



**ARMALITE®, INC
OWNER'S MANUAL
FOR
SPR Mod 1™ CARBINES**



**⚠ READ THIS MANUAL THOROUGHLY, PARTICULARLY THE
WARNINGS, BEFORE USING THIS FIREARM! IT'S IMPORTANT!**

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September 2012 Rev 25
P/N: MANUAL SPR MOD1

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Congratulations on buying an ArmaLite! You won't be disappointed.

Our many ArmaLite-made parts and accessories for your gun are shown on our website www.armalite.com. You can also check our web specials for great deals or browse through our on-line catalog.

Check with your local ArmaLite dealer for any special deals or sales that he may be running.

To learn more about your new firearm, we invite you to visit the Library on our website. There, we have on-line Manuals, Frequently Asked Questions and Technical Notes you're sure to find helpful.

There's nothing better than adding to your ArmaLite firearm with GENUINE ArmaLite parts!

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1. READ THIS FIRST!

Throughout this manual you will find **WARNINGS**, **CAUTIONS** and **NOTICES** printed in bold print. All **WARNINGS**, **CAUTIONS** and **NOTICES** must be read carefully and followed completely. **WARNINGS** indicate a situation, which, if not avoided, could result in death or serious injury. **CAUTIONS** indicate a situation, which, if not avoided, could result in minor or moderate injury. **NOTICES** indicate a situation that could result in damage to the rifle or other property.



WARNING: IT IS YOUR RESPONSIBILITY TO ASSURE THAT YOUR FIREARM IS HANDLED, FIRED, AND STORED SAFELY AND RESPONSIBLY AT ALL TIMES.

This manual provides instructions on the operation and maintenance of your ArmaLite® firearm. Read and understand it carefully before you try to use your firearm. Your safety, and that of those around you, depends on your knowledge of your firearm and on your knowledge of safety rules common to all firearms. Please study the common-sense safety rules noted in this manual. Your first responsibility as a gun owner is always safety!

Your second responsibility as a gun owner is security. Make sure that your firearm remains in responsible hands... **YOURS!** Don't become an unwitting partner in a crime or tragedy: make sure your firearm is properly secured. Lock it in a secure storage container or, if none is available, remove the bolt and bolt carrier assembly and store it separately. If you have more than one similar firearm, make sure that you specifically identify the removed assembly with its original firearm because the assemblies may not be interchangeable.

It is also your responsibility to assure that you comply with all federal, state, and local laws with regard to the purchase, ownership, use, and storage of your firearm.

NOTICE: THIS MANUAL MAY COVER NUMEROUS MODELS AND/OR CALIBERS OF OUR FIREARMS. THE TEXT, PICTURES, AND EXPLODED VIEWS DO NOT NECESSARILY DEPICT ALL MODEL VARIATIONS. YOU MAY NEED TO CONTACT US FOR INFORMATION ON PARTS THAT ARE UNIQUE TO YOUR MODEL.

IMPORTANT

ArmaLite® has no control over the use of your firearm, and shall not be responsible for injury, death, or damage to property resulting from either intentional or accidental discharge of this firearm. In addition, ArmaLite® shall not be responsible for proper function of the firearm when it is used for purposes or subjected to treatment for which it was not intended. ArmaLite® will not honor claims which may result from careless or improper handling, unauthorized adjustments or parts replacement, corrosion, neglect, use of the wrong type or caliber of ammunition, or the use of ammunition other than original, high quality commercially manufactured ammunition in good condition or any combination thereof.

2. SAFETY FIRST! IT'S YOUR RESPONSIBILITY!

- * Treat every gun as if it is loaded ...AT ALL TIMES!
- * Always keep the muzzle pointed in a safe direction.
- * Never point your firearm at anything that you do not intend to shoot.
- * Keep your finger off the trigger and out of the trigger guard until you are aiming at your target and ready to shoot.
- * Always keep the safety in the "SAFE" position, especially when the firearm is loaded and cocked, until you are ready to fire.
- * Always keep and carry your firearm with an empty chamber until you intend to shoot, so that your firearm cannot be fired unintentionally. Firearms should be unloaded when not actually in use.
- * Be sure of your target and backstop before you shoot. Ask yourself what your bullet will hit if it misses or goes through the target.
- * Never shoot at hard, flat surfaces or water...bullets can ricochet.
- * Always wear hearing and eye protection when shooting.
- * Discharging firearms in poorly ventilated areas, cleaning firearms, or handling ammunition may result in exposure to lead, a substance known to be associated with birth defects, reproductive harm, and other serious injury. Have adequate ventilation at all times and wash hands after handling.
- * Be sure that your barrel is clear of obstructions, including excessive oil, grease, cleaning patches, etc before shooting.
- * Use only clean, high quality factory loaded ammunition in good condition. ArmaLite® cannot condone the use of handloaded ammunition. Any such use voids the ArmaLite® warranty.
- * Do not alter or modify your firearm.
- * Do not try to change your firearm's trigger pull, because alterations of trigger pull can affect sear engagement and might cause accidental firing.
- * Store firearms and ammunition separately, and beyond children's reach.



WARNING: IN CASE OF MALFUNCTION, STOP! REVIEW THIS MANUAL TO IDENTIFY AND RESOLVE THE PROBLEM. IF YOU CANNOT RESOLVE IT, CONTACT ARMALITE®.

KEEP THIS MANUAL WITH YOUR RIFLE. IF YOU SELL THE RIFLE, GIVE THIS MANUAL TO THE NEW OWNER.

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4. SAFE STORAGE

 **WARNING: ALWAYS ASSURE THAT YOUR FIREARM IS COMPLETELY UNLOADED BEFORE STORING IT. ALWAYS TREAT YOUR FIREARM AS IF IT WERE LOADED. ALWAYS STORE YOUR FIREARM IN A SAFE LOCATION, SEPARATE FROM THE AMMUNITION.**

Make certain that both the chamber and magazine of your rifle are unloaded before you store it. Store your rifle in a securely locked gun safe. If you do not have a safe, remove the bolt and bolt carrier assembly from your rifle, and store it separately from the rifle in a secure location. Store your ammunition separately from the rifle and from the bolt and bolt carrier assembly.

 **WARNING: IF YOU HAVE MORE THAN ONE SIMILAR FIREARM, MAKE SURE THAT YOU SPECIFICALLY IDENTIFY THE REMOVED ASSEMBLY WITH ITS ORIGINAL FIREARM BECAUSE THE ASSEMBLIES MAY NOT BE INTERCHANGEABLE.**

5. GENERAL INFORMATION

Your firearm is a lightweight, gas operated, air cooled, magazine fed rifle produced for a high degree of accuracy, reliability, and durability. The firearm's construction features extensive use of aircraft-grade forgings, with no die-cast or extruded parts employed in the receivers. The patented bolt assembly provides higher strength than that found on similar designs.



WARNING: YOUR ARMALITE® FIREARM WAS DESIGNED TO FUNCTION PROPERLY WITH ITS ORIGINAL COMPONENTS. ALTERATIONS TO ITS ORIGINAL COMPONENTS OR REPLACEMENT OF THEM WITH AFTERMARKET (NON-ARMALITE®) COMPONENTS CAN CAUSE MALFUNCTIONS OR EVEN MAKE THE FIREARM UNSAFE. DO NOT ALTER ANY PART OR ADD / SUBSTITUTE PARTS NOT MANUFACTURED BY ARMALITE® INC.

5.1 BARREL LIFE

Barrel life depends on how fast the rifle is fired and how accurate the shooter insists it must be. Shooting the rifle as fast as the trigger can be pulled can ruin the barrel in just a few hundred rounds. Firing at controlled rates will allow a standard grade barrel to last for 10,000 to 15,000 rounds with accuracy acceptable for police use. Target shooters fire at very moderate rates, but their higher accuracy requirements may mean barrel replacement as early as 3,500 match rounds.

5.2 RECEIVER FIT

The SPR Mod 1™ is not a custom firearm. ArmaLite® requires a close fit between the receivers, but normal forging and machining variations may result in play or slight side to side receiver mismatch. This is not a manufacturing defect and has no adverse effect on accuracy.

5.3 APPEARANCE

Almost all complaints concerning appearance come from customers who forget that the SPR Mod 1™ is a Military Specification rifle, not a polished commercial or collectors-grade rifle. It is an industrial product, not a custom rifle, and bears finishes appropriate for its intended purposes.

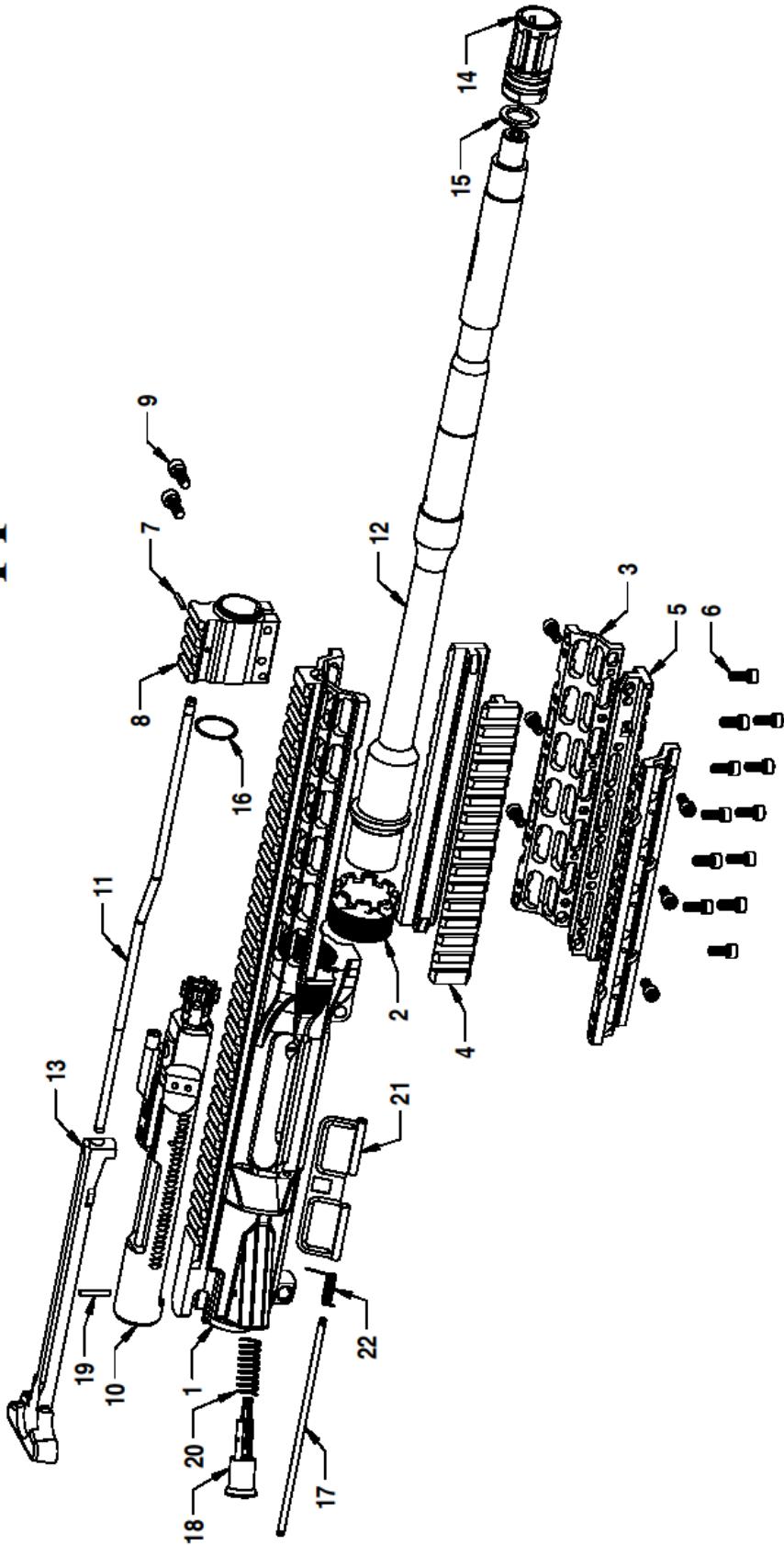
ArmaLite® rifles are all thoroughly test fired before shipping. New rifles will normally show evidence of this firing. If the receiver looks light or uneven in color, it's probably just dry. A light coat of oil on the metallic surfaces will improve its appearance.

