



**SHS FIREARMS**  
CUSTOM MODERN SPORTING RIFLES

## **AR USER MANUAL**



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# **DISCLAIMER OF LIABILITY**

**SHS FIREARMS SHALL NOT BE RESPONSIBLE FOR PRODUCT MALFUNCTION OR FOR PHYSICAL INJURY, DEATH OR DAMAGE TO PROPERTY RESULT FROM EITHER INTENTIONAL OR ACCIDENTAL DISCHARGE OF THIS FIREARM, ITS CRIMINAL OR NEGLIGENT USE, IMPROPER OR CARELESS HANDLING, UNAUTHORIZED MODIFICATIONS OR ALTERATION, USE OF DEFECTIVE, IMPROPER, HAND-LOADED OR REPLACED AMMUNITION, OR FROM ITS USE FOR PURPOSES OR SUBJECTION TO TREATMENT FOR WHICH IT WAS NOT DESIGNED. FOR YOUR SAFETY, USE ONLY ORIGINAL HIGH QUALITY COMMERCIALY MANUFACTURED AMMUNITION IN GOOD CONDITION THAT IS APPROPRIATE TO THE CALIBER OF YOUR RIFLE OR PISTOL. SHS FIREARMS SHALL NOT BE RESPONSIBLE FOR THE PRODUCT OR ITS RESULT FROM USE OF DEFECTIVE, IMPROPER, REMANUFACTURED OR RELOADED AMMUNITION.**

# **WARNINGS! DANGEROUS PROCEDURES**

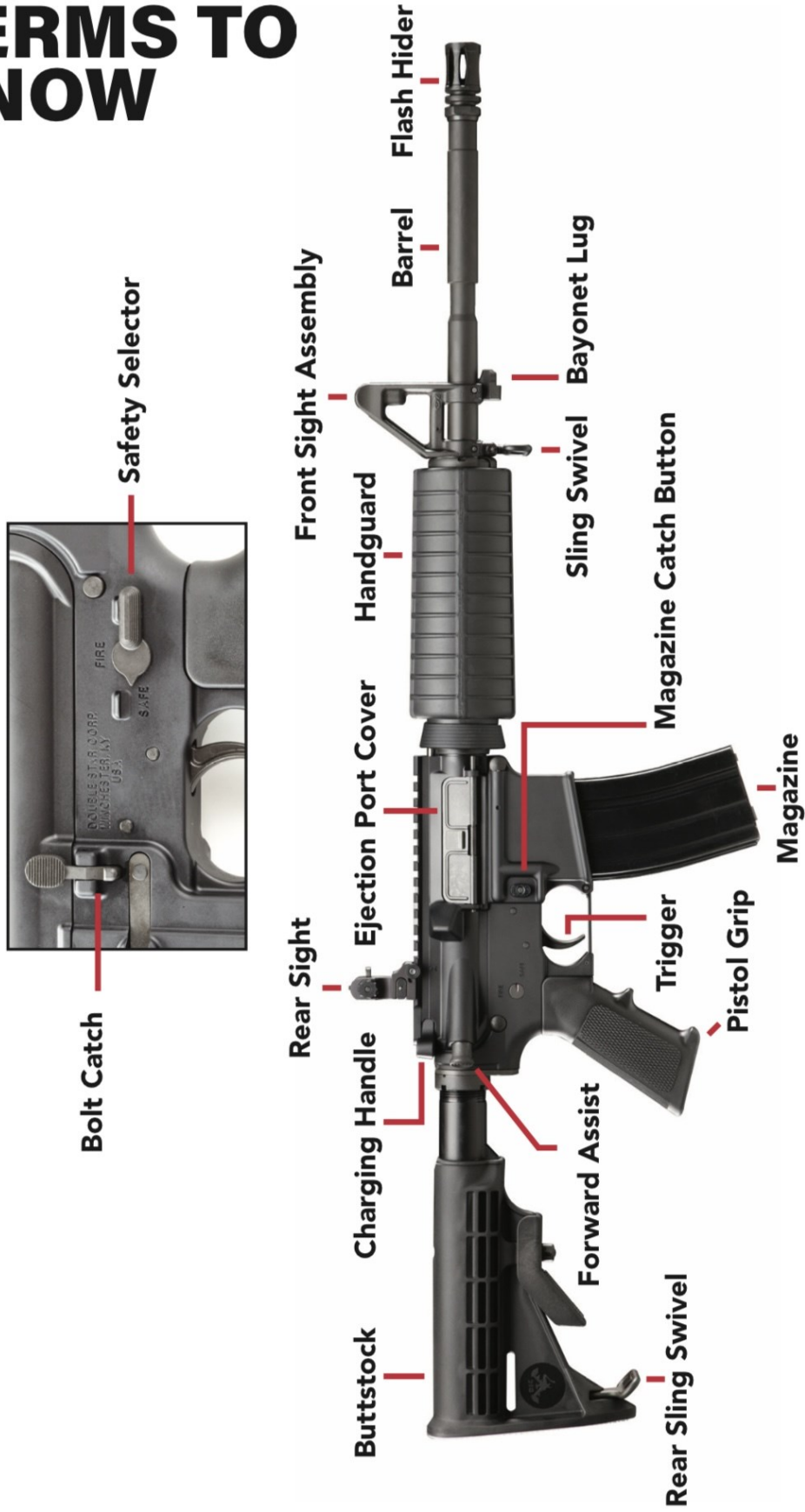
**DO NOT INTERCHANGE BOLT ASSEMBLIES FROM ONE RIFLE TO ANOTHER. DOING SO MAY RESULT IN PERSONAL INJURY OR DEATH TO YOU AND/OR OTHERS AND CAUSE SEVERE DAMAGE TO YOUR RIFLE. IF YOUR RIFLE MISFIRES WITH A LIVE ROUND IN THE CHAMBER OF A HOT BARREL, IMMEDIATELY REMOVE THE ROUND KEEPING THE BARREL POINTED IN A SAFE DIRECTION. IF YOU ARE UNABLE TO REMOVE THE LIVE ROUND, WAIT 10 SECONDS, REMOVE THE MAGAZINE KEEPING BARREL POINTED IN A SAFE DIRECTION AND WAIT 15 MINUTES FOR THE BARREL TO COOL. AFTER COOLING, TRY TO REMOVE THE ROUND. CONTINUOUS OR RAPID FIRING OF YOUR RIFLE CAN CAUSE THE BARREL TEMPERATURE TO REACH A “COOKOFF POINT” WHERE THE HEAT OF THE BARREL CAN CAUSE A LIVE ROUND TO FIRE WITHIN 10 SECONDS OF CONTACT WITH A HOT A CHAMBER. ALWAYS KEEP YOUR FACE AWAY FROM THE EJECTION PORT WHEN CLEARING A HOT CHAMBER. IF YOUR BOLT FAILS TO UNLOCK AND YOU TRY TO FREE IT BY BANGING THE BUTTSTOCK ON THE GROUND OR MORTARING IT, KEEP CLEAR OF THE MUZZLE IN CASE OF AN ACCIDENTAL DISCHARGE. NEVER FIRE YOUR RIFLE WITH WATER IN THE BARREL AS THIS COULD CAUSE THE RIFLE TO EXPLODE. IF YOU EXPERIENCE A NOTICEABLE DIFFERENCE IN SOUND OR RECOIL WHEN FIRING, STOP FIRING! THE CAUSE FOR EITHER CONDITION COULD BE INCOMPLETE POWDER BURN OR A BULLET STUCK IN THE BORE. IMMEDIATELY CLEAR THE RIFLE AND CHECK FOR UNBURNED POWDER RESIDUE IN THE BORE AND THE RECEIVER OR FOR A BULLET STUCK IN THE BORE. REMOVE THE UNBURNED POWDER BEFORE YOU RESUME FIRING. IF A BULLET IS STUCK IN THE BORE, HAVE A QUALIFIED GUNSMITH TAKE CARE OF THE ISSUE. FIRING WITH UNBURNED POWDER IN THE BARREL COULD CAUSE THE BARREL TO EXPLODE**

