



MAC IX SEMI-AUTOMATIC FIREARM

USER MANUAL & SPARE PARTS CATALOGUE



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IMPORTANT SAFETY MESSAGE

Children are attracted to firearms and can operate firearms, which can cause severe injuries or death. Prevent child access by always keeping gun locked, unloaded and separated from ammunition 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.

Firearm Safety Depends on You

A gun is only as safe as the person operating it. You can never be overly careful when handling a firearm.

Carelessness is often the cause of shooting accidents; such as failing to keep the muzzle pointed in a safe direction, not being sure of your target and what is behind it, failing to properly engage the safety, leaving ammunition in the chamber or using improper ammo. Since a bullet can never be called back once fired, such errors in gun handling can result in the loss of life, severe injury or property damage thus, it is crucial for your safety and the safety of those around you, that you learn the principles of safe gun handling and storage before you begin to use your new firearm. Be a safe shooter - please read this instruction book thoroughly even if this is not your first firearm purchase as not all firearms are the same. The first step in being a safe shooter is to learn the rules for the safe operation and handling of firearms. There is nothing more important in gun handling than safety.

▲ RULES OF FIREARM SAFETY

Rules of Firearm Safety must be etched into your memory before you begin to handle firearms. These rules are intended to be followed by all persons handling firearms in the field, on the range or at home. Please read, review and understand these rules before you begin to use or even take your new firearm out of its box. Remember, firearms safety depends on you! Memorizing these safety rules will help prevent gun accidents. Please study these safety rules before handling your firearm.

RULE 1

Always Keep the Muzzle Pointed in a Safe Direction

This is the most basic and most important safety rule. A safe direction is one in which an accidental discharge will not cause injury to yourself, to others or property damage. This is particularly important when loading or unloading your firearm. Never point your gun at anything you do not intend to shoot. Treat every gun as if it were loaded at all times.



IMPORTANT SAFETY MESSAGE

Rule 2

Firearms Should Be Unloaded When Not Actually in Use

Firearms should only be loaded when you are in the field or on the target range or shooting area, ready to shoot. When not in use, firearms and ammunition should be secured in a safe place, separate from each other. Remember to unload your firearm completely so that there is no ammunition in the chamber or magazine. Before handling this or any firearm, or handing it to someone else, visually check the chamber. Never assume a gun is unloaded even if you were the last person to use it. Never cross a fence, climb a tree, wade through a stream or perform any awkward movement with a loaded gun. When in doubt, unload your gun! Never pull or push a loaded firearm toward yourself or another person. Never carry a loaded gun in a scabbard, a holster not being worn or a gun case - common sense prevails in gun safety!

RULE 3

Don't Completely Rely on Your Gun's Safety

Treat every gun as though it could fire at any time, even if you are not applying pressure to the trigger. The "safety" on a firearm is a mechanical device which, like any such device, can become inoperable at the worst possible time and fail to function. By mistake, you may think the safety is "ON" when it actually is not. Or you may think your gun is unloaded when there is actually a round of ammunition in it. The safety serves as a supplement to proper gun handling but cannot serve as a substitute for common sense. Never handle a gun carelessly and assume that the gun won't fire just because "the safety is on."

Never touch the firearm's trigger until you are ready to shoot. Keep your fingers away from the trigger when loading or unloading. Never pull the trigger when the safety is engaged or when the safety is positioned between the "SAFE" and "FIRE" positions.

Alcohol, Drugs and Guns Don't Mix. Make No Mistake About It!

Never handle firearms after consuming alcohol or taking drugs that can affect your judgment. Shoot sober! Alcohol, certain kinds of drugs and firearms don't mix. Safe firearms handling requires alertness and concentration on one's actions. You cannot handle a firearm safely after consuming alcohol. Never consume anything that can impair your judgment or physical coordination when handling a firearm.

RULE 4

Be Sure of Your Target - And What Is Beyond It!

Once fired, a bullet (or shot charge) can never be called back; so before you shoot, know where the bullet is going and what it will strike. Be certain your shot will not injure someone or strike something beyond the target. Never fire in the direction of noise, a movement or at any object you cannot positively identify. Be aware that a .22 Short bullet can travel over 1 mile. A centerfire cartridge, such as the .30-06, can send its bullet over 3 miles. Shotgun pellets can travel 500 yards and a shotgun slug has a range of over a half mile. Make sure your shot has a safe backstop such as a hillside. Keep in mind how far the bullet will travel if it misses your intended target. You are responsible for your actions and judgment.



IMPORTANT SAFETY MESSAGE

RULE 5

Every firearm is designed to use a certain caliber or gauge of ammunition.

It is important that you use the correct ammunition for your firearm. Information on the correct ammunition to use with your firearm appears in the firearm's instruction manual and the manufacturer's markings on the firearm itself. Use of the wrong ammunition, improperly reloaded ammunition or corroded ammunition can result in the destruction of the firearm, serious personal injury and/or death. Form the habit of examining every round of ammunition before you put it into your gun to ensure it is of the proper gauge or caliber and that it is in good condition.

RULE 6

If Your Gun Fails to Fire When the Trigger Is Pulled, Handle With Care.

If a cartridge or shell does not fire when the trigger is pulled, follow Commandment #1 and keep the firearm's muzzle pointed in a safe direction. Keep the muzzle down range with the action closed and wait at least 30 seconds (to ensure that the ammunition is not delayed in firing) before carefully opening the action, taking care to avoid exposure to the breech area and unloading the firearm and safely disposing of the ammunition.

RULE 7

Always Wear Eye and Ear Protection When Shooting

Exposure to shooting noise can permanently damage hearing. Flying debris, such as powder residue and ejected cartridge cases, can injure your eyes.

Thus, it is only common sense to wear both eye protection (such as shooting glasses) and ear protection (such as a sound-muffling headset) whenever shooting. Also, wear eye protection when cleaning or disassembling your gun to ensure that cleaning solvent and tensioned parts (such as springs) do not come into contact with your eyes.