The receivers and front sights are made of forgings because forgings provide exceptional strength. By its very nature, the forging process may leave small dents and dings on the outside of the forging. ArmaLite® inspects all forgings for excessive marks, but no forging is free of them. This is not a defect.

6. EXPLODED DRAWINGS AND PARTS LISTS

The drawings and associated parts lists in this section will give you visual references to parts discussed in the text. In the text, you will note part numbers in parentheses behind some part names. Those part numbers are the same as part numbers shown in the exploded drawings and part lists. For example, a part numbered “U-7” in the text would refer to the part numbered “7” in the Upper Assembly exploded view.

SPR Mod 1 Carbine Upper Half



SPR Mod 1 Carbine Upper Half Parts List

1	SPR Mod 1 Carbine Upper Receiver	15003053	9	Picatinny Housing Clamp Screw, #10-32 x 1/2"	EA1152
*	SPR Mod 1 Mid-Length Upper Receiver	15003052	10	.223 Bolt Carrier Group	EB0170
2	SPR Mod 1 Barrel Nut	15105111	11	M15 Carbine Gas Tube	EC0060
3	SPR Mod 1 Carbine Handguard Bridge	157013900	*	M15 Carbine Gas Tube, Median Length	EC0058
*	SPR Mod 1 Mid-Length Handguard Bridge	157013800	12	5.56mm Barrel Tube, 16" Carbine	EPCT07C01P
4	SPR Mod 1 Carbine Handguard Rail	157013911	*	5.56mm Barrel Tube, 16" Medium	EPCT03P
*	SPR Mod 1 Carbine Handguard Insert	157013921	13	M15 Charging Handle Assembly	EU0010B
*	SPR Mod 1 Carbine Handguard Half Rail Insert	157013930	14	.223 A2 Flash Suppressor	EU0100
*	SPR Mod 1 Mid-Length Handguard Rail	157013811	15	Shim Washer, .223 Peel Washer	EU0120
*	SPR Mod 1 Mid-Length Handguard Insert	157013821	16	Picatinny Gas Block Spacer, Shim Washer	EU0335
*	SPR Mod 1 Mid-Length Handguard Half Rail Insert	157013830	17	SPR Mod 1 Port Door Rod	15006201
5	SPR Mod 1 Carbine Handguard QD Rail	157013912	18	Forward Assist (Round)	EU0460
*	SPR Mod 1 Carbine Handguard QD Insert	157013922	19	Sight Base/Forward Assist Pin, 3/32"x 5/8" Spiroil	EU20090
*	SPR Mod 1 Mid-Length Handguard QD Rail	157013812	20	Forward Assist Spring	EU0480
*	SPR Mod 1 Mid-Length Handguard QD Insert	157013822	21	M15 Ejection Port Cover	EU0370
6	SPR Mod 1 Handguard Screw	157013701	22	M15/AR-10 Port Door Spring	EA1167
7	Gas Tube Retaining Pin, 5/64"x 1/2" Spiroil	EA1132	*	Quick Detach Push-Button Sling Swivel	15903016
8	Picatinny Gas Block (Clamp) Moly	EA1151			

