it, because it’s the correct term. Yes, they don’t silence – I know – they are more accurately called “suppressors”, but it is what it is.

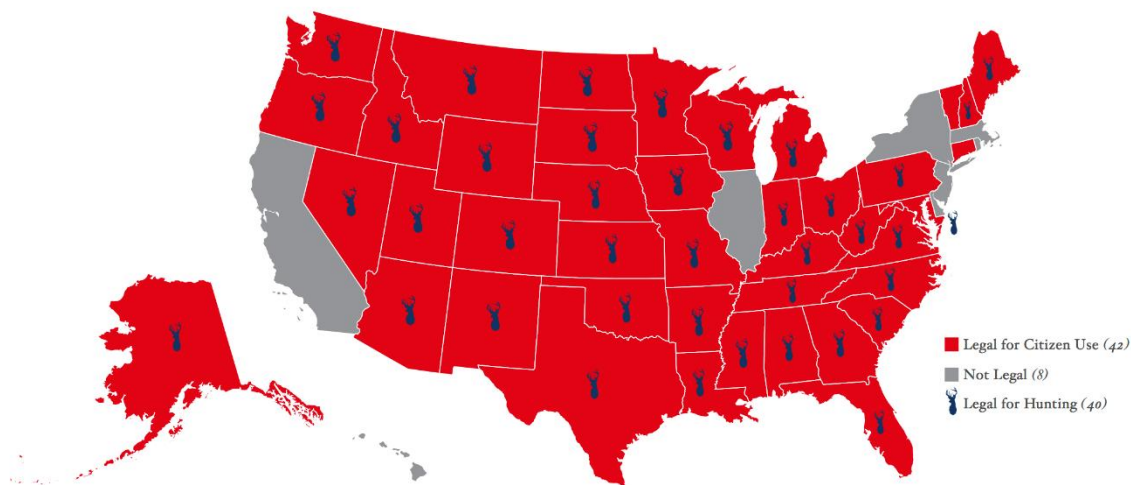
Further, the guy seemed to get the idea for a gun silencer from the development of “mufflers” for cars, so we should probably just call them mufflers and in a perfect world without tyrants you could go buy a gun muffler for your guns at the auto-parts store... but I digress.

## **MYTH: Silencers Are Illegal!**

Actually, silencers are and always have been legal to own...

They ARE however restricted items under the National Firearms Act (NFA). This means, they are legal to own in most states after obtaining a \$200 tax stamp and undergoing a more “serious” background check. Some states do not allow silencers, but at a national level, silencers are legal to obtain. That also means it’s legal to build them, if you can legally own/purchase them.

The graphic and information below is from the American Suppressors Association (ASA) (<https://americansuppressorassociation.com/education/>)



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## The Underground Build-Your-Own Silencers Manual

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What this graphic shows is the 2019 data, displaying that Silencers are legal for citizen use in 42 states, and in 40 of those states they are legal for hunting as well.

**In only 8 states, they are not legal.** It probably goes as no surprise to most gun owners that the places that make silencers illegal for citizens are often the same places that make guns like AR-15's illegal.

Again, from the same education page on the ASA website, here is the information on the legality and ownership of silencers:

Suppressors are regulated under the National Firearms Act (NFA) of 1934, which falls under the purview of the Bureau of Alcohol, Tobacco, Firearms and Explosives (ATF). To legally purchase or possess a suppressor you must:

1. Be at least 21 years of age to purchase a suppressor from a dealer.
2. Be at least 18 years of age to purchase a suppressor from an individual on a Form 4 to Form 4 transfer (contingent on state laws).
3. Be at least 18 years of age to possess a suppressor as a beneficiary of a trust or as a member of a corporation (contingent on state laws).
4. Be a resident of the United States.
5. Be legally eligible to purchase a firearm.
6. Pass a BATFE background check with a typical process time of 8 to 10 months.
7. Pay a one-time \$200 Transfer Tax.
8. Reside in one of the 42 states that currently allows civilian ownership of suppressors.

So, yes, silencers are legal to own for most people, just like an AR-15 is legal to own for most people. Unlike an AR-15, you have to do more paperwork and pay a special tax stamp to the government for the “privilege” to own them.

Is that a violation of your rights? Yes. Does that suck? Yes. But we are discussing legality here, and they are still legal to own under current laws.

# The Underground Build-Your-Own Silencers Manual

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Some pro-gun groups (like the aforementioned ASA) keep trying to get legislation passed to take silencers out of the NFA and make them as legal as any other firearm or firearm part, but I don't have much confidence they'll ever get a bill like that passed.

Again, they are nothing more or less than a “muffler” for your gun, so they should be completely legal to buy at the auto-parts store, but that's beside the point. Let's continue...

## **MYTH: Silencers Make Your Gun Super Quiet Like a Hollywood Spy or Assassin!**

This is kind of why people want to call them “Suppressors”, because silencers don't actually make your gun super quiet like in the movies. To achieve that, you need a really good silencer AND subsonic ammunition in the correct caliber AND even then, only some types of cartridges will be *really* quiet. But pretty much never as quiet as the movies. I would say that subsonic .300 Blackout and .22 LR get pretty darn close if anything does and if you want “Hollywood quiet” – those are your best bets!

The American Suppressors Association (ASA) actually has this really useful chart that shows you the decibel ratings of silencers vs other noises...

The important part to remember, is that **anything above 140 dB can cause instant hearing damage.**

But, even below that, you can damage your hearing... so in most cases, everyone that knows anything will still tell you to wear hearing protection when you're shooting guns, even with silencers.

On the next page, you'll see the infographic from ASA, of particular note:

- Right above “heavy traffic” at only 85 dB, it says “8 Hours OSHA regulations begin”. I did some research and found this “*OSHA sets legal limits on noise exposure in the workplace. These limits are based on a worker's time weighted average over an 8 hour day. With noise, OSHA's permissible exposure limit (PEL) is 90 dBA for all workers for an 8 hour day. The OSHA standard uses a 5 dBA exchange rate. This means that when the noise level is increased by 5 dBA, the amount of time a person can be exposed to a certain noise level to receive the same dose is cut in half.*”. So essentially, even if you're shooting really quiet silenced guns with ear protection, you could still be damaging your ears if you're

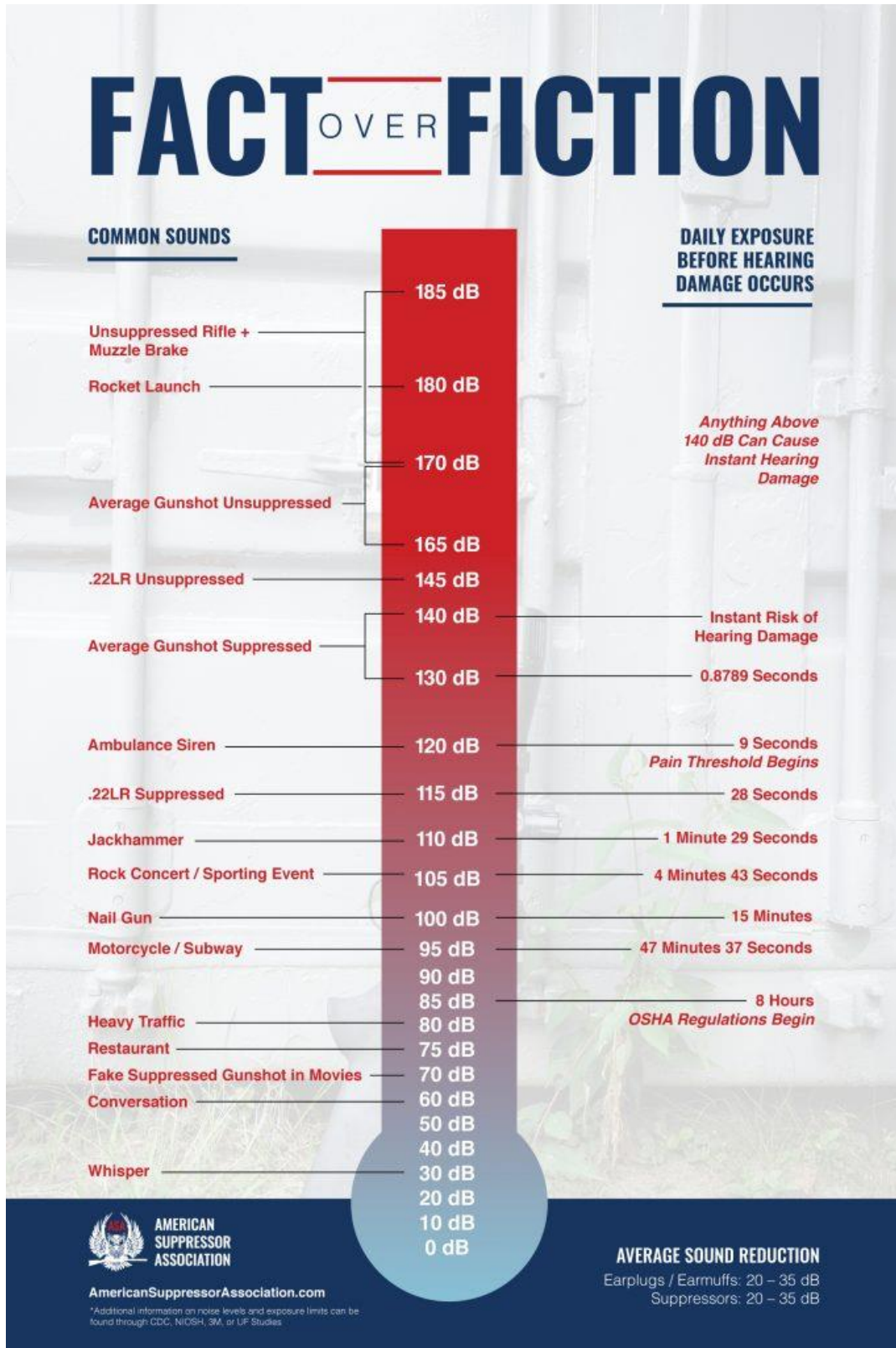
## The Underground Build-Your-Own Silencers Manual

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doing it for 8-hours a day.