# **WARNINGS! GENERAL SAFETY**

**CARELESS AND IMPROPER HANDLING OF YOUR SHS FIREARMS RIFLE COULD RESULT IN UNINTENDED DISCHARGE CAUSING INJURY, DEATH OR PROPERTY DAMAGE. SAFETY MUST BE THE FIRST AND A CONSTANT CONSIDERATION WHEN HANDLING A FIREARM AND AMMUNITION. YOUR SHS FIREARMS RIFLE OR PISTOL WAS DESIGNED TO FUNCTION PROPERLY IN ITS ORIGINAL CONDITION. DO NOT ALTER ANY PARTS OR REPLACE PARTS. YOUR SHS FIREARMS RIFLE OR PISTOL SHOULD ALWAYS BE CARRIED WITH AN EMPTY CHAMBER AND WITH SAFETY SELECTOR ON “SAFE” TO PREVENT ACCIDENTAL DISCHARGE. ALWAYS HANDLE AND TREAT YOUR FIREARM AS IF IT WERE LOADED. NEVER TAKE ANOTHER PERSONS WORD THAT A FIREARM IS UNLOADED. ALWAYS PERFORM A CHECK WITH YOUR FINGERS OFF OF THE TRIGGER AND THE BARREL POINTED IN A SAFE DIRECTION. NEVER PLACE YOUR FINGERS INSIDE THE TRIGGER GUARD AREA UNLESS YOU ARE READY TO FIRE. WATER, SNOW, MUD, EXCESSIVE LUBRICATING OIL, GREASE OR ANY OTHER MATERIAL CAN OBSTRUCT THE BARREL OF YOUR FIREARM AND CAUSE THE BARREL TO EXPLODE. ALWAYS CHECK THE BARREL OF YOUR FIREARM FOR OBSTRUCTION BEFORE LOADING AND FIRING. CLEAN A FOULED GUN IMMEDIATELY TO ENSURE ITS CORRECT AND SAFE FUNCTION. KEEP THE GUN’S MUZZLE POINTED IN A SAFE DIRECTION AT ALL TIMES. NEVER LET THE MUZZLE OF A FIREARM POINT AT ANY PART OF YOUR BODY, ANOTHER PERSON OR ANYTHING YOU DO NOT INTEND TO SHOOT. ALWAYS BE SURE OF YOUR TARGET AND WHAT IS BEHIND IT BEFORE FIRING. UNLOAD ALL FIREARMS WHEN NOT IN USE. NEVER STORE A LOADED FIREARM. FIREARMS AND AMMUNITION SHOULD BE SAFELY STORED SEPARATELY SO THAT THEY ARE INACCESSIBLE TO CHILDREN OR UNAUTHORIZED USERS.**

**ALWAYS MAKE SURE YOUR FIREARM IS UNLOADED BEFORE CLEANING, STORING, OR HANDING IT TO ANOTHER PERSON. ALWAYS WEAR AND ENCOURAGE OTHERS TO WEAR SAFETY GLASSES WHILE SHOOTING TO PROTECT YOUR EYES FROM INJURY BY GUN POWDER GAS, LUBRICANT, DIRT, METALLIC PARTICLES, CARBON RESIDUE, SPARKS OR OTHER DEBRIS. ALWAYS WEAR AND ENCOURAGE OTHERS TO WEAR EAR PROTECTION WHEN SHOOTING ESPECIALLY AT THE GUN RANGE. WITHOUT EAR PROTECTION, THE NOISE FROM YOUR FIREARM AND OTHER FIREARMS CLOSE TO YOU COULD LEAVE A “RINGING” IN YOUR EARS FOR SOME TIME AFTER FIRING. REPEATED EXPOSURE TO SHOOTING NOISE COULD RESULT IN PERMANENT HEARING LOSS. NEVER CLIMB A TREE, A FENCE OR A WALL WHILE CARRYING A LOADED FIREARM. DO NOT SHOOT AT A HARD SURFACE OR AT WATER. DOING SO MAY RESULT IN A RICOCHET—SENDING THE BULLET IN UNPREDICTABLE DIRECTIONS AND COULD CAUSE PROPERTY DAMAGE, INJURY OR DEATH. IF YOU HAVE ANY DOUBTS ABOUT YOUR ABILITY TO SAFELY HANDLE OR USE YOUR FIREARM, SEEK SUPERVISED, PROFESSIONAL INSTRUCTION. DO NOT CONSUME ALCOHOL OR TAKE DRUGS BEFORE OR WHILE SHOOTING AS THIS CONSTITUTES CRIMINAL DISREGARD FOR YOUR SAFETY AND THAT OF OTHERS. NEVER USE A FIREARM WHILE YOU ARE TAKING MEDICATION UNLESS YOU HAVE CHECKED WITH YOUR DOCTOR TO ENSURE YOU ARE FIT TO HANDLE YOUR FIREARM SAFELY. DO NOT HORSEPLAY AROUND FIREARMS. DOING SO CAN RESULT IN INJURY OR DEATH. FOLLOW THE LAW. OBEY ALL LOCAL, STATE AND FEDERAL LAWS REGARDING STORAGE, SHOOTING AND TRANSPORTING YOUR SHS FIREARMS RIFLE OR PISTOL.**

# TERMS TO KNOW



# PRODUCT HIGHLIGHTS

**-FULLY CERAKOTED, RUST RESISTANT FINISH, ENSURING MAXIMUM PROTECTION FOR YOUR FIREARM**

**-SX-15 7075 T6 BILLET ALUMINUM LOWER RECEIVER DESIGNED FOR MAXIMUM DURABILITY AND EXTRA TIGHT FITMENT. ENJOY ABSOLUTELY ZERO PLAY BETWEEN THE UPPER AND LOWER RECEIVERS**

**-TIMBER CREEK OUTDOORS ENFORCER EXTENDED MAG RELEASE CREATES COMFORT AND EASE OF USE WHEN RAPIDLY CHANGING OUT MAGAZINES**

**-CARPENTER STEEL BCG FOR CONTINUED RELIABILITY. THE NUMBER ONE CAUSE CYCLING ISSUES LIES IN THE QUALITY OF YOUR BCG: AT SHS FIREARMS, WE SPARED NO EXPENSE IN THE LEGENDARY QUALITY OF OUR BOLT CARRIER GROUPS**

**\*NOTE: THESE ARE THE MINIMUM PRODUCT HIGHLIGHTS OF OUR BASE MODELS, UPGRADED MODELS MAY INCLUDE UPGRADED FEATURES\***

## FUNCTION OVERVIEW

**SHS FIREARMS RIFLES AND PISTOLS ARE GAS OPERATED SEMIAUTOMATIC FIREARMS. WHEN A ROUND IS FIRED, THE PRIMER IGNITES THE PROPELLANT IN THE ROUND. THE GAS PRESSURE FROM THE BURNING PROPELLANT PUSHES THE BULLET THROUGH THE BARREL OF THE RIFLE. STABILITY DURING THE FLIGHT TO THE TARGET IS OBTAINED BY THE ROTATION OF THE BULLET CAUSED BY THE RIFLING IN THE BARREL. ONCE THE BULLET NEARS THE END OF THE BARREL, THE GAS PRESSURE FROM THE BURNING PROPELLANT GOES THROUGH THE GAS PORT IN THE BARREL TO THE GAS KEY ON THE CARRIER AND FORCES THE CARRIER ASSEMBLY REARWARD. THIS ACTION EJECTS THE SPENT ROUND AND CHAMBERS A NEW ROUND.**

**SHS FIREARMS 9MM CARBINE RIFLES AND PISTOLS ARE BLOWBACK OPERATED PROVIDING THE SAME FUNCTIONALITY AS GAS OPERATED FIREARMS WITHOUT THE USE OF GAS TUBE, GAS BLOCK AND GAS KEY.**