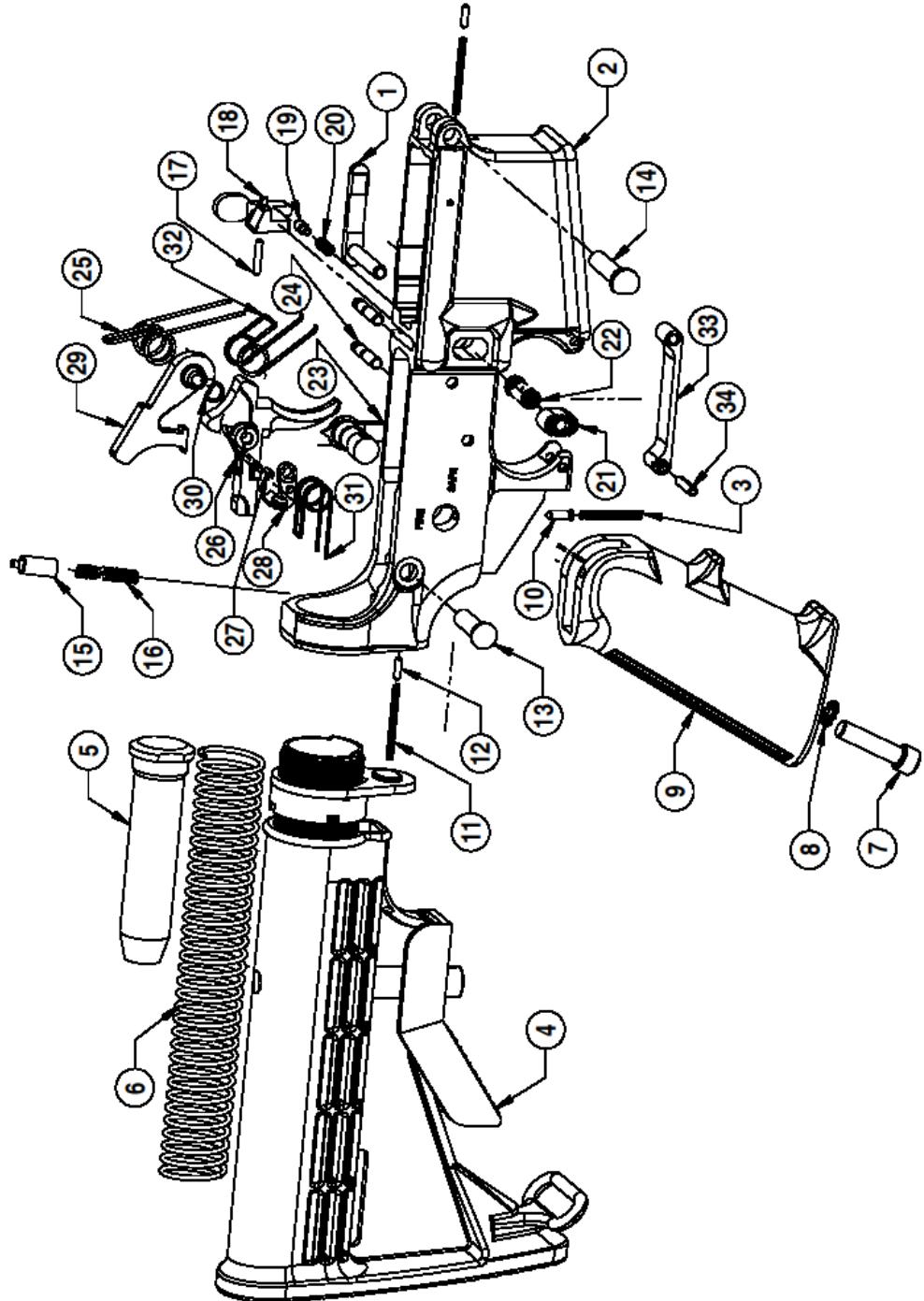
-PARTS MARKED WITH AN "*" ARE NOT SHOWN

-BARREL TUBES AND BARREL EXTENSIONS ARE SOLD AS ASSEMBLIES WITH INDEX PIN

-INDEX PIN ALSO SOLD SEPARATELY

-IF BOLT CARRIER ASSEMBLY OR BARREL IS REPLACED, HEADSPACE NEEDS TO BE
CHECKED BY QUALIFIED GUNSMITH

SPR Mod 1 Carbine Lower Half

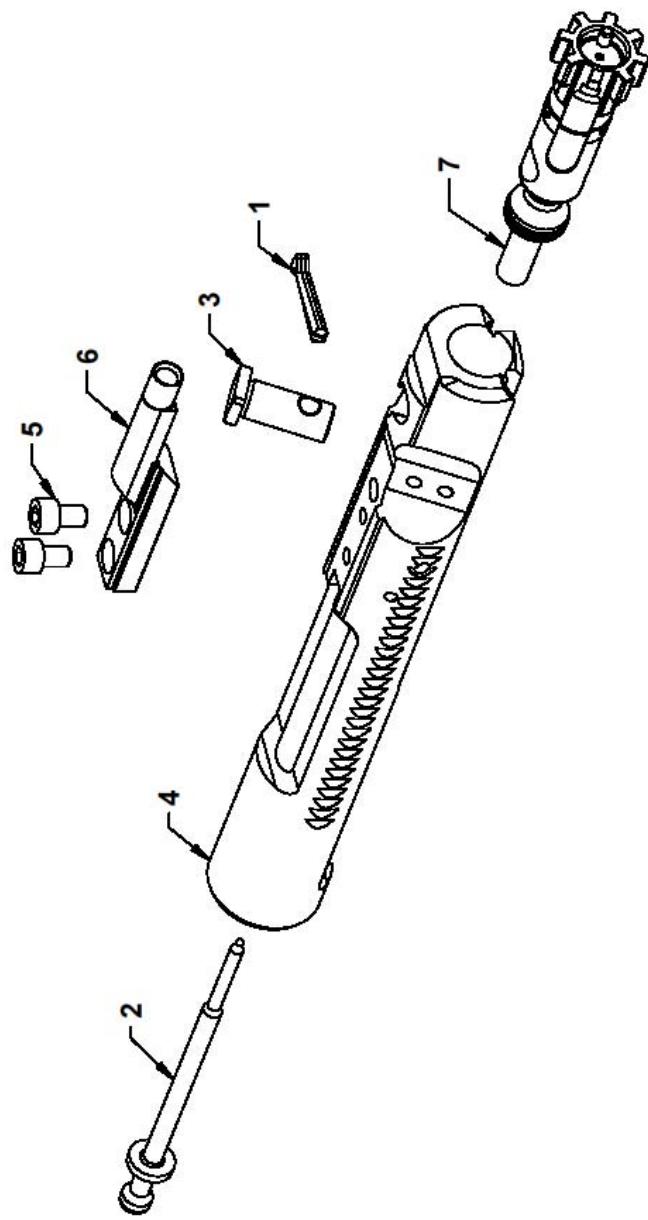


SPR Mod 1 Carbine Lower Half Parts List

1	Magazine Catch	EL0260	17	Bolt Stop Pin, 3/32" x 1/2"	EL0220
2	SPR Mod 1 Lower Receiver	EA900N	18	M15 Bolt Stop	EL0230
3	Ejector/Safety Spring	EB0110	19	Bolt Stop Plunger	EL0240
4	M15 Collapsible Buttstock Assembly (Black)	15702301	20	Bolt Stop Spring	EL0250
*	M15 Collapsible Buttstock Assembly (Green)	15702306	21	Magazine Catch Button	EL0270
5	M15 Carbine Buffer	EC0030R	22	Magazine Catch Spring	EL0280
6	M15 Carbine Operating Spring	EC0040	23	Safety Selector	EL0290
7	Pistol Grip Screw	EL0010	24	Hammer/Trigger Pin	EL0300
8	Pistol Grip Washer	EL0020	25	Hammer Spring	EL0320
9	Pistol Grip, Black	EL0030	26	Two Stage Trigger	10303050
*	Pistol Grip, Green	EG0050	27	Coiled Spring Pin, Two Stage Disconnector	10306000
10	Safety Detent	EL0060	28	Two Stage Disconnector	10307000
11	Detent Spring, Pivot/Takedown Pin	EL0140	29	Two Stage Hammer	10308025
12	Detent, Pivot/Takedown Pin	EL0150	30	Clip, Hammer Pin Retaining, "D-Ring"	10308020
13	M15 Takedown Pin	EL0160	31	Two Stage Disconnector Spring	10806100
14	M15 Pivot Pin	EL0170	32	Two Stage Trigger Spring	15303055
15	Buffer Detent	EL0190	33	Trigger Guard Assembly	EL0380
16	Buffer Detent Spring	EL0200	34	Trigger Guard Pin, 1/8" x 5/8"	EL0430

-PARTS MARKED WITH AN "*" ARE NOT SHOWN
 -PARTS 26, 28, AND 29 ARE SOLD AS MATED ASSEMBLY ONLY

M15 BOLT CARRIER ASSEMBLY

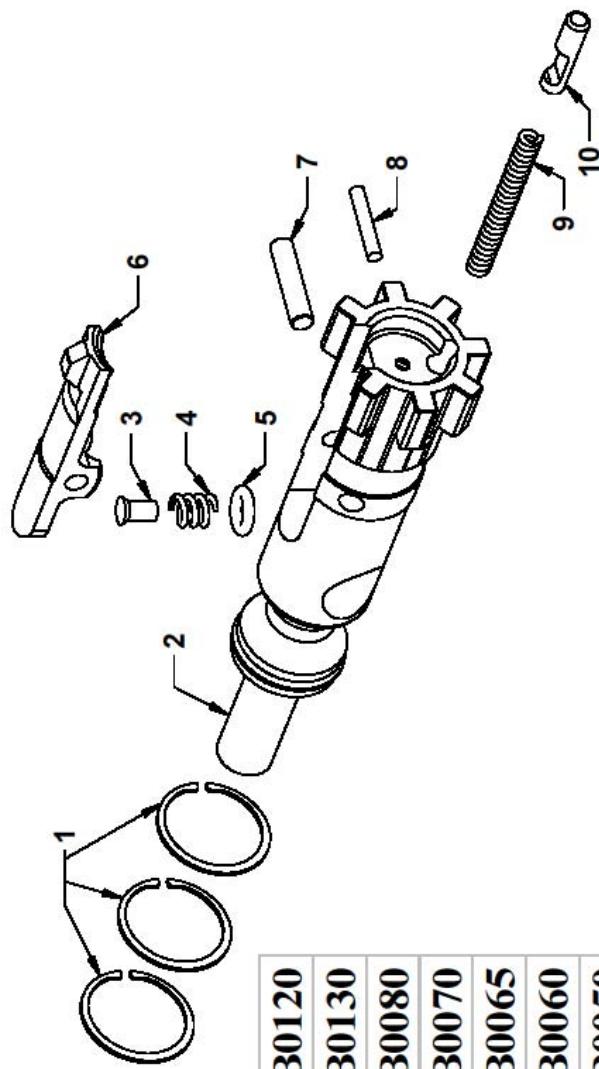


M15 BOLT CARRIER PARTS LIST

1	Firing Pin Retaining Pin	EB0010
2	Firing Pin	EB0020
3	Cam Pin	EB0030
4	Bolt Carrier	EB0160
5	Key Screws	EB0140
6	Bolt Carrier Key .223/.308	EB0150
7	Bolt Assembly	EB0040

-PARTS 4, 5, AND 6 ARE NOT SOLD AS SEPARATE PIECES BUT ARE SOLD TOGETHER AS
ARMALITE PART NUMBER EB0167
-PART 7 IS FACTORY REPLACEABLE ONLY SO PROPER HEADSPACE CAN BE OBTAINED

M15 BOLT ASSEMBLY



1 Gas Rings	EB0120
2 Bolt	EB0130
3 Extractor Spring Plunger	EB0080
4 Extractor Spring	EB0070
5 O-Ring	EB0065
6 Extractor	EB0060
7 Extractor Pin	EB0050
8 Ejector Pin	EB0090
9 Ejector Spring	EB0110
10 Ejector	EB0100

-PART NUMBER 2 IS NOT
SOLD AS A SEPARATE ITEM

7. AMMUNITION

ArmaLite sells our SPR Mod 1s™ chambered for several different cartridges. Nomenclature of cartridges can be confusing. It is vital that you understand cartridge nomenclature and only fire cartridges for which this firearm was designed. To assist you, the name of the appropriate cartridge will be etched on the receiver and/or barrel of each ArmaLite®. (More information regarding cartridge nomenclature can be found in the Tech Notes on our website.)



WARNING: USE OF INCORRECT AMMUNITION CAN CAUSE FIREARM DAMAGE, PERSONAL INJURY, OR DEATH. MAKE ABSOLUTELY CERTAIN THAT YOU ARE USING CARTRIDGES DESIGNED FOR YOUR FIREARM. DO NOT FIRE OLD, CORRODED, DEFORMED, OR HANDLOADED AMMUNITION. IF YOU HAVE ANY QUESTIONS, CONTACT ARMALITE® BEFORE FIRING.

ArmaLite® chambers its SPR Mod 1™ family of firearms for a number of different cartridges. In order to assure that you are using the correct cartridges for your firearm, you must look on the firearm itself. The caliber is marked on the barrel and/or upper receiver. If you have any questions regarding ammunition compatibility, **CONTACT ARMALITE® BEFORE FIRING THE RIFLE!!!!!!**

If your SPR Mod 1™ Series firearm is chambered for 5.56 cartridges, it will fire all standardized U.S. military 5.56mm cartridges and all factory loaded cartridges in .223 Remington caliber. Do not attempt to fire any other cartridges in this firearm.

For information regarding projectile weights recommended for your particular ArmaLite, see Technical Note 110: "PROJECTILE WEIGHT VERSUS RIFLING TWIST" in the Library on our website, www.armalite.com.

If your SPR Mod 1™ Series firearm is chambered for any cartridge other than 5.56mm, it will fire appropriate cartridges manufactured to SAAMI standards.



WARNING: DO NOT FIRE SABOTED AMMUNITION FROM YOUR RIFLE. THE SABOT COULD LODGE IN YOUR FLASH SUPPRESSOR CAUSING FIREARM DAMAGE AND POTENTIAL INJURY OR DEATH.

NOTICE: FIRING TRACER AND ARMOR PIERCING AMMUNITION REDUCES BARREL LIFE.

NOTE: Some types/brands of ammunition have unique characteristics (e.g. extremely light or heavy projectiles, particularly soft cartridge cases, propellant that burns unusually slowly or rapidly) that reduce its reliability in any semiautomatic firearm. ArmaLite® recommends that you purchase and test a small quantity of any type of ammo in your firearm before you buy large quantities.

8. INITIAL ASSEMBLY, INSPECTION, AND CLEANING

8.1 INITIAL ASSEMBLY

Your firearm is shipped to you completely assembled. However, the buttstock may require adjustment in length to fit you.

ADJUSTING THE COLLAPSIBLE BUTTSTOCK

To extend the collapsible buttstock (L-4), Depress the lever and pull the stock out until it locks into position. To collapse the buttstock, depress the lever again and push forward until it locks into position.



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INSTALLING ACCESSORIES TO PICATINNY RAIL

To install removable accessories (front/rear sights, scope mounts, or other Picatinny rail mountable accessories), follow the instructions provided with the accessory.

⚠ CAUTION: IF YOU MOUNT A SCOPE TO YOUR RIFLE, MAKE CERTAIN THAT THE SCOPE IS MOUNTED FAR ENOUGH FORWARD SO THAT IT WILL NOT IMPACT YOUR FACE DURING RECOIL. CHECK THE DISTANCE BETWEEN THE SCOPE AND YOUR FACE WHEN YOU ARE IN THE FIRING POSITION. BEAR IN MIND THAT YOUR EYE WILL BE CLOSER TO THE SCOPE WHEN SHOOTING FROM PRONE OR FROM THE BENCH THAN WHEN SHOOTING OFF-HAND. WHEN IN DOUBT, INCREASE THE EYE RELIEF.

