

**MADE IN
USA**



SPEC ARMS LLC
SPECIALTY WEAPONS AND COMPONENTS



GUN OWNERS MANUAL

Firearm Record



Firearm Owner's Record

Model: _____

Serial #: _____

Date Purchased: _____

Purchased From: _____

Price Paid: _____

TM

THIS IS NOT A SAFETY MANUAL

***IF YOU NEED ANY
ASSISTANCE WITH THE
SAFE HANDLING OF ANY
OF YOUR FIREARMS,
PLEASE CONTACT A
CERTIFIED FIREARMS
INSTRUCTOR
OR SCHOOL***



Contents

Introduction	2
Safety Information	3
Safety Features	4
Your Spec Arms Rifle	5
Loading/Firing Instructions	7
Unloading/Reloading Instructions	9
Disassembly Instructions	10
Maintenance Instructions	13
Transportation, Storage & Service	16
Troubleshooting	19
Warranty Information	20



Introduction



Congratulations on the purchase of your very own Spec Arms firearm!

Your Spec Arms firearm is a powerful weapon in every sense of the word, that should be used with extreme caution. Please familiarize yourself with the following assembly, operating and safety information. Read this manual before using your firearm. Failure to follow these instructions could cause personal injury, property damage, or both. Save this manual for other users to read prior to them using your Spec Arms firearm. If you have any questions about or problems with your firearm please call our company number at 1-(616)-887-1714 and talk with our team. We are available to talk with you Monday through Friday from 8 a.m. to 4:30 p.m. E.S.T. We can help you with questions regarding operation, warranty or accessories. This Operating Manual covers all Spec Arms firearm models. They are gas operated, air-cooled, magazine-fed rifles that are Semi-Automatic in operating mode (i.e., a single round will fire each time the trigger is pulled). On all models, the Upper And Lower Receivers are easily opened for cleaning and inspection. Spec Arms AR Models are made from 7075 - T6 billet aluminum.

WARNING

**YOU MUST READ THROUGH THIS BOOKLET
BEFORE USING/FIRING THIS GUN**

Functions

How it Works

With the action cocked, chamber loaded, and selector lever set to if FIRE™ the firearm may be fired by squeezing the trigger. The trigger rotates, disengaging the trigger sear surface from the hammer. The hammer spring drives the hammer forward to strike the firing pin, which in turn strikes the primer in the base of the cartridge, igniting the primer composition which ignites the main powder charge. High pressure gases push the bullet down the barrel where rifling grooves impart a stabilizing spin to the bullet. As a bullet passes the gas port (a small hole in the barrel underneath the gas block) gas is tapped off and flows through the gas tube, into the chamber driving the bolt carrier group rearward. As the bolt carrier group moves to the rear the firing pin is withdrawn into the bolt while the cam track in the bolt carrier group acts upon the bolt cam pin, causing the bolt to rotate until its locking lugs are no longer in engagement with the lugs of the barrel extension. The bolt is now unlocked and is carried rearward by the bolt carrier group. The extractor extracts the spent case and holds it against the face or bolt until the ejector throws the spent case through the ejection port. The bolt carrier group continues rearward, compressing the action spring and returning the hammer to its cocked position, until the buffer assembly strikes the bottom of the receiver extension and stops. The action spring then forces the bolt carrier group forward so that the face of the bolt strips the next round of ammunition from the magazine and thrusts it into the chamber. Simultaneously the extractor snaps into the groove of a cartridge case and the bolt locks into the barrel. The hammer is now held rearward by the disconnect. When trigger is released, the disconnect is rotated back releasing the hammer. However, before the disconnect hook actually releases the hammer, the trigger sear surface has rotated in front of the hammer notch so that hammer is held on the trigger sear surface making the firearm ready for another shot. Also known as a trigger reset.

THIS IS A SEMI—AUTOMATIC FIREARM AND IS IMMEDIATELY LOADED AND IS READY TO FIRE AGAIN AFTER EACH SHOT UNTIL THE MAGAZINE IS EMPTY. TO UNLOAD THE RIFLE, THE MAGAZINE MUST BE REMOVED, AND THE BOLT CARRIER GROUP MUST BE PULLED TO THE REAR WITH THE CHARGING HANDLE, EXTRACTING ANY ROUND IN THE CHAMBER.

AMMUNITION SELECTION

Spec Arms weapons systems are designed to function with a variety of brands and types of factory manufactured ammunition in the appropriate caliber. Spec Arms also suggests that after you read and understand this manual, you go to the range and fire different ammunition which is appropriate to the caliber of your firearm and to the application which you are using it. To protect yourself and others from danger as well as your firearm from being severely damaged, Spec Arms does not recommend the use of any hand-loaded or re-manufactured ammunition.

CAUTION: NOT ALL AMMUNITION WILL PRODUCE THE SAME RESULTS. SPEC ARMS DOES NOT RECOMMEND THE USE OF STEEL-CASED AMMUNITION.

FORWARD ASSIST

The forward assist is intended to ensure the bolt is locked, but it will only be useful on rare occasions when the bolt fails to lock automatically. When you must use the forward assist, it is usually time for you to clean your firearm paying particular attention to the cleanliness of the chamber and bolt.

ADJUSTABLE BUTTSTOCK (where applicable on rifle)

A 6-position collapsible buttstock allows you to extend or shorten the buttstock. Press the rear end of the release lever up against the buttstock and slide the buttstock forward or backward and release the lever to lock the buttstock at the desired position.

Safety Information



SAFETY IS YOUR NUMBER ONE RESPONSIBILITY!