Rule 8

Be Sure the Barrel Is Clear of Obstructions Before Shooting.

Discharging a firearm with an obstruction in the barrel can result in personal injury, property damage and/or death. Before you load your firearm, check the chamber and magazine to ascertain that no ammunition is inside. Also, check the inside of the barrel (called the "bore") to ensure it is free of obstructions. Even a small amount of mud, snow or excess lubricating oil or grease in the bore can cause excessive pressures resulting in a bulged or burst barrel which can injure or kill the shooter and bystanders. It is a good idea to make a habit of cleaning the bore and checking for obstructions with a cleaning rod just before each shooting session. If the noise or recoil experienced upon firing seems low or weak, or something doesn't feel "right," cease firing immediately and check to make sure that there is no obstruction in the barrel. Placing an undersized Shell or cartridge into a gun (such as a 20 gauge shell in a shotgun chambered for 12 gauge ammunition) can result in the smaller round of ammunition failing into the barrel and acting as an obstruction. When a round is subsequently fired, the barrel may burst, causing injury to the shooter and bystanders. For reference, re-read Commandment #5.



IMPORTANT SAFETY MESSAGE

Rule 9

Do Not Alter or Modify Your Gun and Have It Serviced Regularly.

Firearms are complex mechanisms that are designed to function properly in their original condition. Any alterations or changes made to a firearm after its manufacture can make the gun unsafe and will void its warranty. Do not jeopardize your safety or the safety of others by altering the trigger, mechanical safety or other mechanisms of your firearm. You should have your firearm periodically checked for proper functioning and serviced by a qualified gunsmith.

Rule 10

Learn the Mechanical and Handling Characteristics of Your Firearm.

Not all firearms operate the same way. The method of carrying, handling and operating firearms varies with the mechanical characteristics of each gun. Thus, you should never handle any firearm until you become familiar with the safe handling, loading, unloading and carrying procedures for that particular firearm, as well as the rules for safe gun handling in general.

LEAD WARNING!

Discharging firearms in poorly ventilated areas, cleaning firearms or handling ammunition may result in exposure to lead and other substances known to cause birth defects, reproductive harm and other serious injuries. Have adequate ventilation at all times when shooting. Wash hands thoroughly after exposure.

Basics of Safe Gun Handling

- 1- Always keep the muzzle pointed in a safe direction.
- 2- Firearms should be unloaded when not actually in use.
- 3- Don't totally rely on your gun's safety.
- 4- Be sure of your target and what is beyond it.
- 5- Use the correct ammunition for your firearm.
- 6- If your gun fails to fire when the trigger is pulled, handle with care.
- 7- Always wear eye and ear protection when shooting and cleaning.
- 8- Be sure the barrel is clear of obstructions before shooting.
- 9- Do not alter or modify your firearm. Maintain your firearms at regular intervals.
- 10- Learn the mechanics and usage characteristics of the firearm you are using.

Safe gun handling depends on you! A safe shooter is a knowledgeable shooter.

WARNING! STOP SHOOTING IMMEDIATELY AND UNLOAD YOUR FIREARM if your firearm develops a mechanical malfunction; binding or stoppage, spitting powder/gas, a cartridge primer is punctured, a cartridge case is bulged or ruptured, or the sound on firing does not sound quite right. Do NOT try one more shot, but unload your firearm and take it and the ammunition to a qualified gunsmith. Do not assume that the firearm is empty merely because you checked the chamber. You must also check the bore for any obstruction.

WARNING! Always ensure that the ammunition you are using is clean, undamaged and of the proper caliber before loading your pistol. The manufacturer and distributor of this pistol disclaim any liability for the use of remanufactured, reloaded or hand-loaded ammunition. Protect your investment in this fine firearm by using only factory fresh, quality ammunition. The use of improper caliber or low-quality ammunition could result in injury, death and/or property damage upon firing. Remember, firearms safety depends on you! Follow all warnings provided by the manufacturer of the ammunition you are using.



LIABILITY, CHAMBER SAFETY FLAG

Our Products are classified as FIREARMS and are sold by MILITARY ARMAMENT CORPORATION with the understanding that we will not be liable in any way for firearm malfunction, physical injury or property damage resulting in whole or in part from:

- Criminal or negligent shootings
- Improper, careless or malicious use
- Unauthorized modifications or replacement of parts
- Defective, inappropriate, hand-loaded or reloaded ammunition
- Corrosion/Maintenance neglect
- Other effects beyond our direct and immediate control

This limitation applies regardless of whether liability is based on contract, negligence or strict liability (including any failure to warn). As MILITARY ARMAMENT CORPORATION In no event shall we be liable for incidental or consequential damages such as loss of use of property, business loss, loss of profits or profits.

Keep this manual next to your firearm. Make sure you understand the warnings, operating instructions and safety procedures. When loaning or selling a firearm, make sure this manual is included with the gun. You can request a copy of this manual from MILITARY ARMAMENT CORPORATION.

THE SAFETY OF FIREARMS IS ENTIRELY THE RESPONSIBILITY OF THE SHOOTER. ALWAYS TREAT ALL FIREARMS AS LOADED!

IMPORTANT! READ THE SECTION AND WARNINGS IN THIS BOOKLET BEFORE USING THE FIREARM.

CHAMBER SAFETY FLAG

MILITARY ARMAMENT CORPORATION firearm is shipped with a chamber safety flag. The chamber safety flag prevents the chambering of a round when installed and provides a readily visible indication that the firearm's chamber is empty. The chamber safety flag is to be installed in the firearm's chamber at all times when the firearm is not in use. Many public ranges require chamber safety flags be installed when the firing line is cold.



GENERAL INFORMATION



Congratulations on your purchase of MAC IX.

With proper care and handling, it will give you long, reliable service. The MAC IX series are semi-automatic pistols chambered for the 9mm cartridge.