CONFIGURING YOUR HANDGUARD PICATINNY RAILS AND INSERTS

Your SPR MOD 1 comes equipped with two handguard rails (U-4) and one handguard rail with a Quick Detach swivel hole (U-5) at the 6 o'clock position. These rails will accept any accessory that is compatible with Picatinny rail systems. The Quick Detach swivel hole is compatible with most QD sling swivels including those manufactured by LaRue Tactical, Midwest Industries Inc., and Troy Industries.

The carbine is also shipped with two handguard half rail inserts, two handguard inserts, and one handguard insert with a Quick Detach swivel hole. The handguard inserts are used to provide a comfortable grip when it is not desired to add an accessory to that side of the upper receiver. The half rail insert affords the comfort of the insert plus a Picatinny rail to accommodate an accessory. The Quick Detach insert or rail can be located on the bottom or either side of the upper receiver. Rails and inserts can be installed in any combination.

To re-configure your SPR Mod 1 handguard, first make certain that the firearm is completely unloaded and safe. Set the SPR Mod 1 upper receiver upside down on a flat surface. Using the Torx L-shaped wrench, first remove the screws (U-6) that hold the 6 o'clock rail, two side rails, and two bridges (U-3) to the SPR Mod 1 upper receiver. Then disassemble the 6 o'clock rail from the two bridges by removing the screws (U-6). (NOTE: This step is not necessary if the 6 o'clock rail/insert is not being changed.)

All inserts and rails can be installed with either end forward. However, the two bridges must be installed so that the side of each bridge with more screw holes interfaces with the upper receiver. (Six screw holes for the carbine length bridge and eight screw holes for the mid-length bridge interface with the upper receiver.) The easiest way to install the bridges/inserts/rails to the upper receiver is to first select the insert or rail that you want at the 6 o'clock position. Assemble the two bridges loosely to that insert/rail, making certain that you install the sides of the bridges with the three (or four) screw holes to the insert/rail.



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A3526



Typical 6 O'clock Rail Attached To Two Bridges

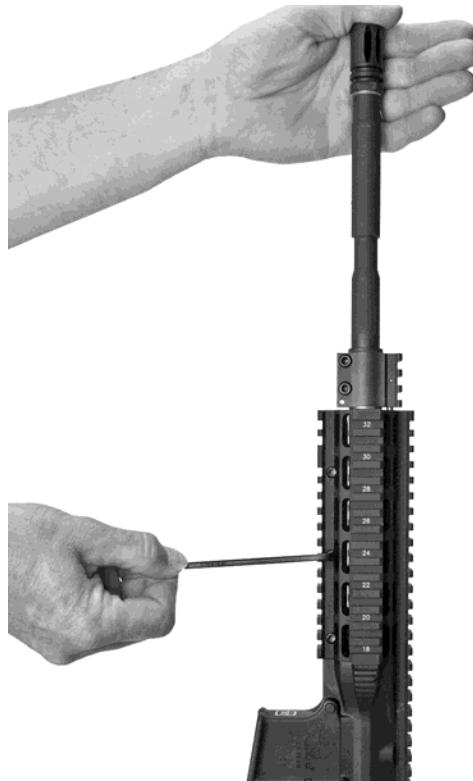
Next, select the inserts/rails that you want at 3 o'clock and 9 o'clock positions. Set them in the upper receiver. Set your assembled bridges on them. Install all screws loosely. Then torque all screws evenly to 20 – 25 in lbs. (NOTE: The mid-length system has an extra screw that connects the rear of the six o'clock rail to the bottom of the upper receiver.)

NOTICE: DO NOT TORQUE THE SCREWS ABOVE 40 IN LBS. DOING SO MAY RESULT IN STRIPPING THE SCREW HOLES.

Reassemble the carbine installing the bolt carrier assembly and charging handle into the SPR Mod 1 upper receiver and then re-attaching the upper receiver to the lower receiver assembly.

IF YOU DON'T HAVE A TORQUE WRENCH HANDY, YOU CAN USE THE WEIGHT OF THE CARBINE

As a field expedient, if you don't have a torque wrench handy, you can torque the screws using the following procedure. Snug all screws lightly. Then completely assemble the carbine. The carbine weighs approximately 6.6 lbs. Hold the carbine vertically by the muzzle or buttstock. Insert the short end of the supplied Torx wrench into a screw so that the Torx wrench is perpendicular to the long axis of the carbine. Hold the long end of the Torx wrench approximately 4 inches from the short end. Carefully allow the weight of the carbine to hang from the Torx wrench. That should apply approximately 25 in-lb of torque to the screw ($6.6\text{lb} \times 4" = 26.6\text{ in-lb}$). Repeat for all screws. If you have difficulty using this method, torque the screws snugly, being careful not to exceed 40 in-lbs.



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8.2 INITIAL INSPECTION

⚠ WARNING: READ THIS MANUAL COMPLETELY AS YOU INSPECT YOUR NEW ARMALITE® FIREARM. MAKE CERTAIN THAT YOU UNDERSTAND HOW TO ASSEMBLE, OPERATE, DISASSEMBLE, MAINTAIN, AND STORE YOUR FIREARM SAFELY BEFORE YOU USE IT.

Any time you disassemble and reassemble a firearm, you should conduct a functional check of it. Check your firearm's function as described in the Reassembly section of this manual.

8.3 INITIAL CLEANING

Merely clean the bore of your firearm and lubricate the firearm as described in the Maintenance section below. ArmaLite® firearms are made more tightly than other rifles of similar design. A break-in period of 200 rounds allows machined or phosphate-coated surfaces to smooth out the rifle's action. Lubricate the rifle well before firing.

⚠️ WARNING: TO ASSURE ITS PROTECTION FROM CORROSION, YOUR ARMALITE® FIREARM HAS BEEN SHIPPED WITH PRESERVATIVE OIL IN THE BORE. FIRING THE FIREARM WITH PRESERVATIVE IN THE BORE CAN INCREASE PRESSURES, WITH POSSIBLE FIREARM DAMAGE OR PERSONAL INJURY OR DEATH. CLEAN AND DRY THE BORE BEFORE FIRING YOUR ARMALITE® FIREARM.

8.4 BREAKING IN MATCH BARRELS

“Match barrels” are any of our stainless steel barrels. Our chrome lined barrels do not require break in. ArmaLite® has spoken with several barrel manufacturers. NONE of them recommend breaking in barrels using abrasives. For optimum accuracy and barrel life, ArmaLite® recommends the following break-in procedure:

1. Fire 9 single shots. After each shot, push a cotton patch wet with solvent through the bore. Then wet a bronze brush with solvent and stroke the barrel five to ten round trips. Follow with another wet patch and then a dry patch or two. (We do NOT recommend nylon or stainless steel brushes.) After you finish, wash the solvent off your brush so that the brush won't deteriorate.
2. From 10 to 30 shots, clean as above after each five shots. Initial break-in should now be complete.

For subsequent, normal cleaning, it is suggested that you clean after each range session. It is often suggested that the barrel be brushed one stroke for each shot fired.

8.5 DRY FIRING YOUR RIFLE

Reasonable amounts of dry firing should not damage your rifle.

NOTICE: NEVER DRY FIRE YOUR RIFLE WITHOUT THE BOLT CARRIER ASSEMBLY INSTALLED. THE FIRING PIN STOPS THE FALL OF THE HAMMER. WITHOUT THE BOLT CARRIER ASSEMBLY INSTALLED, THE HAMMER CAN IMPACT ON THE LOWER RECEIVER, DAMAGING IT.



**WARNING: FOLLOW ALL OF THE RULES OF SAFE GUN HANDLING
ANYTIME YOU DRY FIRE YOUR FIREARM.**

8.6 INSTALLING, ADJUSTING, AND USING THE RIFLE SLING

Some rifle slings serve only as simple carrying straps. However, a tactical/competition sling has far more uses. In addition to carrying the rifle, it can serve to improve shooter accuracy by stabilizing the rifle during firing.

Depending on the particular model of ArmaLite® you own, it may be shipped with a carrying strap sling or a tactical/competition sling. Tactical/competition slings can be purchased on our website (ArmaLite Part # EX0081).

For detailed information on the tactical/competition sling, see Technical Note 109: “INSTALLING, ADJUSTING, AND USING THE PRECISION/TACTICAL RIFLE SLING” in the Library on our website, www.armalite.com.

9. LOADING AND FIRING

! **WARNING:** ALWAYS KEEP THE SAFETY IN THE “SAFE” POSITION UNTIL YOU ARE READY TO FIRE THE FIREARM. REMEMBER THAT THE SAFETY IS SIMPLY A MECHANICAL DEVICE, AND AS SUCH, COULD POSSIBLY FAIL. NEVER DEPEND ON ANY SAFETY TO JUSTIFY UNSAFE GUN HANDLING. ALWAYS KEEP THE CHAMBER EMPTY AND THE FIREARM POINTED IN A SAFE DIRECTION EVEN WHEN THE SAFETY IS ON.

! **WARNING:** INJURY, DEATH, OR FIREARM DAMAGE CAN RESULT FROM FIRING A FIREARM WITH AN OBSTRUCTION IN THE BORE. BEFORE YOU FIRE, MAKE SURE THAT THE BORE IS NOT OBSTRUCTED. NEVER ATTEMPT TO SHOOT OUT A BORE OBSTRUCTION.

! **WARNING:** ALWAYS WEAR EYE AND EAR PROTECTION. MAKE SURE THAT NEARBY BYSTANDERS ALSO WEAR EYE AND EAR PROTECTION.

! **WARNING:** HANDLING OF CARTRIDGES AND FIRING FIREARMS MAY EXPOSE YOU TO LEAD. ALWAYS ASSURE THAT THERE IS ADEQUATE VENTILATION. ALWAYS WASH YOUR HANDS AFTER HANDLING AMMUNITION OR FIRING YOUR FIREARM.

! **WARNING:** THIS FIREARM WILL FIRE WITHOUT A MAGAZINE IN IT. ALWAYS ASSURE THAT THE CHAMBER IS EMPTY. THE FIREARM SHOULD NOT BE CONSIDERED TO BE SAFE UNLESS THE MAGAZINE IS REMOVED, THE SAFETY IS ON, AND THE BOLT IS OPEN, AND THE CHAMBER IS EMPTY.

! **CAUTION:** THE FIRED CARTRIDGE CASE IS HOT WHEN IT IS EJECTED FROM THE FIREARM. DO NOT ALLOW IT TO BURN YOU, OR TO DISTRACT YOU FROM SAFE HANDLING OF THE FIREARM.