At home, in the field or at the range, the first concern of every firearm owner should be safety. Before handling any firearm, understand its operation and familiarize yourself with its mechanical features. If you feel uncertain about any operational aspects of your Spec Arms firearm, please contact Spec Arms at 1-(616) 887-1714, before proceeding with its operation. Never allow a firearm to be used by individuals who do not understand its safe operation or who have not read these firearm safety rules. As a firearm owner, you accept responsibility for your firearm. How serious you take this responsibility can be the difference between life and death. There is no excuse for careless or abusive handling of your firearm. At all times, handle your firearm with intense respect for its power and potential danger. Firearms are dangerous and can cause serious injury or death if they are used inappropriately. Accidents are the result of violating the rules of safe firearm handling and common sense. Contact your firearms dealer, law enforcement agency, local sportsman's club, etc. for firearm safety training availability.

Apply the following safety rules in every situation, with any kind of firearm:

ALWAYS KEEP YOUR FIREARM POINTED IN A SAFE DIRECTION.

Never point a firearm at anyone or anything you do not intend to shoot whether or not it is loaded. This is particularly important when loading, unloading, or field stripping the firearm. ALWAYS control the direction of the firearm.

ALWAYS TREAT EVERY FIREARM AS IF IT IS LOADED AND WILL FIRE.

Do not take anyone's word that the firearm is unloaded – always check for yourself. Never pass your firearm to another person until the chamber or action is open and you visually check that it is unloaded. Keep your firearm unloaded and safely stored when not in use.

NEVER PLACE YOUR FINGER INSIDE THE TRIGGER GUARD OR ON THE TRIGGER UNLESS YOU INTEND TO FIRE.

You should also take care to ensure that other objects do not touch the trigger.

ALWAYS BE SURE OF YOUR TARGET AND WHAT IS BEYOND IT.

Always be sure of where the bullet will strike and shoot only where there is a safe back stop. Be sure your bullet will stop behind your target. Do not fire randomly into the sky.

ALWAYS WEAR EYE AND EAR PROTECTORS SPECIFIED FOR USE WITH FIREARMS.

Wear eye and ear protection specified for use with firearms every time you discharge your firearm. Make sure others in the vicinity of where you will be shooting do so as well.

NEVER RELY ON MECHANICAL FEATURES OF THE FIREARM ALONE.

Only your safe firearm-handling habits will ensure the safe use of your firearm. This is your responsibility.

NEVER CROSS OBSTACLES SUCH AS FENCES OR STREAMS WITH A LOADED FIREARM.

Always make certain your firearm is unloaded before crossing a fence, climbing a tree, jumping a ditch or negotiating other obstacles.

NEVER USE ALCOHOL OR DRUGS BEFORE OR WHILE SHOOTING.

Further, do not use your firearm if you are on any medication which impairs, even slightly, your mental or physical ability.

ALWAYS HAVE ADEQUATE VENTILATION.

Discharging firearms in poorly ventilated areas, cleaning firearms, or handling ammunition may result in exposure to lead and other substances known to cause birth defects, reproductive harm, and other serious physical injury. Review the warnings and labels for all ammunition and cleaning products carefully. Wash hands thoroughly after exposure.

ALWAYS USE THE CORRECT AMMUNITION FOR YOUR PARTICULAR FIREARM.

Never use non-standard, reloaded, or "hand-loaded" ammunition which has not been subjected to internal ballistic pressure testing.

BEWARE OF BARREL OBSTRUCTIONS.

Be sure the barrel is clear of obstructions before shooting. Mud, water, snow or other objects may inadvertently lodge in the bore of the barrel. A small obstruction can cause a dangerous increase in pressure and may damage your firearm and cause injury to yourself and others.

BE SURE ALL ACCESSORIES, SUCH AS HOLSTERS, GRIPS, SLINGS, SCOPES AND OTHER ACCESSORIES ARE COMPATIBLE WITH YOUR PARTICULAR FIREARM AND THAT THE ACCESSORIES DO NOT INTERFERE.

It is your responsibility to understand and follow all of the instructions in the safety manual that accompanied the firearm.

NEVER DISASSEMBLE YOUR FIREARM BEYOND THE FIELD STRIPPING PROCEDURE OUTLINED IN THE MANUAL THAT ACCOMPANIED YOUR FIREARM.

Improper disassembly or reassembly of your firearm may be dangerous and can lead to serious injury or death.

NEVER MANIPULATE, ADJUST OR CHANGE ANY OF THE INTERNAL COMPONENTS OF YOUR FIREARM UNLESS SPECIFICALLY INSTRUCTED TO DO SO IN THE MANUAL THAT ACCOMPANIED YOUR FIREARM.

Improper manipulation of any other internal component may affect the safety and reliability of your firearm and may cause serious injury or death.

Safety Features



Trigger Guard

The Trigger Guard is a permanent metal strip below the trigger to protect it from damage and to help prevent accidental discharge. The Trigger Guard on the AR-15 features radiused and beveled edges to accommodate shooters wearing gloves.

Safety Selector Lever

The Safety Selector Lever is located on the left side of the lower receiver and has two positions, "FIRE" and "SAFE." When set to "FIRE," the firearm will discharge a single shot each time the trigger is squeezed without manually reloading. When set to "SAFE," a cam bears upon the rear portion of the trigger, blocking the sear surface of the trigger and preventing the hammer from being released.

