

SERIAL NUMBER INFORMATION

Record the serial number of your Samcorp Arms Mfg. firearm!

(When holding the firearm the serial number will be found on the left side of the firearm, stamped on the magazine well)

NOTE: The caliber marking can be found on the barrel of the rifle in front of the gas block.

Describe your firearm:

Make a copy of this operations manual and proof of purchase/sales record. Maintain these items in a secure safe or fireproof container. These materials will be necessary if the firearm is damaged, stolen or returned to S.A.M. for warranty or repair. Attach original proof of purchase to this document!

WARNING

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

FOR YOUR SAFETY AND THE SAFETY OF OTHERS, this Operations Manual contains important instructions, warnings and safety procedures that must be understood BEFORE using your S.A.M. firearm. It is imperative that you read the ENTIRE MANUAL and if you do not understand any part of it or the operation of your firearm, you should seek professional firearms instruction.

NOTICE

Samcorp, Inc. shall not be responsible for personal injury, death or damage to property resulting from either intentional or accidental discharge of this firearm, or from its function when used for purposes or subjected to treatment for which it was not designed. Samcorp, Inc. will not honor claims involving this firearm which result from careless or improper handling, unauthorized adjustment or parts replacement, corrosion, neglect, or the use of wrong caliber ammunition, other than original high quality commercially manufactured ammunition in good condition, or any combination thereof. Samcorp, Inc. will not honor claims involving this firearm for any reason or cause when the second or subsequent owner makes such claims.

Before the rifle left the factory it was tested, carefully inspected and packaged. Samcorp, Inc. cannot control product handling after it leaves the factory; therefore please examine this firearm carefully at the time of purchase to ensure that it is unloaded and undamaged.

WARNING Children are attracted to and can operate firearms that can cause severe injuries or death. Prevent child access by always keeping guns locked away and unloaded when not in use. If you keep a loaded firearm where a child obtains and improperly uses it, you may be fined or sent to prison.

ADVERTENCA A los niños los atraen las armas de fuego y las pueden hacer funcionar. Ellos pueden causarse lesiones graves y la muerte. Evite que los niños tengan acceso a las armas de fuego guardándolas siempre con llave y descargadas cuando no las este utilizando. Si usted tiene una arma de fuego cargada en un lugar en que un niño tiene acceso a ella y la usa indebidamente, le pueden dar una multa o enviarle a la cárcel.

GENERAL HANDLING CAUTIONS

1. Do NOT alter or modify your Samcorp Arms Mfg. firearm, and have it serviced regularly!
2. Always handle your firearm as if loaded.
3. Never point your firearm at anything you don't intend to shoot.
4. Always make sure your firearm is not loaded and the bolt is latched open and to the rear before laying it down or handing it to someone else.
5. Never leave a loaded firearm unattended.
6. Always be sure bore, muzzle, chamber and action are clear of obstruction.
7. Always check that ammunition is clean and undamaged.
8. Never drink alcoholic beverages or take drugs before or during shooting.
9. Always wear eye and ear protection when shooting.
10. Always keep safety on "SAFE" when firearm is loaded and a round is chambered until ready to shoot.
11. Never attempt to fire if water is in the bore.
12. Never indulge in "horseplay" when holding your firearm.

DANGEROUS PROCEDURES

1. Be sure the cam pin is installed in the bolt group. If it isn't, your rifle can still fire but it could possibly explode, causing you personal injury or harm.
2. DO NOT exchange or switch bolt assemblies from one rifle to another. It could cause personal injury to you and others and damages to your rifle.
3. If your firearm fails to fire, hold it, keep it pointed towards the target and wait 30 seconds. If a hangfire has occurred, the round will fire within 30 seconds. If the round does not fire, remove magazine, eject round and examine the primer. If firing pin indent is light, misaligned or non-existent, have your firearm examined by a competent gunsmith. If firing pin indent on primer appears normal (in comparison to previously fired rounds) assume faulty ammunition; appropriately dispose of misfired round from other live ammunition; reload and resume firing.

USE OF SAFETY SELECTOR

A selector lever, located on the left of lower receiver, has two positions, "FIRE" and "SAFE". When set to "FIRE" the firearm will fire a single shot each time the trigger is squeezed. When set to "SAFE" a cam bears upon the rear of the trigger, blocking movements and pre-venting the hammer from being released.

FUNCTION CHECK

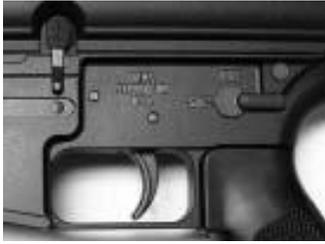
SAFE: Remove magazine and make sure your rifle is unloaded and there is no ammunition in the chamber. Point in safe direction. Pull charging handle to rear and release. Place on safe. Pull trigger. Hammer should not fall.