# WARNING NOTICE

**ALL SHS FIREARMS UNDERGO STRICT INSPECTION AND FUNCTION TESTING PRIOR TO SHIPPING TO ANY DEALER, WHOLESALER OR END USER. SHS FIREARMS CANNOT CONTROL THE PRODUCT HANDLING AFTER IT HAS LEFT OUR FACILITY. AT THE TIME OF PURCHASE OR TRANSFER, CAREFULLY EXAMINE THE FIREARM TO ENSURE IT IS UNLOADED AND UNDAMAGED AND ALL COMPONENTS ARE INCLUDED. SEEK YOUR DEALER'S HELP FOR ASSISTANCE OR CONTACT OUR SUPPORT TEAM AT [SUPPORT@SHSFIREARMS.COM](mailto:SUPPORT@SHSFIREARMS.COM) FOR ANY QUESTIONS.**



# CLEARING YOUR RIFLE OR PISTOL

**WARNING!** ALWAYS HANDLE AND TREAT YOUR FIREARM AS IF IT IS LOADED! NEVER TAKE ANYONE'S WORD THAT IT IS UNLOADED. KEEP THE MUZZLE POINTED IN A SAFE DIRECTION.

TO CLEAR YOUR RIFLE OF LIVE AMMUNITION OR TO MAKE SURE IT IS UNLOADED, KEEP THE MUZZLE POINTED IN A SAFE DIRECTION WHILE PERFORMING THE FOLLOWING STEPS:

1. PLACE THE SAFETY SELECTOR TO THE "SAFE" POSITION (FIG. 1). NOTE: IF THE RIFLE IS NOT COCKED, THE SAFETY SELECTOR CANNOT BE MOVED TO THE "SAFE" POSITION AND PROCEED TO STEP 2.
2. PRESS THE MAGAZINE CATCH BUTTON AND PULL THE MAGAZINE DOWN AND OUT OF THE RIFLE (FIG. 2).
3. LOCK THE BOLT OPEN BY PULLING THE CHARGING HANDLE REARWARD. PRESS THE BOTTOM OF THE BOLT CATCH AND SLOWLY RELEASE THE CHARGING HANDLE UNTIL IT CATCHES THE BOLT (FIG 3). IF THE SAFETY SELECTOR WAS NOT PUT IN THE "SAFE" POSITION IN STEP 1, DO SO AT THIS TIME.

FOR REFERENCE REGARDING THE TERMS USED ON THIS PAGE SUCH AS, SAFETY SELECTOR, CHARGE HANDLE, MAGAZINE CATCH AND BOLT CATCH, PLEASE SEE PAGE 5 OF THIS USER MANUAL.

ALWAYS CLEAN AND LUBRICATE A NEW RIFLE BEFORE FIRING USING A HIGH QUALITY BORE SOLVENT AND HIGH QUALITY OIL BASED LUBRICANT

FIG. 1



FIG. 2



FIG. 3



# SAFETY SELECTOR FUNCTION AND CHECK

**WARNING!** ALWAYS KEEP THE MUZZLE POINTED IN A SAFE DIRECTION.

THE SAFETY SELECTOR IS LOCATED ON THE LEFT SIDE OF THE LOWER RECEIVER AND HAS TWO POSITIONS: “FIRE” AND “SAFE”. THE SAFETY SELECTOR POSITION IS ALSO VISIBLE FROM THE RIGHT SIDE OF THE LOWER RECEIVER AND FEATURES A WITNESS MARK POINTING TO THE “FIRE” AND “SAFE” ENGRAVINGS.

NOTE: IF THE RIFLE IS NOT COCKED, THE SAFETY SELECTOR CANNOT BE MOVED TO THE SAFE POSITION. HOWEVER, WITH THE BOLT CARRIER LOCKED IN THE REARWARD POSITION, THE SAFETY SELECTOR CAN BE MOVED TO EITHER POSITION.

WITH THE SAFETY SELECTOR IN THE HORIZONTAL POSITION ON THE LEFT SIDE AND POINTING TO “SAFE” THE FIREARM IS IN THE SAFE POSITION (FIG. 4). ON THE RIGHT SIDE OF THE LOWER RECEIVER THE WITNESS MARK WILL BE POINTING TO “SAFE” (FIG. 5). IN THIS POSITION A CAM BEARS ON THE TRIGGER BLOCKING THE MOVEMENT AND PREVENTS THE HAMMER FROM BEING RELEASED.

FOR REFERENCE REGARDING THE TERMS USED ON THIS PAGE SUCH AS, ‘SAFETY SELECTOR’, PLEASE SEE PAGE 5 OF THIS USER MANUAL.

**FIG. 4**



**FIG. 5**



**WITH THE SAFETY SELECTOR IN THE VERTICAL POSITION AND POINTING TO “FIRE” ON THE LEFT SIDE OF THE LOWER RECEIVER, THE FIREARM WILL FIRE A SINGLE SHOT EACH TIME THE TRIGGER IS PULLED (FIG. 6). IN THE FIRE POSITION THE WITNESS MARK WILL POINT TO THE “FIRE” MARK ON THE RIGHT SIDE OF THE RECEIVER (FIG. 7).**

**ALWAYS POSITION THE SAFETY SELECTOR TO THE SAFE POSITION WHEN LOADING AND UNLOADING YOUR RIFLE!**

**FIG. 6**



**FIG. 7**



# **SAFETY SELECTOR FUNCTION TEST**

**WARNING!** MAKE SURE THE MAGAZINE HAS BEEN REMOVED AND THE CHAMBER IS CLEAR BEFORE PERFORMING THE SAFETY SELECTOR FUNCTION TEST. KEEP MUZZLE POINTED IN A SAFE DIRECTION.

**1. PULL THE CHARGING HANDLE TO THE REAR AND RELEASE. PLACE THE SAFETY SELECTOR TO THE “SAFE” POSITION (FIG. 4). PULL THE TRIGGER. THE HAMMER SHOULD NOT FALL.**

**2. MOVE THE SAFETY SELECTOR TO THE “FIRE” POSITION (FIG. 6). PULL THE TRIGGER. THE HAMMER SHOULD FALL.**

**3. HOLD THE TRIGGER TO THE REAR. PULL THE CHARGING HANDLE TO THE REAR AND RELEASE. RELEASE THE TRIGGER WITH A SLOW AND SMOOTH MOTION UNTIL THE TRIGGER IS FULLY FORWARD. NOTE: AN AUDIBLE CLICK SHOULD BE HEARD. THE HAMMER SHOULD NOT FALL.**

**4. WITH THE HAMMER IN THE FORWARD POSITION (FIRED POSITION), ATTEMPT TO PLACE THE SAFETY SELECTOR TO THE “SAFE” POSITION. THE SAFETY SELECTOR SHOULD NOT BE ABLE TO MOVE TO THE “SAFE” POSITION WITH THUMB PRESSURE.**

**IF THE RIFLE OR PISTOL FAILS ANY OF THE ABOVE TESTS; DO NOT USE THE RIFLE AND HAVE IT SERVICED.**

# AMMUNITION

**WARNING!** DISCHARGING FIREARMS IN POORLY VENTILATED AREAS, CLEANING FIREARMS, OR HANDLING AMMUNITION MAY RESULT IN EXPOSURE TO LEAD AND OTHER SUBSTANCES THAT MAY CAUSE BIRTH DEFECTS, REPRODUCTIVE HARM, AND OTHER SERIOUS PHYSICAL INJURY. HAVE ADEQUATE VENTILATION AT ALL TIMES. WASH YOUR HANDS THOROUGHLY AFTER EXPOSURE. SHOOTING OR CLEANING GUNS MAY EXPOSE YOU TO LEAD. USE ONLY HIGH QUALITY COMMERCIALY MANUFACTURED AMMUNITION IN GOOD CONDITION OF THE APPROPRIATE CALIBER. THE CALIBER OF YOUR RIFLE IS MARKED ON THE BARREL. NOT ALL AMMUNITION PRODUCES THE SAME RESULT. SHS FIREARMS RECOMMENDS THAT ONCE YOU FIND A BRAND THAT FUNCTIONS WELL, KEEP USING IT. SHS FIREARMS DOES NOT RECOMMEND USING HAND LOADS OR REMANUFACTURED AMMUNITION AND THE USE OF THIS AMMUNITION WILL VOID THE WARRANTY.