***NOTE:** The safety featured on a Spec Arms AR is a mechanical safeguard. As with all mechanical systems, failures within this system are possible and may not be visible to the operator. ACTIVATING THE SAFETY SELECTOR LEVER TO THE "SAFE" POSITION DOES NOT MEAN THE FIREARM IS INCAPABLE OF FIRING IF MIS-HANDLED OR DROPPED.*

Bolt Locking Safety Features

This firearm can fire only when the bolt is fully locked to the barrel and the firing pin is free to move forward. The firing pin is prevented from reaching the cartridge by the bolt carrier. Only when the bolt carrier moves forward rotating into the bolt, rotating it to the fully locked position, can the firing pin move forward enough to fire the rifle. This design feature makes sure that the rifle will not fire before the cartridge is fully chambered and the bolt is fully rotated (locked) to the barrel.

Separation of Upper and Lower Receivers

In the event of functional problems, the lower receiver can be separated from the upper receiver by pivoting it downwards after pushing out the rear take down pin. This provides access to the mechanism and separates the firing mechanism from other components so that the cocked hammer can not strike the firing pin.

***NOTE:** The Bolt Carrier Group must be in the full forward position in order to separate the Upper Receiver from the Lower Receiver.*



Your Spec Arms Rifle

Standard AR (Right Side View)



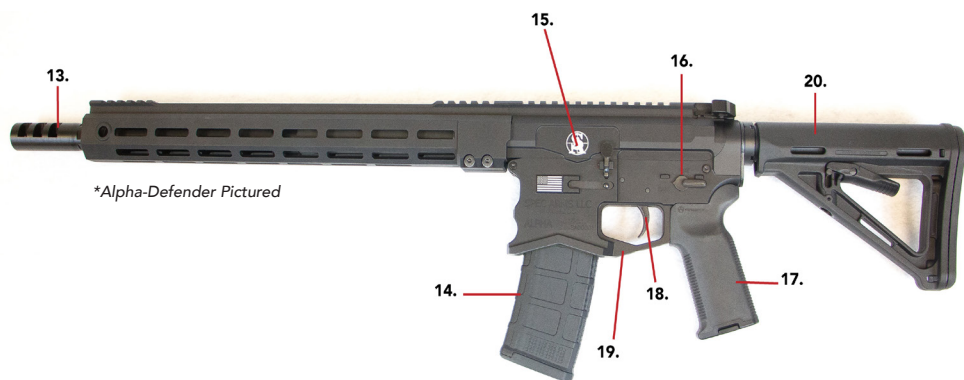
LIST OF COMPONENTS

- | | |
|-----------------------------|-------------------------------------|
| 1. Fixed Stock | 7. Dust Cover |
| 2. Charging Handle | 8. Oversized Grooved Magwell |
| 3. Forward Assist | 9. Front Pivot Pin |
| 4. Rear Takedown Pin | 10. Picatinny Rail |
| 5. Shell Deflector | 11. Free-Float Handguard |
| 6. Magazine Release | 12. Barrel |

Your Spec Arms Rifle



Standard AR (Left Side View)



LIST OF COMPONENTS

- | | |
|-----------------------------------|-----------------------------|
| 13. Muzzle Device | 17. Pistol Grip |
| 14. Magazine | 18. Trigger |
| 15. Bolt Release | 19. Trigger Guard |
| 16. Safety/Selector Switch | 20. Adjustable Stock |



Loading/Firing Instructions

TO LOAD THE FIREARM:

CAUTION: READ SAFETY INSTRUCTIONS (Page 4) - KEEP YOUR FIREARM POINTING IN A SAFE DIRECTION AND DO NOT TOUCH THE TRIGGER.

1. Remove empty magazine: depress magazine catch which is located on the right side of the lower receiver, and extract magazine from the magazine well.
2. Press in on bottom of thumb piece of bolt catch while grasping and pulling back on the charging handle, to cock the hammer and leave bolt and carrier latched open to the rear.

THE BOLT CARRIER GROUP BEING LATCHED OPEN IS NOT A SAFE CONDITION WHEN A LOADED MAGAZINE IS INSTALLED.

3. Return charging handle fully forward until it locks and remove finger from bolt catch.
4. Set selector lever (located on left of lower receiver) to "SAFE", this will lock the trigger.
5. With bullet points forward, insert the loaded magazine into the magazine well and push it home until it stops and is locked by the magazine catch. When the magazine is inserted, pull down on the magazine to ensure it is fully seated in the magazine well.
6. Keeping fingers away from the ejection port and muzzle pointing in a safe direction, press in on the top of the thumb piece of the bolt catch. This will release the bolt carrier group to move forward and feed a round from the magazine into the chamber. THE FIREARM IS NOW LOADED WITH A ROUND IN THE CHAMBER AND THE HAMMER IS COCKED.
7. You may now close the ejection port dust cover if you wish; it is located on the right hand side of the upper receiver and will open automatically when the first round is fired.

CAUTION: NEVER LEAVE YOUR FIREARM COCKED AND LOCKED, READY TO FIRE WITHOUT SELECTOR LEVER BEING SET TO SAFE, as this is the Fire Condition and is extremely dangerous. Firearms can easily be accidentally discharged, causing injury, death or damage to property.

WARNING

THIS FIREARM MAY DISCHARGE ACCIDENTALLY WHEN A ROUND IS FED INTO THE CHAMBER, IF IT IS DROPPED OR RECEIVES A BLOW TO THE MUZZLE OR FRONT OF THE FIREARM. (This can occur regardless of the position of the hammer or any of the various safety devices.) Therefore, extra care and strict adherence to these instructions by the firearm's user is mandatory for minimizing the risk of accidents.