! **WARNING:** IF THE FIREARM FAILS TO FIRE WHEN THE TRIGGER IS PULLED:

1. KEEP THE FIREARM POINTED AT THE TARGET!!!
2. WAIT 15 SECONDS TO ALLOW A POSSIBLE “HANGFIRE” TO GO OFF. THEN,
3. CHECK TO SEE IF THE SAFETY IS ENGAGED BY MISTAKE. IF SO, PUSH THE SAFETY TO THE “FIRE” POSITION AND FIRE.
4. IF THE FIREARM STILL DOESN’T FIRE, BE CAUTIOUS AND ASSUME THAT THE CARTRIDGE WILL DISCHARGE WHEN THE BOLT IS OPENED.
5. OPEN THE BOLT QUICKLY AND UNLOAD THE FIREARM.

6. EXAMINE THE FIREARM AND CARTRIDGE CAREFULLY TO IDENTIFY THE CAUSE OF THE MALFUNCTION.



WARNING: RAPID FIRING OF THE FIREARM MAY CAUSE SOME COMPONENTS TO BECOME HOT ENOUGH TO CAUSE INJURY. EXTENDED SESSIONS OF VERY RAPID FIRING MAY CAUSE A CARTRIDGE LEFT IN THE CHAMBER TO "COOKOFF", FIRING ITSELF WITHOUT YOU PULLING THE TRIGGER. ALWAYS UNLOAD THE FIREARM IMMEDIATELY AFTER YOU FINISH FIRING.

To prevent cookoffs and maximize barrel life, the rate of fire should not exceed the following:

2 minutes --- 40 rounds per minute
10 minutes --- 30 rounds per minute
20 minutes --- 20 rounds per minute
30 minutes or more --- 13 rounds per minute

9.1 LOADING THE MAGAZINE

Set the cartridge on the follower, between the feed lips and pointing the same direction as the "bullet" on the follower, and press it straight down until it's held by the lips of the magazine.

NOTICE: CURRENTLY ARMALITE® SELLS 5.56MM MAGAZINES THAT ARE DESIGNED FOR CAPACITIES OF 5, 10, 20, AND 30 ROUNDS. DO NOT EXCEED THESE CAPACITIES. DUE TO VARIATIONS IN DIAMETERS OF VARIOUS BRANDS OF CARTRIDGES, IT MAY BE POSSIBLE TO FORCE AN ADDITIONAL CARTRIDGE INTO A MAGAZINE. DOING SO WILL DAMAGE YOUR MAGAZINE AND LEAD TO ELEVATED MALFUNCTION RATES.

Take it easy with your magazines. Keep them clean, dry, and don't pound them into the rifle. It looks great in the movies but is wrong. Insert them smoothly then check to assure they're locked in the rifle by tugging downward.

1. Pull the charging handle (U-13) rearward, lock the bolt carrier assembly (U-10) by depressing the bolt stop (L-18) and releasing the charging handle and moving it to its normal forward locked position. Place the safety (L-23) on SAFE. Check to see that the chamber is clear and the bore is not blocked.



A2996

2. Push upward on the magazine until the magazine catch (L-1) engages and holds the magazine. Pull down on the magazine slightly to make sure that it is locked in place.



9.2 CHAMBERING AND FIRING A ROUND, STARTING WITH THE BOLT OPEN AND MAGAZINE INSERTED

1. Depress the upper portion of the bolt stop (L-18) to release the bolt.



2. With the rifle pointed in a safe direction, move the safety (L-23) to "FIRE".
3. Squeeze the trigger (L-26) and fire.



9.3 CHAMBERING AND FIRING A ROUND, STARTING WITH THE BOLT CLOSED AND MAGAZINE INSERTED

1. Pull the charging handle (U-13) all the way back.



A3004

2. Release the charging handle completely and let it slide forward at full speed; never “ride” the charging handle. Assure it is latched in the forward position after it is released.
3. If the bolt carrier (U-10) doesn’t fully close, tap the forward assist (U-18) to close it. If it still doesn’t close, clear the rifle (See Section 10) and correct the problem.
4. Set the safety to “FIRE”, grip the rifle firmly, and squeeze the trigger.



A3545



A3009



WARNING: GRIPPING THE RIFLE LOOSELY WHEN FIRING CAN CAUSE THE SHOOTER TO FIRE TWO SHOTS (THE SECOND AS THE TRIGGER STRIKES THE SHOOTER'S TRIGGER FINGER DURING COUNTER-RECOIL.) THIS IS A SHOOTER ERROR, NOT A RIFLE MALFUNCTION.

NOTICE: DO NOT REST THE RIFLE ON ITS MAGAZINE WHEN YOU ARE LOADING OR FIRING IT. DOING SO CAN FORCE THE MAGAZINE UP INTO THE RIFLE, REDUCING THE RELIABILITY OF FEEDING CARTRIDGES.

10. CLEARING / UNLOADING THE FIREARM

! **WARNING: ALWAYS ASSUME ALL FIREARMS ARE LOADED. ANYTIME YOU HANDLE A FIREARM, YOU SHOULD IMMEDIATELY INSPECT IT TO ASSURE THAT IT IS COMPLETELY UNLOADED.**

! **WARNING: IF YOU KNOW NOTHING ELSE ABOUT YOUR ARMALITE® FIREARM, YOU MUST KNOW HOW TO UNLOAD IT AND CLEAR IT TO MAKE IT SAFE.**

Keep your rifle cleared when not in use.

1. Place safety lever (L-23) on “SAFE”.

NOTE: If the rifle is not cocked, the lever cannot be pointed toward SAFE.



A3011

2. Remove the magazine by depressing the magazine catch button (L-21) and pulling the magazine down.



A3017

NOTE: Some legal jurisdictions require use of a tool to remove the magazine. ArmaLite firearms sold to such jurisdictions contain a magazine catch button that has been inset so that you will need to use a bullet nose or other similar tool to release the magazine.

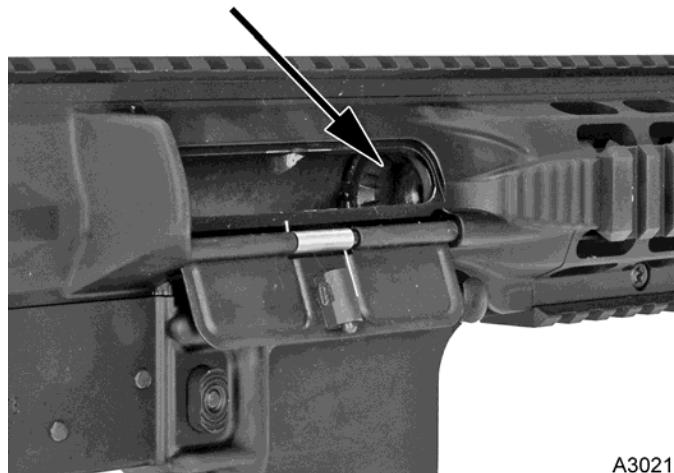
NOTICE: THE MAGAZINE WILL FALL FREE WHEN THE MAGAZINE CATCH IS PRESSED. DON'T ALLOW THE MAGAZINE TO FALL ONTO A HARD SURFACE. DOING SO MAY DAMAGE THE MAGAZINE.

3. Extract the cartridge (if any) from the chamber. To lock the bolt carrier assembly (U-10) open, pull the charging handle rearward, press the lower portion of the bolt catch, and then allow the bolt to move forward until the bolt stop retains it. Return the charging handle forward, to its locked position.



A2996

4. Look into the receiver and chamber to ensure that these areas contain no ammunition.



A3021

⚠ WARNING: NEVER ASSUME THAT THE CHAMBER IS EMPTY UNTIL YOU HAVE VISUALLY EXAMINED IT AND SEE THAT IT IS EMPTY.

5. Empty all remaining cartridges out of your magazines.

⚠ WARNING: THE STEPS IN UNLOADING YOUR FIREARM MUST BE FOLLOWED IN THE EXACT ORDER GIVEN. THE MAGAZINE MUST BE REMOVED BEFORE THE CHAMBER IS INSPECTED. IF YOU CLEAR THE CHAMBER BEFORE REMOVING THE MAGAZINE, YOU MAY REMOVE ONE CARTRIDGE FROM THE CHAMBER AND THEN, UPON CLOSING THE BOLT, CHAMBER ANOTHER CARTRIDGE FROM THE MAGAZINE. THE FIREARM WILL STILL BE LOADED. REMEMBER THAT A CARTRIDGE IN THE CHAMBER CAN STILL BE FIRED EVEN AFTER THE MAGAZINE IS REMOVED.

11. ZEROING THE SIGHTS

Your ArmaLite® SPR Mod 1™ is designed to employ a telescopic sight as its primary sighting device. To install and zero the scope or any other accessory on your SPR Mod 1™ follow the instructions in accessory's owner's manual.

12. DISASSEMBLY

⚠️ WARNING: ALWAYS UNLOAD YOUR FIREARM BEFORE CLEANING, LUBRICATION, DISASSEMBLY, OR REASSEMBLY.

⚠️ WARNING: ALWAYS WEAR SAFETY GLASSES WHEN DISASSEMBLING, MAINTAINING, OR ASSEMBLING YOUR FIREARM. IN PARTICULAR, THE OPERATING SPRING IS UNDER HIGH COMPRESSION. IF IT SLIPS FROM YOUR GRASP, IT COULD CAUSE INJURY.

12.1 CLEAR THE RIFLE

IMPORTANT: Put the safety on “SAFE”. Remove the magazine, THEN pull back the charging handle and check the chamber.

SLING

Remove the sling (if attached) by unbuckling from the buttstock swivel and depressing the push button of the quick detachment swivel from the SPR Mod 1 Handguard QD Rail.



A3529

12.2 UPPER AND LOWER RECEIVERS

1. Push the takedown pin (L-13) as far as it will go.

NOTICE: EXCESS FORCE CAN SEVERELY DAMAGE THE RECEIVER. TAKE IT EASY!



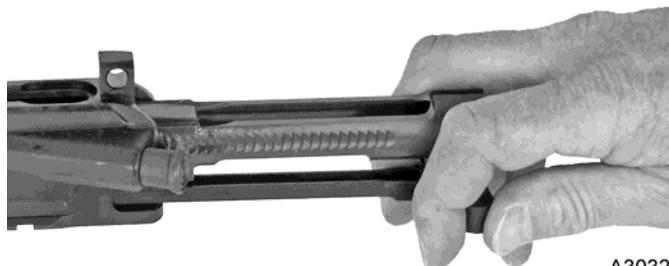
A3025

2. Pivot the upper receiver (U-1) from the lower receiver (L-2).
3. Push the receiver pivot pin (L-14) as far as it will go. Take it easy!
4. Separate the upper and lower receivers.