# LOADING YOUR RIFLE OR PISTOL

**WARNING!** ALWAYS CHECK THAT THE AMMUNITION IS CLEAN AND UNDAMAGED. FORCING DAMAGED AMMUNITION INTO THE CHAMBER COULD RESULT IN INJURY, DEATH, DAMAGE TO PROPERTY, AND/OR DAMAGE TO YOUR RIFLE.

**1. LOAD THE MAGAZINE. USING ONLY HIGH QUALITY COMMERCIAL AMMUNITION; LOAD THE MAGAZINE. WITH THE FRONT OF THE MAGAZINE FORWARD (FIG. 8), PLACE A ROUND BETWEEN THE MAGAZINE LIPS WITH THE ROUND POINTED FORWARD. PUSH THE ROUND DOWN INTO THE MAGAZINE UNTIL IT IS RETAINED BY THE MAGAZINE LIPS. PLACE THE NEXT ROUND ON TOP OF THE PREVIOUS ROUND AND PRESS DOWN AGAIN. REPEAT UNTIL THE DESIRED NUMBER OF ROUNDS ARE LOADED.**

**2. LOAD THE RIFLE. WITH THE BOLT IN THE CLOSED POSITION AND THE SAFETY SELECTOR ON “SAFE”, INSERT THE LOADED MAGAZINE INTO THE MAGAZINE WELL AND PUSH IT UP UNTIL IT IS RETAINED BY THE MAGAZINE CATCH. TAP THE BOTTOM OF THE MAGAZINE TO ENSURE THAT IT IS SEATED PROPERLY (FIG. 9). PULL THE CHARGING HANDLE REARWARD AND RELEASE AND THIS WILL CHAMBER A ROUND. THE RIFLE CAN ALSO BE LOADED WITH THE BOLT IN THE REAR POSITION. PULL THE CHARGING HANDLE REARWARD AND HOLD; DEPRESS THE BOTTOM OF THE BOLT RELEASE LEVER AND THEN SLOWLY RELEASE THE CHARGING HANDLE UNTIL IT CATCHES THE BOLT RELEASE LEVER (FIG. 10). PUT THE SAFETY SELECTOR TO THE “SAFE” POSITION. INSERT THE LOADED MAGAZINE INTO THE MAGAZINE WELL AND PUSH IT UP UNTIL IT IS RETAINED BY THE MAGAZINE CATCH. TAP THE BOTTOM OF THE MAGAZINE TO ENSURE IT IS PROPERLY SEATED. PRESS THE TOP OF THE BOLT RELEASE LEVER AND THE BOLT WILL CLOSE AND CHAMBER A ROUND.**

FIG. 8



FIG. 9



FIG. 10



# FIRING YOUR RIFLE

**WARNING! DO NOT CHAMBER A ROUND UNTIL YOU ARE READY TO FIRE THE RIFLE. ALWAYS KEEP THE MUZZLE POINTED IN A SAFE DIRECTION. DO NOT DISENGAGE THE SAFETY UNTIL YOU ARE READY TO FIRE. ALWAYS WEAR EYE AND HEARING PROTECTION WHEN FIRING YOUR RIFLE.**

- 1. WITH THE RIFLE LOADED AND SAFETY SELECTOR ON “SAFE,” FIRMLY POSITION THE BUTT-STOCK TO YOUR SHOULDER WITH ONE HAND ON THE HANDGUARD AND THE OTHER HAND ON THE PISTOL GRIP WITH THE TRIGGER FINGER ALONG SIDE THE TRIGGER GUARD. DO NOT PUT YOUR FINGER ON THE TRIGGER AT THIS TIME.**
- 2. AIM BY ALIGNING THE FRONT AND REAR SIGHTS TO THE TARGET. 3. MOVE THE SAFETY SELECTOR TO THE “FIRE” POSITION (FIG. 11). 4. GENTLY PULL THE TRIGGER UNTIL THE HAMMER RELEASES AND THE RIFLE FIRES. RELEASE THE TRIGGER. THE SEMI-AUTOMATIC RIFLE WILL AUTOMATICALLY EJECT THE SPENT ROUND AND LOAD THE NEXT ROUND.**
- 3. MOVE THE SAFETY SELECTOR TO THE “FIRE” POSITION (FIG. 11).**
- 4. GENTLY PULL THE TRIGGER UNTIL THE HAMMER RELEASES AND THE RIFLE FIRES. RELEASE THE TRIGGER. THE SEMI-AUTOMATIC RIFLE WILL AUTOMATICALLY EJECT THE SPENT ROUND AND LOAD THE NEXT ROUND FROM THE MAGAZINE INTO THE CHAMBER. REPEAT PULLING THE TRIGGER AND RELEASING TO FIRE THE NEXT ROUND AND SUBSEQUENT ROUNDS. THIS CAN BE CONTINUED UNTIL THE MAGAZINE IS EMPTY.**
- 5. WHEN FINISHED FIRING, REMOVE THE FINGER FROM THE TRIGGER AND MOVE THE SAFETY SELECTOR TO THE “SAFE” POSITION. AFTER THE LAST ROUND IS FIRED FROM THE MAGAZINE, THE BOLT CARRIER WILL LOCK IN THE REAR POSITION.**
- 6. THE EMPTY MAGAZINE CAN BE REMOVED BY PUSHING THE MAGAZINE RELEASE BUTTON. TO CONTINUE THE FIRING SEQUENCE, INSERT ANOTHER LOADED MAGAZINE, RELEASE THE BOLT CATCH AND A NEW ROUND WILL BE CHAMBERED.**

FIG. 11



# RIFLE DISASSEMBLY

**WARNING: MAKE SURE YOUR RIFLE IS UNLOADED BEFORE STARTING DISASSEMBLY!**

FOR LUBRICATION INSTRUCTIONS, FOLLOW STEPS 1-8. IF YOUR RIFLE IS DIRTY, DAMAGED OR WET, FOLLOW ALL 11 STEPS.

1. MAKE SURE BOLT CARRIER IS CLOSED IN THE FORWARD POSITION. PUSH THE REAR TAKEDOWN PIN FROM THE LEFT SIDE OF THE RECEIVER AS FAR AS IT WILL GO TO THE RIGHT (FIG. 16). PIVOT THE UPPER RECEIVER FROM THE LOWER RECEIVER.

2. PUSH THE FRONT TAKEDOWN PIN FROM THE LEFT SIDE OF THE RECEIVER AS FAR AS IT WILL GO TO THE RIGHT. SEPARATE THE UPPER AND LOWER RECEIVER ASSEMBLIES. (FIG. 17 & FIG. 18).

3. WITH THE UPPER RECEIVER IN THE UPSIDE DOWN POSITION, PULL THE CHARGING HANDLE AND BOLT CARRIER OUT AND REMOVE BOLT CARRIER AND BOLT ASSEMBLY (FIG. 19 & 20). THEN REMOVE THE CHARGING HANDLE (FIG. 21).

