

BLACK RIFLE MANUAL

OPERATION,
MAINTENANCE &
TROUBLESHOOTING



⚠ IMPORTANT

This manual contains operating, care and maintenance instructions. To assure safe operation, any user of this firearm must read and understand this manual before using the firearm. Failure to follow the instructions and heed the warnings of this manual can cause property damage, personal injury, and/or death.

This manual should always accompany this firearm, and be transferred with upon change of ownership.

WARNING! Keep this firearm out of the reach of children, unauthorized individuals, and other unfamiliar with safe handling of firearms.



**ADVANCED
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THE TEN COMMANDMENTS OF FIREARM SAFETY

The Ten Commandments of Firearm Safety should be etched in your memory forever. Let them govern your action wherever and whenever you're involved with firearms, in the field, on the range, or in your home. Please take the time to review and understand these rules.

1ST COMMANDMENT

ALWAYS KEEP THE MUZZLE POINTED IN A SAFE DIRECTION.

This is the most important firearm safety rule. A safe direction is one in which an accidental discharge will not cause injury to yourself or others. Never allow your firearm to point at anything you don't intend to shoot. Be especially careful when you're loading or unloading. Treat every firearm as if it were loaded. Make it a habit to know where the muzzle is pointed at all times, even when your firearm is un-loaded. No one will be injured by an accidental discharge if you keep your firearm pointed in a safe direction. It's as simple as that.

2ND COMMANDMENT

FIREARMS SHOULD BE UNLOADED WHEN NOT ACTUALLY IN USE.

Load your firearm only when you're in the field or on the target range and ready to fire. Never let a loaded firearm out of your sight or out of your hands. Unload it as soon as you're finished shooting - before you bring it into your car, camp or home. Remember, unloading your firearm means unloading it completely, so there is no ammunition in the chamber or in the magazine. Before handling a firearm or passing it to someone else, visually check the chamber, receiver and magazine to be certain they do not contain ammunition. Always keep the firearm's action open when not in use. Never assume a firearm is unloaded even if you were the last person to use it. Always check for yourself.

- Let common sense rule when you carry a loaded firearm. If you're in a situation that could risk accidental discharge - such as crossing a fence, wading through a stream or climbing a tree - always unload your firearm. Never pull or push a loaded firearm toward yourself or another person. Never carry a loaded firearm in a scabbard, detached holster or gun case.

- Certain firearms are equipped with internal security devices to prevent unauthorized use. In addition, some firearms owners use external devices, such as cable locks and trigger blocks, for the same purpose. Even if you use such a device, you should still keep your firearm unloaded when stored or not in use. And using internal or external devices cannot substitute, however, for securing your firearms and ammunition in a separate, locked location.

- Safe storage of firearms is just as critical as safe handling. Never store firearms loaded. Be sure to keep your firearms in a secure place where unauthorized persons cannot get their hands on them without your knowledge.

- Take special care if there are children around. Children are fascinated by firearms. It's a natural curiosity that can have tragic consequences when not properly supervised. Store your firearms in a locked gun safe or some other location that physically bars a child from gaining access.

- Ammunition should be stored and locked in a location separate from your firearm. Never leave an unsecured firearm or ammunition in a closet, dresser drawer or under the bed. Remember, it is your responsibility to make sure that children and others unfamiliar with firearms cannot get access to your firearm and ammunition.

3RD COMMANDMENT

DON'T RELY ON YOUR FIREARM'S SAFETY

Treat every Firearm as if it can fire at any time, whether or not there's pressure on the trigger. Your firearm has been carefully designed to maximize performance and safety. However, because a firearm's safety is a mechanical device, it could fail.

Human error is a more likely reason for a firearm safety to fail. By mistake, you may think the safety is on when it really isn't, or the safety may have been disengaged without your knowledge, or you could think your firearm is unloaded when there's actually a cartridge or shell in it. A mechanical safety is not a substitute for common sense. It's merely a supplement to your proper handling of a firearm.

Never touch the trigger on a firearm until you are ready to shoot. Keep your fingers away from the trigger when you're loading or unloading. And don't pull the trigger

when the safety is engaged or positioned between safe and fire.

Before using your firearm, read this instruction book to understand the exact location and operation of your firearm's safety. Even when the safety is on, maintain control of your loaded firearm and control the direction of the muzzle. In other words, don't rely on your safety to justify careless handling. If your firearm's internal mechanisms are broken or have been altered, your firearm may fire even when the safety is on. Remember, you and your safe firearm handling practices are your firearm's best safety.

4TH COMMANDMENT

BE SURE OF YOUR TARGET AND WHAT'S BEYOND IT.

You can't stop a shot in mid-air, so never fire unless you know exactly where your shot is going and what it will strike. Never fire at a sound, a movement or a patch of color. A hunter in camouflage can easily be mistaken for a target by an impulsive shooter. Before you pull the trigger be absolutely sure of your target and what's behind it. Make sure the shot has a backstop such as a hillside or dense material like sand. Remember, bullets can travel great distances with tremendous velocity. Know how far your shot will go if you miss your target or the bullet ricochets.

5TH COMMANDMENT

USE PROPER AMMUNITION

Every firearm is designed to use a certain caliber or gauge of ammunition. Using the wrong ammunition, mixing ammunition or using improperly reloaded ammunition can cause serious personal injury or death. It only takes one cartridge or shotshell of the incorrect caliber or gauge, or which has been improperly reloaded, to destroy your firearm.

It's your responsibility to make sure the ammunition you use exactly matches the caliber or gauge of your firearm. Refer to this instruction book to find out the specific requirements of your firearm. Always read and heed the instructions on ammunition boxes. Confusing shells or cartridges can cause serious personal injury or death and destroy your firearm. Examine your shells or cartridges closely and use only the precise caliber or gauge for your specific firearm. For example, suppose you accidentally loaded a 20 ga. shell into a 12 ga. shotgun. Because the 20 ga. shell is too small for the chamber, the 20 ga. shell could travel down the barrel and get lodged in the bore.

If you then loaded a standard 12 ga. shell behind it and fired, the 12 ga. shot will slam into the lodged 20 ga. shell and may cause the barrel to explode right in your hand. This is commonly called a 12/20 burst, and it can kill you.

Check all ammunition before you load it to make sure it matches your firearm's requirements. Every Remington® and Barnes Bullets cartridge and shell is head-stamped with its caliber or gauge for easy identification. Likewise, you'll find the caliber or gauge of your new AAC firearm imprinted on the barrel.

RELOADING REQUIRES EXTRA DILIGENCE.

If you're an ammunition reloader, you are responsible for personally assuring that the loads and components of your reloaded ammunition meet your firearm's factory-tested standards. Never use ammunition, which has been reloaded by someone else!

Many shooters handload as a hobby or to save money on commercial, factory-made ammunition. However, it requires a thorough knowledge of reloading procedures and a deep respect for the explosive potential of gunpowder.

Firearms are designed, manufactured and proof-tested to standards based on factory-loaded ammunition. Handloaded or reloaded ammunition that deviates, either intentionally or accidentally, from load or component recommendations can be very dangerous.

Reloaders must observe all possible safety precautions and practices related to the proper handling of explosives. Whether you're a seasoned reloader or just starting out, you should study the subject, watch reloading demonstrations and talk to experienced reloaders.

The first rule of reloading is to always follow the manufacturer's instructions for the components you're using. They'll tell you to follow certain guidelines. Namely:

1. Don't mix or substitute powders or primers.
2. Don't use unknown or substandard components.
3. Use only suitable components that have been factory-tested by reputable ammunition, powder and bullet manufacturers.
4. Always be sure to use the manufacturer's recommended recipe when reloading.

Not following these guidelines could result in severe injury to yourself or severe damage to your firearm. Dangerously high pressure and explosions can result

from an overcharge of powder or other deviations from established reloading guidelines. Be very careful. The process of reloading exposes you to environmentally hazardous material. Lead, which is known to cause cancer and birth defects, is the most common substance in bullets and shot. It is important to handle lead bullets and shot with extreme care. Work only in a well-ventilated area and always wash your hands after exposure and before eating. Never smoke while reloading.

Primers and powders are also highly toxic and flammable. So after reloading be sure to clean up all materials from your work area. Don't leave primer or powder spills anywhere on the floor or bench top. Dispose of all waste material in accordance with the manufacturer's recommendations.

Finally, when reloading or hand loading, concentrate on what you're doing at all times. Do not be distracted by talking to others, listening to the radio or watching TV while reloading. Never reload after consuming alcoholic beverages or drugs of any kind. You are working with extremely hazardous materials, and you can't risk even a few seconds of distraction. Remember, if you reload, you are the ammunition manufacturer, and you are responsible for the performance and safety of your reloaded ammunition.

6TH COMMANDMENT

IF YOUR FIREARM FAILS TO FIRE WHEN THE TRIGGER IS PULLED, HANDLE WITH CARE.

If for some reason the ammunition doesn't fire when you pull the trigger, stop and remember the 1st Commandment of Firearm Safety - always keep the muzzle pointed in a safe direction. Keep your face away from the breech, then put the safety on, carefully open the action, unload the firearm and dispose of the cartridge safely. Remember that anytime there's a shell in the chamber, your firearm is loaded and ready to use. Even if you tried to shoot and your firearm didn't fire, treat your firearm as if it could still discharge.