The Picatinny rails on the top of receiver and the M-Lock on the sides of the forearm allow for the attachment of compatible accessories. This 9x19mm semi-automatic pistol features a blowback-closed bolt for a more balanced and accurate shot.

BASIC FEATURES

- Light and ergonomic for ease of use and transportation
- High wear resistant, hard chrome coated barrel alloy that provides a long barrel life span
- The overhead spring system allows the firearm use with stockless, folding pistol brace or telescopic pistol brace.
- Possibility to use with folding or telescopic pistol brace
- Thanks to the Picatinny rails on the top firearm, and M-LOCKS on the other sides of the fore-arm, it allows the various attachment and use of additional equipment.



MAC IX TECHNICAL SPECIFICATION



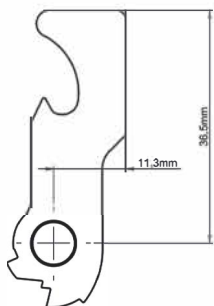
The MAC IX is a semi-auto, civilian legal version of a military issue firearm. It was designed to cycle with NATO Spec. Ball Ammunition. Hollow point and other flat nose ball ammo with large diameter cross sections on the face of the projectile may not feed successfully or consistently in this firearm.

Caliber	9x19 mm	Fire Selector Position	: Ambidextrous
Barrel Length	: 165 mm (6.5")	Trigger Pull Force	: 25-55 Newton (5.5-12 lb)
Barrel Material	: AISI-SAE 4140 (42CrMo4)	Cocking Force Safety	: 60-100 Newton (13-22 lb)
Barrel Finish	: Melonite	Sight	: Trigger Block & Firing Pin Safety
Receiver Material	: 7075 T6 Aluminum Alloy	Height	: Mechanic Sight
Muzzle	1/2-28 TPI, 3 lugged for flash hiders & suppressors	Width	: 218 mm (8.58") Approx
Flash Hiders	: 46 mm (1.80")	Range	: 57.5 mm (2.26") Approx
Magazine Capacity	: 10-20-30 Rnd	Shot Pattern Muzzle	: 150 m (490 ft) (Effective)
Total Length (w/o Brace)	: min. 14.70" (374 mm)	Velocity Barrel	: 3 MOA / 100 m
Weight (Without Magazine)	: Min. 2270 gr (5 lb)	Profile	: 400(+30) m/s (1312 ft/s)
Operation	: Blowback Close Bolt		: Saami Z299-3 Standard Luger 9 mm, Luger Plus 1:10" 6 grooves right hand twist
Mode of Operation	: Semi-Automatic		

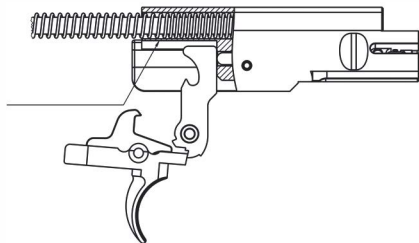


MAC IX TECHNICAL SPECIFICATION

We have identified that this firearm works in conjunction with our factory trigger and hammer and many AR-15 trigger group. This drawing shows the maximum allowable height for hammers to function, but we only guarantee function with original factory parts.



In our firearm, the critical maximum hammer dimensions are shown. You can use AR-15 trigger groups that fall within these dimensions.



AR-15 trigger groups with the hammer of the appropriate sizes, including pin holes will operate correctly.



LAYOUT OF THE MAC IX SEMI-AUTOMATIC FIREARM IN THE CARRY BAG

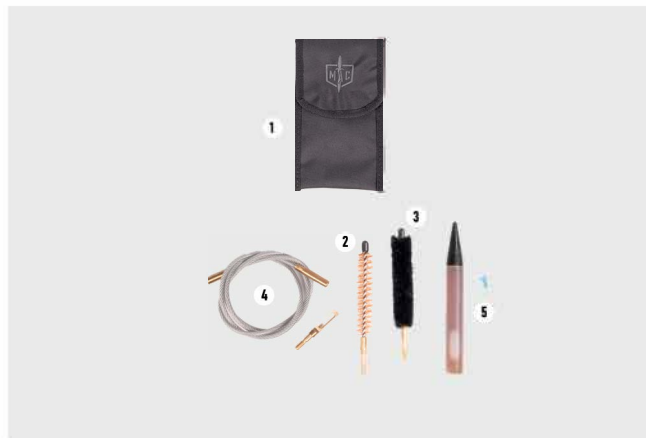
PACK INCLUDES



- 1 MAC IX Series Semi-Automatic Pistol
- 2 Maintenance and Cleaning Kit
- 3 Sling
- 4 Magazine
- 5 User Manual

**In case of purchase together with MAC IX*

CLEANING KIT AND COMPONENTS

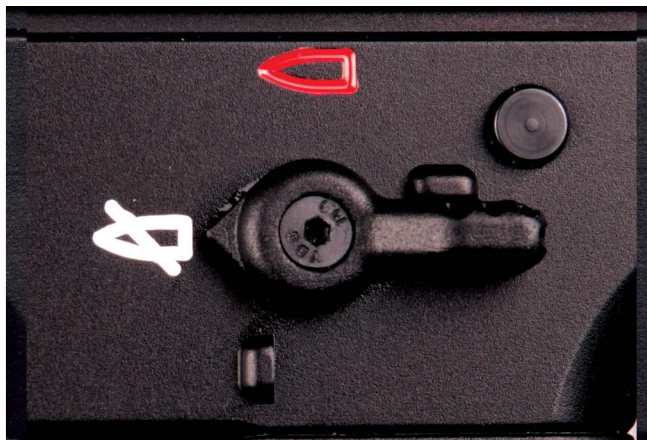


- 1 Cleaning Kit
- 2 Bronze spiral barrel brush
- 3 100% cotton round cleaning brush
- 4 Cleaning Cable
- 5 Cleaning Oil Bottle

SAFETY OPERATIONS

Selecting the Firearm to the SAFE Position:

To place the firearm in the SAFE position, rotate the safety lever clockwise, which is located on the lower receiver above the trigger guard, pointing to the white bullet shape. The safety lever's position must be at the position showed in the picture. This will lock the trigger and the firearm cannot be fired.