FIRE: Remove magazine and make sure your rifle is unloaded and there is no ammunition in the chamber. Point in safe direction. Place selector on fire. Pull trigger and hold to rear. Hammer should fall. Pull charging handle to rear and release. Release trigger and pull again. Hammer should fall.

SAFETY FEATURES

"SAFE" Rifle will not fire. Selector lever cannot be on safe unless rifle is cocked. Always place on SAFE when loading and unloading.

"FIRE" Rifle will fire one round each time the trigger is pulled.



SAFE



FIRE

"Disconnector" The disconnector, a part of the firing mechanism, prevents the firearm from firing full automatic. As the hammer is cocked after each shot the disconnector holds the hammer until the trigger is released. When the trigger is released, retention of hammer passes from disconnector to trigger ready for the next shot.

"Firing Pin Collar" The bolt carrier assembly, located within the upper receiver, is designed to prevent the firing pin from striking a cartridge until the bolt is locked to the barrel.

LOADING A MAGAZINE

1. Use only ammunition for which your firearm is chambered.
2. With front of magazine forward, place a round between the lips of the magazine with the bullet forward. Press the round down until it is retained by the magazine lips. Place the next round on top of the last and repeat until desired number is loaded.

TO LOAD THE RIFLE

1. Press in on bottom of bolt catch while pulling back on charging handle, to cock the hammer and leave the bolt and carrier to the rear.
2. Return the charging handle to fully forward until it locks and remove finger from bolt catch.
3. Set selector to "SAFE" position.
4. With the bullets pointing forward, insert loaded magazine into magazine well and push it in until it stops and is retained by magazine catch.
5. With the rifle pointed in a safe direction press in on top of bolt catch. This will release the bolt and carrier and move a round into chamber. The rifle is now loaded with a round in the chamber and the hammer cocked.
6. You may now close the ejection port cover if you wish; it is located on the right side of the upper receiver and will open automatically when the first round is fired.

TO UNLOAD THE RIFLE

1. Set selector to "SAFE" position.
2. Press magazine catch button and remove magazine.
3. Pull charging handle to rear and push in lower portion of bolt catch. If a round had been in the chamber it should have been ejected. If last round in magazine had been fired and if the magazine was in place, bolt and carrier should already be held to the rear.

CAUTION: Always check that ammunition is clean and undamaged before using the forward assist. Forcing damaged ammunition into the chamber could result in personal injury or death to you and others and damage your rifle and property. The use of reloaded, hand-loaded or high pressure ammunition can be dangerous and will void the warranty.

Make sure the rifle is pointed in a safe direction and the safety is engaged at all times while loading the rifle. NEVER allow your fingers or other objects to contact the trigger while loading or unloading the rifle. Do NOT disengage the safety until you are ready to fire and have the rifle pointed safely downrange.

CLEAR YOUR RIFLE

- 1. Place selector on SAFE. If weapon is not cocked, lever cannot be pointed toward SAFE.**
- 2. Remove magazine.**
- 3. To lock bolt open, pull charging handle rearward, press bottom of bolt catch & allow bolt to move forward until it engages bolt catch. Return charging handle to forward. If you haven't before, place on SAFE.**
- 4. Eyeball receiver and chamber to ensure these areas contain no ammo.**
- 5. With selector lever pointing toward SAFE, allow bolt to go forward by pressing upper portion of bolt catch.**

FIRE YOUR RIFLE

- 1. Always wear ear and eye protection when firing your weapon.**
- 2. Load firearm as previously described.**
- 3. Set rear sight (not included) to range required.**
- 4. Grasp firearm with one hand on hand guard and other hand on pistol grip with trigger finger resting along side of trigger guard. Raise firearm and pull buttstock firmly into shoulder.**
- 5. Aim by aligning target with front and rear sights.**
- 6. Move selector lever to "FIRE".**
- 7. Keeping steady aim, place trigger finger on trigger and squeeze gently until trigger releases hammer. Do not jerk the trigger as you will disturb your aim and ruin your accuracy. To fire the next round and subsequent rounds, all that is necessary is release the trigger and squeeze it again after every shot until you are finished or the magazine is emptied.**
- 8. This is a semi-automatic firearm and is immediately loaded and ready to fire after each shot until magazine is empty.**
- 9. Release trigger, remove finger from trigger, and set selector lever to "SAFE". If you have fired the last round from magazine, the bolt and carrier will be held to the rear so that you can quickly reload by replacing the magazine or the chamber can be checked to ensure it is empty.**

WARNING: PROJECTILE LODGED IN BORE

If an audible "POP" or reduced RECOIL is experienced during firing, immediately CEASE FIRE and remove the magazine

- (1) Lock the bolt to the rear and place the selector lever on the "SAFE" position.**
- (2) Visually inspect and/or insert a cleaning rod into the bore to ensure there is not a projectile lodged in the bore**

If a projectile is lodged in the barrel of the weapon, DO NOT attempt to remove it. Contact S.A.M.