FIG. 16



FIG. 17



FIG. 18



FIG. 19

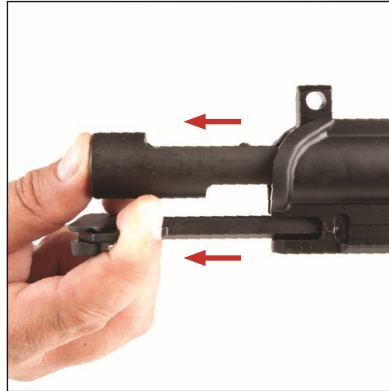


FIG. 20

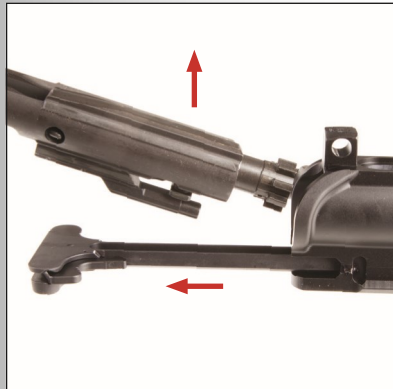
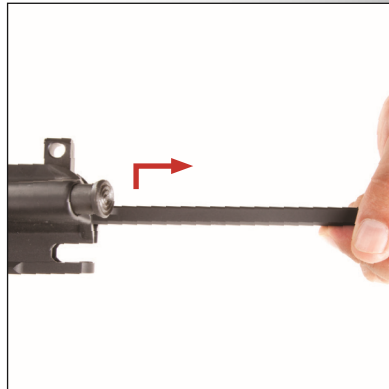


FIG. 21





**4. REMOVE THE FIRING PIN RETAINING PIN FROM THE BOLT CARRIER (FIG. 22). BE CAREFUL TO NOT OPEN OR CLOSE THE SPLIT END OF THE RETAINING PIN AND NEVER SUBSTITUTE A COMMON COTTER PIN FOR THIS PART.**

**5. REMOVE THE FIRING PIN FROM THE REAR OF THE BOLT CARRIER (FIG. 23).**

**6. PUSH THE BOLT TO THE CLOSED AND LOCKED POSITION (FIG. 24).**

**7. ROTATE THE CAM PIN ¼ TURN AND LIFT OUT OF THE BOLT CARRIER (FIG. 25).**

**8. PULL THE BOLT ASSEMBLY STRAIGHT OUT FROM THE BOLT CARRIER (FIG. 26).**

**9. WITH A PUNCH, REMOVE THE EXTRACTOR PIN (FIG. 27).**

**10. REMOVE EXTRACTOR, EXTRACTOR SPRING, BLACK INSERT, AND BLACK O-RING (FIG. 28 & 29).**

**11. MAKE SURE THE HAMMER IS IN THE COCKED POSITION THEN DEPRESS THE BUFFER RETAINER PIN WITH A PUNCH (FIG. 30). REMOVE THE BUFFER AND ACTION SPRING FROM THE LOWER RECEIVER.**

**IF ANY FURTHER DISASSEMBLY IS REQUIRED, IT SHOULD BE DONE BY A QUALIFIED GUNSMITH.**

FIG.22



FIG. 23



FIG. 24



FIG. 25



FIG. 26



FIG. 27

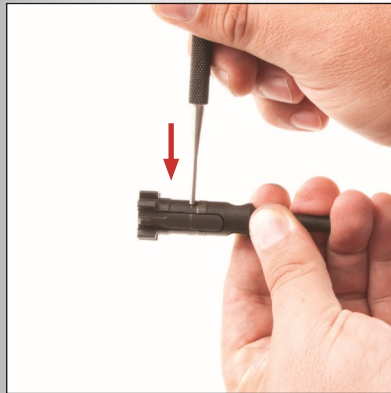


FIG. 28



FIG. 29



FIG. 30



## CLEANING AND LUBRICATION

### **WARNING!**

**ALWAYS KEEP THE MUZZLE POINTED IN A SAFE DIRECTION!**

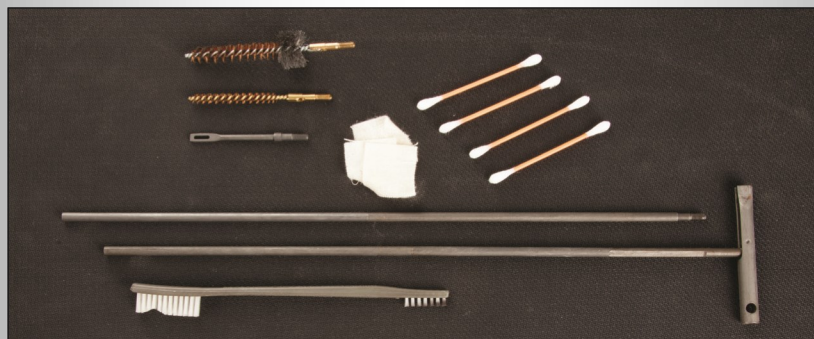
### **WHEN TO CLEAN**

**ALWAYS CHECK THAT THE BARREL IS CLEAN AND DRY BEFORE FIRING YOUR RIFLE. AFTER FIRING YOUR RIFLE, CLEAN IT AS SOON AS POSSIBLE TO PREVENT CORROSION AND MAKE THE JOB EASIER. IF YOUR FIREARM GETS WET, CLEAN IT AS SOON AS POSSIBLE. WHEN YOUR RIFLE HAS NOT BEEN FIRED, CLEAN IT ONCE OR TWICE A YEAR IN A DRY CLIMATE. IN A TROPICAL CLIMATE YOUR RIFLE SHOULD BE CLEANED EVERY WEEK.**

### **MATERIALS REQUIRED:**

**THE FOLLOWING ITEMS ARE RECOMMENDED FOR PROPER MAINTENANCE OF YOUR RIFLE: A HIGH QUALITY CLEANING KIT THAT INCLUDES A CLEANING ROD, BRASS BRISTLE BORE BRUSH AND CHAMBER BRUSH, SWAB HOLDER AND COTTON PATCHES. OTHER ITEMS INCLUDE A SMALL TOOTH BRUSH, A GOOD QUALITY GUN OIL/CLEANER/PRESERVATIVE, AND COTTON SWABS.**

### **MATERIALS REQUIRED**



## CLEANING PROCEDURE

1. CLEAN THE BARREL BORE AND CHAMBER. ALWAYS CLEAN FROM THE CHAMBER END TO THE MUZZLE. IF THE GUN HAS NOT BEEN FIRED, ATTACH A COTTON PATCH TO THE CLEANING ROD, INSERT IT IN THE CHAMBER AND PASS IT THROUGH THE BORE. CONTINUE THIS PROCEDURE UNTIL THE PATCH COMES OUT CLEAN. IF THE GUN HAS BEEN FIRED, ATTACH A BRASS BRISTLE BORE BRUSH TO THE CLEANING ROD AND DIP THE BRUSH IN GUNCLEANING SOLUTION AND THOROUGHLY SCRUB OUT THE BARREL (FIG. 31). MAKE SURE TO GO ALL THE WAY THROUGH THE BARREL AND OUT THE MUZZLE END BEFORE REVERSING DIRECTION. NEVER REVERSE THE DIRECTION OF THE BORE BRUSH WHILE IT IS IN THE BORE. ATTACH THE CHAMBER BRUSH TO THE CLEANING ROD, DIP THE BRUSH IN BORE CLEANING SOLUTION AND CLEAN THE CHAMBER (FIG. 32). USE A MINIMUM OF 5 PLUNGE STROKES AND 3 ROTATIONAL STROKES OF 360 DEGREES. THEN SWAB OUT BORE AND CHAMBER WITH A COTTON PATCH ON THE CLEANING ROD.

FIG. 31

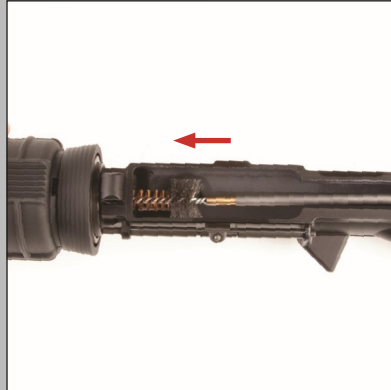


FIG. 32



2. WITH THE BORE BRUSH STILL WET WITH GUN CLEANING SOLUTION, CLEAN THE CARBON AND POWDER RESIDUE AROUND THE GAS TUBE IN THE UPPER RECEIVER, BOLT LOCKING LUGS, BOLT RINGS, FIRING PIN, BOLT CAM PIN, LIP OF THE EXTRACTOR, AND INSIDE THE BOLT CARRIER FROM BOTH THE FRONT AND REAR.