7TH COMMANDMENT

ALWAYS WEAR EYE AND EAR PROTECTION WHEN SHOOTING.

Your sight and hearing risk injury from shooting and should be protected at all times. Wear protective shooting glasses to guard against falling shot, clay target chips, powder residue, ruptured cartridge cases and even twigs and branches in the field.

Also be sure to wear eye protection when you're disassembling or cleaning a firearm so that tensioned parts (like springs) and cleaning solvents don't come in contact with your eyes. Continued exposure to shooting noise can permanently damage your hearing. On the range, where shooting volume is the loudest, be sure to use the maximum protection of a headset. Learn to use ear protection at all times.

8TH COMMANDMENT

BE SURE THE BARREL IS CLEAR OF OBSTRUCTIONS BEFORE SHOOTING.

Before loading your firearm, open the action and make sure there's no ammunition in the chamber or magazine. Check the barrel for any obstructions or debris. Even a small amount of snow, mud, excess lubricant or grease in the bore can dangerously increase pressure and cause the barrel to bulge or burst when firing. Use a cleaning rod and patch to wipe away anti-rust compounds or any other residues or obstructions in the barrel. Never try to shoot out an obstruction by loading another shell and firing!

When firing, rely on your instincts. If the noise or recoil of your firearm seems weak, stop everything, unload your firearm and be sure nothing is lodged in the barrel. Remember the 12/20 burst? That's what can happen when the barrel is obstructed.

Always be sure you're using the correct ammunition in your firearm and that it's free of obstructions.

9TH COMMANDMENT

DON'T ALTER OR MODIFY YOUR FIREARM AND HAVE IT SERVICED REGULARLY.

Your firearm has been designed to operate according to certain factory specifications. You'll jeopardize your safety and that of others around you by attempting to alter its trigger, mechanical safety or other mechanisms. So never alter or modify your firearm in any way.

Like any mechanical device, a firearm is subject to wear. It must be maintained and periodically serviced to assure optimum safety and performance. Only a qualified service facility should service, repair or modify your AAC firearm. Consult your instruction book for instructions on how to send your firearm to the factory or for the location of the nearest AAC authorized repair station.

Proper cleaning and lubrication are also important to firearm maintenance and are necessary to assure accuracy, safety and reliability. Before cleaning,

always make sure that your firearm is completely unloaded. And always clean the barrel from the chamber end to the muzzle when possible.

Make it a practice to clean your bore every time you're going to shoot. Be sure to clean your entire firearm before and after long-term storage and no less than once a year. It's also important to clean your firearm whenever it's been exposed to adverse conditions such as rain, dirt, mud, snow, sleet or saltwater.

For safe and dependable operation of your firearm, all parts of your firearm must be properly cleaned and lubricated. Periodically inspect the internal workings of your firearm to be sure they're clean and free of rust, unwanted dirt and debris.

Use recommended lubricants on your firearm and do not over-lubricate. Excessive use of a non-recommended lubricant could adversely affect the function and safe operation of your firearm. Remember, you are responsible for the proper care and maintenance of your firearm. Failure to properly maintain your firearm cannot only damage or ruin your firearm, it can expose you and others to unnecessary risks of personal injury or death.

Remington® has a wide range of firearm care products and resources for best results when cleaning your firearm. Everything from solvents and lubricants to rods and patches. They're all available from your Remington and AAC dealer.

10TH COMMANDMENT

LEARN THE MECHANICS AND HANDLING CHARACTERISTICS OF YOUR FIREARM.

Not all firearms are alike. They have different mechanical characteristics that dictate how you should carry and handle them. Anyone who plans to use a firearm should first become totally familiar with the type of firearm it is and the safe handling procedures for loading, unloading, carrying, shooting and storing it.

Before you even unpack your new AAC firearm, read this instruction book from cover to cover and familiarize yourself with the different component parts of the firearm. Then read, understand and follow the Ten Commandments of Firearm Safety in this manual.

WARNING! Discharging firearms in poorly ventilated areas, cleaning firearms or handling ammunition may result in exposure to lead, a substance known to cause birth defects, reproductive harm, cancer and other

serious physical injury. Have adequate ventilation at all times. Wash hands thoroughly after exposure.

SHOOT SOBER!!

There's one other rule that must be followed when handling firearms. In fact, respect for this rule is necessary in order to effectively practice the Ten Commandments of Firearm Safety. The rule is: SHOOT SOBER! Firearms and alcohol or drugs make a deadly combination. Never consume anything that would mildly impair your judgment or physical coordination when you're using a firearm. A staggering percentage of the shooting accidents that occur every year involve alcohol or drugs. Be smart. Always shoot sober and stay alive.

WARNING! Failure to follow any of these safety rules may cause personal injury or death to the shooter or bystander and damage to property. Do not use a firearm until you fully understand and practice the Ten Commandments of Firearm Safety. If you have any questions about the safe use of a AAC firearm, write to us at Remington Arms Company, LLC, Consumer Service, P.O. Box 700, Madison, NC 27025-0700, or call us at 1-800-243-9700.

DON'T KEEP THIS TO YOURSELF.

Now that you're a firearm owner you have the obligation to help ensure that shooting sports are safe for everyone, participants and bystanders alike. You can do that by practicing these principles of firearm safety and passing them on to others - especially new shooters. Set an example for beginners. Be a guide to their safe entry into the exciting world of shooting sports. Invest your time and patience for the love of the sport and for its future. After all, it's your love of the sport that led you to buy a new AAC firearm.

Firearm ownership is a right and privilege. It's a privilege, which carries with it a personal responsibility to use your firearm in a way which will ensure your safety and the safety of others. The preservation of this right and privilege depends on the personal commitment of you and your fellow shooters to the safe and responsible use of firearms. Let the Ten Commandments of Firearm Safety outlined in the book guide you at all times. Teach and promote these rules whenever you can. Remember, firearm safety depends on you! That's the only way to really enjoy your new AAC firearm and to preserve sport shooting as we know it today.

THANK YOU FOR BUYING AN ADVANCED ARMAMENT CORP (AAC) PRODUCT.

PLEASE PRACTICE SAFE FIREARMS HANDLING!

WARNING: It is very important that you read and understand this manual before using the new rifle. Warnings should be read and heeded carefully. Always follow the "Ten Commandments of Firearm Safety," listed in this manual. Failure to follow these rules, warnings, and other instructions in this manual, can result in personal injury, property damage or death.

WARNING: If this firearm is carelessly or improperly handled, unintentional discharge could result and could cause injury, death, or damage to property.

WARNING: Use only clean, dry, high quality commercially manufactured ammunition in good condition which is appropriate to the caliber of your firearm. AAC does not recommend the use of remanufactured or hand loaded ammunition. The use of improperly loaded or reloaded ammunition may cause property damage, personal injury and/or death.

DANGEROUS PROCEDURES

WARNING! This firearm may inadvertently chamber a cartridge if it is dropped or jarred with a loaded magazine in place. An unintentional discharge of a firearm may cause property damage, personal injury and/or death.

WARNING! This firearm can fire without the cam pin present. Firing the rifle without the cam pin properly installed in the bolt group can cause property damage, personal injury, and/or death.

WARNING! An unfired cartridge can discharge if left in a hot barrel, this is often referred to as a "cook-off". Always keep the rifle pointed in a safe direction. If an unfired cartridge cannot be cleared from a hot barrel quickly, remove the magazine from the rifle and allow the barrel and unfired cartridge to cool 15 minutes. A cook-off can cause property damage, personal injury, and/or death.

WARNING! Never discharge a firearm with water in the barrel. Discharging the firearm with water in the barrel can cause property damage, personal injury, and/or death.

WARNING! If you experience a change in sound report and/or recoil while discharging the rifle, do not attempt to discharge the rifle again. A change in sound report and/or recoil are symptoms of a defective cartridge, which could lead to an obstructed bore. Discharging a firearm with an obstructed bore can cause property damage, personal injury, and/or death.



ABOUT YOUR AAC RIFLE

This Operating Manual covers all AAC AR15-style rifles. They are lightweight, gas operated, air-cooled, magazine-fed rifles and carbines that are Semi-Automatic in operating mode (i.e., a single round will fire each time the trigger is pulled). Note: For Law Enforcement and Military markets, AAC makes similar models in either Full-Automatic (continuous fire as long as the trigger is pulled) or Three Round Burst (a group of 3 shots will fire as long as the trigger is pulled) configurations. Sales of these models require special permits, are regulated by ATF and available to Agency only.

On all models, the Upper and Lower Receivers are easily opened for cleaning and inspection. Rifle models have forged aluminum Upper and Lower Receivers

Specifications subject to change without notice.

RIFLE FEATURES + CONTROLS - IDENTIFICATION / LOCATION

Note: ATF Regulations require a minimum barrel length of 16" on commercially available rifles and carbines. This 16" length can be a combination of barrel and permanently fixed (pinned & welded over) muzzle brake / flash suppressor as long as total length equals 16".



*NOT INCLUDED

** RIFLE COMES WITH ONE MAGAZINE, HOWEVER UPPER DOES NOT

CLEARING/UNLOADING YOUR RIFLE

⚠ WARNING! Never assume your firearm is unloaded to justify careless handling. Always control the direction of the muzzle of your firearm, even if you think it is completely unloaded. Careless handling of a firearm may cause property damage, personal injury and/or death.