- Going up in sound, one of the quietest gun shots you can achieve is the .22 LR silenced they show at 115 dB.
- The next levels to pay attention to are the 130dB to 140 dB levels – of most silenced shots. Right below that at 120 dB – pain threshold begins. Again, I've seen really good subsonic shots with silencers get down around that range.
- It's interesting to me that an unsilenced .22 LR is right around 145 dB. That's interesting (to me at least) because in my experience – using a silencer on an AR-15 sounds about like a .22 LR unsuppressed... maybe a little quieter. Probably around the top end of hearing damage instant risk (around 140 dB)

See the chart for yourself on the next page...



## **MYTH: Silencers slow your bullet's velocity.**

Actually, you get a “little” more barrel length, which can also cause a “little” more velocity. So, you should get MORE velocity, not less. In layman terms of course...

## **MYTH: Silencers make your gun less accurate!**

No. What a silencer will do (most likely) is “shift” your point of impact. So often times, you will need to have a zero that is either to your silenced or unsilenced gun.

As an aside, that is, of course, if you can even shoot accurate enough to notice it! You, the guy behind the trigger are the most important part of accuracy. To give you an example – most of the time – the shift is 2” or less at about 100yds... so would you even notice at 100yds if your zero shifted 2” to the left or down? I know a lot of gun guys who would not notice that because they're so inconsistent. That said, be aware you can experience this.

With that in mind, **many people report that having a silencer actually increases accuracy**. This is because adding a silencer changes some barrel harmonics, but more importantly, it strips away many of the turbulent gasses from the muzzle after the rifle is immediately fired - the location where the bullet is at its most unstable and suggestible to change...

(In a moment, we'll get into all the other things that silencers do – that are not exactly a “mechanical accuracy” advantage – but they do make YOU more accurate.)

In short, there is a reason why 51% of Professional Shooters in the Precision Rifle Series (PRS) and the top 50 shooters in the National Rifle League (NRL) run either a muzzle break or a silencer on their rifles - it's because it makes them more accurate!

## **What are the benefits of A Silencer?**

There are a lot of benefits to silencers, here are just a few to think about...

**1. Quieter** – obviously there is less noise. This can be a big deal in a tactical or hunting situation. Here's a home defense example... if you're shooting with your AR-15 in your house – it could be really, really loud. Super loud. Instant hearing damage loud. Now, I will say, that some dudes that have shot people for real without ear pro have said they didn't think it hurt their ears... and I believe I've read that there is a “stress response”

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# The Underground Build-Your-Own Silencers Manual

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that helps protect against noise-induced hearing loss. Still, I have a family and their ears can get hurt too. For hunting, with some species like Wild Hogs, you **NEED** to have silencers or they will all run off and you only kill one with the first shot. Personally, even if you're just shooting one shot at a deer – you can protect your hearing from instant hearing damage.

For SHTF, it's obvious that having the ability to silence shots can help you avoid any hordes of cannibalistic San Franciscans or other zombies.

**2. Recoil Reduction** – silencers help mitigate recoil. This is another reason why Precision Rifle shooting competitors use them. And snipers do it too, but also for...

**3. Flash Suppression** – a silencer works just like a flash suppressor on the end of your rifle, but probably better. If you're doing ninja night stuff with NODs you want this too because you want to be hidden and don't want to blind yourself too much.

**4. Faster Sight Recovery** – because there's less recoil, your sights come back down on target more quickly, meaning your shot-to-shot recovery times (splits) could be better.

**5. More accurate** – Not only can your rifle be mechanically more accurate, but because you're getting less recoil, less noise, and less flash – you're making it easier on yourself to not have that “flinch” or be the reason you are less accurate.

**6. Better Neighbor** – Whether you're target shooting or hunting, if you do it silenced you will disturb your neighbors less. In a SHTF situation, or for any other “tactical” reason, this is obviously a huge benefit too...

**7. Safer and More Fun (especially for new shooters)** – the best way to introduce guns to new shooters is dry fire, with no bullets. Because there's nothing to distract from the gun manipulations like gun shots and blinding flashes and loud noises that make everyone flinch. The second-best way, after that, would then be silenced guns, for all the same reasons. For example, you could take a new shooter out with a silenced .22 LR and use no ear protection outside and show them everything to do and they probably won't get freaked out due to recoil, noise, etc.

## Why Would You Want To Build A Silencer Instead of Buy One?

There are many reasons you might want to build your own silencers instead of buy them...

# The Underground Build-Your-Own Silencers Manual

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First, it's an extremely fun and neat Do-it-Yourself (DIY) project!

Just like building your own guns, there's an extreme satisfaction that comes from building your own silencers. It's just useful knowledge to have, again, in case of SHTF as well.

Second, you can build your silencers just the way you want it. If you ever wanted a certain size silencer for your rifle or pistol, with specific characteristics, then instead of shopping for "just the right one" you can simply build it.

Third, you can save a LOT of money. Because silencers are a "restricted" item due to the NFA, that means the entire free market system has *not* been unleashed in the development of silencers. If they were not restricted, you could probably buy today's top silencers for less than the \$200 ATF Tax Stamp it costs to own them...

But, that's not the case, so most silencers are \$1,000 or approaching that amount... add in the \$200 tax stamp to the ATF... and you're looking at a decent chunk of change. Then, of course, you're not going to be happy with just one! So, you're going to want to get more, and it all adds up...

So, yes, you could save a good chunk of change by building your own silencers.

That's what this short – yet extremely powerful guide will teach you!

## HOW DO YOU BUILD YOUR OWN SILENCER AND STAY LEGAL?

Building a silencer and staying compliant with the laws is actually a lot less intimidating than you may think...

This is probably why silencers are one of the fastest growing segments of the firearm industry.

Again, the ATF regulates silencers under the NFA – National Firearms Act of 1934. What that means, is you basically need to pay the ATF a one-time \$200 fee for a tax stamp and fill out extra paperwork, as compared to buying a firearm the “regular” way at a gun shop for example.

After that, really, the only major difference is there is a waiting period for the ATF to go over your paperwork, clear you, and give you the stamp and permission to build the silencer. That’s really the most annoying part, because they are almost always backed up months in advance. Like anything though, the sooner you get started, the sooner you’ll get what you want, so you just kind of have to get it over with.

So, let’s talk about a few things...

Should you use a trust or put the silencer in your name?

There are a few ways to own your silencer.

If you’re making your own silencer, you’ll file an ATF Form 1. If you’re buying a silencer, you will file an ATF Form 4... Going forward, because this is a guide to building silencers, we’ll talk about Form 1’s...

You can either own it in your name, as an individual, or the other popular method is to have a legal entity, such as a “trust” own it.

### Why Would You Want To Use A Trust To Own Your NFA Items?

There used to be some good privacy benefits with using a trust to acquire NFA items, but those are (mostly) gone...

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# The Underground Build-Your-Own Silencers Manual

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But there are still reasons to think about using a trust to own the NFA items, and I'll share why I personally went this route myself...

Let's compare the two:

## **Filing as an individual:**

If you are going to apply for a ATF 5320.1 Form 1, it's somewhat simplified. You will only be required to fill out the Form 1. This still requires two fingerprint cards and a passport photo. But the 5320.23 Responsible Person's Questionnaire isn't required, as this information is obtained on the ATF 5320.1 Form 1.

Benefits of filing as an individual:

- **Less Paperwork:** ATF 5320.23 Responsible Persons Questionnaire Paperwork isn't required. This information is filled out on the ATF 5320.1 Form 1.
- **Potentially Faster:** You are required to submit paperwork for yourself only, not anyone else like a trust or legal entity. No paperwork needs to be notarized, dated or witnessed like a trust does.
- **Less Cost:** Doesn't require the creation of a trust, and however much money you spend on that.
- **CLEO (Chief-Law-Enforcement-Officer):** No CLEO signature is required; this is a newly added benefit since the ATF41F regulations went into place.
- **Inheritance:** Items owned by the individual can be passed down, there are specific forms for this that you'll have to research.

Disadvantages of filing as an individual:

- **Limited Use of the NFA item (aka your silencer):** - You have to be with the silencers when they are in use. It is your responsibility to keep the silencer secure and safe at the location provided on your ATF Form 1 and you are supposed to be the only one who has access to the item.

A literal interpretation of this, would mean for example, you are the only one who can have the safe combination and/or key if the silencers are in your safe. And the

# The Underground Build-Your-Own Silencers Manual

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silencers cannot be left out of a safe when you are not present. More on this in a moment...

- **Adding to trust later:** If you decide later to move the silencers to a trust, you will be required to pay the \$200 tax stamp again for every NFA item moved to the trust. This is because technically a new entity is buying the items and requires a new tax stamp.

So, let's talk about Trusts...

## **Filing with an NFA Gun Trust:**

When you fill out the ATF 5320.1 Form 1 with a Gun Trust you will be required to fill out ATF 5320.23 Responsible Person's Questionnaire for each responsible person named in the NFA Gun Trust.

This means every responsible person named in the NFA Gun Trust will be required to submit the two fingerprint cards, a ATF 5320.23 Responsible Person's Questionnaire, and a passport photo.