Selecting the Firearm to the FIRE Position:

To place the firearm in the FIRE position, rotate the safety lever clockwise which is located on the lower receiver above the trigger guard, pointing to the red bullet shape. The safety lever's position must be at the position shown in the picture.



HOW TO LOAD THE FIREARM

⚠ WARNINGS

WARNING!

Before loading, make sure the inside of the barrel is free of dirt or other obstructions.

WARNING!

Always check each cartridge to ensure it is of the correct caliber and in good condition before loading the firearm.

WARNING!

Never load a firearm indoors. An accidental discharge will cause property damage serious injury and/or death! Never use live ammunition to function test your pistol indoors.

WARNING!

Keep fingers away from the trigger while loading.

WARNING!

Keep muzzle pointed in a safe direction.

1. Place the safety lever in the SAFE 'white bullet shape' position.
2. Load the magazine with the correct ammunition by pressing the cartridges one at a time into the magazine's feed lips. When loading the rounds into the magazines ensure the base of the cartridge is in contact with the inside back of the magazine.
3. Pick up the firearm with your strong hand and the magazine with your support hand. Insert the magazine into the magazine slot at the bottom.
4. Press the magazine in until you feel the magazine catch lock engage. You should hear an audible click when it locks into the place, pull down on the magazine to ensure it has locked into position properly.
5. Keep the muzzle pointed in a safe direction with fingers away from the trigger.
6. Place the safety lever in the FIRE 'Red bullet shape' position
7. While holding the firearm in your strong hand, use the support hand to pull the charging handle rearward, disengaging it and allowing it to move forward. As it moves rapidly forward under spring pressure, the bolt will strip a round from the magazine and insert it into the chamber. The pistol is now loaded and ready to fire.



HOW TO LOAD THE FIREARM

8. CAUTION: WHEN RELEASING THE CHARGING HANDLE, BE SURE TO AVOID PINCHING HAZARDS, AS IT IS UNDER PRESSURE FROM THE RECOIL SPRING. IT IS IMPORTANT TO ALLOW THE CHARGING HANDLE AND BOLT TO MOVE FREELY FORWARD UNDER SPRING TENSION. WHILE GOING INTO BATTERY, DO NOT ATTEMPT TO SLOW THE CHARGING ARM AND BOLT. THIS MAY CAUSE IT TO NOT FULLY CHAMBER A ROUND.

9. If you don't want to shoot, please ensure the safety is in the SAFE 'white bullet shape' position.

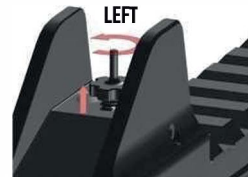


WARNING!

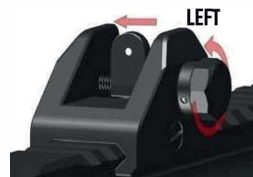
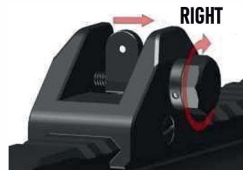
The pistol is now loaded and will fire if the safety lever is moved to the FIRE 'Red bullet shape' position and the trigger is pulled! Handle with extreme caution and keep the muzzle pointed in a safe direction!

SIGHT SYSTEM AND ADJUSTMENTS

MAC IX model sighting system consists of two parts, the front and rear. Both parts have protective ears to protect the sight system against external impacts.



There is a height adjustment on the front sight for elevation. This setting allows you to move the target hits up or down. The adjusting wrench is in the box.



There is a peep-hole aperture in the rear sight. You can adjust the windage by turning the adjustment screw next to the Rear Sight.

MAC IX barrel muzzle end has a 1/2x28 threaded and 3-lug quick attachment for muzzle device and suppressor mounting options.



AIMING AND SHOOTING

⚠ WARNINGS

WARNING!

The barrel will be very hot after firing!

WARNING!

Keep your fingers away from the muzzle! Avoid touching the barrel or placing the hot barrel in contact with objects that may be damaged by heat or those that could ignite!

WARNING!

Always unload your pistol immediately after use and prior to cleaning and storage to minimize the risk of an accidental discharge. If your pistol ever fails to fire keep it pointed at the target at least 30 seconds in the event of a hang fire (slow ignition). If the ammunition is still not firing, first remove the magazine, operate (pull & release) the charging lever to remove the live ammunition while being careful not to expose it to recoil.

1. Aim the pistol at the lower-midpoint of the target to get good accuracy result. When firing this firearm, you may need to experiment with different shooting styles until you find the method which best suits your sporting or shooting activity. Remember to always, fire the firearm in such a manner that you can maintain a safe muzzle direction at all times.

2. Disengage the safety lever by moving to the FIRE 'red bullet shape' position.

3. After aiming at your target, place your finger on the trigger.

4. Keep your sights aligned on the target. Slowly pull the trigger to fire the first round.

5. Being a semi-automatic pistol, the pistol's action (its moving parts) will cycle after the first round is fired. As the bolt moves rearward, the extractor will pull the empty cartridge case from the chamber and eject it from the firearm. (Make sure there are no bystanders in close proximity on either side of the firearm who could be injured by the ejected cartridge case or gases expelled from the pistol.)

NOTE: If the trigger is pressed again, the pistol will fire! Keep the pistol pointed in a safe direction. Keep your fingers away from the muzzle when firing the pistol.

6. Firing may be continued in this manner until the magazine is empty.

7. When the last round is fired, the bolt will lock to the rear.

8. When finished firing, place the safety lever in the SAFE 'white bullet shape' position.



HOW TO UNLOAD

⚠ WARNINGS

WARNING!