1. Always keep the rifle pointed in a safe direction.
2. Place the Safety Selector Lever in the “Safe” position. See Figure 1. If the safety will not engage proceed to step 3.
3. Press the Magazine Release button and remove the Magazine Box. See Figure 2.
4. Lock the bolt open by pulling the Charging Handle fully to the rear and pressing the bottom of the Bolt Release. While depressing the bottom of the bolt release, slide the charging handle forward until the bolt engages the bolt catch. See Figure 3.
5. With the bolt locked open, slide the Charging Handle fully forward.
6. Verify the Safety Selector Lever is fully in the “Safe” position. If the Safety Selector Lever could not be engaged in step two, place it in the “Safe” position now.
7. Look into the ejection port and visually check the chamber and magazine well for cartridges, ensuring the firearm is completely unloaded.

PREVENTATIVE MAINTENANCE CHECKS + SERVICES

⚠ WARNING! Before discharging the firearm, make sure the inside of the barrel is free of dirt, oil, water, or other obstructions. Discharging an obstructed barrel may cause property damage, personal injury and/or death.

1. Always keep the rifle pointed in a safe direction.
2. Check to see that there is no excessive oil in the bore. If there is, swab it out with a patch and the cleaning rod. See the “Cleaning the Bore” section of this manual. Always clean a new rifle before discharging it for the first time.
3. Retract the Bolt to ensure free movement between Bolt Carrier and Gas Tube. See Figure 4.
4. Perform a Safety Function Check to ensure that Safety Selector Lever works properly. See the “Safety Function Check” section of this manual.



FIGURE 1



FIGURE 2



FIGURE 3



FIGURE 4

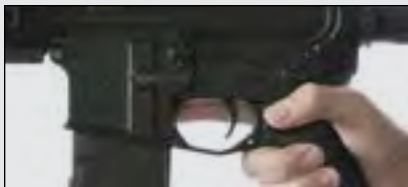


FIGURE 5

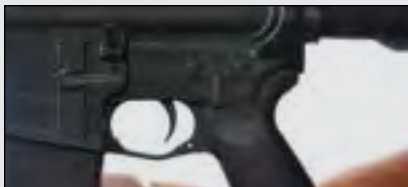


FIGURE 6

SAFETY FUNCTION CHECK

⚠ WARNING! If the firearm experiences a malfunction during the Safety Function Check, the firearm is unsafe and its use may cause property damage, personal injury, and/or death. This firearm should be serviced by an AAC authorized repair center. See the How to Obtain Parts and Service From AAC section of the manual to have your firearm repaired.

1. Always keep the firearm pointed in a safe direction.
2. Place the Safety Selector Lever in the “Safe” position. If the safety will not engage proceed to step 3.
3. Press the Magazine Release button and remove the Magazine Box. See Figure 2.
4. Lock the bolt open by pulling the Charging Handle fully to the rear and pressing the bottom of the Bolt Release. While depressing the bottom of the bolt release, slide the charging handle forward until the bolt engages the bolt catch. See Figure 3.
5. With the bolt locked open, slide the Charging Handle fully forward. Verify the Safety Selector Lever is fully in the “Safe” position. If the Safety Selector Lever could not be engaged in step 2, place it in the “Safe” position now. Look into the ejection port and visually check the chamber and magazine well for cartridges, ensuring the firearm is completely unloaded. Only proceed if the rifle is completely unloaded.
6. With the firearm completely unloaded, press the bolt release button, allowing the bolt to fully close.
7. With the safety selector lever in the “Safe” position (See Figure 5) and the rifle pointed in a safe direction, pull the trigger. The trigger should not release the hammer and the hammer should not strike the firing pin with an audible click. If the hammer is released by the trigger, the firearm has malfunctioned and failed this safety function check. Do not proceed with the check and see the warning above for instructions.
8. Place the safety selector lever in “Fire” position. See Figure 6. Pull the Trigger. The trigger should release the hammer and the hammer should strike the firing pin with an audible snap. If the hammer is not released by the trigger, the firearm has malfunctioned and failed this safety function check. Do not proceed with the check and see the warning above for instructions.
9. Pull and hold the trigger.

10. Pull the charging handle fully rearward and release it, allowing the bolt to fully close.
11. Release the pressure on the trigger with a slow continuous motion until the trigger is fully forward. A slight audible click should be heard, but the hammer should not be released and strike the firing pin. For the purposes of this step, the rate by which to release the trigger is defined as one fourth the normal rate by which you release the trigger after discharging the firearm. If the hammer is released by the trigger and strikes the firing pin, the firearm has malfunctioned and failed this safety function check. Do not proceed with the check and see the warning below for instructions.
12. Repeat steps 9 through 11 a total of five times. The firearm must not malfunction during these steps to pass the Safety Function Check. If the firearm malfunctions, it has failed this safety function check. Do not proceed with the check and see the warning at the beginning of this section for instructions.

SERIAL NUMBER + CALIBER IDENTIFICATION

The serial number of your firearm is located on the shooter's left side of the magazine well. See Figure 7. The intended caliber of the firearm can also be found on the shooter's left side of the magazine well. Always check the cartridge designation on the barrel of the firearm to insure it matches the cartridge designation on the lower receiver. See Figure 8.



FIGURE 7



FIGURE 8

WARNING! AR15 style firearms are modular and due to the modularity, it is possible to affix an upper receiver to a lower receiver with a differently designated caliber/cartridge. Only use ammunition designated by the barrel of the upper receiver with your firearm. Using ammunition not designated by the barrel of the upper receiver may cause property damage, personal injury and/or death.

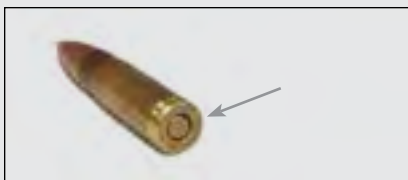


FIGURE 9

Always check the cartridge for the correct designation before loading the firearm. The caliber of a cartridge is located on the case head of the cartridge. See Figure 9. To find additional ammunition information, see the Remington Arms catalog or visit the Remington website at www.remington.com.

WARNING! Do not apply oil, grease or any lubricants to cartridges. Applying lubricants to cartridges may cause property damage, personal injury and/or death.

WARNING! Always wash hands after handling ammunition. See the “Ten Commandments of Firearm Safety,” section of this manual.

PREPARING TO FIRE - LOADING A MAGAZINE

WARNING! Always check the cartridge for the correct designation before loading the firearm. Use of an incorrect cartridge could result in property damage, personal injury and/or death.

WARNING! The use of improperly loaded or hand-loaded ammunition can lead to barrel obstructions, excessive pressure and/or inadvertent discharge of a firearm, resulting in personal injury, property damage and/or death. Use only quality factory ammunition suitable for your firearm. Examine each Cartridge, particularly around the primer. Look for dents, scratches, and other signs of damage. **DO NOT LOAD DAMAGED AMMUNITION!**

WARNING: Safe Firearms Handling dictates that you only load live ammunition into your rifle when you wish to discharge the firearm. See the “Ten Commandments of Firearm Safety”, in this manual.

1. Hold the magazine with the front of the magazine facing forward. See Figure 10.
2. With the primer flush with the rear inside face of the magazine, position a cartridge of proper caliber on top of the magazine, between the feed lips.



FIGURE 10

3. With the cartridge properly positioned, push down on the cartridge until it is fully seated in the magazine. Make sure the cartridge is touching the rear inside face of the magazine.
4. Place the next cartridge on top of the previously seated cartridge and push it down between the feed lips until it becomes seated in the magazine. The cartridge will sit on the opposite side of the magazine with respect to the cartridge that preceded it. The primer end of each cartridge should be touching the rear inside face of the magazine.
5. Repeat step four until the magazine is full or the desired number of rounds have been loaded. Do not attempt to exceed magazine capacity as it may damage the magazine and your firearm.

LOADING YOUR RIFLE

WARNING! Never assume your firearm is unloaded to justify careless handling. Always control the direction of the muzzle of your firearm, even if you think it is completely unloaded. Careless handling of a firearm can lead to property damage, personal injury and/or death.

WARNING! Always check the cartridge for the correct designation before loading the firearm. Use of an incorrect cartridge could result in property damage, personal injury and/or death.

WARNING! The use of improperly loaded or hand-loaded ammunition can lead to barrel obstructions, excessive pressure and/or inadvertent discharge of a firearm, resulting in property damage, personal injury and/or death.

WARNING! The firearm can be discharged even if the magazine has been removed. If a cartridge is chambered, the safety selector is in the “Fire” position and the magazine is removed from the rifle, depressing the trigger will cause the rifle to discharge.

NOTE: When closing the bolt with the charging handle, never ride or push the charging handle forward. Always allow the bolt to carry the charging handle forward under its own power as it closes. Interfering with the charging handle during bolt closing may prevent the bolt from fully closing.

NOTE: A magazine may be inserted into this firearm and a round chambered with the Bolt Assembly starting in the open or closed position.

CHAMBERING A ROUND FROM AN OPEN BOLT

1. Always keep the rifle pointed in a safe direction.
2. Remove the magazine, pull and hold the bolt fully rearward to inspect the chamber. See Figure 11. Visually and physically verify the Chamber is completely unloaded. See the section “Clearing/Unloading Your Rifle”.