Benefits of filing with a Gun Trust:

- **Multiple Co-Trustees:** You can name multiple responsible persons in your trust. This allows them to use, transport and have access to the NFA items that are owned by the Gun Trust.
- **Amendments:** You can amend the trust later. Meaning you can add or remove co-trustees to the trust, change the successor trustee, add or remove beneficiaries, etc. This adds flexibility to the Trust and is a major advantage of having a Trust. Amendments allow you to add or remove co-trustees to the trust without having to pay for a new \$200 tax stamp.
- **CLEO:** No CLEO signature is required.
- **Inheritance:** NFA items that the trust owns can be passed down, but the trust may simplify this because you can name all that you want to happen in the trust.

Disadvantages of filing with a Gun Trust:

# The Underground Build-Your-Own Silencers Manual

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- **Cost:** There is a cost to form and establish a Gun Trust. This could be \$100's of dollars if your situation is a complex one.
- **More ATF Paperwork:** ATF 5320.23 Responsible Person's Questionnaire paperwork is required for every responsible person in the gun trust.
- **Trust Paperwork:** Trust paperwork may require pages within the trust to be, notarized, dated and witnessed.
- **Copy of Trust Must Be With You:** A photocopy of the notarized trust must accompany a copy of your tax stamp when you are transporting and shooting the NFA item(s).

## Why I Decided To Use A Trust.

It all comes down to having to making sure that everyone I wanted to enjoy the silencers, could enjoy the silencers...

And I wanted the extra legal protection.

Consider this example, from ArsenalAttorneys.com, who did my trust:

### **Manage Risk of Handling NFA firearms**

You can violate the NFA if another person simply has the potential, or knowledge of how, to access or control of your NFA firearms outside your presence. Consider these examples:

- Your spouse knows the combination to your gun safe.
- During lunch after target shooting with a friend, you leave your NFA firearms in his car.
- While hunting you leave your NFA firearms in your parents' cabin.
- A cousin stores your NFA firearms during your military deployment.

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# The Underground Build-Your-Own Silencers Manual

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All of these situations run the risk of violating the NFA. The maximum penalties for such violations include:

- \$250,000 in fines
- 10 years in jail
- Confiscation of your guns

The Arsenal Gun Trust™ is your risk management solution for these situations. Others properly named in your trust may lawfully handle, store, and possess your NFA firearms, whether in an emergency or for your convenience.

Is it probably overkill to worry about such things? Maybe, maybe not. But I figured the peace of mind was worth it and for my particular situation, it was. You can contact ArsenalAttorneys.com and see if their solution works for you.

We'll cover an even faster and cheaper way to use a Trust in a moment, for now, let's continue...

## **You Need An Approved Form 1 To Build An NFA Firearm – With Tax Stamp In Hand**

Once you've established whether you want to file as an individual or with a trust, then you will get ATF Form 1 from the ATF website and fill it out.

Because I'm not a lawyer or legal expert, I'm not going to give you advice here. I will suggest a quick search online and you'll find many sites from actual lawyers like this one: <https://rocketffl.com/atf-form-1/> and this one:

<https://www.guntrustlawyer.com/form1/>

Also, if you're filing as an individual, the ATF is now doing efile with their eForm 1 which can be found here: <http://eforms.atf.gov/>

**\*\*\* The EASIEST Way To Get Your Stamp, With Or Without A Trust, And Do Your Paperwork \*\*\***

## The Underground Build-Your-Own Silencers Manual

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Probably the easiest way to make your own silencer is also the easiest way to buy your own silencer... simply visit **SilencerShop.com**.

They have a very thorough walkthrough of how to buy a silencer <https://www.silencershop.com/how-to-buy-a-silencer> and they also make it super easy, because they pretty much allow you to do it all online, with follow-up from them by email, making it as streamlined as possible...

At the same time that I wanted to build my silencers, I also bought a few commercial ones too, so I did it all with them...

After you have an account with them, you can simply purchase the ATF form 1 service from them:

<https://www.silencershop.com/atf-form-service.html>

You can pay for the ATF tax stamp with them (they then pay the ATF for you, etc):

<https://www.silencershop.com/form-4-tax-stamp.html>

And they even have multiple gun trust options on their site:

<https://www.silencershop.com/single-shot-trust.html>

<https://www.silencershop.com/catalog/product/view/id/251/s/nfa-gun-trust/>

<https://www.silencershop.com/single-shot-unlimited-gun-trust.html>

I know from experience; they are good at what they do.

Once you make a purchase, you have a secure login area to put all your information that goes on the Form 1 or Form 4 and to upload pictures of yourself, and then they make it easy to do your fingerprints too because they have Kiosks at major gun/outdoor stores. If you go here:

[https://www.silencershop.com/storelocator/?store\\_group=store&flag=3](https://www.silencershop.com/storelocator/?store_group=store&flag=3)

And select “Has Kiosk” – you can find one near you.

# The Underground Build-Your-Own Silencers Manual

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They will follow up with you by email to get all the rest of your details filled out for your paperwork and make sure everything is good to go.

Overall, they probably make it the easiest at SilencerShop.com to do all your paperwork, so I recommend that as an option.

So, let's assume now, that you did all the paperwork, paid, and waiting 6-12 months and now you have a tax stamp and you are ready to build your silencer. What else to remain legal?

## You NEED To Engrave Your Silencer

If you live in most of America, you can build your own firearm, and it does not need a serial number or any other engravings.

However, if you are building an NFA firearm – which includes a silencer – then you absolutely DO need to engrave it.

Here is what you need to engrave on your silencer – and all this information MUST match the information you put in your Form 1 paperwork:

**Name** of the individual or entity that made/registered the NFA firearm.

**Location** (City and State) where the NFA item was made.

**Caliber** of the registered NFA firearm.

**Serial Number** of the registered NFA firearm.

**Model Number** of the registered NFA firearm.\*

\* Example below

The only neat thing here, is that you can make up your serial number and model number to whatever you want.

As an example, here is how you would engrave the silencer if you were a fictional John Doe who created a NFA trust called the “John Doe Trust” living in Anytown, VA and you were making a .30 caliber silencer.

# The Underground Build-Your-Own Silencers Manual

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John Doe Trust  
Anytown, VA  
SN: 0001  
CAL: .30  
MODEL: Freedom

**IMPORTANT:** The minimum depth of engraving is .003 inch and in a print size no smaller than 1/16<sup>th</sup> inch.

If you do not want to do the engraving yourself, then you can find a machine shop that will do it for you at a reasonable cost. A quick search online revealed there are companies like “Tar Heel State Firearms”

<https://tarheelstatefirearms.com/store/index.php?route=product/category&path=119> and Precision Gun Engraving <http://www.precisiongunengraving.com/> that seem to be able to provide this work specifically for NFA items.

Also, be on the lookout when you purchase your silencer tube – that many of these shops will also offer the option of engraving it for you before you receive it.

### WHY IT'S NOT THAT COMPLICATED TO BUILD A SILENCER

The fact of the matter is, despite them not being that common, building a silencer is not that hard.

Of course, we've all seen in movies how a criminal or spy will use something like an empty coke bottle stuck on the end of a gun as a silencer. The pic below is from a movie where Mark Wahlberg does this with a rifle:



There are even some guys on YouTube that have tried re-creating these pop bottle silencers, but at least the ones I saw the didn't work (I will admit, I stopped watching after maybe two, you can lose hours on YouTube watching silly videos if you're not careful!)

Anyways, the point is that silencers are not that complicated, but they are a little more complicated than some forms of entertainment would have you believe.

### The Three Major Components To Building A Silencer

Because I like simplifying, you need three major things to build your own silencer, a “**tube**” and the internal components-which we will call a “**baffle stack**”, and the “**attachment**” device.

The tube holds everything inside, the baffle stack is all the stuff that goes inside to actually make the silencer reduce noise, and the attachment device is going to be the endpiece of the silencer that attaches to your barrel.

Simple enough so far...

## What Type Of Silencer Will I Show you How to Build?

I'm going to show you how to build two types of silencers in this guide...

1. **Titanium Silencer** – this one is the more “professional” grade silencer. I will show you how to build a silencer that’s basically “military-grade” and should mimic the performance of any commercial silencer you can buy. It’s going to cost more, because it’s better than an improvised solution.

2. **SHTF Silencer** – this is more like an “improvised” silencer. The idea here is that the SHTF, and you have to make a silencer, quick out of the available parts around your house or that you could commonly buy from the auto parts store, or online, that type of thing.

Let’s continue...

## Choosing Your Tube Material and Size

Pre-threaded tubes intended for form 1 builds are readily available online.

There used to be a thriving business of companies selling “Solvent Trap” kits that people then turned around and used to build their Form 1 silencers, however the ATF raided one of the bigger of these companies, so it’s somewhat of a murky gray area.

That said, you can buy tubes online...

The typical size of these – in width at least – is “D-Cell” size, which is a reference to the size of a D-cell Maglite flashlight...

There are three main material types - Aluminum, Steel, and Titanium.

## Pistol VS Rifle Caliber Tubes

**PISTOL:** In short, you probably only want to use Aluminum for a pistol caliber silencer, that you intend to put on a handgun. Because it's more lightweight and because it's not going to have to deal with higher pressures from a centerfire rifle caliber.

Also, I would say that aluminum is fine for a .22 LR – even if it's on a rifle barrel – as you will see me do with the Maglite SHTF silencer in the videos.

**RIFLE:** With your rifle calibers – pretty much any centerfire caliber – you want to use either steel or titanium.

- 1. Steel** – is the cheapest, and will probably take more abuse with rapid fire, if that's your thing. They will corrode easier though. Great for a budget build if you don't mind the extra weight. A lot of commercial “full auto rated” cans are steel.

- 2. Titanium** – is light, strong and corrosion resistant. If you are going to do a lot of mag dumps and rapid-fire shooting, you probably want to let the can cool down in between.