Loading/Firing Instructions

LOADING AND FIRING WITH MAGAZINE

Safe firearm handling should be practiced with an unloaded firearm until you can perform each of the following steps with skill and confidence. Please read through this manual completely prior to operating your Spec-Arms firearm.



1. Grasp firearm with one hand on handguard and other hand on firearm grip with index finger resting along outside of trigger guard. Raise firearm and pull buttstock firmly into shoulder (**Figure 1**)

2. BE CERTAIN THE MUZZLE IS POINTED IN A SAFE DIRECTION.

3. Before inserting a loaded magazine, engage the bolt catch so that the bolt carrier is held open. Verify the chamber is empty. Move the safety selector to the "SAFE" position.

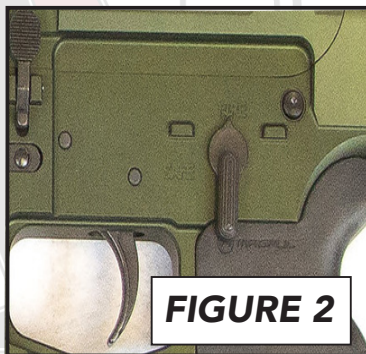
4. Insert a loaded magazine into the magazine well and release the bolt catch by either depressing the pad on the left side or pulling the charging handle rearward completely, and releasing the charging handle. A cartridge will be stripped from the magazine and chambered by the motion of the bolt carrier moving forward.

CAUTION: *If cartridges do not feed smoothly from the magazine into the chamber then do not use the firearm until the problem is corrected (See TROUBLESHOOTING SECTIONS)*

5. The firearm is now cocked and a cartridge is chambered. Visually check to be certain the safety is in the "SAFE" position, and the firearm is pointed in a safe direction.

6. When you are ready to fire, move the safety lever to the "FIRE" position. (**Figure 2**)

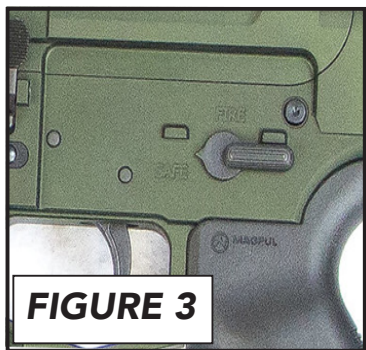
CAUTION: *Do Not Touch the trigger until you are actually ready to fire. Keep the safety on unless actually firing your firearm. Keep the chamber empty unless actually firing. Keep the safety on the "SAFE" position unless actually firing!*



7. Keep steady aim, place index finger on trigger and pull gently until the rifle fires. Your firearm chambers the next round immediately after firing.

8. You may continue to fire by pulling and fully releasing the trigger until the magazine is empty

9. If you wish to stop firing, release trigger, remove finger from trigger guard, and set safety selector to "SAFE" (**Figure 3**). If you have fired the last round from the magazine, the bolt will be held to the rear so the firearm can quickly be reloaded by replacing the magazine, or the chamber can be inspected to ensure that it is empty.





Unloading/Reloading Instructions

CAUTION: This sequence must be followed exactly as spelled out. Failure to do so can result in the rifle's chamber becoming unintentionally loaded!

1. Keep the muzzle pointed in a safe direction at all times and keep fingers outside the trigger guard. Rotate the safety to the "SAFE" position.
2. Remove the magazine. REMEMBER that even though the magazine has been removed, the gun is still dangerous! Refer to Rule 1 (Page 3).
3. Pull the charging handle all the way to the rear, removing any cartridge in the chamber.
4. When the bolt carrier is fully retracted, lock the bolt carrier back.
5. Always visually double check the chamber to be certain it is empty.
6. The only "safe" firearm is one in which the bolt carrier is open and the chamber and magazine are empty, and the muzzle is pointed in a safe direction.

TO RELOAD THE FIREARM

1. Firing all cartridges in the magazine and the chamber will cause the bolt carrier to automatically lock open. Keep the rifle pointed in a safe direction. Put the safety in the "SAFE" position. Removal of the magazine can be accomplished by pressing inward on the magazine catch button with the thumb or forefinger. The magazine will fall free of the rifle of its own weight. To avoid the possibility of damage to the magazine, do not let it fall to the ground.

2. Insert a loaded magazine.

CAUTION: The bolt catch is held in place by friction between the bolt face and the rear surface of the bolt catch. Therefore, when there is a loaded magazine in place and the rifle is jarred, the bolt can release and chamber a cartridge.

3. Release the bolt carrier. A cartridge will be chambered when the bolt carrier shuts.

CAUTION: The rifle is ready for instant use once the bolt carrier moves forward. If the rifle is not to be fired immediately, keep the safety on "SAFE". When you are ready to fire, move the selector to the "FIRE" position and resume firing, putting the safety back on "SAFE" when you cease firing, even for a moment.

EXTRACT AND EJECT A CHAMBERED CARTRIDGE

When the rifle is fired, the same gas pressure that drives the bullet forward bleeds through the gas port to push the bolt carrier group to the rear. This action causes extraction and ejection of the fired cartridge case. If a cartridge fails to fire or if the shooter wishes to eject the chambered cartridge manually, follow the procedure described in "UNLOAD". When the charging handle is operated, there can be a failure to extract the cartridge from the chamber, or a failure to eject the cartridge clear of the rifle. These failures usually are the result of the charging handle not being pulled rearward vigorously.