FIGURE 11

WARNING: Do not load a hot chamber, a round may “Cook Off”. “Cooking Off” means that a Round may Detonate (Fire) unexpectedly just from being exposed to the heat of the Rifle’s Firing Chamber. An unintentional or uncontrolled discharge of your firearm may cause property damage, personal injury and/or death.

3. With the magazine facing forward, center the loaded magazine in the firearm’s magazine well and push the magazine up until magazine catch engages and holds the magazine. See Figure 12.
4. Slap upwards on magazine bottom to ensure it is seated fully.
5. Pull down on the magazine bottom to verify it is securely engaged in the magazine well. If the magazine releases from the magazine well, repeat steps two through four.



FIGURE 12

6. With a loaded magazine secured in the magazine well, depress the upper portion of the bolt release button. See Figure 13. This will cause bolt to close and chamber a loaded cartridge. Pulling the charging handle fully rearward and releasing it will also cause the bolt to close and chamber a loaded cartridge. See Figure 15.

7. Tap the forward assist with the heel of your hand to ensure the bolt is fully forward and closed. See Figure 14. If the bolt does not fully close, see the Clearing Your Rifle section of this manual.

8. Verify the safety selector is in the "Safe" position. If it is in the "Fire" position, rotate it fully to the "Safe" position.

WARNING! The firearm is now fully loaded with the safety in the "Safe" position. Failure to follow safe firearm handling practices, as found in the "Ten Commandments of Firearm Safety" may cause property damage, personal injury, and or death.

CHAMBERING A ROUND FROM A CLOSED BOLT

1. Always keep the rifle pointed in a safe direction.

2. Remove the magazine, pull and hold the bolt fully rearward to inspect the chamber. See Figure 11. Visually and physically verify the Chamber is completely unloaded. See the section "Clearing/Unloading Your Rifle".

WARNING: Do not load a hot chamber, a round may "Cook Off". "Cooking Off" means that a Round may Detonate (Fire) unexpectedly just from being exposed to the heat of the Rifle's Firing Chamber. An unintentional or uncontrolled discharge of your firearm may cause property damage, personal injury and/or death.

3. With a loaded magazine secured in the magazine well, depress the upper portion of the bolt release button. See Figure 13. This will cause bolt to close.



FIGURE 13



FIGURE 14

4. With the magazine facing forward, center the loaded magazine in the firearm's magazine well and push the magazine up until magazine catch engages and holds the magazine. See Figure 12.

5. Slap upwards on magazine bottom to ensure it is seated fully.

6. Pull down on the magazine bottom to verify it is securely engaged in the magazine well. If the magazine releases from the magazine well, repeat steps two through five.

7. With a loaded magazine secured in the magazine well, pull the charging handle fully rearward and release it to allow the bolt to close and chamber a loaded cartridge. See Figure 15.

8. Tap the forward assist with the heel of your hand to ensure the bolt is fully forward and closed. See Figure 16. If the bolt does not fully close, see the Clearing Your Rifle section of this manual.

9. Verify the safety selector is in the "Safe" position. If it is in the "Fire" position, rotate it fully to the "Safe" position.



FIGURE 15

WARNING! The firearm is now fully loaded with the safety in the "Safe" position. Failure to follow safe firearm handling practices, as found in the "Ten Commandments of Firearm Safety" may cause property damage, personal injury, and or death.

FIRING THE RIFLE

WARNING! Always wear eye and hearing protection when discharging your firearm, failure to do so could result in personal injury. See "The Ten Commandments of Firearm Safety," section of this manual.

WARNING! The inside of the barrel must be clean and free of any obstructions. Discharging the firearm with a dirty and/or obstructed barrel may cause property damage, personal injury, and/or death. See the "Ten Commandments of Firearm Safety," section of this manual.

1. Always keep the firearm pointed in a safe direction.

2. Point the muzzle at your intended target.

3. Rotate the safety selector lever fully to the "Fire" position.

4. With the target acquired and the butt of the firearm mounted firmly against your shoulder, pull the trigger. The firearm will discharge and continue to discharge each time the trigger is pulled, until the magazine and chamber are empty.

NOTE: After the last Round is fired, the Bolt Carrier will lock in the rear position.

WARNING! If a cartridge does not discharge when the trigger is pulled (misfire), keep the firearm pointed in a safe direction and wait one minute before opening the bolt or the action. See "Clearing / Unloading Your Firearm," section of this manual. Failure to wait the allotted time could result in a delayed and/or uncontrolled discharge of the cartridge, possibly causing property damage, personal injury, and/or death.

WARNING! If the "report" of the discharged cartridge is noticeably softer or louder or in any way irregular, keep the firearm pointed in a safe direction; unload the firearm and check the bore for obstructions. See "Checking for and Removing a Barrel Obstruction", on page 13. Discharging a firearm with an obstruction can cause property damage, personal injury, and/or death.

WARNING! If the recoil of the firearm during discharge is harder or softer or any way irregular, keep the firearm pointed in a safe direction; unload

the firearm and check the bore for obstructions. See "Checking for and Removing a Barrel Obstruction," on page 13. Discharging a firearm with an obstruction can cause property damage, personal injury, and/or death.

5. Without touching the trigger, fully rotate the safety selector lever to the "Safe" position.

6. Press the magazine release button and remove the magazine box. See Figure 2.

7. If the bolt is locked in the open position, the chamber and magazine well are visible through the ejection port, proceed to step 10.

8. Lock the bolt open by pulling the charging handle fully to the rear and pressing the bottom of the bolt release. While depressing the bottom of the bolt release, slide the charging handle forward until the bolt engages the bolt catch. See Figure 3.

9. With the bolt locked open, slide the charging handle fully forward.

10. Look into the ejection port and visually check the chamber and magazine well for cartridges, ensuring the firearm is completely unloaded.

11. Make sure the barrel is free of obstructions, see "Checking for and Removing a Barrel Obstruction", on page 13.

CHECKING FOR AND REMOVING A BARREL OBSTRUCTION

WARNING! NEVER try to remove an object from the barrel by loading another cartridge and discharging it into the obstruction. This may cause property damage, personal injury and/or death.

1. Always keep the firearm pointed in a safe direction.

2. Remove the magazine, pull and hold the bolt fully rearward to inspect the chamber. See Figure 11. Visually and physically verify the Chamber is completely unloaded. See the section "Clearing/Unloading Your Rifle".



FIGURE 16

3. Push the Takedown Pin (a bullet tip may help) as far as it will go to the shooter's right. See Figure 17.
4. Pivot the upper receiver away from the lower receiver. See Figure 18.
5. Carefully pull rearward on the Charging Handle and Bolt Assembly. See Figure 19.
6. Remove the Bolt Assembly from the upper receiver. See Figure 20.
7. To check for an obstruction by looking through the receiver and barrel from the chamber end.
8. If an obstruction exists, insert a correct size cleaning rod from the chamber end of the barrel until the obstruction is detected.
9. Lightly tap the cleaning rod against the obstruction to free the object from the barrel.
10. Push the rod completely through the barrel until the rod can be seen at the muzzle.
11. If an object cannot be easily pushed out of the barrel with a cleaning rod, return the firearm to the factory or to an AAC Authorized Repair Center.

WARNING! Before loading the firearm, make sure the inside of the barrel is free of dirt, oil, or other obstructions. Discharging the firearm with a dirty and/or obstructed barrel may cause property damage, personal injury and/or death.



FIGURE 17



FIGURE 18



FIGURE 19

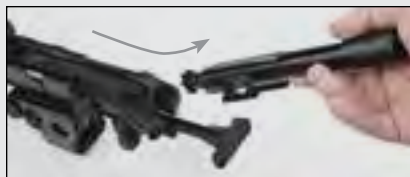


FIGURE 20



DISASSEMBLING YOUR RIFLE

WARNING! Before disassembling your firearm, make sure it is completely unloaded (both the chamber and the magazine) and engage the safety mechanism by placing the safety lever in the "S" or "SAFE" position. Failure to follow these instructions may cause property damage, personal injury and/or death.

1. Always keep the firearm pointed in a safe direction.
2. Remove the magazine, pull and hold the bolt fully rearward to inspect the chamber. See Figure 11. Visually and physically verify the Chamber is completely unloaded. See the section "Clearing/Unloading Your Rifle".
3. Push the Takedown Pin (a bullet tip may help) as far as it will go to the shooter's right. See Figure 17.
4. Push the Pivot Pin (a Bullet tip can help) as far as it will go to the shooter's right. See Figure 18.

NOTE: The Pivot Pin and Takedown Pin are captured in the Lower Receiver, preventing them from falling out and becoming lost.

5. Separate Upper Receiver from the Lower Receiver.
6. Pull back Charging Handle fully rearward. See Figure 19.
7. Pull the Bolt Assembly fully rearward and remove it from the Upper Receiver. See Figure 20.
8. Remove the Charging Handle by pulling rearward and up until the "Ears" clear the cutouts in Upper Receiver. See Figure 22.

9. Remove Firing Pin Retaining Pin. A Bullet tip can help push it out of the Bolt Carrier. See Figure 23.

NOTE: Do not open or close the split end of Firing Pin Retaining Pin, and do not substitute a common cotter pin on reassembly.