## How To Configure Your Baffle Stack

There's two main parts to the stuff that goes inside your silencer...

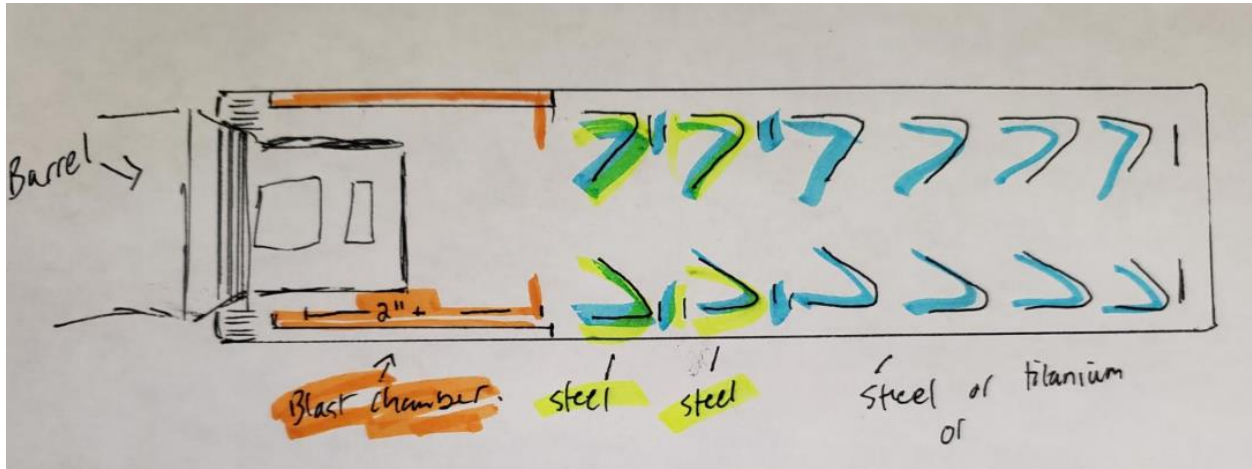
- 1. The blast chamber** – this is a section of strong, steel, that should be about 2” – maybe a little more or maybe a little less – that should be the **FIRST** part of your silencer after the barrel. This is called the “blast chamber” because it's going to take the most blast.

- 2. Baffles** – this is the rest of your baffles which are going to be made from cones or freeze plugs or other materials.

So basically, you want a blast chamber and a bunch of things filling the rest of the silencer that are going to dissipate gasses and lessen the sound. So, check out the drawing I made for you on the next page for an example.

# The Underground Build-Your-Own Silencers Manual

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This is obviously a cutaway of a silencer design, that I color coded for your benefit and labeled...

On the left, we have the end of the barrel.

In orange – we have the blast chamber – you basically just want to account for the length of your muzzle device or end of your barrel if screwing on – and you’ll use a steel section of pipe that fits inside the diameter of your tube that basically gives some space AFTER the end of the barrel before your first baffle.

Then we have the baffle stack in blue, but the first two baffles you see that I highlighted in yellow also? In this case, I’m showing that if I’m doing titanium baffles, it’s also a good idea to have the first two baffles be steel as well because this is the part of the silencer that’s going to take the most abuse.

Then you have as many other baffles as you need to fill the space to the end of the silencer. Note that you can also put “spacers” in between each baffle if you so desire.

Does it really matter how many baffles you have and how you arrange them?

Honestly? I don’t think it matters that much...

Unless you get really into this and do some testing yourself, you probably won’t be able to notice a difference in how the silencer sounds.

As an example, the images on the next page are cutaways of various different “commercial” cans that you might buy from the factory – you can see how they all utilize

# The Underground Build-Your-Own Silencers Manual

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the same concepts – a blast chamber and then baffles, but each of these companies has their own “secret sauce” method of shaping the baffles and arranging them – but it’s all the same principle.

These three pics are from a post online <https://www.thetruthaboutguns.com/cutaway-silencers/>:

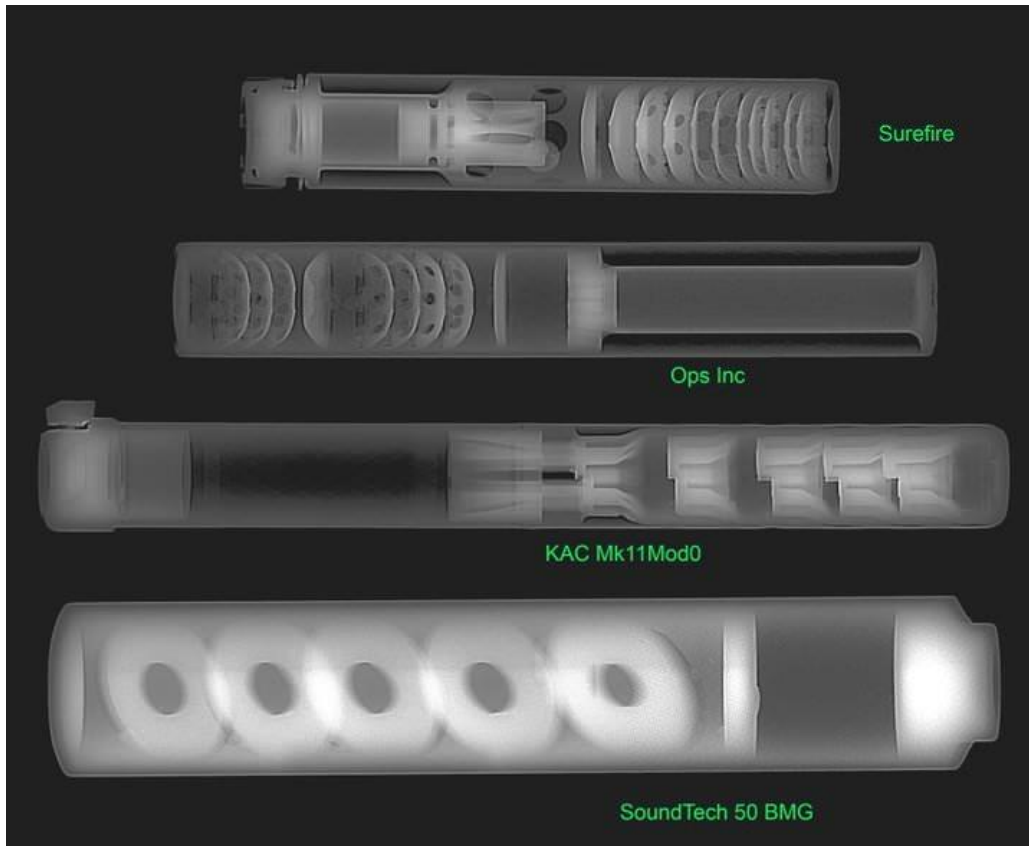


# The Underground Build-Your-Own Silencers Manual

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Here's an Xray of some other commercial silencers found on Google images:



# The Underground Build-Your-Own Silencers Manual

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And here's a few more I randomly found online:



It's also worth noting at this point, that if you have machining skills and access to a lathe, that you can certainly create a "monolithic" baffle stack by machining a solid piece of material that fits inside the tube like this silencer design:



However, that type of work is beyond the scope of this project or this author's ability, so we'll focus on how to just assemble ours using baffles.

In short, you can google around online and look for inspiration for design, but that's all there is to a silencer.

## **What To Make Your Baffles Out Of**

You can make baffles out of most anything I suppose, but there's a few readily-available materials that have been proven to work for form 1 builders over time...

### **OPTION #1: Freeze Plugs.**

These are made for engines, but work great for baffles.

They're the cheapest option too!

# The Underground Build-Your-Own Silencers Manual

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The model you want, that will fit a standard “D-cell” sized tube, is “Freeze Plugs 381-3179”.

Now, you can either run these just as they are, with a hole in the center for the bullet to go through, or you can “form” them into a cone shape, so you have that nice Christmas tree effect. You want a 45-60 degree form. That’s the more professional way to do it...

To achieve this, you can piece together your own tool kit, using some type of combo of jig and lathe tips to press down into the center to form them into cones. This is an example of a lathe tip that would work from amazon – listed as Grizzly H5789 HSS Lathe Center MT2:



Or there are some websites that sell a complete tool kit if you think you’re going to do a lot of them, like this: [http://www.jstactical.com/JForm-D-SS-Complete\\_p\\_15.html](http://www.jstactical.com/JForm-D-SS-Complete_p_15.html)

Or, because I was lazy, I went ahead and ordered them pre-formed from this company here: <https://www.badgerridgeind.com/store/p9/Formed381-3179.html> – already pre-formed to 50 degrees. Those are aluminum, and the same website sells stainless steel ones too: <https://www.badgerridgeind.com/store/p28/FormedDcellStainless.html>

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# The Underground Build-Your-Own Silencers Manual

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All that said, please remember, that you could just not form them into a “cone” shape and you will still get sound reduction. But that the “60 degree” cone is the ideal structure as you see for the baffles in commercial cans:



If you’re looking to save money, or do-it-yourself, then freeze plugs are your best bet!

## **OPTION #2: Machined Cones**

There are a few companies that machine cones at the correct 60 degrees like this:



As you can see, they’re the perfect shape, and all you really need to do is drill them and stick them inside your tube.