NOTE: Before firing your rifle, practice your stance, aim, rhythm and breathing for steady aim with your firearm unloaded. Practice firing on a range before going hunting or using your firearm for any other type of shooting.

NEVER load a cartridge into the chamber until you are ready to fire the rifle. Do NOT disengage the safety until the rifle is pointed in a safe direction and you are ready to fire.

After firing, clean with Rifle Bore Cleaner (RBC). Wipe dry and lube according to lubrication guide.

MAINTENANCE

Your S.A.M. rifle is based on military rifle design and is very rugged but proper maintenance is necessary to keep it in good working condition.

Field Stripping/Disassembly

1. Press take down pin in from left rear of lower receiver (it may be necessary to use a punch as the fit between upper and lower may be very tight). Pull it out the right side until it comes to a positive stop.
2. Pivot lower receiver down and away from upper portion of receiver.
3. Press front pivot pin in from left side of lower receiver and pull out right side until it comes to a positive stop.
4. You can now separate the upper and lower receivers.
5. Pull charging handle to rear and remove bolt and carrier assembly.
6. Remove charging handle by pulling it backwards to key way and down out of receiver.
7. Push in firing pin retaining pin right-to- left of bolt carrier and remove it by pulling it out to the left.
8. Tilt bolt face up and remove firing pin.
9. Push bolt in towards the carrier until it rotates and comes to a stop, then turn cam pin 90°.
10. Remove cam pin by lifting it out away from bolt and carrier.
11. Pull bolt forward out of carrier.
12. Depress buffer, maintaining pressure as buffer is under spring tensions, to prevent it from being ejected when buffer retainer is depressed. Depress buffer retainer to permit buffer and spring to move forward. Then depress hammer to allow the buffer and spring to continue to move forward and be removed from receiver extension.
13. To remove handguard, loosen and remove hex head bolts from handguard. Slide handguard away from upper exposing barrel nut.

STOP! A COMPETENT GUNSMITH SHOULD ONLY PERFORM FURTHER DISASSEMBLY.

Your rifle is now field stripped for cleaning. To reassemble repeat procedure in reverse order. With the rifle disassembled, thoroughly clean, inspect and lube so you have a reliable weapon you can always depend on.

THOROUGH CLEANING (upper)

CLEAN WITH RBC (Rifle Bore Cleaner) • All areas of powder fouling, corrosion, dirt and rust.

Be sure to include:

- **Bore & chamber**
- **Locking lugs**
- **Gas tube**
- **Outer & inner surfaces of bolt carrier**
- **Carrier key**
- **Firing pin recess and firing pin**
- **Firing pin hole (Use pipe cleaner there)**
- **Carbon deposits & dirt from locking lugs**
- **Areas behind bolt ring and under lip of extractor**

THOROUGH CLEANING Lower (receiver)

- **Clean areas of powder fouling, corrosion and dirt**
- **Wipe dirt from trigger mechanism**
- **Clean buffer and inside lower receiver extension**

CAUTION

Do not use wire brush or any type of abrasive material to clean aluminum surfaces.

INSPECT AND LUBE

Lightly Lube - A film of oil barely visible to the eye.

Generously Lube - Heavy enough so that it can be spread with the finger.

Remember to remove excessive oil from the bore before firing.

LUBRICATING GUIDE: UPPER

Lightly lube bore, chamber and outer surfaces of barrel.

Using a bore brush of the proper caliber, start at receiver and go right through the compensator.

(DON'T REVERSE DIRECTIONS IN BORE)

BOLT CARRIER GROUP

Generously lube cam pin area, piston rings, and outside of bolt body.

Lightly lube charging handle and inner / outer surfaces of bolt carrier. Generously lube slide and cam pin area of bolt.

Lightly lube firing pin and firing pin recess in bolt.

LOWER RECEIVER GROUP

Generously lube takedown and pivot pins and inside receiver parts.

Generously lube action spring, buffer, and inside lower receiver extension.

INSPECT - before assembly

WARNING: DO NOT interchange bolts between rifles

BOLT - Cracks or fractures, especially in the cam pin hole area. Bolts that contain pits extending into the firing pin hole need replacing.

FIRING PIN - Replace if it has a bent, cracked or blunted end.

FIRING PIN RETAINING PIN - Replace if bent, broken, or badly worn.