10. Remove the Firing Pin from the rear of the Bolt Carrier. See Figure 24.
11. Push the Bolt fully rearward into Bolt Carrier. See Figure 25.
12. Remove the Cam Pin by rotating it 1/4 turn and lifting it out of the Bolt Carrier. See Figure 26.
13. Pull the Bolt Assembly out of the Bolt Carrier. See Figure 27.
14. Press the rear of the Extractor to check the Extractor Spring function. The Extractor should return to its original position when the pressure is removed.

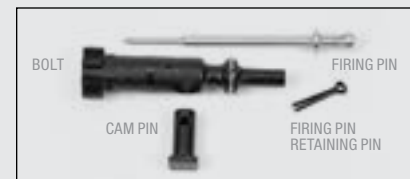


FIGURE 21

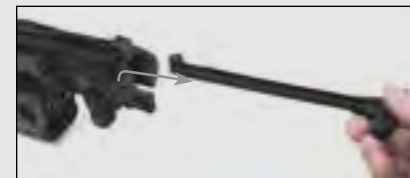


FIGURE 22

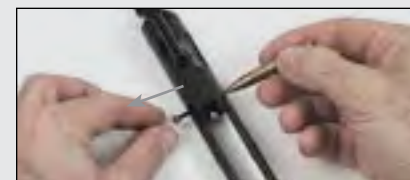


FIGURE 23



FIGURE 24

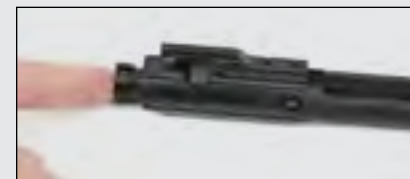


FIGURE 25



FIGURE 26

DISASSEMBLE USING STEPS 15 THROUGH 18 ONLY WHEN PARTS ARE DIRTY OR DAMAGED.

NOTE: The Extractor Spring is under compression and may be easily lost when the Extractor Pin is removed.

15. Remove the Extractor Pin by pushing it out with a punch or the tip of a Bullet. See Figure 28. **DON'T LOSE IT!**

16. Remove the Extractor and Extractor Spring. See Figure 29.

17. With Hammer cocked, depress Buffer Retainer with a punch or Bullet tip to release the Buffer and Spring. See Figure 30.

CAUTION! The Buffer is under compression from the Action Spring.

NOTE: The Hammer needs to be cocked to allow the Buffer and Buffer Spring to clear Lower Receiver.

18. Remove the Buffer and Action Spring from the Lower Receiver for cleaning. See Figure 31.

AAC DOES NOT RECOMMEND ANY FURTHER DISASSEMBLY.

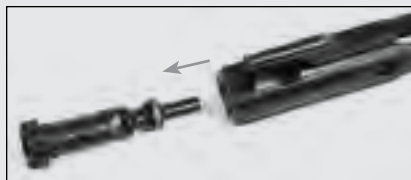


FIGURE 27



FIGURE 28

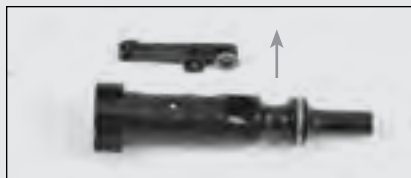


FIGURE 29



FIGURE 30



FIGURE 31

INSPECTION/CLEANING/LUBRICATION

WARNING! Before cleaning your firearm, make sure it is completely unloaded (both the chamber and the magazine) and engage the safety mechanism by placing the safety lever in the "S" or "SAFE" position. Failure to follow these instructions may cause property damage, personal injury and/or death.

WARNING! After each use, follow the lubrication and maintenance directions in this Owner's Manual. If the firearm is immersed in water, it must be thoroughly cleaned and lubricated as soon as possible. In case of saltwater immersion, first flush all parts with fresh water, then dry, clean and lubricate the firearm. If the firearm does not function properly, have it checked and corrected by an AAC Authorized Repair Center before further use. Failure to follow these instructions may lead to firearm malfunctions which could result in property damage, serious personal injuries and/or death.

After discharging your rifle, clean it as soon as possible to avoid corrosion. When your firearm has not been fired, you should clean it at least once or twice a year if you live in a temperate climate, or as often as once a week in a tropical climate.

If you get your firearm wet, clean it as soon as possible to avoid the onset of corrosion/rust. Use a high quality rifle cleaning kit that includes a cleaning rod; swab holder; cotton flannel bore patches; pipe cleaners; a small toothbrush; brass wire bristle bore and chamber brushes and a Cleaner/Lubricant/Preservative (CLP in Army terminology). Plus, a small brush (old toothbrush) for cleaning parts and dislodging dirt build-up, and pipe cleaners or Q-tips for cleaning Gas Key and Gas Tube and other hard to reach areas.

NOTE: The procedures below describe cleaning your firearm with a standard military issue multi-piece rod cleaning kit. Other commercial cleaning kits may include alternate cleaning instructions which may be just as effective.

WARNING! Excessive use of a lubricant could adversely affect the function and safe operation of your firearm. Failure to properly maintain your firearm can not only damage your firearm, it can expose you and others to unnecessary risks of property damage, personal injury and/or death.

When the firearm is to be stored, it should be carefully cleaned and thoroughly oiled. Outside metal surfaces should be wiped with Rem Oil™ occasionally. When the firearm is to be reused, all excess lubrication must be removed. The chamber and bore must be thoroughly wiped dry. For safe and dependable operation of your firearm, the barrel and action must be cleaned periodically.

NOTE: Remington's Rem Oil™ is available from your local dealer. If your dealer is out of stock, ask him to order Rem Oil™ from his Remington Distributor.

WARNING! The use of non-recommended lubricants or cleaners could adversely affect the function and safe operation of your firearm. Do not use congealing lubricants. The use of non-congealing lubricants such as Rem Oil™ is strongly recommended. The use of improper lubricants could cause property damage, personal injury and/or death.

CLEANING THE BORE

WARNING! Unload the firearm before cleaning. Look into the ejection port and visually check the chamber and magazine to make sure there are no cartridges in the firearm. Always wear eye protection when handling, disassembling and reassembling the firearm. Failure to follow these instructions may cause property damage, personal injury and/or death.

The bore of your rifle has Lands and Grooves called "Rifling". Rifling makes the bullet spin very fast as it moves down the Bore and down range. It is difficult to push a new, stiff Bore Brush through the Bore. You will find it much easier, and more effective, to pull your Bore Brush through the Bore. Also, because the brush will clean better if the bristles follow the grooves (this is called tracking), you want the Bore Brush to be allowed to turn as you pull it through.

ALWAYS CLEAN FROM CHAMBER TOWARD THE MUZZLE. Follow these steps:

1. Always keep the firearm pointed in a safe direction.

2. Remove the magazine, pull and hold the bolt fully rearward to inspect the chamber. See Figure 11. Visually and physically verify the Chamber is completely unloaded. See the section "Clearing/Unloading Your Rifle".

3. Disassemble the firearm per the instructions in the "Disassembling Your Firearm," section of this manual.

4. Attach the three Cleaning Rod Sections together, but leave each one about two turns short of being tight.

5. Attach the Patch Holder to the Cleaning Rod, but leave it two turns short of tight.

6. Holding only the Upper Receiver in one hand, Point Muzzle down.

7. Insert the threaded end of the Cleaning Rod into the Chamber. Guide the Rod carefully through the Bore.

CAUTION: Do not let the Cleaning Rod or its threaded end scratch the Bore or Chamber. About 2 - 3 inches of the Rod should protrude out of the Muzzle.

8. Attach the Handle Section of the Cleaning Rod to the end of the Rod sticking out of the Muzzle, and swab out the Bore with a patch moistened with "CLP".

9. Remove Patch Holder and attach the Bore Brush (leaving it two turns short of tight).

10. Remove the Handle Section of the Cleaning Rod.

11. Insert the threaded end of the Cleaning Rod into the Chamber. Guide the Rod carefully through the Bore.

12. Attach the Handle Section of the Cleaning Rod to the end of the Rod sticking out of the Muzzle.

13. Pull the Brush through the Bore and out the Muzzle. You should be able to see the Rod twisting as you pull it - this is the Brush "tracking" in the rifling. Never reverse the direction of the Bore Brush while it is in the Bore.

14. After one pull, take off the Handle Section and repeat steps 11 - 13 three to four times. If the three rod sections and the Bore Brush become screwed tightly together, loosen them two turns.

15. Repeat steps 5 - 14 until the bore is clean.

16. Push a clean patch saturated with Rem Oil™ through the barrel.

17. Push a clean dry patch through the barrel to remove excess lubricant.

- Apply a light application of Rem Oil™ to the outside of the barrel with a soft clean cloth.

WARNING! After cleaning, make sure the barrel is free of obstructions, see the “Checking for and Removing a Barrel Obstruction,” section of this manual. Discharging the firearm with a dirty and/or obstructed barrel may cause property damage, personal injury and/or death.

CLEANING THE UPPER RECEIVER

WARNING! Unload the firearm before cleaning. Look into the ejection port and visually check the chamber and magazine to make sure there are no cartridges in the firearm. Always wear eye protection when handling, disassembling and reassembling the firearm. Failure to follow these instructions may cause property damage, personal injury and/or death.