# The Underground Build-Your-Own Silencers Manual

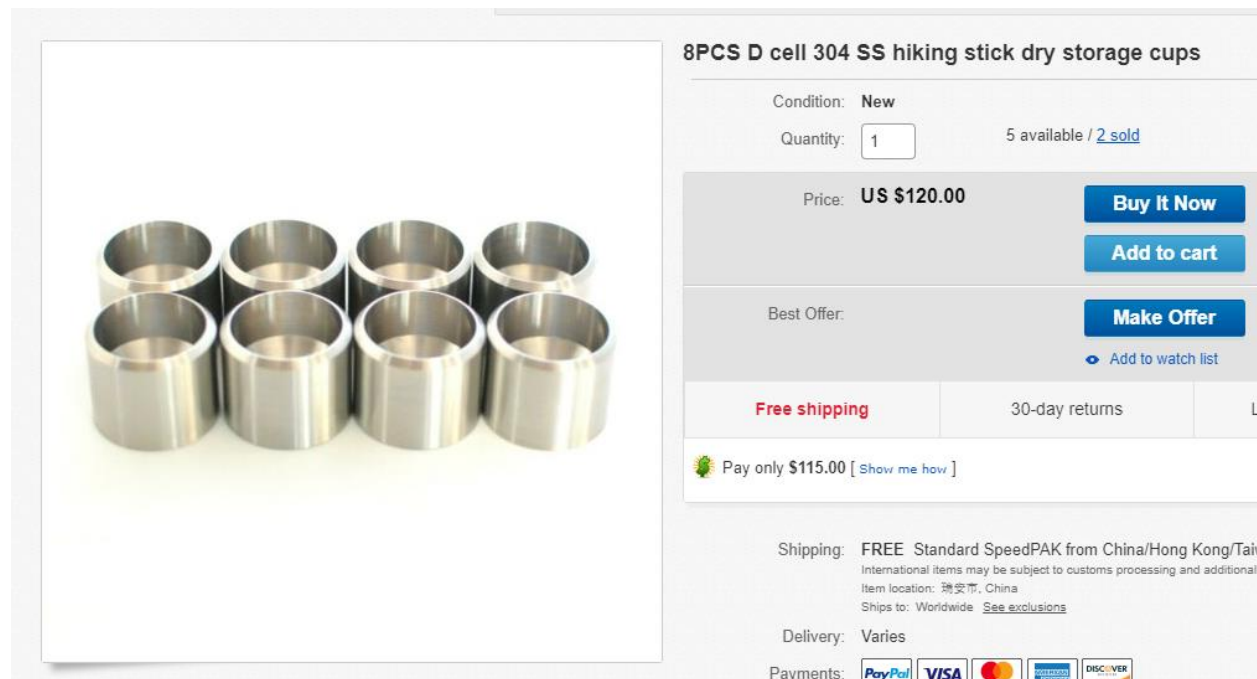
These companies often offer these in titanium and stainless steel too, so you can make a professional grade silencer.

Finally, the company I used was the one listed with the picture:

<https://totalityindustries.com/> but there are other companies out there you can find. You can do searches online for “60° Skirtless Cone” or look on message forums like <https://www.ar15.com/forums/armory/Silencers-Build-It-Yourself/55/> to see updated lists or reviews from people that have used other companies before.

## **OPTION #3: Dry Storage Cups**

This is an option that I have no personal experience with, but if you search online for “Dry Storage Cups” there are appear to be many sources, especially on eBay for storage cups that look the right shape and size:



**8PCS D cell 304 SS hiking stick dry storage cups**

Condition: **New**

Quantity:  5 available / [2 sold](#)


Price: **US \$120.00** [Buy It Now](#)

[Add to cart](#)

Best Offer: [Make Offer](#)






[Add to watch list](#)

**Free shipping** 30-day returns L

 Pay only **\$115.00** [[Show me how](#)]

Shipping: **FREE** Standard SpeedPAK from China/Hong Kong/Taiwan  
International items may be subject to customs processing and additional  
Item location: 深圳市宝安区, China  
Ships to: Worldwide [See exclusions](#)

Delivery: Varies

Payments:     

Again, I do not have personal experience with these, but they look like they could be modified to work perfectly as a baffle stack and they appear to be available at many places online. You'll have to do some research to see if that will work for you.

## How To Determine Your Drill Bit Size For Your Caliber

Probably the easiest way to do this is to convert your caliber to millimeters and then choose the next size up drill bit.

If you are using a milling machine or have really good machining skills, then you could probably do alright with that method because you're using an oversized hole...

For example, the standard AR-15 fires a .223 or 5.56mm caliber projectile. So, I could use a 6mm or 7mm drill bit for that...

Likewise, a .308 rifle is the same as a 7.62x51mm – any .30 caliber is 7.62mm -- so you could use an 8mm drill bit.

However, if you're like me and you're using a drill press, and you're not quite confident that all your holes are going to be perfectly aligned, then you may want to “oversize” the hole even more...

The only “downside” here is that you may not have the absolute “maximum” silencing ability with your silencer, but honestly, making sure that you don't have baffle strikes is probably more important.

So, because this was my first silencer build, I went even more oversized and used a 3/8” drill bit which = 9.5250 millimeters.

Somewhere, online, I found this chart which might be helpful to you:

**Recommended Suppressor Bore Sizes**

Caliber	Diameter	Over Bore	Bore	Drill Size
.22 Caliber	0.224	0.057	0.281	9/32
9mm	0.355	0.067	0.422	27/64
40 S&W	0.4	0.069	0.469	15/32
45 ACP	0.452	0.0636	0.5156	33/64
.450 Bush	0.452	0.0793	0.5313	17/32
.458 Socom	0.458	0.0733	0.5313	17/32
6.5 Gren	0.264	0.0641	0.3281	21/64
6.5 Creed	0.264	0.0641	0.3281	21/64
.30 Caliber	0.308	0.067	0.375	3/8
.338 Lapua	0.338	0.0682	0.4062	13/32
.50 Beowulf	0.5	0.0625	0.5625	9/16

As you can see, I utilized the recommended bore size for my .30 caliber drilling later on.

## How Does The Silencer Attach?

You have two basic options here...

**1. Thread On Silencer** – you simply use an endcap that is threaded to the particular thread for your barrel. For example, SilencerShop has this quick reference page: <https://www.silencershop.com/blog/post/common-barrel-thread-reference/> with more data, but I'm copying here the most common ones:

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# The Underground Build-Your-Own Silencers Manual

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Abbreviations:

- **M=Metric** (for example - M13.5x1 LH means that the numbers are metric instead of standard.)
- **LH=Left Hand** (for example - M13.5x1 LH means the threads are backwards from what you typically expect. This thread pitch would require righty-loosey, lefty-tighty...)
- **RH=Right Hand** (for example - M16x1RH means the threads work how you typically expect (righty-tighty...)). If there is no LH or RH designation - RH is the default.)

## **.22 LR, .22 MAG, .17 HMR**

The standard thread for these calibers is 1/2x28.  
Please [let us know](#) if you are aware of any notable exceptions.

### **9mm**

- 1/2x28 is the most common thread for 9mm weapons - both carbine and pistol.
- H&K weapons use the M13.5x1 LH thread pitch
- Sig Sauer weapons use the M13.5x1LH thread pitch

### **5.56mm (.223)**

- AR-15s use the 1/2x28 thread pitch
- Steyr Aug uses the M13x1 LH thread pitch
- H&K weapons use the M15x1 thread pitch
- Ruger Mini uses 9/16x24 thread pitch

### **7.62mm (.308)**

- 5/8x24 is the most common thread for 7.62mm/.308 weapons
- Sako TRG uses the M18x1 thread pitch
- Accuracy International uses the M18x1.5 thread pitch
- AK-47s use the M14x1LH thread pitch

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# The Underground Build-Your-Own Silencers Manual

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For example, if you're building a silencer for your AR-15, you'll look for an endcap that fits your tube that is threaded for the 1/2x28 thread pitch. In this manual, you'll see me build a .22 LR caliber silencer that is threaded to the 1/2x28 thread pitch because that's what my 10/22 rifle barrel is. Because I was using a Maglite I used this endcap <https://www.infiniteproductsolutions.com/adapters/1228-DCELL-BA/> it was threaded to fit on one side of the Maglite and the internal thread is threaded to fit the barrel. Easy peasy.

**2. Some Type of “Muzzle device and Mount” System** – the alternative to threading on your silencer is to put a specific muzzle device on your barrel that will work with a particular silencer model “mount”. I show you this type of silencer with my titanium build.

I decided that at the same time as I was filling out paperwork to build my own silencers, that I wanted to buy a few commercial made silencers too, in order to compare them to my own builds.

I chose the DeadAir “Sandman” line of silencers because they have a good reputation, are durable and have a good “quick attach” system called “KeyMo”.  
<https://deadairsilencers.com/product/key-mo/>

I also decided that I wanted my titanium silencer to use this same KeyMo system. This system works so well, that many people buy it to replace the unreliable mounts that come with SilencerCo Omega and Saker silencers. To use it you need a muzzle device like a a Keymount Muzzle Brake from DeadAir or a DeadAir flash hider.  
<https://deadairsilencers.com/product-category/accessories/muzzle-devices-accessories/>

NOTE: many different silencer companies have their own “muzzle and mount” systems. So, it's up to you to decide if you want to find a particular company and standardize across their mounts. I did.

## HOW I BUILT MY MILITARY-GRADE/COMMERCIAL-GRADE TITANIUM SILENCER AND PARTS LIST

Ok, enough theory, here is what I did to build the titanium silencer...