The pistol will fire if the magazine is removed and the trigger is pulled when a cartridge is in the chamber.

WARNING!

If dropped, any firearm could fire when there is a cartridge in the chamber and the safety lever is in the 'red bullet shape' position.

WARNING!

When you have finished shooting, to unload the pistol, you cannot move the safety lever to the SAFE - white bullet position if the bolt is closed and the hammer is in the forward position. For this, you need to pull the charging handle (at most 1-2 cm or half inch) till the click sound occurred (hammer reset), then release. The hammer will return to its cocked position and you can the selector to SAFE - white bullet position.

1. Move the safety lever to the SAFE 'white bullet shape'.
2. Remove the magazine from the pistol. While holding the pistol grip with one hand, use the thumb of the other hand to press the magazine release lever forward. Now, you can remove the magazine by pulling it down from the magazine well.
3. Pull the charging (cocking) lever to the rear. If there is a live round or empty cartridge in the chamber, make sure that it comes out. When the lever is fully rearward, press the underside of the bolt catch button on the left side of the firearm. This will lock the bolt open. Check the chamber, to make sure it is empty. Once you have determined that the chamber is empty and there is no magazine in the pistol, press the top of the bolt catch button to allow the bolt to travel forward.
4. Your firearm is now in the safe condition. Store your firearm in the safe and unloaded condition separate from the ammunition.



IN CASE OF SHOOTING FAILURE

WARNING!

Keep muzzle pointed in a safe direction.

1. Move the safety lever to the SAFE 'white bullet shape' position. If the hammer is in the fired or forward position, the gun will not go into the safe mode.
2. Remove the magazine from the pistol. While holding the pistol grip with one hand, use the thumb of the other hand to press the magazine release lever forward. Now, you can remove the magazine by pulling it down from the magazine well.
3. Pull the charging (cocking) handle rearward. When the handle is fully rearward, push the downside of bolt catch button located on left side of the pistol. This will lock the bolt open. Move the safety lever to the SAFE 'white bullet shape' position. Inspect the chamber to ensure it is empty, once you determine that the chamber is empty and the gun has no magazine, let the bolt go forward.
4. If there is a bullet (empty or live round) in the chamber, release the bolt with bolt catch button, Move the safety lever to the FIRE 'red bullet shape' position and try to fire again in a safe direction. If it doesn't fire or eject a spent round, repeat steps 2 and 3. If this fails to clear the chamber, proceed to step 5 on the following page.



CLEARING MISFIRE

5. In the event that a cartridge remains in the chamber after pulling the trigger and the extractor fails to remove it (whether or not it has fired), you should remove the magazine, then work the bolt charging/cocking handle several times to try to eject the cartridge. If this does not eject the cartridge, pull the charging/cocking handle rearward. When the handle is fully rearward, push the downside of bolt catch button located on left side of the pistol. This will lock the bolt open. Follow the instructions found on this manual to field stripping your pistol before attempting to remove the cartridge. If after field stripping your pistol, you are still unable to remove the cartridge or cartridge casing, do not reassemble the pistol. Take the pistol to a competent gunsmith to remove the round and ensure proper functioning.



TYPE OF JAM/STOPPAGE	REASON FOR MISFIRE	REPAIR AND OPERATION TO BE DONE
Misfire	<ul style="list-style-type: none"> - Safety - Empty cartridge chamber - Defective ammunition - Broken Hammer - Closed sear or dirty firing pin 	<ul style="list-style-type: none"> - Take a fire position - Load the gun - Reload the gun - Replace - Clean
Cocking Failure	<ul style="list-style-type: none"> - Broken sear - Incorrect trigger cocking mechanism 	<ul style="list-style-type: none"> - Replace - Replace
Failure to Feed	<ul style="list-style-type: none"> - Defective ammunition - Dirty chamber 	<ul style="list-style-type: none"> - Replace - Clean
Cartridge Extraction Problem	<ul style="list-style-type: none"> - Extractor breakage and jamming - Excessively dirty cartridge chamber 	<ul style="list-style-type: none"> - Replace - Clean
Safety Pin Does Not Stay in Position	<ul style="list-style-type: none"> - Safety Lever breakage - Safety Lever jamming 	<ul style="list-style-type: none"> - Replace - Adjust
Front sight and rear sight do not stay in the adjusted position	<ul style="list-style-type: none"> - Sight adjustment lock wear or breakage - Loosening or dislocation of the sight position screw - Rear sight may have been damaged 	<ul style="list-style-type: none"> - Replace - Tighten screw or replace - Replace



FIELD STRIPPING / DISASSEMBLY, ASSEMBLY OF THE FIREARM

To access the inside of the gun, press the retaining pin on the left side next to the safety lever on lower receiver and pull it all the way from the right side

Remove the spring and the mechanism together by pulling the spring back on the rear part of the opened upper receiver.

WARNING!

Please check the firearm and ensure that there is no damage to the internal parts.



Removing the recoil spring from Bolt



Remove the bolt from the upper receiver.



Press forward from the metal plate behind the spring rod and you will see the protruding part in front of the bolt. Rotate approximately 45° counterclockwise and pull back. The spring will come off the bolt.



To reattach the spring: Insert the spring rod into the hole of the bolt, with the rounded corner of the metal plate behind the spring rod facing up. When the end of the metal rod protrudes from the other side, turn the rod clockwise. The protrusion on the rod end will fit into its bearing in the bolt.



You can place the assembled bolt inside the upper receiver with the spring side up.



FIELD STRIPPING / DISASSEMBLY, ASSEMBLY OF THE FIREARM

Attaching the lower and upper receivers

WARNING!

Be careful not to pinch your finger during this process.

WARNING!

Keep muzzle pointed in a safe direction.