From the foregoing, it is clear that the user must:

1. Always visually check the chamber after opening the action to eject a chambered cartridge. If the charging handle is not vigorously retracted, the extracted cartridge can be "ejected" into the magazine area.
2. Thoroughly clean the chamber and the extractor as often as necessary. If an empty magazine is in the rifle when the charging handle is being retracted to extract a cartridge, the cartridge may drop on top of the magazine or remain held to the bolt face by the extractor. Then, when the bolt carrier goes forward, the cartridge will be chambered again!

REMEMBER -- always remove the magazine before clearing the chamber, and visually check to ensure that no cartridges remain in the firearm.

Disassembly Instructions



DISASSEMBLING THE AR: PART 1

1. CLEAR YOUR RIFLE!

Disconnect the Sling for convenience.

2. Push in Takedown Pin (a Bullet tip can help) as far as it will go. Pivot Upper Receiver from Lower Receiver.



3. Push in Pivot Pin (a Bullet tip can help).



4. Separate Upper and Lower Receivers.



5. Turn Upper over and Pull Back Charging Handle and Bolt Carrier



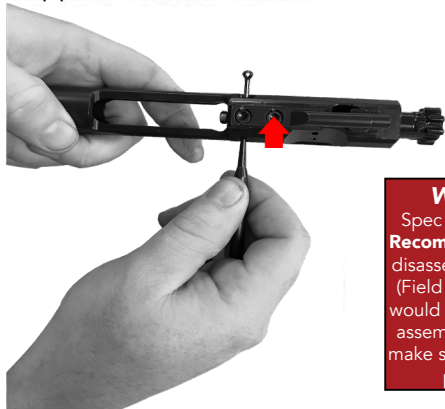
6. Remove Bolt Carrier Group and Bolt



7. Remove Charging Handle by pulling back and up until "Ears" clear cutouts in Receiver.

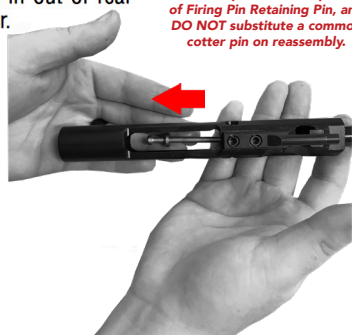


8. Remove Firing Pin Retaining Pin. A Bullet tip can help push it out of the Bolt Carrier.



9. Drop Firing Pin out of rear of Bolt Carrier.

DO NOT open or close split end of Firing Pin Retaining Pin, and **DO NOT** substitute a common cotter pin on reassembly.



WARNING

Spec Arms **Does Not Recommend** any further disassembly past step 7 (Field Stripping). If you would like to further disassemble your firearm, make sure a professional performs it.

Disassembly Instructions



DISASSEMBLING THE AR: PART 2

10. Push Bolt in to locked position.



11. Remove Cam Pin by rotating 1/4 turn and lifting out.



12. Remove Bolt Assembly from Bolt Carrier by pulling straight out.



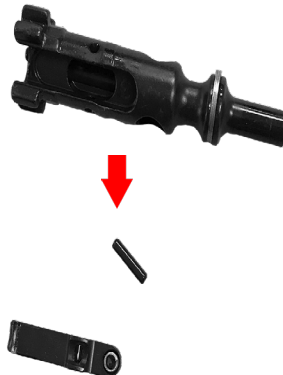
13. Remove Extractor Pin by pushing out with a punch or the tip of a Bullet.

PUSH EXTRACTOR PIN OUT:

Don't lose it!



14. Remove Extractor with Spring.



NOTE:

Press rear of extractor to check Spring function.

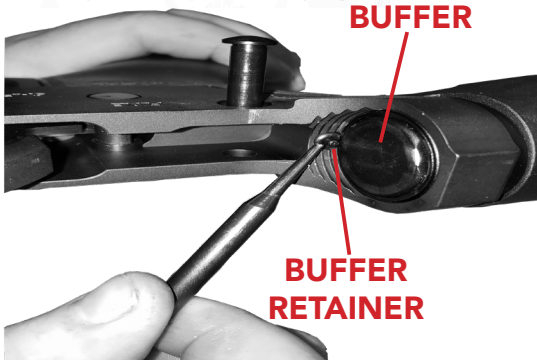
Disassembly Instructions



DISASSEMBLING THE AR: PART 3

DISASSEMBLE USING STEPS 13 THRU 16 ONLY WHEN DIRTY OR DAMAGED.

15. With Hammer cocked, depress Buffer Retainer with punch or Bullet tip to release Buffer and Spring.



CAUTION:

Buffer is under tension from Action Spring.

NOTE: *Hammer needs to be cocked to allow Buffer and Spring to clear Receiver.*

15. Pull out Buffer and Action Spring for cleaning.



SPEC ARMS DOES NOT RECOMMEND ANY FURTHER DISASSEMBLY

The Handguards may be disassembled at any point in your cleaning procedures as necessary

If your Rifle is equipped with the A3 Type Removable Carry Handle, remove for cleaning by loosening the 2 thumbnuts. Clean as per instructions for aluminum Upper and Lower Receivers. Lightly lubricate the thumbnut threads and the Rear Sight mechanism (as described in Lubrication - Adjustable Rear Sight).

FOR REASSEMBLY, FOLLOW DISASSEMBLY INSTRUCTIONS IN REVERSE



Maintenance Instructions

CAUTION: ANY MAINTENANCE, ADJUSTMENT OR SERVICE NOT SPECIFIED IN THIS MANUAL MAY AFFECT THE SAFETY AND RELIABILITY OF YOUR FIREARM AND MUST BE PERFORMED BY A QUALIFIED GUN-SMITH USING GENUINE SPEC ARMS PARTS. IF YOU DO OTHERWISE, IMPROPER FUNCTIONING OF YOUR FIREARM MAY OCCUR AND SERIOUS INJURY OR DEATH MAY RESULT.