### Where to get your parts

Here's my complete build list:

**1. TUBE** – I used the Diversified Machine “SiCo ASR Advantage Tube” in 7.812” length. This one has one end threaded to accept the ASR mount (for me, I used to put my KeyMo DeadAir mount on). <https://diversifiedmachine.us/product/sico-asr-tube/>  
- COST: \$157

**NOTE:** I believe if before you order, you email them, they will engrave these tubes for you.

**2. End Cap** – from the same company, I bought their Low Profile Endcap in titanium with the thread pitch & OD: DM 1.500 OD-24tpi (this is because it matches the Outer Diameter (OD) of the tube I bought from them:  
<https://diversifiedmachine.us/product/low-profile-endcap/>  
COST: \$52

**3. Baffles** – I got these in were SS (Stainless Steel) and Ti (Titanium) cones that are preformed to 60-degrees. At the time I purchased, there was a combo pack containing “2 SS + 5 Ti 60° Skirtless Cone Kit” available from this seller. The outer diameter was 1.347” (to fit inside the inner diameter (ID) of 1.375” of the tube I used).  
COST: \$125.40

Also, from this same company, I picked up spacers made of Titanium. “1.347” O.D. Spacers (D-Cell) Grade 9 Titanium” and I got 7 of them: <https://totalityindustries.com/>  
COST: \$29.40

**4. Blast Chamber** – you could definitely just cut yourself some stainless steel pipe that fits inside the diameter of your tube, but I was lazy and saw it for sale here:  
<https://www.badgerridgeind.com/store/p55/DcellspacerPipe.html> - I got a 2” stainless steel section for the blast chamber for this build.  
COST: \$8.69

## The Underground Build-Your-Own Silencers Manual

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**5. Mounting Hardware** – for this one, I went with the DeadAir Keymo Adapter <https://deadairsilencers.com/product/key-mo/> (choose “Silencerco Saker” model to fit the tube threading) and a DeadAir Muzzle Device

<https://deadairsilencers.com/product/keymount-muzzle-brake-2/>

I ended up ordering the Key-Mo adapter from CapitolArmory.com for a slightly better price: \$225.00

TOTAL COST: So, adding up total costs, \$597.49 – about \$452 cheaper than the DeadAir silencer I ordered...

Again, that number could be brought down by using different components (stainless steel instead of titanium, different length tube, etc), but I wanted to show you an example of a “no expense spared” titanium build to show how it’s still hundreds of dollars cheaper than a commercial can.

(NOTE: of course, you pay a \$200 tax stamp no matter what type of silencer you build/buy to the ATF – so keep that in mind for your costs)

In just a moment, we’ll cover how to build it with all those parts.

## HOW I BUILT MY SHTF SILENCER AND PARTS LIST

The SHTF silencer, again is the silencer you make that's low cost out of readily available materials.

**1. Tube** – D-cell Maglite. You want the older style incandescent bulbs, not the LED one, because I could not figure out how to take it apart. I got it at home depot I think? Or maybe it was the local Wal-Mart. Can't remember!

COST: \$20 (guessing and rounding up because I can't remember)

**2. End cap and Mounting Hardware** – This company sells a combo kit for the 1/2-28 to D Cell Maglite Adapter + Cap Combo Kit

<https://www.infiniteproductsolutions.com/adapters/maglite-adapters/1228-DCELL-KIT/>

COST: \$38.50

**4. Blast chamber** – I also ordered the 3" stainless steel spacer pipe from Badger here:

<https://www.badgeridgeind.com/store/p55/DcellspacerPipe.html>

COST: \$8.99

**5. Maglite Button Coverup** – I forgot about this until I went to assemble the silencer, and ended up taking the Maglite to the local hardware store and found some piece of PVC plumbing tubing that fit inside it – then cut the PVC for this part.

COST: \$12 (I can't remember)

**7. Baffles** – For this build, I used freeze plugs that are made for cars. The model is listed here and you can get an unopened bag from them here:

<https://www.badgeridgeind.com/store/p12/SealedPower3813179.html> or your local autoparts store. And that will work fine. However, if you want more of the "cone" shaped baffles, you'll have to "Form" them, using a home-made jig. I again was lazy so I just ordered them already formed from the same company here:

<https://www.badgeridgeind.com/store/p9/Formed381-3179.html>

COST: \$32.99

TOTAL COST: \$112.48

Again, you can bring that number down. Remember, I was being lazy and paid for convenience!

## The Underground Build-Your-Own Silencers Manual

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If you bought the freeze plugs and formed them yourself, you save \$20. If you bought stainless steel pipe locally from your hardware store and cut it yourself, you'd save a few bucks, and if you already had Maglite to use then that part is "Free", but any way you look at it, you're right around \$100 or LESS to build a SHTF silencer which aint bad!

(NOTE: of course, you pay a \$200 tax stamp no matter what type of silencer you build/buy to the ATF – so keep that in mind for your costs)

Now, once you have all those parts, what do you do?

## **PART 1: HOW TO BUILD YOUR MILITARY- GRADE/COMMERCIAL-GRADE TITANIUM SILENCER**

Now, there are a lot of ways to build a silencer as we already covered. If you have access to CNC machines and you have experience milling, then you could do a full monolithic core for your baffles.

But for the DIY patriot like us – we can complete this silencer in our garage with little more than a drill and a drill press, some other simple tools, and some good old red-blooded American Elbow Grease!

What follows are the written instructions for building a military-grade silencer that should provide the same performance that a commercially bought silencer will, at a fraction of the price.

### **Before We Start: General Hints, Tips And Tricks For Drilling/Milling**

I've completed multiple "Ghost guns" by milling and drilling 80% receivers and I picked up a few tips that can help you with your silencer build going forward...

- 1. Let the drill bit "center" itself.** You want to lower the drill press bit to what you intend to drill and let the bit "center" itself, before you make your final tightness adjustments to your clamps. This will help make sure there's no sideways pressure on the drill bit or and just better drilling in general.
- 2. Always "peck" drill the holes.** This means you drill downward a bit until it starts cutting the metal, then raise the bit back out a little bit so that the metal shavings can be pulled out of the hole. It takes more time, but if you don't do this, you're just re-drilling the shavings, dulling your bit, and making it more likely you'll disturb the alignment of your drilling.
- 3. Lubrication is your friend!** Don't be afraid to use a lot of oil while drilling, this will keep the drill bit cool and overall help things out. Spray WD-40 is the easiest but you can use most oils to lubricate. Yes, it will make a mess but it's worth it.
- 4. Take your time!** Every mistake I've ever made building my own guns or doing practically any DIY project is when I was "rushing" or in a hurry to get a hole drilled or whatever. If you are impatient like me, take your time, and take breaks so you can focus.

**5. Drill one side at a time.** Whenever you have to drill holes on both sides of an object, never try to drill all the way through both sides. Drill one side, then flip and drill the other side.

OK, those are some helpful tips, now let's continue.

**\*\*\* The Written Instructions Below  
Are Only Meant to Give a BRIEF  
Outline Of The Entire Process of  
Completing Your Silencer --  
PLEASE Watch The Videos  
Included With This Course for  
STEP-BY-STEP, More Detailed  
Instructions! \*\*\***

## Step 1: Engrave Your Silencer

Because we want to remain legal and within the law here, the first step once we have our tax stamp and paperwork approved is to engrave the silencer with the required info.

Here is what you need to engrave on your silencer – and all this information **MUST** match the information you put in your Form 1 paperwork:

**Name** of the individual or entity that made/registered the NFA firearm.

**Location** (City and State) where the NFA item was made.

**Caliber** of the registered NFA firearm.

**Serial Number** of the registered NFA firearm.

**Model Number** of the registered NFA firearm.\*

\* Example below

The only neat thing here, is that you can make up your serial number and model number to whatever you want.

As an example, here is how you would engrave the silencer if your were a fictional John Do who created a NFA trust called the “John Do Trust” living in Anytown, VA and you were making a .30 caliber silencer.

```
John Doe Trust  
Anytown, VA  
SN: 0001  
CAL: .30  
MODEL: Freedom
```

**IMPORTANT:** The minimum depth of engraving is .003 inch and in a print size no smaller than 1/16<sup>th</sup> inch.

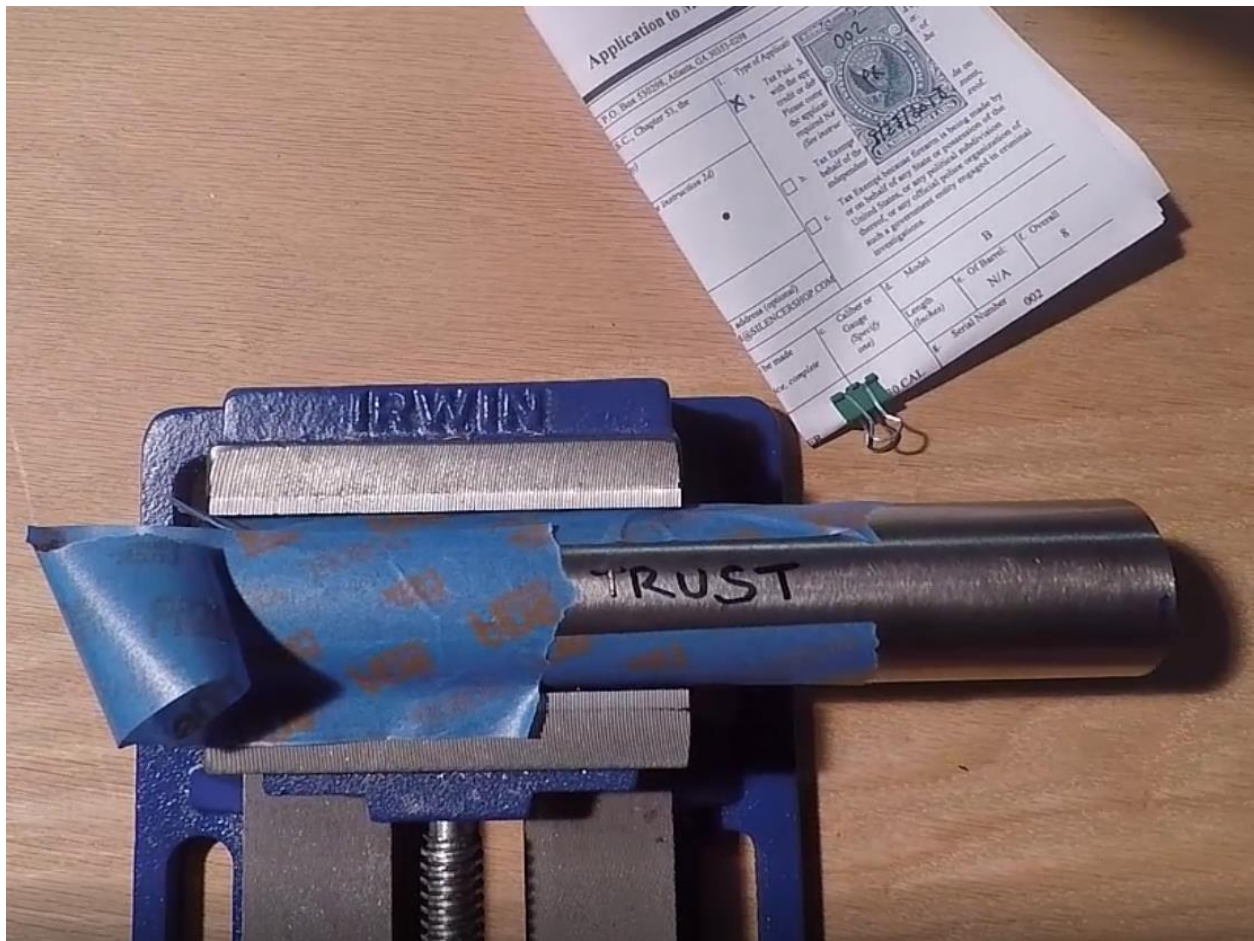
If you do not want to do the engraving yourself, then you can find a machine shop that will do it for you at a reasonable cost. A quick search online revealed there are companies like “Tar Heel State Firearms”