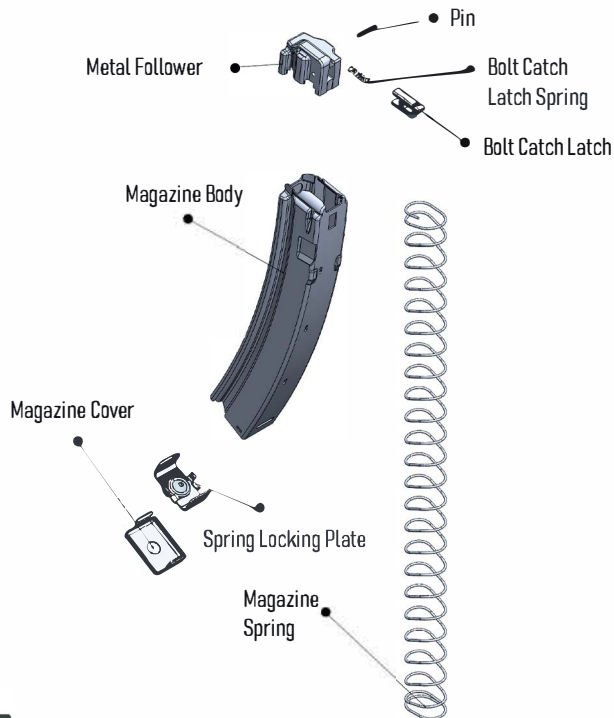
Push the hammer back with your hand to cock it and be sure that locked. Ensure that, the upper-lower receivers pivot pins, completely pulled. The lower receiver is ready to assemble.



As shown in the figure, first press the recoil spring plate on the upper receiver and at the same time push the lower receiver upwards to close the upper receiver. Then lock the upper receiver by placing the fixing pin in its position before it was opened.

Magazine Assembly

The metal magazine assembly of 10, 20, or 30 rounds contains the following parts.



USER LEVEL MAINTENANCE AND CLEANING

WARNINGS

WARNING! Before beginning the cleaning process, check to ensure the firearm is unloaded. (See the Unloading section.)

WARNING! There may be sharp edges on parts of the firearm. Keep your fingers protected by wearing a pair of protective gloves when cleaning.

WARNING! You should wear eye protection, such as shooting glasses or goggles, when cleaning this firearm to protect your eyes from the tensioned parts, such as springs, that could become dislodged during the cleaning procedures.

WARNING! Excessive use of cleaning solvents or lubricants can adversely affect your firearm's functioning. Wipe the inside of the barrel dry before firing and ensure that it is free of obstructions.

WARNING! Some cleaning solvents produce hazardous vapors. Read and follow the solvent manufacturer's cautions found on the product's package.

WARNING! Handling ammunition and cleaning firearms results in exposure to lead and other substances that can pose healthy risks. Wash your hands and face after firing your firearm or after cleaning it.

WARNING! This firearm should be checked periodically for worn or damaged parts by a competent gunsmith. This will help ensure its safe functioning and a long service life.

WARNING! Do not spray or apply lubricants directly on ammunition. If the powder charge of a ammunition is affected by the lubricant, it may not be ignited, but the energy from the primer may be sufficient to push the bullet into the bore where it may become lodged. Firing a subsequent bullet into the obstructed bore will damage the firearm and may cause injury to the shooter and those nearby. Use lubricants properly. You are responsible for the proper care and maintenance of your firearm and ammunition.

Cleaning Intervals

Always clean your firearm as soon as possible after firing to prevent buildup of shooting residue and to prevent corrosion from starting. To maintain your firearm in good working order, it should be cleaned regularly even if it has not been fired. If you live in a low-humidity area, this may mean doing a full clean once or twice a year; but if you live in a high-humidity area, it may be necessary to clean your firearm as often once a week.

NOTE: In freezing weather (below 32°F. or 0°C.) the use of a dry lubricant (instead of oil) for lubrication may work better.



USER LEVEL MAINTENANCE AND CLEANING

1. Obtain a quality cleaning kit and thoroughly review the manufacturer's instructions.
2. Follow the field stripping procedures.
3. To clean the barrel, select the correct caliber cleaning brush and attach it to a cleaning rod.
4. Dampen the brush with gun cleaning solvent and then push the brush through the barrel several times.
5. Remove the brush and attach a correctly sized cloth cleaning patch to the cleaning rod and push it through the barrel several times to remove loosened fouling.
6. Repeat this process with the brush and cleaning patches until a final patch comes out clean after swabbing the bore. Lightly oil the bore.
7. Remove shooting residue from the firearm action parts and outer surfaces by wiping them with a soft cloth dabbed in gun cleaning solvent. Then ensure to remove all excess solvent and dry them.
8. Finally, wipe down all outer surfaces with a soft cloth dipped in a good quality gun oil.

WARNING!

When cleaning the inside of the barrel with a bore brush and cloth, never pull the rod from the end of the barrel towards the chamber..

WARNING!

Never use force when disassembling, cleaning and assembling the Firearm. !



STORAGE

a. **Preparation for Storage:** Before your firearm is stored, it should be thoroughly cleaned and lightly oiled. A thin layer of high-quality firearm oil should be applied to all exposed surfaces. In humid conditions, ensure that cleaning cloths used are dry. After the metal parts are dried, they should not be touched with bare hands. For normal storage periods, metal parts should be lightly lubricated with protective oil, and for longer periods, they should be lubricated with grease. The firearm should never be wrapped with cloth or similar material, and no plug should be placed in the barrel, as these can absorb moisture and cause the firearm to rust.

b. **Cleaning After Long-Term Storage:** A firearm taken out of storage after an extended period should be thoroughly cleaned and oiled with normal protective oil. If it is to be fired instantly, ensure that the oil used for storage (protective or grease) is completely removed, the inside of the barrel is dry, and there is no obstruction before firing.