If your firearm will be used in a cold climate, be sure to use an oil of an appropriate weight so that it will not congeal in cold temperatures, causing the interaction of important parts to be slowed or halted.

MAINTENANCE BEFORE USE

Before using your firearm for the first time, it should be cleaned. See the cleaning instructions that accompanied your particular firearm. Your firearm was treated at the factory with either a preservative or oil to protect it against corrosion during shipping and storage. Preservative and oil should be wiped from the bore, chamber and exposed areas using a clean swab or patch before using the firearm.

Purchase cleaning supplies from your firearms dealer that are specifically designated for your type and caliber of firearm. Many suppliers offer these in kit form for your convenience. Follow the instructions provided with your cleaning supplies. Whenever your firearm has been exposed to sand, dust, extreme humidity, water or other adverse conditions, it must be cleaned and lubricated.

MAINTENANCE BEFORE STORAGE

When storing, do not encase your firearm in anything that will attract or hold moisture, for example, leather or heavy cloth. Also, do not store firearms with a plug inserted in the barrel for this can be a contributing factor to moisture accumulation. If your firearm is to be stored for an extended period, the bore, chamber and internal surfaces should be oiled with a high-quality lubricating oil or preservative intended for firearms.

CLEANING & MAINTENANCE

The external parts; receiver, bolt and barrel should be coated with an anti-rust oil. Before using your firearm again, be sure to clean it. Every time you clean your firearm, check it for signs of wear. If wear is noted, do not use the firearm. Return it to Spec Arms for service or have it checked by a qualified gunsmith.

CAUTION: Use of ammunition manufactured with corrosive primers in this firearm will cause oxidation to develop on any exposed metal parts of the firearm. To prevent such oxidation, the residue from these primers must be completely removed from all exposed metal parts after each time ammunition with it is used in this firearm. Conventional oil or solvent-based firearm cleaners WILL NOT dissolve the residue from corrosive primers. Residue from corrosive primers MUST be completely dissolved with a water-based cleaner. After the corrosive residue has been completely dissolved from all exposed metal parts, remove any excess water-based cleaner from the firearm. Finally, lubricate the firearm as instructed in the Troubleshooting section. Failure to follow these instructions will cause damage to the firearm and may affect the ability of the firearm to function properly.

Check with the ammunition manufacturer or a qualified gunsmith if you are unsure whether the particular ammunition you plan to use in this firearm has been manufactured with corrosive primers. If in doubt, follow all the instructions above to prevent oxidation caused by ammunition manufactured with corrosive primers.

Ammunition manufactured by SAAMI member companies do not use corrosive primers.

HEALTH AND ENVIRONMENTAL WARNING

DISCHARGING FIREARMS IN POORLY VENTILATED AREAS, CLEANING FIREARMS, OR HANDLING AMMUNITION MAY RESULT IN EXPOSURE TO LEAD AND OTHER SUBSTANCES KNOWN TO CAUSE BIRTH DEFECTS, REPRODUCTIVE HARM, CANCER, AND OTHER SERIOUS PHYSICAL INJURY. HAVE ADEQUATE VENTILATION AT ALL TIMES. WASH HANDS THOROUGHLY AFTER EXPOSURE.



Maintenance Instructions

Upper Maintenance

IMPORTANT: To prevent loss of small components during stripping and cleaning, lay them out in an orderly fashion.

1. Use cleaning fluid on the bore and chamber the gas tube, the upper receiver, barrel assembly, locking lugs, and all areas of powder fouling, corrosion, dirt or dust.
2. Install the chamber brush on the cleaning rod, dip the brush in cleaning fluid and insert it into the chamber and locking lugs. Clean by pushing and twisting the cleaning rod.
3. Install the bore brush on the complete cleaning rod. Dip the brush in cleaning fluid. Run the rod through the chamber and flash suppressor or muzzle brake several times.
4. Take the bore brush off the rod and install a swab holder and a swab. Apply cleaning fluid to the swab; then run it through the chamber and out the flash suppressor (if applicable). To remove carbon build up, let the solvent sit, then wipe clean. Wipe the bore dry by running clean swabs all the way through from the chamber to the flash suppressor.
5. Once the patches come out dry they should be clean. If not repeat steps 2 & 3.
6. Use a worn out bore brush to clean the outside surface of the protruding gas tube. NOTE: Heat will discolor your gas tube; do not try to remove this discoloration.
7. Wipe the charging handle with a patch dipped in solvent; wipe off solvent with a dry cloth.
8. Inspect the upper assembly for any worn broken or damaged parts.
9. Lightly lubricate the bore and chamber, outer surface of the barrel, front sight, under the hand guards, and the charging handle.
10. With a lubricated swab, run the rod from the receiver to the flash suppressor or muzzle brake. Do not overlubricate.
11. Lubricate the locking lugs.
12. Reassemble Upper

IMPORTANT: DO NOT STRIP YOUR FIREARM FURTHER THAN PREVIOUSLY DESCRIBED. IF ADDITIONAL MAINTENANCE IS REQUIRED, SEE "SERVICE AND REPAIR" LATER IN THIS INSTRUCTION MANUAL. REASSEMBLE YOUR FIREARM BY REVERSING THE DISASSEMBLY PROCEDURE ALREADY DESCRIBED, AND MAKE SURE THAT THE CAM PIN IS PROPERLY INSTALLED. IF YOU ATTEMPT TO FIRE WITHOUT THE BOLT CAM PIN INSTALLED, DAMAGE OR INJURY MAY RESULT.