# The Underground Build-Your-Own Silencers Manual

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<https://tarheelstatefirearms.com/store/index.php?route=product/category&path=119> and Precision Gun Engraving <http://www.precisiongunengraving.com/> that seem to be able to provide this work specifically for NFA items.

In the videos and this manual, I show you that I did it with a Dremel tool. Be aware that you'll have to go over your work multiple times to make sure it's deep enough and clear enough:



As you can see, I used some painter's tape to put down to guide me. I also simply used a permanent marker to write on the metal of the tube the words to guide my engraving. Simply engrave until you reach the proper depth, pretty self-explanatory here:



Let's continue...

## Step 2: Decide On Your Baffle Stack Layout and Drill Your Baffles

Now, you're going to take your baffles and figure out how you're going to lay them out.

I'm using two stainless steel baffles, along with 5 titanium baffles, and a stainless-steel tube for the blast chamber, and multiple titanium "spacers" in between the baffles. Add to that the end cap and the DeadAir Key-Mo muzzle attachment:

The picture below is an attempt to label them for you



The cone baffles and spacers are machined so that you put the cone on, and then the spacer sits right on top of it:



## How To Determine Your Drill Bit Size For Your Caliber?

Again, probably the easiest way to do this is to convert your caliber to millimeters and then choose the next size up drill bit.

If you are using a milling machine or have really good machining skills, then you could probably do alright with that method because you're using an oversized hole...

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## The Underground Build-Your-Own Silencers Manual

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For example, the standard AR-15 fires a .223 or 5.56mm caliber projectile. So, I could use a 6mm or 7mm drill bit for that...

Likewise a .308 rifle is the same as a 7.62x51mm – any .30 caliber is 7.62mm -- so you could use an 8mm drill bit.

However, if you're like me and you're using a drill press, and you're not quite confident that all your holes are going to be perfectly aligned, then you may want to "oversize" the hole even more...

The only "downside" here is that you may not have the absolute "maximum" silencing ability with your silencer, but honestly, making sure that you don't have baffle strikes is probably more important.

So, because this was my first silencer build, I went even more oversized and used a 3/8" drill bit which = 9.5250 millimeters.

Somewhere, online, I found this chart which might be helpful to you:

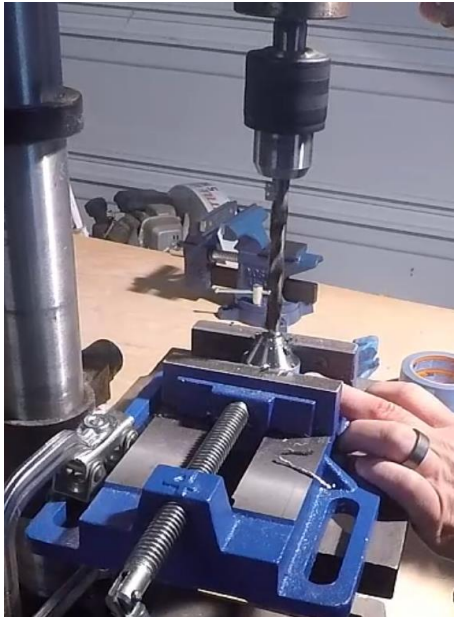
**Recommended Suppressor Bore Sizes**

<b>Caliber</b>	<b>Diameter</b>	<b>Over Bore</b>	<b>Bore</b>	<b>Drill Size</b>
.22 Caliber	0.224	0.057	0.281	9/32
9mm	0.355	0.067	0.422	27/64
40 S&W	0.4	0.069	0.469	15/32
45 ACP	0.452	0.0636	0.5156	33/64
.450 Bush	0.452	0.0793	0.5313	17/32
.458 Socom	0.458	0.0733	0.5313	17/32
6.5 Gren	0.264	0.0641	0.3281	21/64
6.5 Creed	0.264	0.0641	0.3281	21/64
.30 Caliber	0.308	0.067	0.375	3/8
.338 Lapua	0.338	0.0682	0.4062	13/32
.50 Beowulf	0.5	0.0625	0.5625	9/16

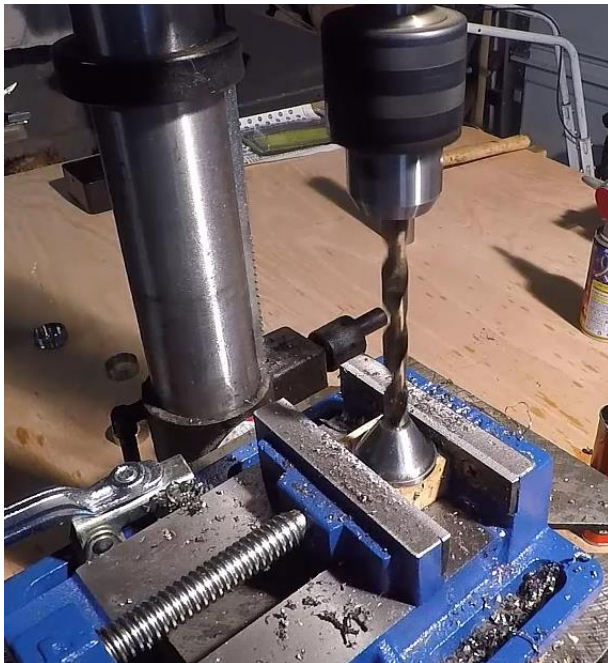
# The Underground Build-Your-Own Silencers Manual

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Now, you start drilling all your baffles...



This is pretty self-explanatory, drilling holes... but one thing that might help, that you can see in a closeup here is that I put a wooden block underneath the baffles, to help hold it in the vice:



## The Underground Build-Your-Own Silencers Manual

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The other thing that I'd like to point out, is that in the video step-by-step you see that I tried taping all the baffles together, one on top of another and just drilling straight through... that turned out not to work too great.

I ended up simply removing the top baffle every time I drilled through it. And the holes were not as perfectly aligned as they should have been.

So, you're better off just doing the baffles one at a time like you see here.

Finally, you'll drill the End Cap too:



The particular end cap that I used actually had a center-aligned “dimple” in it, so it was easy peasy.

Next, we'll start assembly by hand-fitting...

## Step 3: Hand-Fit If Necessary

Now, at this point, your experience may differ from mine...

If you get all your parts from the same supplier, maybe they will all fit together perfectly and you won't have to do any fitting, but that wasn't the case for me at least.

So, I had to do some fitting and hand-filing to try to make the parts fit.

Specifically, I did this to make the parts fit:

1. filed the outside edges of the spacers and cones to fit inside the tube
2. filed the inside of the cone, using an "Adjustable Brake Cylinder Hone" and a hand drill from the local hardware store

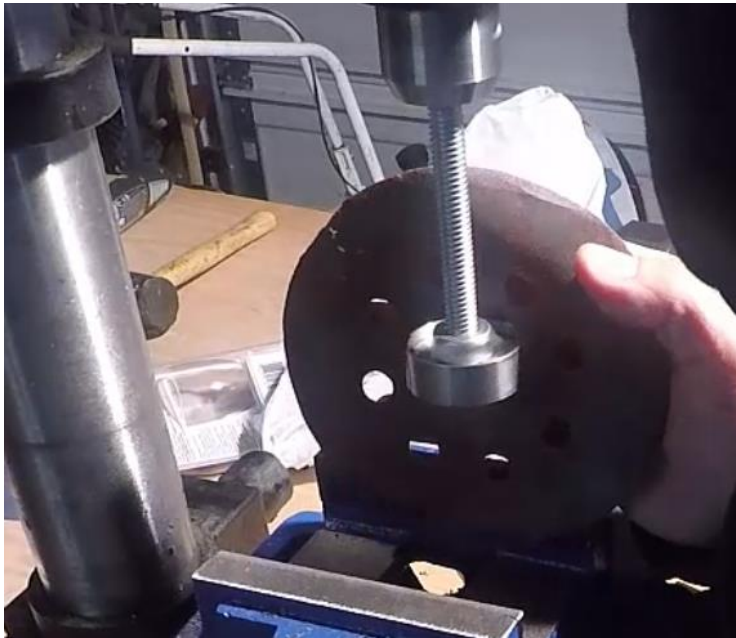
The first thing you see me do is rig up a simple bolt nut and washer combo on the drill press, just so I could have something to jam inside the round spacers



Then, I simply took the spacer, stuck it on the washers, and held some sandpaper in my hand and turned on the drill press...