CAM PIN - Replace if cracked, chipped or missing.

EXTRACTOR AND EXTRACTOR SPRING - Check extractor for chipped or broken edges in the area of the lip that engages the cartridge rim.

IF PARTS ARE MISSING OR DEFECTIVE, CONTACT SAMCORP ARMS.

ASSEMBLY

1. Insert spring and buffer.

2. Slide bolt into carrier.

WARNING: Do not switch bolts between rifles.

STAGGER RING GAPS TO STOP GAS LOSS

3. Replace bolt cam pin.

WARNING Be sure that the cam pin is installed in the bolt group. If it isn't, your rifle can still fire and will explode.

4. Drop in and seat firing pin.

5. Pull bolt back.

6. Replace retaining pin.

NOTE: Firing pin should not fall out when bolt carrier group is turned upside down.

7. Engage, then push in charging handle part way.

BE SURE BOLT IS STILL UNLOCKED

8. Slide in bolt carrier group.

9. Push in charging handle and bolt carrier group together.

10. Join upper and lower receivers.

11. Engage receiver pivot pin.

12. Close upper and lower receiver groups. Push in takedown pin.

CAUTION Selector lever must be on safe before closing upper receiver.

CHECK THE selector lever BY PERFORMING THE FUNCTIONAL CHECK

IS EVERYTHING INSTALLED?

Warranty

Three Year Limited Warranty

This Samcorp Arms Mfg. firearm is warranted for **three years** from the date of purchase against defects in material and workmanship. All parts and labor or replacement at our option are covered.

Government fees, damage caused by failure to perform normal maintenance, sales outside the United States, damage due to high velocity, high pressure, reloaded, or other non-standard ammunition, or any unauthorized repair, modification, misuse, abuse, or alteration of the product is not covered by this limited warranty.

Any implied warranties, including the implied warranties of merchantability and fitness for a particular purpose, are limited to one year from date of purchase. Consequential or incidental damages and/or expenses, or any other expenses are not covered by this warranty.

To obtain warranty performance send your firearm with proof of retail purchase, freight prepaid to:

Samcorp Arms Mfg.
1857 Commander Drive
Lake Havasu City, AZ. 86403

Alterations & Modifications Warning

Altering or modifying parts is dangerous and will void the warranty. This rifle was manufactured to perform properly with the original parts as designed. It is your duty to make sure any parts you buy are made for this rifle and are installed correctly and that neither the originals nor the replacements are altered or changed. Your S.A.M. rifle is a complex precision tool with many parts that must relate correctly with other parts in order for proper and safe operation. Putting a rifle together wrong or with incorrect or modified parts can result in a damaged rifle, serious personal injury or death to you and others through malfunction. Always have a qualified gunsmith work on your rifle or at least check any work not performed by a gunsmith.

Barrel Information Warning

To achieve the best results for accuracy you should clean the chamber and bore after every 10 rounds up to 100 rounds. It usually takes about 200 rounds per barrel for optimum accuracy. Please keep in mind that our barrels are production barrels, not custom barrels. Accuracy is dependent upon many factors such as bullet weight, powder load, rifling twist, rifling lands, operator technique, etc. Our production barrels have achieved anywhere from 1/8" to 1 1/2" M.O.A.. Obviously, we would hope that every production barrel would shoot 1/8" M.O.A., but with all of the above factors, we cannot guarantee a specific group size. NOTE: Using reloaded ammunition will void warranty. Modifying chamber or barrel voids warranty. This includes re-reaming of chamber, re-turning barrel to a lesser diameter and/or re-threading barrel for compensator or attachments.

UNUSUAL CONDITIONS

EXTREME COLD:

- a. Clean and lubricate rifle with gun lubricant. Keep it moisture free.**
- b. Operate controls through their entire range, at intervals, to keep them from freezing up.**
- c. When your rifle is not being used and kept outside, protect it with a cover.**

HOT CLIMATES

- a. Inspect rifle and bipod more frequently, especially the hidden surfaces of bolt carrier group, forward assist assembly and lower receiver components. Make certain they are lubricated using gun lubricant.**
- b. When handling, make certain to wipe dry, as moisture could cause corrosion. After drying, lubricate with gun lubricant.**

HOT, DRY CLIMATES - Clean and oil rifle more frequently with gun lubricant.

DUSTY AND SANDY AREAS

- a. Clean and lubricate your rifle more frequently.**
- b. Keep sand out of parts when inspecting, lubricating, or assembling rifle. Apply only a very light amount of lubrication on outside of rifle.**
- c. Use magazine bag and muzzle cap for dust and sand protection.**

CAUTION: Do not use magazine bag and muzzle cap on stored rifles.