12.3 CHARGING HANDLE AND BOLT CARRIER ASSEMBLY

1. Pull back the charging handle (U-13) and bolt carrier assembly (U-10).



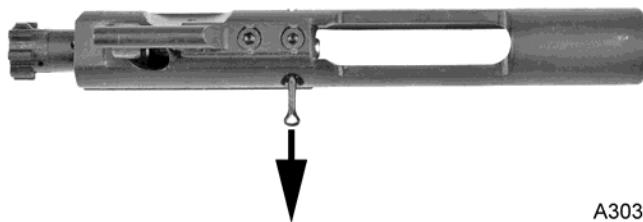
2. Remove the bolt carrier assembly.



3. Pull the charging handle back and down to remove it.



4. Move the bolt assembly (BC-7) forward to the unlocked position and remove the firing pin retaining pin (BC-1). Do not open or close the split end of the firing pin retaining pin.



A3038

5. Push in on the bolt assembly (BC-7) to put it in the locked position.



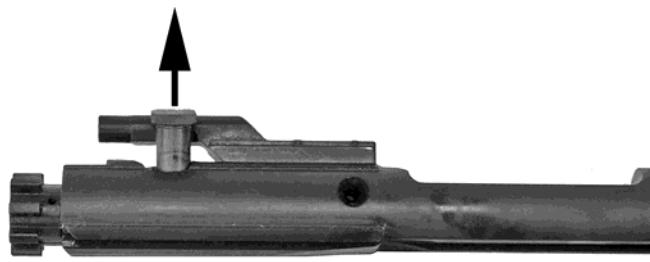
A3041

6. Catch the firing pin (BC-2) as it drops out of the rear of the bolt carrier assembly.



A3042

7. Give the bolt cam pin (BC-3) a $\frac{1}{4}$ turn and lift it out.



A3043

8. Remove the bolt assembly from the bolt carrier assembly.

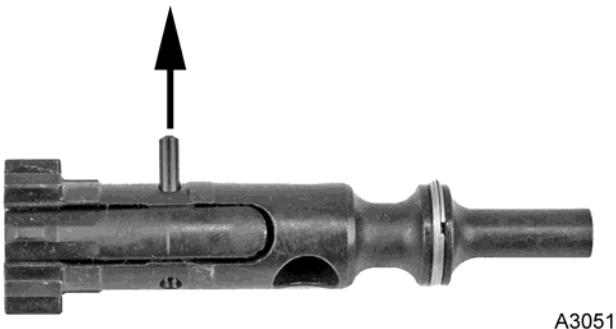


A3046

9. Press the rear of the extractor (B-6) to check that the spring works.



10. Use a punch or dummy round to remove the extractor pin (B-7).



11. Remove the extractor and spring assembly. Do not remove the spring assembly (B-4), its plunger (B-3) or the O-ring (B-5) from the extractor (B-6).



A3053

12.4 LOWER RECEIVER ASSEMBLY

1. Cock the hammer (L-29) with your thumb. Push in the buffer (L-5) and depress the buffer detent (L-15) to release the buffer.



2. Remove the buffer (L-5) and the operating spring (L-6).



A3059

12.5 DISASSEMBLING THE MAGAZINE

1. Use the tip of a cartridge or another suitable tool to very slightly pry the rear of the floorplate up so that it can be pulled off the magazine.



A3060

2. Remove the spring and attached follower from the magazine shell. The spring will exit the shell easily, but the follower must be twisted and withdrawn, rear first. Do not remove the spring from the follower.



A3061

NO FURTHER DISASSEMBLY OF THE FIREARM IS REQUIRED.

13. MAINTENANCE

 **WARNING: ALWAYS UNLOAD YOUR FIREARM BEFORE CLEANING, LUBRICATION, DISASSEMBLY, OR REASSEMBLY.**

 **WARNING: DO NOT APPLY LUBRICANT OR PRESERVATIVE TO YOUR AMMUNITION. DOING SO MAY CAUSE THE CARTRIDGE TO PARTIALLY MALFUNCTION, LEAVING THE BULLET LODGED IN THE BORE, CREATING A BORE OBSTRUCTION.**

13.1 CLEANING SOLVENTS AND LUBRICANTS

The Military Services generally use a multipurpose chemical called CLP (cleaner, lubricant, and preservative) sold commercially as “Break Free.” Although it is useful if nothing else is available, armament engineers prefer individual, specialized products. A combination of military RBC (rifle bore cleaner) and LSA (lubricant, semifluid, automatic firearms) is superior. High quality cleaning solvent like Hoppe's No. 9 removes metal fouling from the bore excellently; and Teflon bearing lubes are outstanding lubricants. For maximum reliability and service life, lubricate your rifle (especially the highly stressed bolt and bolt carrier assembly) generously with high quality firearms lubricants.

Under NO conditions should any lubricant containing graphite be used with your rifle. Graphite can encourage rapid corrosion to the aircraft-grade aluminum used in your rifle.

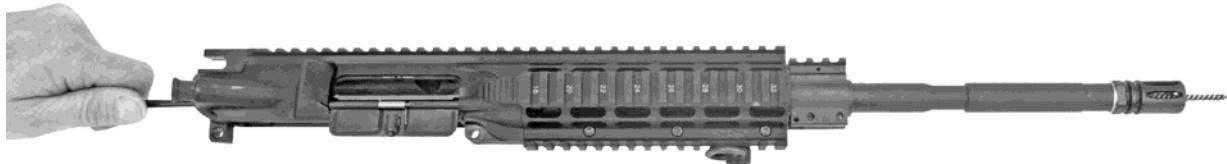
In addition to cleaning solvents and lubricants, the basic cleaning equipment you will need includes a cleaning rod, brass bore brush, chamber brush, toothbrush, patches, pipe cleaners, and the most important item: a lint-free cloth. ArmaLite® recommends a pull-through cleaning cable for efficient, breech-to-muzzle cleaning.

13.2 UPPER RECEIVER AND BARREL ASSEMBLY

1. Use cleaning solvent on the bore and chamber, the gas tube (U-11), the upper receiver and barrel assembly, locking lugs and all areas of powder fouling, corrosion, dirt or dust.

 **WARNING: LEAD MAY BE PRESENT IN THE FOULING OF A DIRTY RIFLE. AVOID CONTACT WITH IT, AND CLEAN HANDS AFTERWARD TO AVOID INGESTING LEAD.**

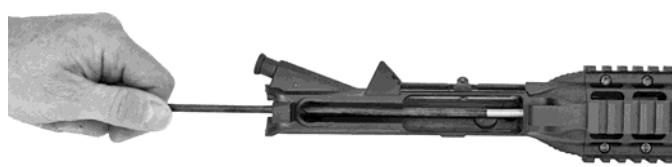
2. Use a cleaning rod, bore brush and cleaning solvent. Run the rod through the chamber completely through past the suppressor (U-14) several times.



A3062

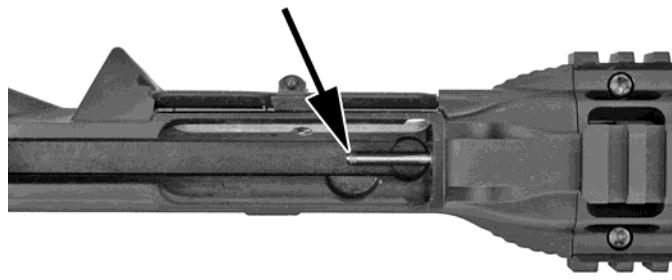
NOTICE: DON'T REVERSE THE DIRECTION OF THE BORE BRUSH WHILE IT'S IN THE BORE.

3. Install the chamber brush on the cleaning rod, dip it in cleaning solvent, and insert it into the chamber and locking lugs. Clean by pushing and twisting the cleaning rod.



A3063

4. Use a worn out bore brush to clean the outside surface of the protruding gas tube (U-11) (get the sides and bottom from the bottom of the upper receiver). This procedure ruins the brush.



A3066

NOTE: Gas tubes will discolor from heat. Do not try to remove this discoloration.

NOTICE: DO NOT TRY TO CLEAN THE INSIDE OF THE GAS TUBE. IT IS NOT NEEDED WITH GOOD QUALITY PROPELLANT, NOR IS IT EFFECTIVE WITH BAD PROPELLANT.

NOTICE: DO NOT BEND THE GAS TUBE. IF THE TUBE IS BENT, IT WILL SLOW OR BLOCK FORWARD MOVEMENT OF THE BOLT CARRIER ASSEMBLY.

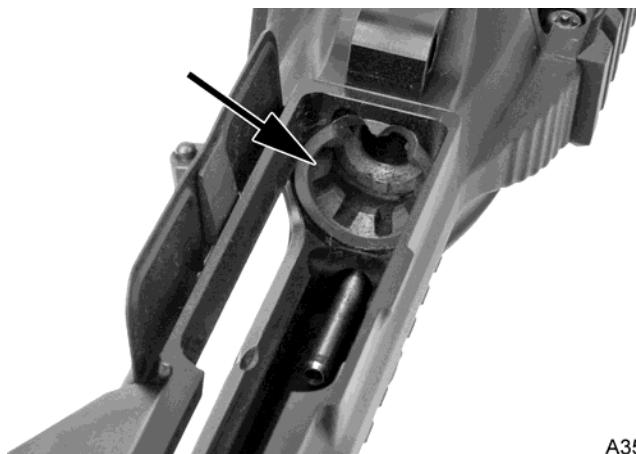
5. Take the bore brush off the rod and install a swab holder and a swab. Apply cleaning solvent to the swab; then run it through the chamber and out the flash suppressor (if applicable). To remove carbon build up, let the solvent sit, then wipe clean. A bore brush may be used with care to remove heavy carbon buildup. Wipe the bore dry by running clean swabs all the way through from the chamber to the flash suppressor. REMEMBER, do not change directions in the bore.