3. WIPE ALL COMPONENTS CLEAN AND DRY AND INSPECT FOR ANY MECHANICAL DAMAGE, EXCESSIVE WEAR AND/OR CORROSION.

4. CLEAN OUT THE GAS KEY AND CARRIER VENT HOLES WITH A COTTON SWAB (FIG. 33).

FIG. 33



5. CLEAN THE LOWER RECEIVER. NEVER USE A WIRE BRUSH OR ANY ABRASIVE TO CLEAN THE ALUMINUM LOWER OR UPPER RECEIVER. CLEAN THE TRIGGER MECHANISM, MAGAZINE RELEASE BUTTON, THE CAVITY OF THE MAGAZINE CATCH ON THE LEFT SIDE OF THE RECEIVER, BOLT CATCH, TAKEDOWN PINS, BUFFER, ACTION SPRING, AND INSIDE OF THE BUFFER TUBE.

6. CLEAN THE BUTTSTOCK AS NECESSARY. THE 6-POSITION ADJUSTABLE STOCK CAN BE DISASSEMBLED BY PULLING DOWN THE ADJUSTMENT TRIGGER AND PULLING THE STOCK OFF (FIG 34). CLEAN THE 6-POSITION LOCK HOLES AND LIGHTLY LUBRICATE THE RECEIVER EXTENSION AND STOCK TRIGGER. REASSEMBLE STOCK.

FIG. 34



## **IMPORTANT PART INSPECTION**

- 1. CHECK THE BOLT FOR CRACKS OR FRACTURES, ESPECIALLY IN THE CAM PIN HOLE AREA. INSPECT FOR BOLT FACE PITTING. ANY PITTING EXTENDING INTO THE FIRING PIN HOLE SHOULD BE REPLACED.**
- 2. CHECK THE CAM PIN FOR CRACKS OR CHIPS. REPLACE IF ANY CRACKS OR CHIPS ARE FOUND.**
- 3. CHECK THE FIRING PIN. IF BENT, CRACKED OR BLUNTED, REPLACE IT.**
- 4. CHECK THE FIRING PIN RETAINING PIN. REPLACE IF IT IS BENT OR SEVERELY WORN. NEVER SUBSTITUTE A "COTTER PIN" AS THEIR ROUND SHAPED HEAD WILL CAUSE DAMAGE.**

## **LUBRICATION**

- 1. LIGHTLY LUBRICATE THE INSIDE OF THE UPPER RECEIVER, THE OUTER SURFACES OF THE BARREL, FRONT SIGHT SURFACES, REAR SIGHT WINDAGE KNOB AND ELEVATION DIAL, EJECTION PORT COVER LATCH AND SPRING, AROUND THE LOCKING LUGS AND THE FORWARD ASSIST. DEPRESS THE FRONT SIGHT DETENT AND APPLY 2 OR 3 DROPS OF OIL.**
- 2. LIGHTLY LUBRICATE THE INSIDE OF THE BUFFER TUBE, THE BUFFER, AND ACTION SPRING.**
- 3. GENEROUSLY LUBRICATE THE TRIGGER, HAMMER, SAFETY, BOLT CATCH, MAGAZINE RELEASE, AND TAKEDOWN PINS.**
- 4. LIGHTLY LUBRICATE THE FIRING PIN, THE CHARGING HANDLE AND LATCH SPRING, BOLT CARRIER, EXTRACTOR, AND EXTRACTOR PIN.**
- 5. GENEROUSLY LUBRICATE THE BOLT, THE CAM PIN HOLE, AND THE GAS RINGS.**

# RIFEL ASSEMBLY

- 1. INSTALL THE BUFFER INTO THE ACTION SPRING. DEPRESS THE BUFFER DETENT AND PUSH THE BUFFER PAST THE DETENT, THEN RELEASE THE DETENT (FIG. 35).**
- 2. INSTALL EXTRACTOR AND SPRING TO THE BOLT. NOTE: EXTRACTOR ASSEMBLY HAS A RUBBER INSERT WITHIN THE SPRING AND AN O-RING AROUND THE SPRING. IF THE SPRING COMES LOOSE, PUT THE LARGE END OF THE SPRING IN THE EXTRACTOR AND SEAT IT WITH A PUNCH OR DUMMY BULLET. PUSH DOWN ON THE EXTRACTOR TO DEPRESS THE SPRING AND INSTALL EXTRACTOR PIN (FIG. 36).**
- 3. ON THE BOLT, STAGGER THE GAS RING GAPS SO THE GAPS ARE NOT IN ALIGNMENT WITH EACH OTHER TO PREVENT GAS PRESSURE LOSS (FIG. 37).**
- 4. INSERT THE BOLT INTO THE BOLT CARRIER (FIG. 38).**
- 5. INSERT THE CAM PIN (FIG. 39). NOTE: THE CAM PIN CAN ONLY BE INSTALLED IN THE BOLT FROM ONE SIDE, IF THE CAM PIN DOES NOT FIT, ROTATE THE BOLT 180° AND TRY AGAIN.**
- 6. ONCE THE CAM PIN IS INSTALLED, ROTATE IT 90° TO ALLOW FIRING PIN INSTALLATION.**
- 7. INSTALL THE FIRING PIN (FIG. 40)**
- 8. PULL THE BOLT OUT (FIG. 41). INSTALL THE FIRING PIN RETAINING PIN (FIG. 42).**
- 9. INSERT THE CHARGING HANDLE INTO THE UPPER RECEIVER AND LOWER THE HANDLE UNTIL THE SIDE TABS ON THE FRONT END OF THE HANDLE FIT INTO THE CUTOUTS IN THE RECEIVER (FIG. 43). SLIDE THE CHARGING HANDLE PARTIALLY INTO THE RECEIVER.**
- 10. INSERT THE BOLT CARRIER GROUP INTO THE UPPER RECEIVER SO THAT THE GAS KEY FITS INTO THE GROOVE OF THE CHARGING HANDLE (FIG. 44).  
*NOTE: THE BOLT MUST BE IN THE OUT POSITION IN THE CARRIER FOR INSTALLATION.***
- 11. PUSH THE BOLT CARRIER ASSEMBLY AND CHARGING HANDLE ALL THE WAY INTO THE UPPER RECEIVER UNTIL THE CHARGING HANDLE LATCH LOCKS ONTO THE RECEIVER (FIG. 45).**
- 12. MATE THE UPPER RECEIVER TO THE LOWER RECEIVER. POSITION THE PIVOTPIN LUG OF THE UPPER RECEIVER INTO THE SLOT AT THE FRONT OF THE LOWER RECEIVER AND PUSH THE PIVOT PIN INTO PLACE (FIG. 46).**
- 13. MAKE SURE THE SAFETY SELECTOR IS IN THE “SAFE” POSITION BEFORE PIVOTING THE UPPER RECEIVER DOWN TO THE LOWER RECEIVER. AFTER THE RECEIVERS ARE CLOSED, PUSH IN THE REAR TAKEDOWN PIN.**