WARNING! Check to ensure that there is no looseness between the Barrel and the Upper Receiver. If you detect any movement by twisting or pulling the barrel relative to the receiver, the Barrel Nut must be retorqued. Have the firearm serviced an AAC Authorized Repair Center before further use. Failure to follow these instructions may lead to firearm malfunctions which could result in property damage, serious personal injuries and/or death.

- Always keep the firearm pointed in a safe direction.
- Remove the magazine, pull and hold the bolt fully rearward to inspect the chamber. See Figure 11. Visually and physically verify the Chamber is completely unloaded. See the section “Clearing/Unloading Your Rifle”.
- Disassemble the firearm per the instructions in the “Disassembling Your Firearm,” section of this manual.
- Using a “CLP” type product, clean all areas of the Upper Receiver (inside and out) of Powder Fouling, Corrosion and Dirt. To avoid scratching and damaging the finish of your Aluminum Upper Receiver, never use a wire brush or any type of abrasive cleaner. A Toothbrush works well for loosening buildup, and will not scratch the Receiver.
- Clean the Chamber by dipping the larger Chamber Brush in CLP. Use at least 5 plunge strokes and 3 - 360° clockwise rotations when cleaning the Chamber.
- Swab out the Bore as described previously to remove contaminated solution or loosened fouling.
- Wipe all components clean and dry
- Inspect all components for excessive wear, corrosion or mechanical damage. Have your AAC Authorized Repair Center replace any worn or defective parts before discharging the firearm again.

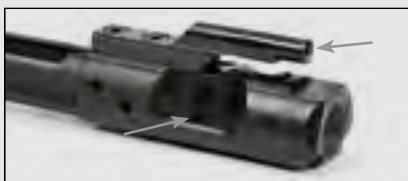


FIGURE 32



FIGURE 33

CLEANING THE BOLT, BOLT CARRIER + COMPONENTS

WARNING! Unload the firearm before cleaning. Look into the ejection port and visually check the chamber and magazine to make sure there are no cartridges in the firearm. Always wear eye protection when handling, disassembling and reassembling the firearm. Failure to follow these instructions may cause property damage, personal injury and/or death.

- Always keep the firearm pointed in a safe direction.
- Remove the magazine, pull and hold the bolt fully rearward to inspect the chamber. See Figure 11. Visually and physically verify the Chamber is completely unloaded. See the section “Clearing/Unloading Your Rifle”.
- Disassemble the firearm per the instructions in the “Disassembling Your Firearm,” section of this manual.
- Use the Bore Brush (wet with CLP) to clean carbon and powder residue from around the Gas Tube. See Figure 32.
- Run a Pipe Cleaner through the Gas Tube.
- With a brush (wet with CLP) clean the Bolt Locking Lugs, Bolt Rings, Firing Pin and Bolt Cam Pin. See Figure 21.
- With a non-abrasive brush (wet with CLP) clean the extractor spring. See Figure 33.
- Wipe all components clean and dry.
- Inspect all components for excessive wear, corrosion or mechanical damage. Have your AAC Authorized Repair Center replace any worn or defective parts before discharging the firearm again.

WARNING! When checking the bolt, look for cracks or fractures, especially in the Cam Pin hole area. A bolt showing cracks or fractures should be replaced. Use of a cracked or fractured bolt may cause property damage, personal injury and/or death.

WARNING! When checking the Bolt Face, the bolt should be replaced if any pitting extends into the firing pin hole. Use of a pitted Bolt Face may cause property damage, personal injury and/or death.

WARNING! When checking the Cam Pin, it should be replaced if it is cracked or chipped. Use of a damaged Cam Pin may cause property damage, personal injury and/or death.

NOTE: When checking the Firing Pin, it should be replaced if it is bent, cracked, too blunted or too sharp. Misfires often result from the use of a damaged Firing Pin.

NOTE: When checking the Firing Pin Retaining Pin, it should be replaced if it is bent, or badly worn, it should be replaced. Never use a “Cotter Pin” as a substitute for a real Firing Pin Retaining Pin. Cotter pins are not made of heat treated spring steel and their round head shape may cause damage to the Upper Receiver.

NOTE: When checking the Extractor and Extractor Spring, the Extractor should be replaced if it is chipped or has broken edges in the area of the lip that engages the cartridge case head. The Extractor Spring should be replaced if it is cracked or broken. The Extractor Spring O-Ring should be replaced if it is crack or broken.

CLEANING / LUBRICATING THE EJECTOR

WARNING! Unload the firearm before cleaning. Look into the ejection port and visually check the chamber and magazine to make sure there are no cartridges in the firearm. Always wear eye protection when handling, disassembling and reassembling the firearm. Failure to follow these instructions may cause property damage, personal injury and/or death.

NOTE: Disassembly of the Ejector is not recommended.

Make sure your firearm ejects empty cases efficiently by following these steps when cleaning:

- Always keep the firearm pointed in a safe direction.
- Remove the magazine, pull and hold the bolt fully rearward to inspect the chamber. See Figure 11. Visually and physically verify the Chamber is completely unloaded. See the section “Clearing/Unloading Your Rifle”.

- Disassemble the firearm per the instructions in the “Disassembling Your Firearm,” section of this manual.

- With the Bolt removed from the Bolt Carrier and the Extractor installed, place a few drops of CLP around the Ejector to form a puddle. See Figure 34.

- Take a fired or dummy cartridge and place it under the lip of the Extractor.

- With a rocking motion, press the cartridge down against the Ejector. The Ejector is spring loaded and some resistance will be felt.

- Depress the Ejector with the cartridge until it stops against the bolt face.

- Allow the Ejector to fully extend by releasing pressure from the cartridge.

- Repeat steps 6 – 8 several time, until the Ejector moves smoothly. Replace the CLP frequently.

- Wipe all components clean and dry.

- Inspect all components for excessive wear, corrosion or mechanical damage. Have your AAC Authorized Repair Center replace any worn or defective parts before discharging the firearm again.

NOTE: When checking the Ejector, the Ejector should be replaced if it is chipped, cracked, bent, blunted or has little return force. Have a damaged Ejector serviced by an AAC Authorized repair center.

CLEANING THE LOWER RECEIVER

WARNING! Unload the firearm before cleaning. Look into the ejection port and visually check the chamber and magazine to make sure there are no cartridges in the firearm. Always wear eye protection when handling, disassembling and reassembling the firearm. Failure to follow these instructions may cause property damage, personal injury and/or death.

1. Always keep the firearm pointed in a safe direction.
2. Remove the magazine, pull and hold the bolt fully rearward to inspect the chamber. See Figure 11. Visually and physically verify the Chamber is completely unloaded. See the section “Clearing/Unloading Your Rifle”.
3. Disassemble the firearm per the instructions in the “Disassembling Your Firearm,” section of this manual.
4. Using a “CLP” type product, clean all areas of the Lower Receiver (inside and out) of Powder Fouling, Corrosion and Dirt. To avoid scratching and damaging the finish of your Aluminum Lower Receiver, never use a wire brush or any type of abrasive cleaner. A toothbrush works well for loosening buildup and will not scratch the Receiver.
5. Wipe any dirt from the Trigger Mechanism.
6. Carefully clean the Magazine Release Button and the cavity for the Magazine Catch on the left side of the Receiver.

7. Inspect and wipe clean the Bolt Catch Mechanism.
8. Inspect and wipe clean the Receiver’s Takedown and Pivot Pins.
9. Wipe clean the Buffer and Action Spring.
10. Wipe clean the inside of the Lower Receiver Extension (Buffer Tube). A piece of rag attached to the Cleaning Rod and Patch Holder can be used to wipe inside the Buffer Tube.
11. Pull the Telescoping Stock Latch down to slide Stock rearward from the Lower Receiver Extension.
12. Clean the Lower Receiver Extension Stock Lock Holes.
13. Lightly lube the Lower Receiver Extension and Latch Mechanism to ensure proper Stock telescoping action.
14. Pull the Telescoping Stock Latch down and slide Stock on the Lower Receiver Extension. Ensure the Stock Latch engages one of the Lower Receiver Extension Stock Lock Holes.
15. Wipe all components clean and dry.
16. Inspect all components for excessive wear, corrosion or mechanical damage. Have your AAC Authorized Repair Center replace any worn or defective parts before discharging the firearm again.

LUBRICATION – UPPER + LOWER RECEIVERS

UPPER RECEIVER

WARNING! Unload the firearm before lubricating. Look into the ejection port and visually check the chamber and magazine to make sure there are no cartridges in the firearm. Always wear eye protection when handling, disassembling and reassembling the firearm. Failure to follow these instructions may cause property damage, personal injury and/or death.

1. Always keep the firearm pointed in a safe direction.
2. Remove the magazine, pull and hold the bolt fully rearward to inspect the chamber. See Figure 11. Visually and physically verify the Chamber is completely unloaded See the section “Clearing/Unloading Your Rifle”.
3. Disassemble the firearm per the instructions in the “Disassembling Your Firearm,” section of this manual.
4. Inspect, clean and lubricate the firearm per the instructions in the “Inspect/Cleaning/Lubricating,” section of this manual.
5. Lightly lubricate the inside of Upper Receiver, the Bore and Chamber (using the cleaning rod and a patch).
6. Lightly lubricate the outer surfaces of the Barrel, Front Sight and surfaces under the Hand guard.
7. Lubricate in and around all the Locking Lugs. See figure 34.
8. The Forward Assist should be lightly lubed inside the Receiver and checked for function.