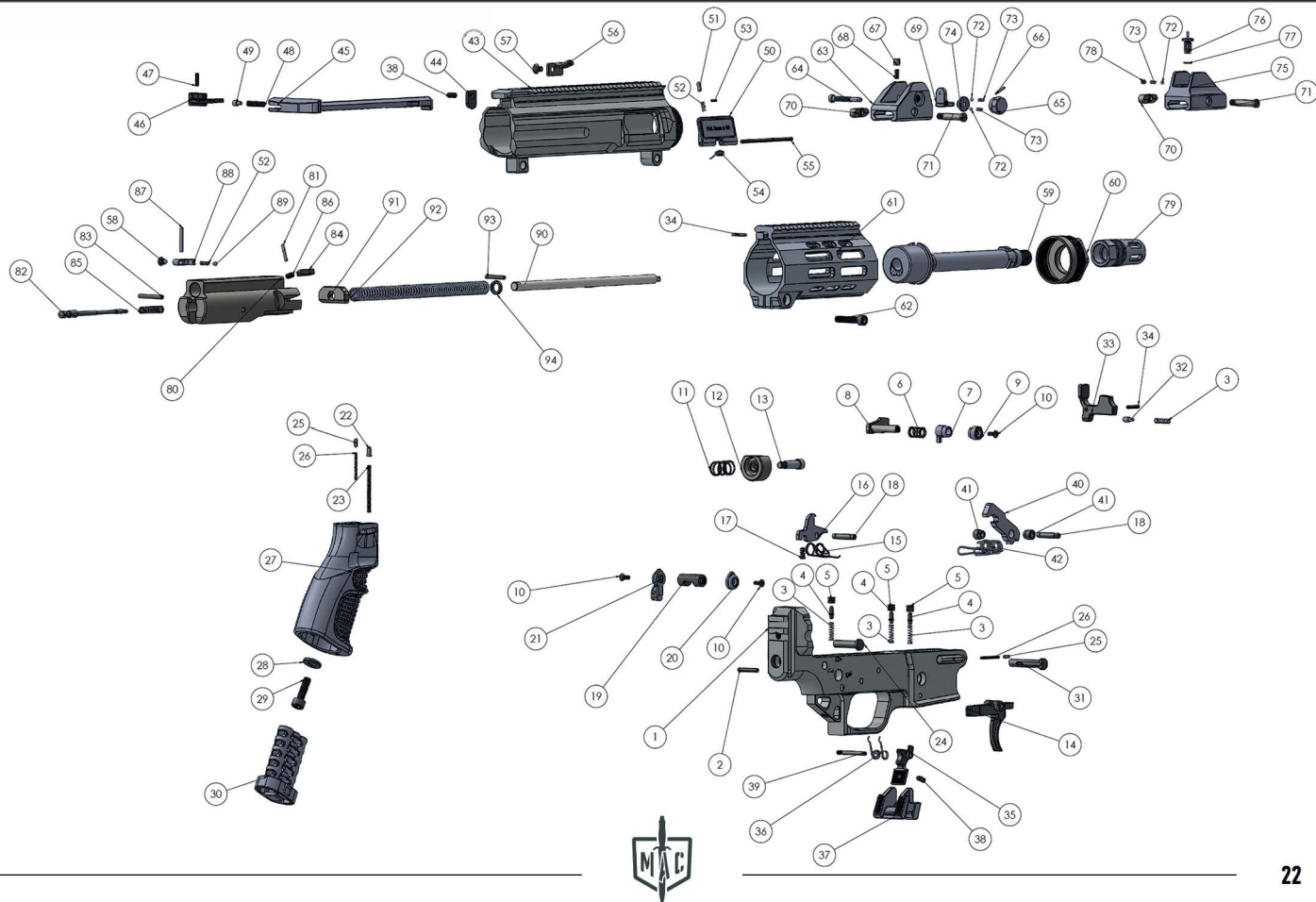
BEFORE STORING, CHECK IF YOUR FIREARM IS LOADED. STORE FIREARMS AND AMMUNITION SEPARATELY AND IN A SECURE PLACE INACCESSIBLE TO UNAUTHORIZED INDIVIDUALS. ALWAYS LOCK YOUR FIREARMS SAFELY WHEN NOT IN USE. FOLLOW YOUR COUNTRY'S FIREARMS REGULATIONS OF THE SAFE STORAGE OF FIREARMS AND AMMUNITION.

WARNING!

Modifying or changing internal parts and/or safeties is dangerous and voids the warranty. This firearm is designed to function properly with original parts. It is your responsibility to ensure that all purchased parts are intended for this firearm, installed correctly, and both spare and original parts are not replaced or modified. Your firearm is a complex and delicate tool with many parts that need to be correctly associated with other parts for proper and safe operation. Assembling a firearm with incorrect or modified parts can lead to damage, danger, and malfunction, resulting in injury or death to yourself and others. Always consult a qualified gunsmith for any work on your firearm.



EXPLODED DIAGRAM



PARTS LIST

NO	PART	NO	PART	NO	PART
1	Lower Receiver	17	Disconnecter Spring	33	Bolt Stopper
2	Split Pin	18	Trigger-Hammer Pin	34	Split Pin
3	Bolt Catch Spring	19	Safety Receiver	35	Magazine Release Lever
4	Inter Receiver Space Reducer Pin	20	Safety Lever(short)	36	Magazine Release Lever Spring
5	Inter Receiver Space Reducer Pin Plug	21	Safety Lever(long)	37	Magazine Extractor
6	Magazine Release Lever Spring	22	Safety Pin	38	Magazine Extractor Screw
7	Magazine Catch Contact Piece	23	Safety Spring	39	Magazine Release Pin
8	Magazine Catch	24	Pivot Pin	40	Hammer
9	Magazine Catch Push Button	25	Pivot Pin Plunger	41	Hammer Bushing
10	Push Button Screw	26	Pivot Pin Spring	42	Hammer Spring
11	Buffer Spring	27	Pistol Grip	43	Upper Receiver
12	Buffer	28	Washer	44	Charging Handle Lock Plate
13	Buffer Screw	29	Screw	45	Charging Handle
14	Trigger	30	Pistol Grip Plug	46	Charging Handle Lock
15	Trigger Spring	31	Pivot Pin	47	Split Pin
16	Disconnecter	32	Bolt Catch Spring Pin	48	Charging Handle Lock Spring