Maintenance Instructions

Bolt and Carrier Maintenance

IMPORTANT: *Never interchange bolts between rifles*

1. Clean all parts and outer surfaces of the bolt carrier assembly with a swab saturated with cleaning fluid.
2. Clean the bolt carrier key with a wornbrush dipped in cleaning fluid and dry with a pipe cleaner.
3. Remove carbon deposits and dirt from the locking lugs with a cleaning brush dipped in cleaning fluid.
4. Clean the areas behind the bolt rings and under the lip if the extractor.
5. Press the ejector in repeatedly to remove accumulated brass shavings from the ejector hole and assure the ejector moves freely.
6. Inspect the bolt assembly for cracks or fractures, especially in the cam pin hole area. Inspect the firing pin retaining pin for bends, breaks or dents. Inspect the bolt cam pin for cracks or chips. Inspect the firing pin for bends, cracks, or a sharp, chipped or blunted tip.
7. Lubricate the bolt carrier, bolt, cam pin, firing pin and firing pin retaining pin. Be sure to coat inner and outer surfaces and the cam pin area of the bolt carrier. Place one drop of lubricant inside the key. Flush the ejector with lubricant and cycle the plunger enough to ensure the ejector spring is well lubricated.

Lower Maintenance

1. Remove any dirt or debris from the trigger group with a cleaning brush and/or cotton swab dipped in cleaning fluid.
2. Remove powder fouling, corrosion and dirt from the lower receiver with a cleaning brush and/or cotton swab
3. Use a pipe cleaner to clean the butt-stock screw vent hole.
4. Clean the buffer, recoil spring and inside of the lower receiver with a cleaning brush and/or cotton swab dipped in cleaning fluid.
5. Examine the lower receiver assembly for any worn, broken or damaged parts.
6. Lightly lubricate the lower receiver and the internal parts of the lower receiver assembly.



Transportation, Storage & Service

CAUTION: ALWAYS UNLOAD YOUR FIREARM FOR STORAGE & STORE AMMUNITION SEPARATELY.

Store your firearm and ammunition securely locked in separate locations out of the reach and sight of children. (Children are naturally curious and do not always believe or understand the real danger and responsibilities of firearms.)

NOTE: Do not store your firearm in an air tight container, and do not seal or attempt to seal the barrel to exclude dust, as an internal steel surface is more likely to corrode.

Should your firearm require adjustment or repair, make sure it is NOT LOADED and call Spec Arms for specific instructions on where to send the rifle. For spare parts, seek advice from your Dealer who should have up-to-date information on how to best obtain genuine Spec Arms parts. An illustration and list of part names are included in the "Your Spec Arms Rifle" section's of this instruction manual to help you identify the parts you need, but it is most important to note that all parts are not available for sale. Those parts which are available should be installed by Spec Arms or by a competent gunsmith. When ordering parts, please provide the part name as it is given on the components list (Page 5 & 6) along with the serial number of the firearm.

IMPORTANT: IF YOU MAKE UNAUTHORIZED ADJUSTMENTS OR USE UNAUTHORIZED PARTS, SPEC ARMS WILL NOT ASSUME RESPONSIBILITY FOR THE FUNCTIONING OF THIS RIFLE.

NOTE: THIS FIREARM IS MANUFACTURED TO PERFORM PROPERLY WITH THE ORIGINAL PARTS AS DESIGNED. IT IS YOUR DUTY TO MAKE SURE ANY PARTS YOU BUY ARE INSTALLED CORRECTLY AND THAT NEITHER REPLACEMENTS NOR ORIGINALS ARE ALTERED OR CHANGED. YOUR FIREARM IS A COMPLEX TOOL WITH MANY PARTS THAT MUST RELATE CORRECTLY TO OTHER PARTS. PUTTING A FIREARM TOGETHER INCORRECTLY OR WITH MODIFIED PARTS CAN RESULT IN A DAMAGED FIREARM. DANGER, INJURY, OR DEATH MAY OCCUR TO YOU AND OTHERS THROUGH MALFUNCTION.

NOTE: VARIOUS FEDERAL AND STATE LAWS AND LOCAL ORDINANCES GOVERN THE TRANSFER AND TRANSPORTATION OF FIREARMS. TAKE THE ADVICE OF THE DEALER IN YOUR STATE ON HOW TO SEND YOUR FIREARM TO SPEC ARMS.

MAKE SURE THE MAGAZINE IS EMPTY AND THE FIREARM IS NOT LOADED!

INSTRUCTIONS FOR RETURNING FIREARMS FOR SERVICE/REPAIR

1. Before seeking any service on your Spec Arms firearm: use this instructional guide in the Owner's Manual to attempt to solve the problem; perform all instructed maintenance; and assure that ammunition and magazines are correct and in good condition. A downloadable copy of the current owner's manual for any Spec Arms firearm is available for free on Spec Arm's website (www.specarmsllc.com). Additional technical information can also be found on Spec Arm's website.
2. If you're unable to solve your problem, you are able to send your firearm in for repair. When getting any services or repairs done to your firearm, **DO NOT** send it back to Spec Arms but to the authorized dealer you bought it from or any listed on our website (www.specarmsllc.com/dealer-list). For any further questions, contact your nearest authorized dealer or the dealer you purchased your firearms from.