6. Inspect the barrel, gas tube, and hand guards for cracks, bends, or breaks. Be sure the barrel has no obstructions.



A3531

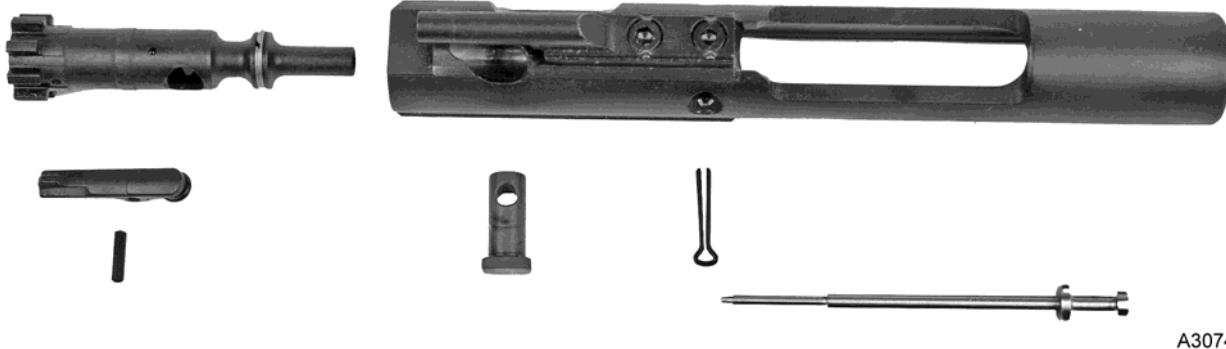
7. Lightly lubricate the bore and chamber, outer surface of the barrel and front sight, and the surfaces under the handguards.
8. With a lubricated swab, run the rod from the receiver to the flash suppressor. Do not over lubricate.
9. Lubricate the locking lugs.



A3542

13.3 CHARGING HANDLE AND BOLT CARRIER ASSEMBLY

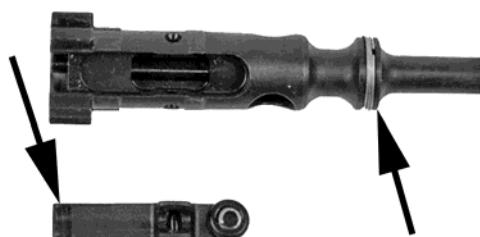
1. Clean all parts and outer surfaces of the bolt carrier assembly with a swab saturated with cleaning solvent.



2. Clean the bolt carrier key (BC-6) with a worn bore brush dipped in solvent and dry with a pipe cleaner.



3. Remove carbon deposits and dirt from the locking lugs with a bore brush dipped in solvent.



4. Clean the areas behind the bolt gas rings and under the lip if the extractor.



5. Press the ejector (B-10) in repeatedly to remove accumulated brass shavings from the ejector hole and assure the ejector moves freely. Lubricate it generously.



6. Inspect the charging handle for cracks, bends or breaks.



7. Inspect the bolt assembly for cracks or fractures, especially in the cam pin hole area.



WARNING: DO NOT INTERCHANGE BOLTS BETWEEN RIFLES.

8. Inspect the firing pin retaining pin for bends, breaks, or dents.



9. Inspect the bolt cam pin for cracks or chips.



10. Inspect the firing pin for bends, cracks, or a sharp, chipped, or blunted tip.

11. Lightly lubricate the firing pin and firing pin recess in the bolt assembly.

12. Generously lubricate the outside of the bolt cam pin and the firing pin retaining pin. Make certain to lubricate the bolt cam pin hole, bolt rings, and outside of the bolt.

13. Lightly lubricate the inner and outer surfaces of the bolt carrier.
Generously lubricate the slide and the cam pin area of the bolt carrier.



14. Lightly lubricate the charging handle.

15. Dry the key (BC-6) of the bolt carrier assembly (U-10) with a pipe cleaner. Place one drop of lubricant inside the key.

NOTE: Carbon in the groove at the bottom of the gas cylinder in the carrier cannot accumulate enough to become a problem. Efforts to remove it cause more damage than leaving it. Avoid the instinct to over clean your rifle.

A3084

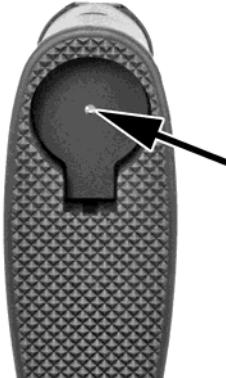
13.4 LOWER RECEIVER ASSEMBLY

NOTICE: DO NOT USE A WIRE BRUSH OR ANY TYPE OF ABRASIVE MATERIAL TO CLEAN ALUMINUM SURFACES

1. Wipe dirt from the trigger with a swab.
2. Use a swab and cleaning brush to clean powder fouling, corrosion, and dirt from the lower receiver.



3. Use a pipe cleaner to clean the hole in the rear of the buttstock tube.



4. Clean the buffer, recoil spring, and inside lower receiver with a swab dipped in solvent.
5. Lightly lubricate the buffer and operating spring.



6. Examine the lower receiver assembly for a broken or bent trigger, buttstock, corroded or deformed lower receiver, cracked or damaged grip, and bent or damaged safety. Look at the inside parts for cracks, dents, or breaks.



A3090

7. Generously lubricate the takedown (L-13) and pivot pins (L-14) and the inside parts of the lower receiver assembly.

13.5 LONG TERM STORAGE

Clean your firearm well and apply a good quality preservative.

It is at least theoretically possible for some springs to take a set during prolonged storage. To preclude this possibility, ArmaLite offers the following recommendations regarding long term storage of your firearm.



WARNING: FOLLOW ALL OF THE RULES OF SAFE GUN HANDLING ANYTIME YOU DRY FIRE YOUR FIREARM.

NOTICE: NEVER DRY FIRE YOUR FIREARM WITHOUT THE BOLT CARRIER ASSEMBLY INSTALLED. THE FIRING PIN STOPS THE FALL OF THE HAMMER. WITHOUT THE BOLT CARRIER ASSEMBLY INSTALLED, THE HAMMER CAN IMPACT ON THE LOWER RECEIVER, DAMAGING IT.

Reasonable amounts of dry firing should not damage your firearm.

Clear all cartridges from your firearm. Remove the magazine. Then pull back the charging handle and visually confirm that the chamber is empty and that there is no cartridge held to the bolt face by the extractor. Then check it again. Then dry fire the firearm to allow the hammer to rotate to the fired position.

It is always best to store your magazines empty. However if you need to store them loaded, we recommend that you store them with 5 rounds less than their stated capacity.

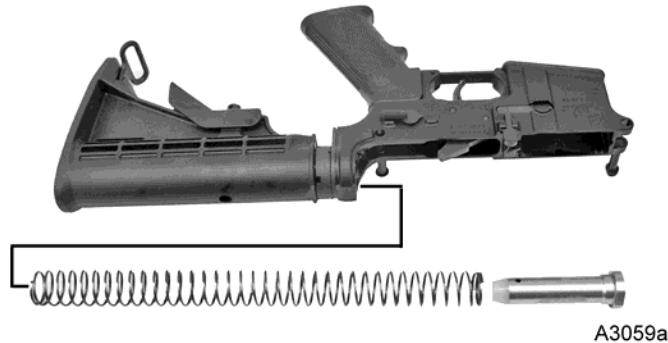
When you're taking your firearm out of long term storage, remove the preservative and lubricate as stated elsewhere in this manual.

14. REASSEMBLY

⚠️ WARNING: ALWAYS UNLOAD YOUR FIREARM BEFORE CLEANING, LUBRICATION, DISASSEMBLY, OR REASSEMBLY.

14.1 LOWER RECEIVER ASSEMBLY

1. Insert operating spring and buffer.

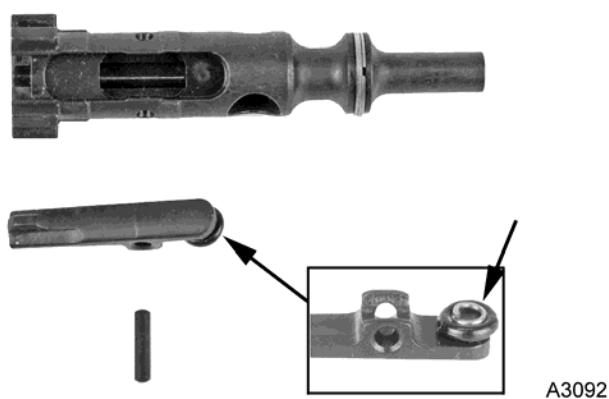


14.2 CHARGING HANDLE AND BOLT CARRIER

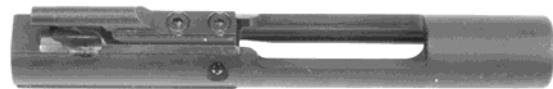
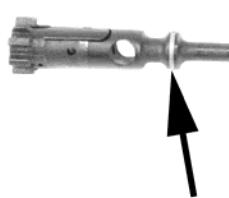
1. If the spring assembly came loose from the extractor, seat the large end of the spring in the extractor. Assure the silicon extractor spring plunger (B-3) and reinforcing O-ring (B-5) are properly assembled.

NOTICE: DO NOT LOSE THE SILICONE PLUNGER IN THE EXTRACTOR SPRING NOR THE O-RING; LOSS MAY LEAD TO GREATER CHANCE OF MALFUNCTION.

2. Insert the extractor with spring assembly into the bolt.
3. Push extractor until the holes on the extractor and bolt are aligned and insert the extractor pin.

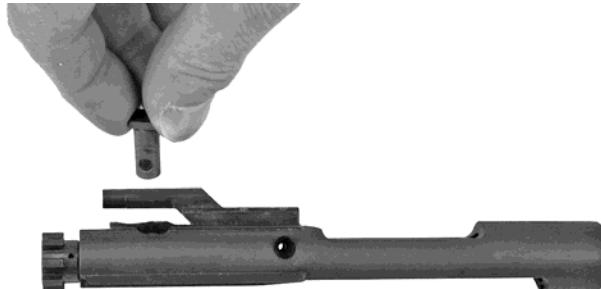


4. Stagger the gaps in the gas rings (B-1) to prevent gas loss.



A3096

5. Slide the bolt assembly into the bolt carrier **only far enough to insert the cam pin.**



6. Insert the cam pin (BC-3) and give it a $\frac{1}{4}$ turn.

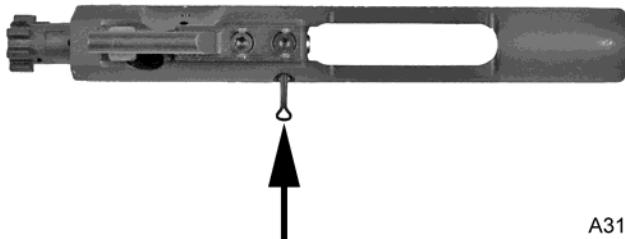
A3098

7. Drop the firing pin into its opening.



A3100

8. Pull the bolt assembly forward and insert the firing pin retaining pin in the area behind the large flange of the firing pin.



A3101

NOTICE: DO NOT POUND OR FORCE THE FIRING PIN RETAINING PIN INTO POSITION; IT MAY BE DAMAGED.