Fig. 35



FIG. 37

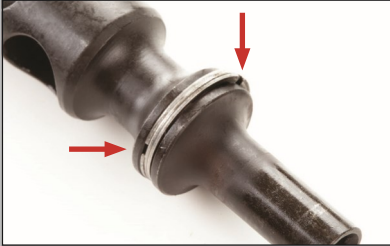


FIG. 39



FIG. 41

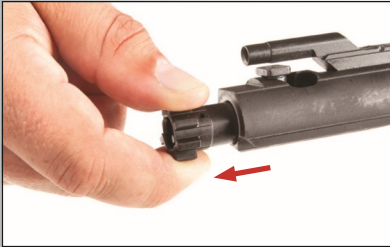


FIG. 43

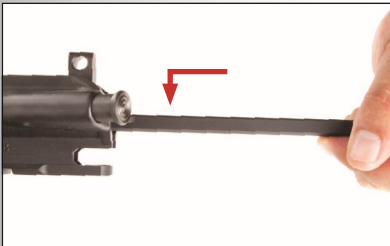


FIG. 45

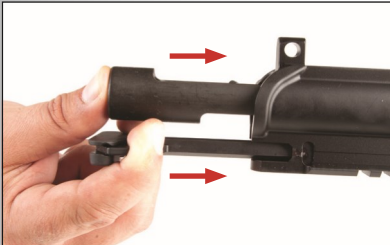


Fig. 36



FIG. 38

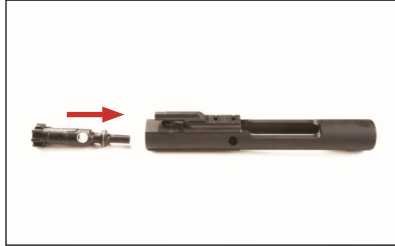


FIG. 40



FIG. 42

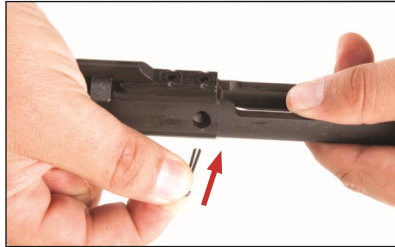


FIG. 44

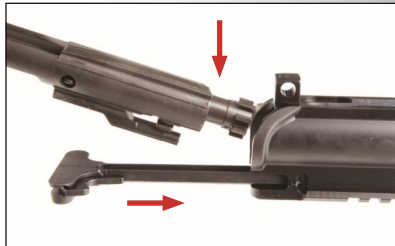


FIG. 46



## **UPPER RECEIVER ASSEMBLY**

## **UPPER RECEIVER PARTS LIST**

- 1. STRIPPED UPPER RECEIVER**
- 2. CHARGING HANDLE**
- 3. FORWARD ASSIST**
- 4. EJECTION PORT COVER**
- 5. CHARGING HANDLE LATCH**
- 6. CHARGING HANDLE LATCH SPRING**
- 7. CHARGING HANDLE LATCH ROLL PIN**
- 8. FORWARD ASSIST SPRING**
- 9. FORWARD ASSIST SPRING PIN**
- 10. EJECTION PORT COVER SPRING**
- 11. EJECTION PORT COVER PIN**
- 12. EJECTION PORT COVER PIN RETAINING RING**

## **BARREL ASSEMBLY**

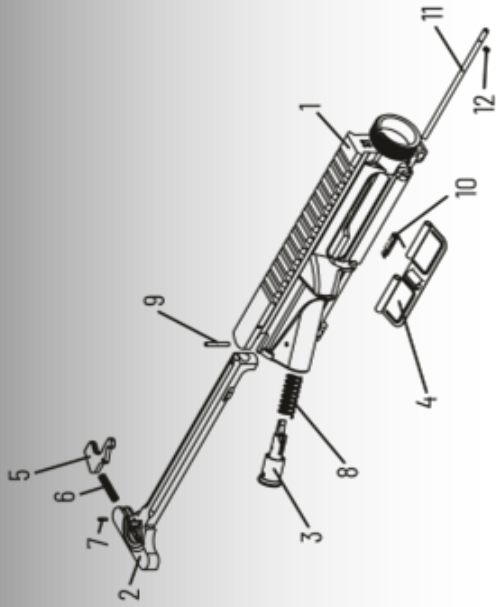
- 1. STRIPPED BARREL**
- 2. HANDGUARD**
- 3. FRONT SIGHT (WHERE APPLICABLE)**
- 4. MUZZLE DEVICE**
- 5. GAS TUBE**
- 6. BARREL NUT**
- 7. BARREL INDEXING PIN**
- 8. DELTA RING (WHERE APPLICABLE)**
- 9. WELD SPRING (WHERE APPLICABLE)**
- 10. HANDGUARD SNAP RING (WHERE APPLICABLE)**
- 11. GAS TUBE ROLL PIN**
- 12. FRONT SIGHT SWIVEL RIVET (WHERE APPLICABLE)**
- 13. FRONT SIGHT TAPER PINS (WHERE APPLICABLE)**
- 14. FRONT SIGHT SLING SWIVEL (WHERE APPLICABLE)**
- 15. FRONT SIGHT DETENT SPRING (WHERE APPLICABLE)**
- 16. FRONT SIGHT DETENT (WHERE APPLICABLE)**
- 17. FRONT SIGHT POST (WHERE APPLICABLE)**
- 18. CRUSH WASHER**
- 19. HANDGUARD CAP (WHERE APPLICABLE)**

## **BOLT CARRIER GROUP**

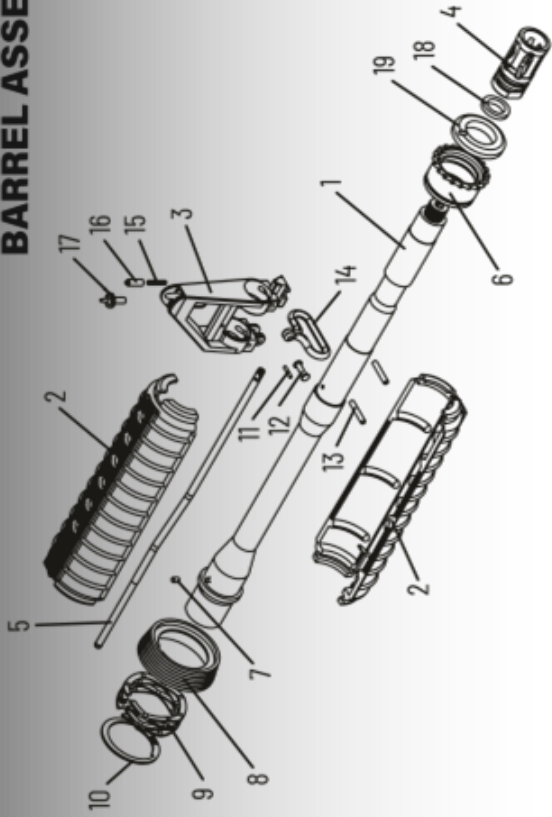
- 1. BOLT CARRIER**
- 2. BOLT**
- 3. FIRING PIN**
- 4. BOLT CARRIER KEY**
- 5. EJECTOR**
- 6. EJECTOR SPRING**
- 7. EJECTOR ROLL PIN**
- 8. EXTRACTOR PIN**
- 9. EXTRACTOR**
- 10. EXTRACTOR SPRING AND INSERT**
- 11. GAS RINGS**
- 12. CAM PIN**
- 13. FIRING PIN RETAINING PIN**
- 14. BOLD CARRIER KEY SCREW (X2)**