PARTS LIST

NO	PART
49	Charging Handle Lock Spring Pin
50	Dust Cover
51	Dust Cover Locker
52	Dust Cover Locker Spring
53	Split Pin
54	Dust Cover Spring
55	Dust Cover Pin
56	Ejector
57	Ejector Screw
58	Firing Pin Safety Opener Screw
59	Barrel
60	Barrel Clamping Nut
61	a- Forearm for Barrel Length 6.5" - 8" b- Forearm for Barrel Length 10" c- Forearm for Barrel Length 12"
62	Forearm Retaining Screw

NO	PART
63	Rear Sight Body
64	Rear Sight Windage Screw
65	Rear Sight Windage Nut
66	Rear Sight Windage Nut Pin
67	Rear Sight Fixing Pin
68	Rear Sight Fixing Pin Spring
69	Rear Sight
70	Picatinny Nut
71	Sight Body Retaining Screw
72	Steel Ball
73	Rear Sight Steel Ball Spring
74	Rear Sight Snap Plug
75	Front Sight Body
76	Front Sight
77	Front Sight Snap Ring
78	Front Sight Spring Screw

NO	PART
79	Flash Hider
80	Bolt Body
81	Extractor Pin
82	Firing Pin
83	Firing Pin Stabilizer Pin
84	Extractor
85	Firing Pin Spring
86	Extractor Spring
87	Firing Pin Safety Lock Retaining Pin
88	Firing Pin Safety Lock
89	Firing Pin Safety Lock Spring Plug
90	Recoil Spring Carrier Rod
91	Recoil Spring Carrier Rod Plug
92	Recoil Spring
93	Steel Pin
94	Guide Ring





WARRANTY

At MILITARY ARMAMENT CORP, we believe in the quality of our firearms, and we want you to as well.

Age & wear cannot be covered under warranty, as the mechanical parts and materials that make up firearms eventually wear out. However, defective parts, materials, and workmanship are not acceptable, and we will stand behind our products. We warrant our firearms to be free from defects in performance and workmanship for five years from the date of purchase. If you have a problem that is directly attributable to the quality of our product, it's on us to make it right, shipping and handling included.

However, if you abuse improperly maintain, or alter the internal workings of your MILITARY ARMAMENT CORP firearm in any way, we will not warrant damage that occurs. Likewise, if you use improper or incompatible ammunition or parts, we will not warrant damage that occurs. That includes altering a serial number.

If you have a problem with your firearm, please contact **MAC** directly at (865) 604-6894 or info@milarmamentcorp.com

RETURN WITHOUT REPAIR

If we receive your firearm and determine that its damage is unwarrantable, we will contact you with an explanation and an estimation of your cost to have us repair or refurbish it. If you would rather we simply return your firearm to you, we will cover the cost of shipping to do so.

FREE REPAIR AND RETURN

If your firearm is defective and we determine the defect is warrantied, Military Armament Corp will try to repair it. If we repair your firearm, after doing so we will ship it directly back to you, provided you originally shipped it to us from your address. If your firearm cannot be repaired, we will consider replacing it.

LIMITATIONS ON WARRANTY

Our only responsibility in the case of breach of warranty is repair. MILITARY ARMAMENT CORP shall not be liable for any other damages, including direct, indirect, or consequential damages.

PLEASE NOTE: This warranty gives you specific legal rights, and you may also have other rights, which vary from state to state, as some jurisdictions do not allow limitations on certain damages and warranties.

MILITARY ARMAMENT CORP stands behind the quality of our firearms. while age and wear cannot be covered under warranty, we believe defective parts, materials, and workmanship to be an unacceptable situation. we warrant our firearms to be free from defects in performance and workmanship for one year from the original retail purchase date. if have a problem that is directly attributable to the quality of our product, we will make it right to include shipping and handling. The **MAC** warranty does not cover any issues related to abuse, improper maintenance, the use of incompatible aftermarket parts or any alteration of the internal components. Likewise, damage caused by the use of improper or incompatible ammunition such as reloaded or other non-SAAMI spec ammunition will also void your warranty. Additionally, sales outside of the United States, unauthorized repair, and modifications to the firearm to include altering a serial number, shall not be covered under warranty.

MILITARY ARMAMENT CORP LIFETIME SERVICE PLAN

Military Armament Corp is committed to supporting our customers with services that are above and beyond what is expected. Beyond our 1-year warranty, our **Lifetime Service Plan** will repair any defect in material or workmanship for the lifetime of the firearm. The Military Armament Corp Lifetime Service Plan will begin after the 1-year warranty has expired. **The Lifetime Service Plan** covers material defects; and does not include wear items such as cosmetics, grips, magazines, recoil springs or sights. This **Lifetime Service Plan** is offered in addition to the 1-year warranty and is not an extension of the warranty.

IMPORTANT WARRANTY INFORMATION

Military Armament Corp Shotguns are warranted to function with factory produced, SAAMI spec ammunition and the original factory magazine. The use of hand-loads will void your warranty and the Lifetime Service Plan.

If you experience a warranty issue, before sending your firearm please contact us at info@milarmamentcorp.com or via phone (865) 604-6894 for a Return Merchandise Authorization number. No firearms will be accepted without pre-approval and completion of this Return Merchandise Authorization.

To review the full warranty and Limited Lifetime Service Plan, please visit www.milaramamentcorp.com

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MILITARY ARMAMENT CORPORATION

Phone: (865) 604-6894

114 Sherlake Lane
Suite 18
Knoxville, TN 37922

www.milarmamentcorp.com



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