9. Turn the bolt carrier assembly up and try to shake out the firing pin. The firing pin must not fall out.



A3103

10. Place the charging handle into the upper receiver and engage the handle's lugs with the track in the receiver, then push the charging handle part way into the upper receiver.



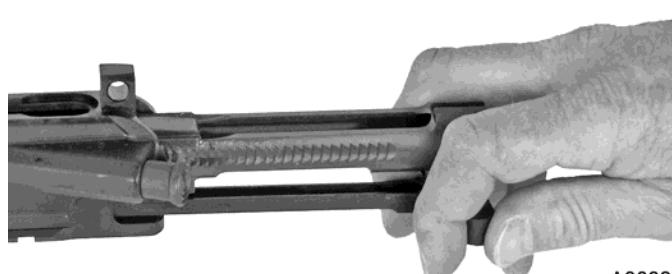
A3036

11. Slide the bolt carrier assembly, bolt extended, into the upper receiver.



A3037

12. Push the charging handle assembly and bolt carrier assembly together into the upper receiver.



A3032

14.3 UPPER AND LOWER RECEIVERS

NOTE: The hammer must be in cocked position to join the receivers.

1. Join the upper and lower receivers.
2. Align the pivot pin holes with the pivot pin and push the pivot pin in.



NOTICE: TO AVOID DAMAGE TO THE EJECTION PORT COVER, CLOSE THE EJECTION PORT COVER BEFORE THE RECEIVERS ARE JOINED.

3. Close the upper and lower receivers.
Push in the takedown pin.

NOTE: Normal forging and manufacturing variations may result in slight overhang or play. This will not affect function or accuracy.



14.4 FUNCTIONAL CHECK

1. Remove the magazine and visually inspect the chamber to assure that it is empty. Install an empty magazine. Assure that it is caught solidly by the magazine catch.
2. Pull the charging handle to the rear and then manually return it forward. The bolt should remain to the rear against the bolt stop. Remove the magazine. Press in on the bolt stop (L-18). The bolt carrier assembly should be propelled forward by the operating spring.
3. Place the safety (L-23) on “SAFE”. Squeeze the trigger (L-26). *The hammer (L-29) should not fall.*
4. Place the safety (L-23) on “FIRE”. Squeeze the trigger (L-26) and hold the trigger to the rear; *the hammer (L-29) should fall.* Pull the charging handle (U-13) to the rear and release it. Release the trigger. *You should hear a click as you release the trigger.* Squeeze again; *the hammer should fall.*



CALL ARMALITE® AT (309) 944-6939 IF YOUR RIFLE FAILS THIS TEST.

15. TROUBLESHOOTING

PROBLEM	CHECK FOR	WHAT TO DO
WON'T FIRE	Selector lever on "SAFE"	Put it on "FIRE".
	Improper assembly of firing pin	Assemble correctly. NOTE: the retaining pin goes in back of large shoulder of firing pin.
	Oil or fouling in bolt	Clean with pipe cleaner.
	Defective ammunition	Remove and discard.
	Too much carbon on firing pin	Clean.
	Bolt not fully locked.	Extract cartridge, clean area.
BOLT WON'T LOCK	Dirty bolt	Clean.
	Burred or broken bolt	Contact ArmaLite®.
	Ejector stuck	Contact ArmaLite®.
	Dirt, corrosion, or carbon buildup in barrel locking lugs	Clean lugs.
WON'T EXTRACT	Broken extractor spring	Replace.
	Inner spring or reinforcement ring missing from extractor spring	Replace.
	Dirty, corroded, or reloaded ammunition	Remove and discard.
	Carbon in chamber	Clean chamber.
	Frozen or worn extractor	Remove and clean.
	Restricted buffer assembly	Remove and clean.
	Restricted movement of bolt carrier assembly.	Remove, clean and lubricate.

TROUBLESHOOTING (CONTINUED)

PROBLEM	CHECK FOR	WHAT TO DO
WON'T EXTRACT	Clogged gas tube	Replace.
	Short recoil	See below.
WON'T FEED	Dirty, corroded, or reloaded ammunition	Remove and discard.
	Dirty or defective magazine	Clean and lubricate or replace.
	Too many rounds in magazine	Remove excess rounds.
	Buffer assembly is restricted	Take out and clean buffer and spring.
WON'T FEED	Magazine not fully seated	Adjust magazine catch: Press button on right side, and turn catch on left. Clockwise tightens.
	Short recoil	See below.
DOUBLE FEED	Defective magazine	Replace.
WON'T CHAMBER	Dirty corroded or defective ammunition.	Remove and discard.
	Ejector stuck	Clean and oil.
	Carbon in carrier key or chamber	Clean.
SHORT RECOIL	Rings worn or too loose.	Replace.
	Carbon or dirt in carrier key or on outside of gas tube	Clean.
	Q-tip/pipe cleaner stuck inside carrier key	Remove.

TROUBLESHOOTING (CONTINUED)

PROBLEM	CHECK FOR	WHAT TO DO
SHORT RECOIL	Loss of gas power	Check entire gas path
	Weak or reloaded ammunition	Replace with factory fresh ammunition.
	Dirty rifle	Clean.
	Improper lubrication	Lubricate generously.
BOLT FAILS TO LOCK OPEN AFTER LAST ROUND	Defective magazine	Replace.
	Dirty or corroded bolt catch	Clean or replace.
SELECTOR LEVER BINDS	Needs oil	Lubricate.
	Dirt or sand under trigger.	Clean.
BOLT CARRIER “HUNG UP”	Round jammed between bolt and charging handle and/or double feed	<ol style="list-style-type: none">1. Remove magazine.2. Push in on bottom of bolt catch.3. Bang rifle butt on ground, bolt should shift to rear.4. While bolt is held to rear, round should fall out through magazine well.
		<p>NOTE: If this procedure fails, use a cleaning rod to push bolt fully to the rear through the ejection port.</p>

16. WARRANTY, SERVICE, AND SUGGESTIONS

Specific warranty provisions for your ArmaLite® firearm are shown on the warranty card shipped with your new firearm. Be sure to complete your warranty card and return it to ArmaLite® immediately.

THE WARRANTY WILL ONLY BE HONORED UPON COMPLETION OF THE WARRANTY FORM AND ITS RETURN TO ARMALITE® WITHIN 30 DAYS OF THE ORIGINAL CUSTOMER'S PURCHASE DATE ALONG WITH A COPY OF THE DATED SALES RECEIPT.

If no warranty card and sales receipt are on file, all work will be billed at shop rates. Custom work will be billed at ArmaLite®'s shop rates, as will work on firearms submitted with no warranty problem existing. Shipping to and from ArmaLite® is the owner's responsibility, except that ARMALITE® will return the firearm to the customer shipping prepaid if the return was covered under warranty.

Returns for any reason will NOT be accepted without a Return Merchandise Authorization (RMA) number issued by ArmaLite. Please call 1-800-336-0184, Ext. 125 to receive your RMA number. After you receive your RMA number, print it on the outside of the box and include a short note in the box. The note should include the RMA number, your name, address, email, phone number, the model and serial number of the firearm you're returning, and a detailed explanation of the problems that you're having with the firearm. If you wish to put your note on our RMA form, you can print out our RMA form by clicking on the link in the Policies or Contact Us sections of our website.

Remove any accessories (scope, scope mount, sling, bipod, cleaning equipment, etc) that don't pertain to your problems before you send the firearm in. If you have any functional problem with the firearm, do send the magazines with it.

Firearms that you wish to return for warranty or out-of-warranty repair may be returned directly to ArmaLite.

Before seeking warranty service: use the troubleshooting guide in this Operator's Manual to attempt to solve the problem, perform all instructed maintenance, and assure that ammunition and magazines are correct and in good condition. **Shop rates plus the cost of return shipping will be applied if no covered defect is found.**

Include a note explaining, in as much detail as possible, the nature of the problem or service needed. The note should include the RMA number, your name, address, email, phone number, and the reason for return. If you wish to put your note on our RMA form, you can print out our RMA form found in the "Contact Us" and "Policies" sections of our website (www.ArmaLite.com). Keep your shipping receipt and the serial number of the firearm for your records in case of loss in shipment.



WARNING: MAKE ABSOLUTELY SURE THAT THE FIREARM IS UNLOADED!!! BELIEVE IT OR NOT, WE SOMETIMES GET FIREARMS BACK THAT ARE LOADED!!!

 **WARNING: NEVER SHIP LIVE AMMUNITION WITH ANY FIREARM THAT YOU ARE RETURNING TO ARMALITE® FOR SERVICE.**

 **WARNING: IT IS THE OWNER'S RESPONSIBILITY TO ASSURE THAT ANY PARTS THAT ARE PURCHASED FROM ARMALITE® ARE CORRECTLY FITTED AND INSTALLED. IMPROPER FITTING OR INSTALLATION MAY RESULT IN INJURY, DEATH, OR DAMAGE/MALFUNCTION OF THE FIREARM.**

A copy of the owner's manual for any ArmaLite® firearm is available free in the Library on ArmaLite®'s website or may be obtained free in hard copy by contacting ArmaLite®.

Additional technical information can be found in Technical Notes in the Library section of ArmaLite®'s website.

To answer any questions you may have about the firearm, or to offer suggestions for improvements, please contact us at:

**ArmaLite, Inc
P.O. Box 299
Geneseo, Illinois, 61254**

Phone: 1-800-336-0184 or 309-944-6939

Fax: 309-944-6949

Email: info@ArmaLite.com

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PATENTS & TRADEMARKS

“ArmaLite®”, “AR-10®”, and “SPR®”, are registered trademarks of ArmaLite, Inc.

“M-15™”, “AR-30™”, “AR-50™”, and other model variants are trademarks of ArmaLite, Inc.

The AR-10® Series Rifles and Carbines (including the SuperSASS™) are protected by U.S. Patents 5,638,626 and 5,911,173 and 6,044,748.

The M-15™ Series Rifles and Carbines are protected by U.S. Patents 5,911,173 and 6,044,748.

The AR-30™ and AR-50™ Series Rifles are protected by U.S. Patents 6,487,805 and 6,637,142.

The AR-23 Subcaliber Device for the Mk-19 Grenade Machine Gun is protected by U.S. Patents 5,983,772 and 6,202,533.

The Blank Firing Adapter for the Mk-19 Grenade Machine Gun is protected by U.S. Patent 5,438,907.

Other patents granted or assigned to ArmaLite include:

Weapons Operating System, U.S. Patent 6,591,535

Cartridge for a Firearm, U.S. Patents 6,367,389 and 6,959,647 and 6,976,431 and 7,458,332

Light Weight Weapon Operating System and Cartridge Feed, U.S. Patent 6,591,535