## The Underground Build-Your-Own Silencers Manual

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And it was slow going, probably because it's titanium, but it worked... you could also use a belt sander, like I did in the next SHTF silencer build possibly.

For the inside of the tube, I used the aforementioned "Adjustable Brake Cylinder Hone" and a hand drill like this:



I just kept going back and forth in the inside of it. One thing to note, is because my tube was threaded inside – you want to avoid hitting those threads as much as possible.

## The Underground Build-Your-Own Silencers Manual

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That's really pretty much it...

The only thing I can say is to remember that you can always take more off, but you can't put material back on, when filing stuff down, so just file for a little bit and check to see if it fits. If it doesn't then, go back and file more.

It's somewhat tedious that way, but better than filing for an hour, and finding out it took way too much off and it's way too small now.

You basically want it to be a pressure fit inside the tube, not too hard to get inside, but you shouldn't have to jam it in either.

## Step 4: Assemble The Silencer

Once you have everything setup, drilled and hand-fitted if necessary, then you're basically ready to assemble. It might help to layout your baffle stack in the order you intend to put it in the tube, kind of like this:



Then, you probably want to start with the muzzle end of the silencer and the blast chamber and work from there... remember to start with the stainless-steel blast chamber and baffles if you are using titanium on the rest:



One thing that helped, when putting them in there, was to use another similar sized piece of tube that fit in the inside of the silencer – to be able to “ram down” the baffles because it helped put equal pressure around the sides of the baffle to keep it from getting pushed to far down on one side and stuck:



And just keep putting them in...



For me, I got to the end, and when I went to screw on the end cap – it wouldn't screw down all the way with the last spacer sticking up after the last baffle. This is good, because it meant I could file down the last spacer until it was just the right height and the fit was nice and tight and the end cap screwed on fine:



When you're done, you should of course have a nice straight hole down the center...



I did not use one, but there are things called “bore rods” that might help you to make sure that your alignment is correct and you did well enough on the holes. If you use that and find that it’s not aligned correctly, then you could go back and re-drill the problem baffle.

## Step 4: Test Fire Your Silencer and Enjoy!

At this point, you should have your silencer ready to use!

Find the appropriate gun to test it on, and take it to the range to test it out:



Remember to keep the appropriate paperwork with you and the silencer.

## PART 2: HOW TO BUILD YOUR SHTF SILENCER

Now, you just saw how to build a “spare no expense” home-made silencer...

But, what if the SHTF – and there are zombies everywhere and you need to build a simple silencer out of common household and store supplies?

That’s the idea behind the next build...

**One thing I will note**, is because we are using an aluminum tube for this silencer, that I designated mine to be a .22LR silencer. Because the pressure should be *less* than a centerfire cartridge.

Will an aluminum tube hold up to something like a 5.56mm (AR-15) or .30 caliber (AK-47, AR-10, etc) – probably... for a little bit.

But for me, it just wasn’t worth the risk.

You would probably want to do more research on exactly how durable a Maglite silencer would be under those circumstances.

Plus, I already build the .30 caliber titanium silencer, so this one is a .22 LR silencer.

What follows are the written instructions for building a SHTF silencer from a Maglite. Enjoy!

**\*\*\* The Written Instructions Below  
Are Only Meant to Give a BRIEF  
Outline Of The Entire Process of  
Completing Your Silencer --  
PLEASE Watch The Videos  
Included With This Course for  
STEP-BY-STEP, More Detailed  
Instructions! \*\*\***

## Step 1: Acquire The Correct Maglite

This is probably the simplest step, but kind of important one too...

I couldn't figure out how to take apart the "new" LED style Maglite.

So, what you want is to buy the "older" style Maglite with incandescent bulbs.

You also want a "D-cell" Maglite, or at least that's the one that I made this project with. You could use the skinnier Maglite, especially for a .22LR pistol build type project, but this one shows you how to use a D-cell Maglite:



When you do that, you basically just screw off the end pieces – one side has the bulbs and the other has the battery compartment, easy peasy.

## Step 2: Engrave The Maglite

Just like the titanium silencer, you're going to take your tax stamp and you're going to engrave the same information from that Form 1 onto your Maglite to make sure you're legal...



Because the Maglite was black, I used the tape on the Maglite, then wrote on the tape in black marker what I was going to engrave and used the Dremel again to do it...



## Step 2: Configure Your Baffle Stack And Drill The Baffles

For this build, instead of the fancy titanium cones from a machinist, we are using freeze plugs from the auto parts store... or that you can order online.

Now, again, you can just use them as is and drill through the center, or you can form them so they are more the “cone” shape that is ideal. Either way will work. Because I ordered online, I bought the ones that were already “formed” into more of a cone shape because I was being lazy, and simply started drilling the freeze plugs.

You also need a blast chamber. Again, I’m using a stainless-steel piece of pipe, approximately 3” for this...

A Piece of PVC pipe is being used to cover the Maglite button hole, from the inside.

And the muzzle attachment is screw on along with the end cap from the same company.

This is how it looks laid out basically:



The barrel screws on the right, and the bullets come out the left... This is simple. If you wanted, you could add spacers between the baffles, or cut down some of the PVC, and add more baffles, etc. But this was quick and dirty.

Now, start drilling the baffles...

## The Underground Build-Your-Own Silencers Manual

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I believe these are made out of aluminum which makes them a lot easier to drill. Drill through the one side, then turn over and deburr the ragged edge on the other side using the drill



You also want to drill the end cap:



## Step 3: Hand-Fit Tube And Baffles If Necessary and Cover Button Hole

Again, I had to file down and “hone” the inside of the Maglite:



And file the freeze plug baffles...



For this one, I also used a belt sander:



Once you drill the center out of the baffle, you can stick a screw driver through it, to hold it, and using a glove, let it get the high-speed sanding on the belt sander...

And I also got a piece of PVC tubing that fit inside the Maglite from the hardware store, some type of plumbing tube and used that inside to cover the hole where the button used to be on the flashlight (I cut it about 3" about the size of the stainless steel pipe I had):



And that's pretty much it...

## Step 3: Assemble the silencer

Now, you should be ready to assemble.

This time I started with the endcap, then did the PVC to cover the hole, then the baffles and then the blast chamber last.



Again, you may have to go back and file more – just test fit – file – try again until you get it together:



## Step 4: Shoot and Enjoy!

The last step is again taking your gun somewhere you can shoot it and testing it!



I was super, duper excited about how quiet the .22LR silencer is. It was really fun!

## ENJOY YOUR SILENCERS!

Congratulations Patriot!

You now know exactly how to build a silencer!

I hope you enjoyed this guide and I sincerely pray that it helps you empower your Second Amendment Rights!

Speaking of the Second Amendment ...

### A Suggestion ...

You may not think it, but your voice counts!

If you care at all about your rights, your freedoms, and fighting the anti-gun criminals in Washington – then you need to step up and join the fight ...

I would encourage you to join the NRA – the National Rifle Association if you haven't already. They're not perfect but they're one of the biggest pro-gun lobbyists in Washington. More information can be found at: [home.nra.org/](http://home.nra.org/).

In recent years though, the NRA has been less than ideal – they basically sold us out by supporting a Bump Stock ban with Trump and I don't think you can really trust them anymore...

That's why I would also HIGHLY encourage you to join the **Gun Owners of America (GOA)** at [gunowners.org/](http://gunowners.org/). They are an excellent organization. The highest praise I can give them is from a Patriot I truly respect: "*The only no-compromise gun lobby in Washington*" – Ron Paul.

I also recommend **Firearms Policy Coalition** – FPC found at [FirearmsPolicy.org](http://FirearmsPolicy.org) and **The Second Amendment Foundation (SAF)** found at [SAF.org](http://SAF.org). Both these organizations are VERY active in suing and taking to court various local, state and Federal governments over their violations of our second amendment rights.

In addition, I encourage you to join whatever LOCAL groups there may be available to you – to get involved at the LOCAL level – as much headway can be made here for gun rights and your voice is sure to be heard.

## The Underground Build-Your-Own Silencers Manual

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Myself, I'm a member of the Virginia Citizens Defense League (VCDL) at *VCDL.org*. They are a grassroots organization. I believe this same organization model is in many other states and I would encourage you to find the one nearest you and to join it (just Google "INSERT YOUR STATE + citizens defense league").

Once you join these organizations – make sure you use your best email – and then they will alert you when there is anti-gun legislation coming up for votes at the local or federal level and you can respond with other Second Amendment supporters to encourage your representatives to fight these freedom robbing laws!

### **It truly is up to us!**

At no time in history (primarily because of the wonder of the internet!) has it been easier to get information on what the Government is doing behind closed doors ... to be notified almost immediately when freedom-stealing legislation is going to pass ... and ... to fight back so that the PEOPLE have a say in Washington!

If we all give up or think our voices won't matter – then it is a self-fulfilling prophecy and nothing will change.

But if we all let our voices be heard—then we can at best change the direction of the Nation for our future, our children's future and future generations ...

... And at worst – we can delay the power-hungry politicians from taking away our freedoms one small bite at a time.

If you consider yourself a Patriot, I encourage you to fight for the former!

All my best,

Caleb