Troubleshooting



WHAT TO DO IF THERE IS A PROBLEM: PART 1

PROBLEM:	CHECK FOR:	SECTION/WHAT TO DO:
Won't Fire	Light indentation on Primer. Selector lever on SAFE. Improper assembly of firing pin. Too much oil in firing pin recess. Defective ammo. Too much carbon on firing pin or in firing pin recess.	Notify an Authorized Dealer. Put in FIRE Position. Assemble correctly retaining pin goes on back of large shoulder of firing pin. Wipe out with pipe cleaner. Remove and discard. Clean.
Bolt Won't Unlock	Dirty or damaged bolt.	Clean or Notify an Authorized Dealer.
Won't Feed	Dirty or corroded ammo. Dirty Magazine. Defective magazine. Too many rounds in magazine. Action of buffer assembly is restricted. Magazine not fully seated.	Clean. Clean. Replace. Take out excess. Take out buffer and spring and clean. Tap on magazine or adjust magazine catch.

Troubleshooting



WHAT TO DO IF THERE IS A PROBLEM: PART 2

PROBLEM:	CHECK FOR:	SECTION/WHAT TO DO:
Double Feed	Defective Magazine.	Replace.
Won't Chamber	Dirty or corroded ammo.	Clean or replace.
	Damaged ammo.	Replace.
	Carbon in chamber.	Clean.
	Improperly loaded ammo.	Use Factory Loaded Ammo.
Won't Lock	Dirt, corrosion, or carbon buildup in barrel or bolt locking logs.	Clean lugs.
Won't Extract	Frozen extractor.	Remove and clean.
	Broken extractor spring.	See an Authorized Dealer.
	Restricted buffer assembly.	Remove and clean.
	Restricted movement of bolt carrier group.	Remove, clean, and lube. (Before putting bolt back in, make sure gas tube fits into carrier key and that the carrier moves freely).
	Dirty or corroded ammo.	Remove and clean. Push out stuck cartridge with cleaning rod.
	Dirty chamber.	Clean Chamber.

Troubleshooting



WHAT TO DO IF THERE IS A PROBLEM: PART 3

PROBLEM:	CHECK FOR:	SECTION/WHAT TO DO:
Short Recoil	Gaps in bolt rings (not staggered).	Stagger rings gaps.
	Missing or broken rings. Three rings required.	Notify an Authorized Dealer.
	Carbon or dirt in carrier key or on outside of gas tube.	Clean.
Bolt Fails to Lock After Last Round	Dirty or corroded bolt latch.	Clean.
	Faulty magazine.	Replace.
Selector Lever Binds	Needs Oil.	Lubricate.
	Dirt or sand under trigger.	
Bolt Carrier "Hung Up"	WARNING Keep clear of muzzle.	
	Round jammed between bolt and charging handle and/or double feed.	Remove magazine. Remove rounds, if not removed notify an Authorized Dealer.
	CAUTION If round is removed, bolt is under spring pressure.	



Warranty Information

SPEC ARMS firearms carry a 100% satisfaction guarantee against manufacturing defects in original materials and workmanship for the original purchaser. SPEC ARMS strives to make every accommodation to repair your firearm. SPEC ARMS only warrants the original purchased products. Any installation of other manufacturers products, should those products cause damage to the original gun, will void the warranty. Be sure to retain your sales slip as proof of purchase date when making a claim.

To initiate a warranty claim, contact your local, Spec Arms authorized dealer or the authorized dealer you purchased your firearm from. Spec Arms DOES NOT handle any firearms warranties. You can find our list of dealers on our website at <https://www.specarmsllc.com/dealer-list>.

WARNING

YOUR SPEC ARMS FIREARM WAS DESIGNED TO FUNCTION PROPERLY WITH ITS ORIGINAL COMPONENTS. ALTERATIONS TO ITS ORIGINAL COMPONENTS OR REPLACEMENT OF THEM WITH AFTER MARKET (NON-SPEC ARMS) COMPONENTS CAN CAUSE MALFUNCTIONS OR EVEN MAKE THE FIREARM UNSAFE. DO NOT ALTER ANY PART OR ADD / SUBSTITUTE PARTS NOT MANUFACTURED BY SPEC ARMS LLC.

In regards to manufacturing defect warranties, we reserve the right to distinguish what is or is not a manufacturers defect. SPEC ARMS LLC will not be responsible for the results of careless handling, unauthorized adjustments, defective, low quality, reloaded, or improper ammunition, corrosion, neglect, ordinary wear and tear, unreasonable use, product color was different than expected, damages caused by the user, damage from non-spec arms products, damage caused to our products by the correct or incorrect installation of other manufacturer's products and more. We will evaluate each claim on a case by case basis. Furthermore, the liability of SPEC ARMS LLC under this warranty shall be limited solely to the obligation to repair or replace the firearm, and to pay transportation and insurance charges for return of the firearm to owner.

Under no circumstances shall SPEC ARMS LLC be responsible for incidental or consequential damages with respect to economic loss or injury to property, whether as a result of express or implied warranty, negligence or otherwise.

NOTE: *Handguns and long guns are classified as FIREARMS or DANGEROUS WEAPONS. Guns are surrendered by SPEC ARMS LLC. with the express understanding that it assumes no responsibility for resale handling under local laws and regulations.*

If your owner's manual becomes lost or destroyed, obtain a replacement by going on our website and looking at the electronic version provided. www.specarmsllc.com/owners-manual



SPEC ARMS LLC
SPECIALTY WEAPONS AND COMPONENTS

This instruction manual should always accompany this firearm. When you lend, give or sell this firearm, be sure that this manual goes with it.

If you need to get into contact with Spec Arms, use the corporate information provided on our website.



MADE IN USA

www.specarmsllc.com

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