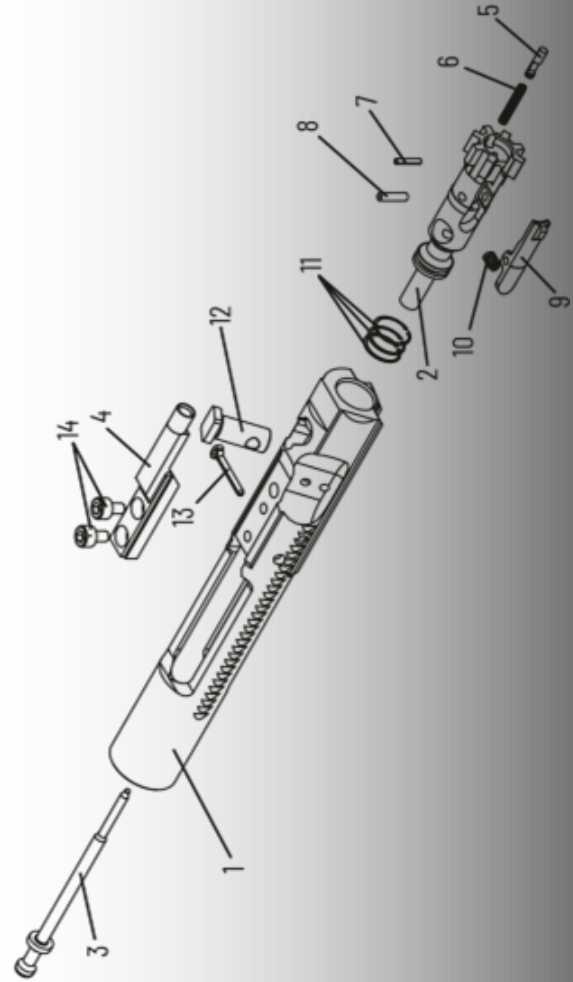
**UPPER RECEIVER ASSEMBLY**



**BARREL ASSEMBLY**



**BOLT CARRIER GROUP**

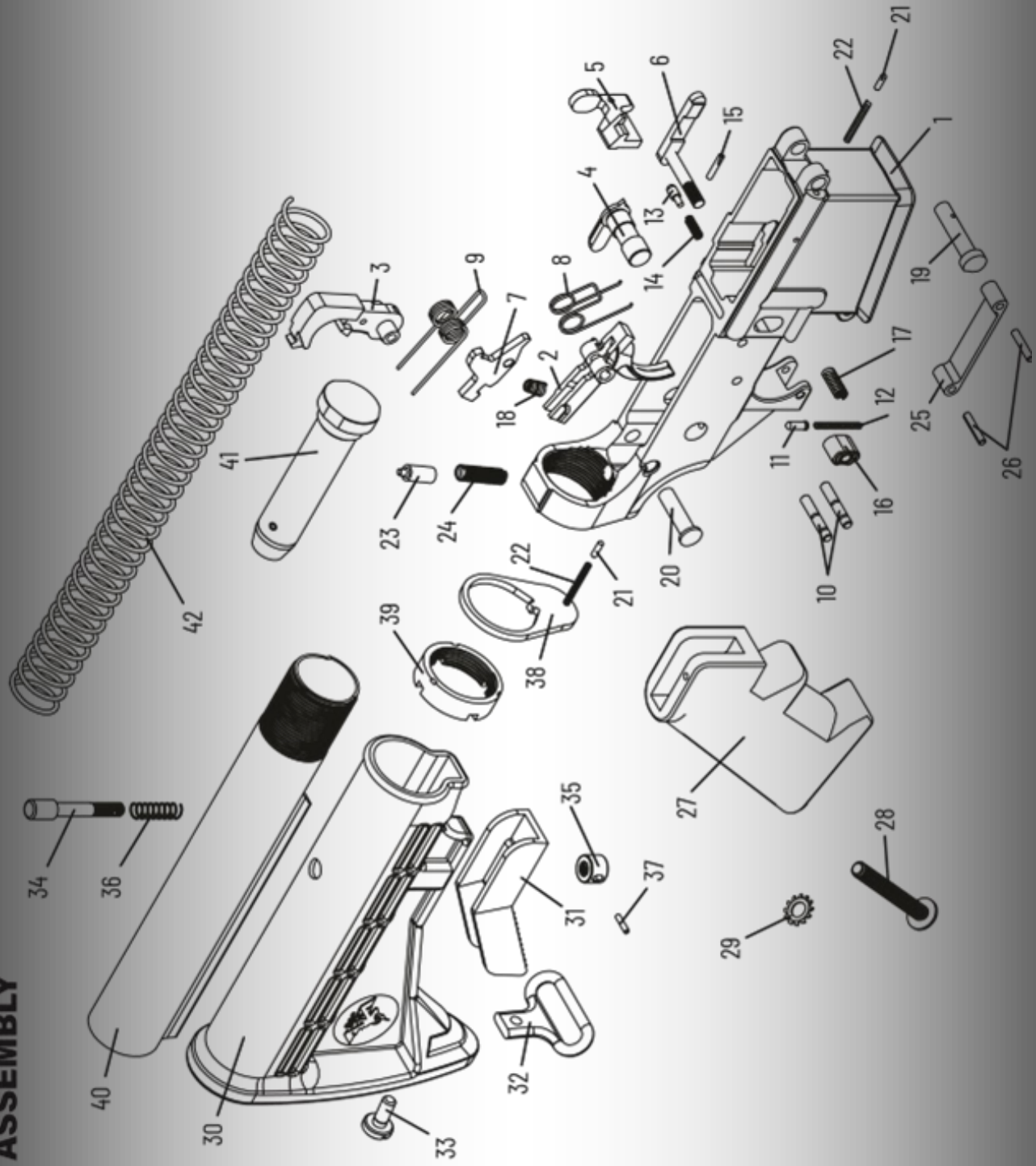


## **LOWER RECEIVER PARTS LIST**

- 1. STRIPPED LOWER RECEIVER**
- 2. TRIGGER**
- 3. HAMMER**
- 4. SELECTOR**
- 5. BOLT CATCH**
- 6. MAG CATCH**
- 7. DISCONNECTOR**
- 8. TRIGGER SPRING**
- 9. HAMMER SPRING**
- 10. TRIGGER HAMMER PIN (X2)**
- 11. SELECTOR DETENT**
- 12. SELECTOR SPRING**
- 13. BOLT CATCH DETENT**
- 14. BOLT CATCH SPRING**
- 15. BOLT CATCH ROLL PIN**
- 16. MAG CATCH BUTTON**
- 17. MAG CATCH SPRING**
- 18. DISCONNECTOR SPRING**
- 19. FRONT PIVOT PIN**
- 20. TAKEDOWN PIN**
- 21. TAKEDOWN DETENT**
- 22. TAKEDOWN DETENT SPRING**
- 23. BUFFER DETENT**
- 24. BUFFER DETENT SPRING**
- 25. TRIGGER GUARD (WHERE APPLICABLE)**
- 26. TRIGGER GUARD PIN (WHERE APPLICABLE)**
- 27. PISTOL GRIP**
- 28. PISTOL GRIP SCREW**
- 29. PISTOL GRIP LOCK WASHER (WHERE APPLICABLE)**
- 30. STOCK**
- 31. STOCK LEVER**
- 32. STOCK SWIVEL (WHERE APPLICABLE)**

- 21. TAKEDOWN DETENT**
- 22. TAKEDOWN DETENT SPRING**
- 23. BUFFER DETENT**
- 24. BUFFER DETENT SPRING**
- 25. TRIGGER GUARD (WHERE APPLICABLE)**
- 26. TRIGGER GUARD PIN (WHERE APPLICABLE)**
- 27. PISTOL GRIP**
- 28. PISTOL GRIP SCREW**
- 29. PISTOL GRIP LOCK WASHER (WHERE APPLICABLE)**
- 30. STOCK**
- 31. STOCK LEVER**
- 32. STOCK SWIVEL (WHERE APPLICABLE)**
- 33. STOCK SWIVEL SCREW (WHERE APPLICABLE)**
- 34. STOCK PLUNGER**
- 35. STOCK PLUNGER CAP**
- 36. STOCK PLUNGER SPRING**
- 37. STOCK PLUNGER CAP RETAINING PIN**
- 38. RECEIVER END PLATE**
- 39. CAR CASTLE NUT**
- 40. 6-POSITION BUFFER TUBE (MIL-SPEC)**
- 41. CAR BUFFER**
- 42. CAR BUFFER SPRING**

**LOWER RECEIVER ASSEMBLY**



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