LOWER RECEIVER

WARNING! Unload the firearm before lubricating. Look into the ejection port and visually check the chamber and magazine to make sure there are no cartridges in the firearm. Always wear eye protection when handling, disassembling and reassembling the firearm. Failure to follow these instructions may cause property damage, personal injury and/or death.

1. Always keep the firearm pointed in a safe direction.
2. Remove the magazine, pull and hold the bolt fully rearward to inspect the chamber. See Figure 11. Visually and physically verify the Chamber is completely unloaded See the section “Clearing/Unloading Your Rifle”.
3. Disassemble the firearm per the instructions in the “Disassembling Your Firearm,” section of this manual.
4. Inspect, clean and lubricate the firearm per the instructions in the “Inspect/Cleaning/Lubricating,” section of this manual.
5. Lightly lubricate inside the Lower Receiver Extension (Buffer Tube).
6. Lightly lubricate the Buffer and the Action Spring.
7. Lightly lubricate the Telescoping Stock Latch and exterior of the Receiver Extension.
8. Lubricate all the moving parts inside the lower receiver, including the Trigger, Hammer, Safety, Bolt Catch, Magazine Release, and their various Pins and Detents.
9. Lightly lubricate the Takedown and Pivot Pins and their Detents. Use an oiled rag to wipe off any fingerprints on the exterior surfaces (they can start the corrosion process). A black cloth is best as it won’t leave visible lint.

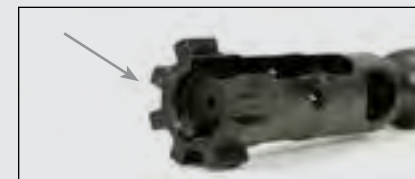


FIGURE 34

BOLT ASSEMBLY

WARNING! Unload the firearm before lubricating. Look into the ejection port and visually check the chamber and magazine to make sure there are no cartridges in the firearm. Always wear eye protection when handling, disassembling and reassembling the firearm. Failure to follow these instructions may cause property damage, personal injury and/or death.

1. Always keep the firearm pointed in a safe direction.
2. Remove the magazine, pull and hold the bolt fully rearward to inspect the chamber. See Figure 11. Visually and physically verify the Chamber is completely unloaded See the section “Clearing/Unloading Your Rifle”.
3. Disassemble the firearm per the instructions in the “Disassembling Your Firearm,” section of this manual.
4. Inspect, clean and lubricate the firearm per the instructions in the “Inspect/Cleaning/Lubricating,” section of this manual.
5. Lightly lubricate the Firing Pin and the Firing Pin recess in the Bolt with oil.
6. Generously lubricate the Bolt, its Cam Pin area and the Bolt Gas Rings. A lighter application is good on the Extractor and its Pin.
7. Lightly lubricate the Charging Handle and its Latch and Spring.
8. Lightly lubricate the inner and outer surfaces of the Bolt Carrier. Generously lubricate the Cam Pin area and the “Slide” Rail areas of the Bolt Carrier where they contact the inside of the Receiver. (Figure 40)
9. The inside of the Carrier Key on the Bolt Carrier should be dried with a Q-Tip or Pipe Cleaner - then place one drop of CLP inside.

REASSEMBLING YOUR RIFLE

WARNING! Before reassembling your firearm, make sure it is completely unloaded (both the chamber and the magazine) and engage the safety mechanism by placing the safety lever in the “S” or “SAFE” position. Failure to follow these instructions may cause property damage, personal injury and/or death.

WARNING! No components/parts may be left out of the reassembly of your firearm. Failure to use all the components/parts and assemble them properly may cause property damage, personal injury and/or death.



FIGURE 35



FIGURE 36



FIGURE 37



FIGURE 38



FIGURE 39



FIGURE 40

1. Always keep the firearm pointed in a safe direction.
2. Remove the magazine, pull and hold the bolt fully rearward to inspect the chamber. See Figure 11. Visually and physically verify the Chamber is completely unloaded See the section “Clearing/Unloading Your Rifle”.
3. Disassemble the firearm per the instructions in the “Disassembling Your Firearm,” section of this manual.
4. Inspect, clean and lubricate the firearm per the instructions in the “Inspect/Cleaning/Lubricating,” section of this manual.
5. Ensure the Hammer is fully cocked and the safety lever is in the “Safe” position.
6. Depress the Buffer Retainer and insert the Action Spring and Buffer.
7. Insert Extractor and Extractor Spring into the Bolt.

NOTE: Extractor Assembly has a Rubber Insert within the Extractor Spring. If the Extractor Spring comes loose, put the large end of the Extractor Spring in the extractor and seat it by pushing down on the Rubber Insert (a Bullet tip works well). See Figure 35.

8. Firmly push the Extractor into the bolt to compress the Extractor Spring and reinsert Extractor Pin.
 9. Press the rear of the Extractor to check the Extractor Spring Function. The Extractor should return to its original position when the pressure is removed.
 10. Insert Bolt into Bolt Carrier.
 11. Twist the Bolt to align the Cam Pin Hole in the Bolt with the Cam Profile in the Bolt carrier.
 12. Insert the Cam Pin in the Bolt Assembly. See Figure 36.
- NOTE:** The Cam Pin can only be installed in Bolt from one side, if it does not fit, twist the Bolt 180° and try again.
13. Once Cam Pin is fully inserted, twist it 90° (this will allow insertion of the Firing Pin).

WARNING! The cam pin must be installed in the Bolt Assembly. Use of a Bolt Assembly without the Cam Pin may cause property damage, personal injury and/or death.

14. Insert the Firing Pin into the Bolt Assembly. See Figure 24.

15. Pull Bolt fully forward of the Bolt Carrier. See Figure 37.

16. Reinsert the Firing Pin Retaining Pin. See Figure 38.

NOTE: After reinserting Firing Pin Retaining Pin, the Firing Pin should not fall out when Bolt Carrier Group is turned with the bolt facing up.

WARNING! Do not interchange bolts between different firearms. Using an improper bolt with your firearm may cause property damage, personal injury and/or death.

17. Insert Charging Handle into Upper Receiver and lower the “ears” at front end of Handle into cutouts in Upper Receiver.
18. If the Ejection Port Cover is closed, open it.
19. Slide Charging Handle partially into the Upper Receiver.
20. Insert the complete Bolt Carrier Assembly into Upper Receiver. The Gas Key will fit into groove in the Charging Handle. See Figure 39.

NOTE: If the Bolt is not fully pulled forward of the Bolt Carrier when the assembly is inserted into the Upper Receiver, the Cam Pin will hit the receiver, preventing assembly.

21. Slide the Bolt Carrier Assembly and Charging Handle fully into the Upper Receiver. The Charging Handle Latch will lock onto the Upper Receiver.
22. To join the Upper and Lower Receivers, position the Pivot Pin Lug of Upper Receiver into slot at front of Lower Receiver and push Pivot Pin into place. See Figure 40.
23. Pivot the Upper Receiver onto the Lower receiver until they are fully mated, push in Takedown Pin. See Figure 41.

NOTE: Pivot Pin and Takedown Pin are captured in the Lower Receiver, preventing them from falling out and becoming lost.

24. Conduct a function check per the steps shown in the “Safety Function Check,” section of this manual.



FIGURE 41

TROUBLESHOOTING

PROBLEM:	CHECK FOR:	WHAT TO DO:
RIFLE WON'T FIRE	SELECTOR LEVER ON SAFE	Put it on fire
	IMPROPER ASSEMBLY OF FIRING PIN	Assemble correctly - Retaining pin goes in back of large shoulder on firing pin
	TOO MUCH OIL IN FIRING PIN RECESS THROUGH BOLT	Wipe out with pipe cleaner
	DEFECTIVE AMMUNITION	Remove and discard
	TOO MUCH CARBON ON FIRING PIN OR IN FIRING PIN RECESS	Clean
BOLT WON'T UNLOCK	DIRTY OR DAMAGED BOLT	Clean, or see your gunsmith
WON'T EXTRACT	BROKEN EXTRACTOR SPRING	See your gunsmith
	DIRTY OR CORRODED AMMO	Remove stuck round with cleaning rod
	CARBON IN CHAMBER	Clean chamber
	FOULING OR CARBON IN EXTRACTOR RECESS OR LIP	Clean extractor
	FROZEN EXTRACTOR	Remove and Clean
	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)
WON'T FEED	DIRTY OR CORRODED AMMO	Remove and discard
	DIRTY MAGAZINE	Clean
	DEFECTIVE MAGAZINE	Replace
	TOO MANY ROUNDS IN MAGAZINE	Take out excess
	ACTION OF BUFFER ASSEMBLY IS RESTRICTED	Clean the Buffer and Action Spring
	MAGAZINE NOT FULLY SEATED	Adjust Magazine Catch: Press magazine catch button on right side, then turn catch on left side. Turn catch clockwise to tighten or counterclockwise to loosen.
DOUBLE FEED	DEFECTIVE MAGAZINE	Replace
WON'T CHAMBER	DIRTY OR CORRODED AMMO	Remove and discard
WON'T LOCK	DAMAGED AMMO	Remove and discard
	CARBON IN CHAMBER OR ON GAS TUBE	Clean

	DIRT, CORROSION, OR CARBON BUILDUP IN BARREL LOCKING LUGS	Clean Lugs
SHORT RECOIL	LOOSE CARRIER KEY SCREWS	Have Gunsmith torque and stake key screws
BOLT FAILS TO LOCK	CARBON OR DIRT IN CARRIER KEY OR ON OUTSIDE OF GAS TUBE	Clean Carrier Key or around Gas Tube
AFTER LAST ROUND	Q-TIP, PIPE CLEANER PIECES, OR OTHER DEBRIS STUCK INSIDE CARRIER KEY	Clean out if possible or have rifle checked by gunsmith
SELECTOR LEVER BINDS	NEEDS OIL	Lubricate with oil
	DIRT OR SAND UNDER TRIGGER	Clean
BOLT CARRIER	ROUND JAMMED BETWEEN BOLT AND CHARGING HANDLE AND/OR DOUBLE FEED	1. Remove magazine.
		2. Push in on the bottom of the bolt latch.
		3. While pulling down on charging Handle, tap the rifle butt on the ground. Bolt should lock to the rear.
		4. While bolt is held to the rear, round should fall through the magazine well.
		Note: if this procedure fails, use a section of the cleaning rod to push the bolt fully to the REAR THROUGH THE EJECTION PORT.

MAINTENANCE IN EXTREME WEATHER

EXTREME COLD: Clean and lubricate Rifle in a warm room with Rifle at room temperature. Do not lay a warm Rifle directly on snow or ice. Moving Rifle from cold into warmth will cause condensation which could keep Rifle from functioning.

HOT, WET CLIMATES: Clean and lube Rifle more frequently in moist climates. Inspect hidden surfaces of Bolt and Carrier Assembly, Upper Receiver, and Chamber / Barrel Extension (Locking Lugs), and Lower Receiver and Receiver Extension Assembly (Buffer Tube) for rust or corrosion. Also pay close attention to the Spring Loaded Detents on the rifle. Wipe off any hand / finger prints on the Rifle as they can accelerate the onset of rust or corrosion.

RAINS: DO NOT FIRE THE RIFLE IF WATER IS PRESENT IN THE BARREL. ALWAYS drain any water from Barrel prior to firing. Dry the Bore with a Swab and Cleaning Rod if wet.

COMPONENT VARIATIONS

This manual is intended to instruct the AAC Rifle Operator in all necessary aspects of Maintenance, Disassembly, Reassembly, Operation and Troubleshooting of any AR15-style AAC Rifle. Within the AAC Weapon System family, there can be infinite variations of Barrel Length, Stock Type, Receiver, Forend and Sights. The rifle you own, or are using, may vary in appearance from the photographs and illustrations in this Manual, but the concepts, procedures and practices recommended in this Manual are universal to the AAC AR15-style weapon family.

300 AAC BLACKOUT PDW UPPER

The 300 AAC BLACKOUT (300 BLK) cartridge is highly efficient and in most cases outperforms 5.56mm with less powder and resulting blast. The included AAC BLACKOUT flash suppressor eliminates all secondary muzzle flash. These properties make it ideal for personal security.

MAGAZINES

AAC 300 BLACKOUT ammo can feed from standard USGI or Magpul P-Mags. A magazine with the standard MIL-STD 17-7 stainless spring may be stored fully loaded with 30 rounds indefinitely. Note that Chrome Silicon springs will not resist taking a set better than MIL-STD 17-7 magazine springs regardless of how they have been marketed.

SOUND SUPPRESSORS

The recommended sound suppressor is the AAC 762-SDN-6. This has been tested to provide a good balance between sound level, weight, accuracy, and reliable function. Suppressed SPL with AAC subsonic ammunition is approximately 126 dB both using MIL-STD measurements and at the shooter's ear.

AMMUNITION

There are two special considerations for the AAC upper - gas port pressure, and reliable feeding from a magazine. 300 AAC BLACKOUT (300 BLK) ammo from Advanced Armament Corp. is designed for reliable function in self-loading firearms. Visit www.300AACBLACKOUT.com for ammunition information.

USER MODIFICATIONS

The gas-port diameter was selected after thousands of rounds of function testing and high-speed video analysis. We do not recommend you enlarge your gas-port to aid subsonic function because then supersonic ammunition will hyper-cycle the upper which will reduce the reliability and part life durability of the system. AAC has developed subsonic and supersonic ammo that both function reliably (with and without an AAC 762-SDN-6 sound suppressor) without the need for an adjustable gas block.

BARREL LIFE

The barrel of the AAC BLACKOUT upper is made from 4150 CMV and specially processed to have up to 60% more life than a chrome-lined barrel and without the potential loss in accuracy from uneven coating. This processing also results in extreme corrosion resistance.



9" PDW UPPER

ACTION SPRING/BUFFER

The 16 inch upper with a carbine length gas system should use a "C" rated buffer. All other uppers should use an H2 buffer (160 grams). H3 buffer may be a good choice if you don't intend to shoot subsonic without a sound suppressor or typically shoot supersonic ammo. Do not use a solid 9mm buffer as it may cause bolt bounce.

EXTRACTOR SPRINGS

We have 5.56mm test data for the Bushmaster '4 coil' extractor spring with an o-ring. Four uppers completed a 12,000 round test with no extractor spring related failures. Two uppers completed an 18,000 round test with no extractor spring related failures.

We do not recommend using extra-power extractor springs because they are under higher stress and will likely break sooner. The included green o-ring adds the desired extra extractor force without requiring a spring which would have more force and hence more stress. Extra-power springs, when combined with an o-ring, may make the extractor harder to snap over the case rim and may lead to function problems. If you do use such a spring, please don't use an o-ring and change the spring every 1500 rounds for mission-critical use. The green color of the o-ring signifies that it meets AAC specifications for endurance and elasticity at low temperatures.



NOTE: Again per our spring discussion, Chrome Silicon springs do not resist taking a set better than ASTM A228 certified music wire when used at temperatures below 250 degrees F.

PARTS REPLACEMENT

The Gas block is press-fit and pinned and may not be removable or replaceable without a press. Additionally, set screws are secured with both torque and Rocksett. If you remove the gas block, reset the set-screws to 30-35 inch/lbs of torque and one drop of Rocksett.

The following recommended replacement schedule for parts depends on the intensity of use and the intended use. After any parts replacement, give the firearm a safety/function check before use.

PART	RECREATIONAL USE	HARD USE / COMPETITION	MISSION-CRITICAL USE
Gas Tube	When fails	10,000 rounds	5,000 rounds
Extractor	When fails	10,000 rounds	5,000 rounds
Gas rings	10,000 rounds	5,000 rounds	5,000 rounds
Bolt	When fails	10,000 rounds	5,000 rounds
Extractor spring/insert/o-ring	15,000 rounds	5,000 rounds	5,000 rounds
Ejector spring	15,000 rounds	10,000 rounds	5,000 rounds
Barrel	50,000 rounds	35,000 rounds	20,000 rounds
Action spring	15,000 rounds	10,000 rounds	5,000 rounds

▲ ALWAYS CHECK HEAD SPACE AFTER CHANGING A BOLT, BARREL, OR BARREL EXTENSION.

REPLACEMENT PART NUMBERS

Firing pin retaining pin, Bushmaster part **8448504**
M16 Chromed Steel Firing Pin, Bushmaster part **8448503**
Extractor pin, Bushmaster part **8448513**
Extractor, Bushmaster part **8448512**
Ejector assembly, Bushmaster part **A EJECT ASS**
Cam pin, Bushmaster part **8448502**
Bolt Gas Rings (set of 3), Bushmaster part **8448511K**
Charging Handle, Bushmaster part **8448617**

LIMITED ONE YEAR WARRANTY

ADVANCED ARMAMENT CORP. (AAC) Firearms and accessories are warranted to be free from defects in materials and workmanship. Any such defect of which AAC is given written notice, as provided below, within one year and ten days from the date of first purchase by a customer will be remedied by AAC. This warranty is granted by ADVANCED ARMAMENT CORP. 2408 Tech Center Parkway, Suite 150, Lawrenceville, GA 30043, USA.

To initiate a Warranty claim, call AAC (1-770-925-9988) to get a "Return Merchandise Authorization" (RMA) number. Warranty claims should state (in writing) the model and serial number of the product concerned, a description of the difficulty experienced, and the date of purchase. The product concerned should be shipped (transportation charges prepaid), to the Warranty Service Department, ADVANCED ARMAMENT CORP. 2408 Tech Center Parkway, Suite 150, Lawrenceville, GA 30043, USA. Shipment should be insured by the owner, as AAC will accept no responsibility for loss or damage in transit.

Under no circumstances shall ADVANCED ARMAMENT CORP. 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. Some states do not allow the exclusion of limitation of incidental or consequential damages, so the above limitation may not apply to you. ADVANCED ARMAMENT CORP. 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, or unreasonable use. Furthermore, the liability of ADVANCED ARMAMENT CORP. under this warranty shall be limited solely to the obligation to repair or replace the firearm or accessory, and to pay transportation and insurance charges for return of the firearm or accessory to owner.

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

ADVANCED ARMAMENT CORP[®]

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