

MAC 1014

SEMI AUTOMATIC SHOTGUN OWNERS MANUAL



MILITARY
ARMAMENT
CORP



MAC 1014 RECOMMENDATIONS

- Your MAC 1014shotgun uses 2 3/4" and 3" shells only.
- We suggest to use 1350 FPS minimum velocity and quality brand ammunition.
- Minimum 1 1/8 oz shells is suggested.
- 100 rounds of 1350+ FPS ammo for a break in period. Your shotgun will cycle lighter
- loads well after completing the proper break in period



BASIC SAFETY RULES

1. NEVER POINT A FIREARM AT SOMETHING THAT IS NOT SAFE TO SHOOT.

Never let the muzzle of a firearm point at any part of your body or at another person. This is especially important when loading or unloading the firearm. When you are shooting at a target, know what is behind it. Some bullets can travel over a mile. If you miss your target or if the bullet penetrates the target, it is your responsibility to ensure that the shot does not cause unintended injury or damage.

2. ALWAYS TREAT A FIREARM AS IF IT WERE LOADED.

Never assume that a firearm is unloaded. The only certain way to ensure that a firearm has the chamber empty is to open the chamber and visually and physically examine the inside to see if a round is present. Unloading the magazine only will not guarantee that a firearm is unloaded or can not fire. Shotguns and rifles can be checked by removing all rounds and by then opening and inspecting the chamber for visual inspection of the chamber for any remaining rounds.

3. STORE YOUR FIREARM SO THAT CHILDREN CAN NOT GAIN ACCESS TO IT.

It is your responsibility to ensure that children under the age of 18 or other unauthorized persons do not gain access to your firearm. To reduce the risk of accidents involving children, unload your firearm, lock it and store the ammunition in a separate locked location. Please note that devices intended to prevent accidents - for example, cable locks, chamber plugs, etc. - may not prevent use or misuse of your firearm storage in a steel gun safe may be more appropriate to reduce the likelihood of intentional misuse of a firearm by an unauthorized child or person.

4. NEVER SHOOT AT WATER OR AT A HARD SURFACE.

Shooting at the surface of water or at a rock or other hard surface increases the chance of ricochets or fragmentation of the bullet or shot, which can result in the projectile striking an unintended or peripheral target.



5. KNOW THE SAFETY FEATURES OF THE FIREARM YOU ARE USING, BUT REMEMBER: SAFETY DEVICES ARE NOT A SUBSTITUTE FOR SAFE HANDLING PROCEDURES.

Never rely solely on a safety device to prevent an accident. It is imperative that you know and use the safety features of the particular firearm you are handling, but accidents can best be prevented by following the safe handling procedures described in these safety rules and elsewhere in the product manual. To further familiarize yourself with the proper use of this or other firearms, take a Firearms Safety Course taught by an expert in firearms use and safety procedures.

6. PROPERLY MAINTAIN YOUR FIREARM.

Store and carry your firearm so that dirt or lint does not accumulate in the working parts. Clean and oil your firearm, following the instructions provided in this manual, after each use to prevent corrosion, damage to the barrel or accumulation of impurities which can prevent use of the gun in an emergency. Before loading your firearm, always check the barrel internal part and the chamber to ensure that they are clean and free from obstructions. Firing with an obstruction in the barrel or chamber can rupture the barrel and injure you or others nearby. In the event you hear an unusual noise when shooting, stop firing immediately, engage the manual safety and unload the firearm. Make sure the chamber and barrel are free from any obstruction, like a bullet blocked inside the barrel due to defective or improper ammunition.

7. USE PROPER AMMUNITION.

Only use factory loaded, new ammunition manufactured to industry specifications: CIP (Europe and elsewhere), SAAMI® (U.S.A.). Be certain that each round you use is in the proper caliber or gauge and type for the particular firearm. The caliber or gauge of the firearm is clearly marked on the barrels of shotguns and on the slide or barrel of pistols. The use of reloaded or remanufactured ammunition can increase the likelihood of excessive cartridge pressures, case head ruptures or other defects in the ammunition that can cause damage to your firearm and injury to yourself or others nearby.



8. ALWAYS WEAR PROTECTIVE GLASSES AND EARPLUGS WHEN SHOOTING.

The chance that gas, gunpowder or metal fragments will blow back and injure a shooter who is firing a gun is rare, but the injury that can be sustained in such circumstances can be severe, including the possible loss of eye sight. A shooter must always wear impact resistant shooting glasses when firing any firearm. Earplugs or other high quality hearing protectors help reduce the chance of hearing damage from shooting.

9. NEVER CLIMB A TREE, FENCE OR OBSTRUCTION WITH A LOADED FIREARM.

Open and empty the chamber of your firearm and engage the manual safety catch before climbing or descending a tree or before climbing a fence or jumping over a ditch or other obstruction. Never pull or push a loaded firearm toward yourself or another person. Always unload the firearm, visually and physically check to see that the magazine, loading mechanism and chamber are unloaded and that the bolt is open before handing the firearm to another person. Never take a firearm from another person unless it is unloaded, visually and physically checked to confirm it is unloaded, and the action is open.

10. AVOID ALCOHOLIC BEVERAGES OR JUDGEMENT/REFLEX IMPAIRING MEDICATION WHEN SHOOTING. Do not drink alcohol and shoot. If you take medication that can impair motor reactions or judgment, do not handle a firearm while you are under the influence of the medication.

11. NEVER TRANSPORT A LOADED FIREARM.

Always unload your firearm before transporting.



WE SPECIFICALLY DISCLAIM ANY RESPONSIBILITY FOR DAMAGE OR INJURY OCCURRING IN CONNECTION WITH. OR AS A RESULT OF THE USE OF FAULTY. OR "REMANUFACTURED," OR HAND-LOADED(RELOADED) AMMUNITION. ADDITIONALLY, WE DISCLAIM ANY RESPONSIBILITY FOR DAMAGE OR INJURY WHICH RESULTS FROM ANY MODIFICATIONS OR CHANGES THAT ARE NOT A PART OF THE FIREARM AS DELIVERED FROM THE FACTORY.

CONGRATULATIONS!!!

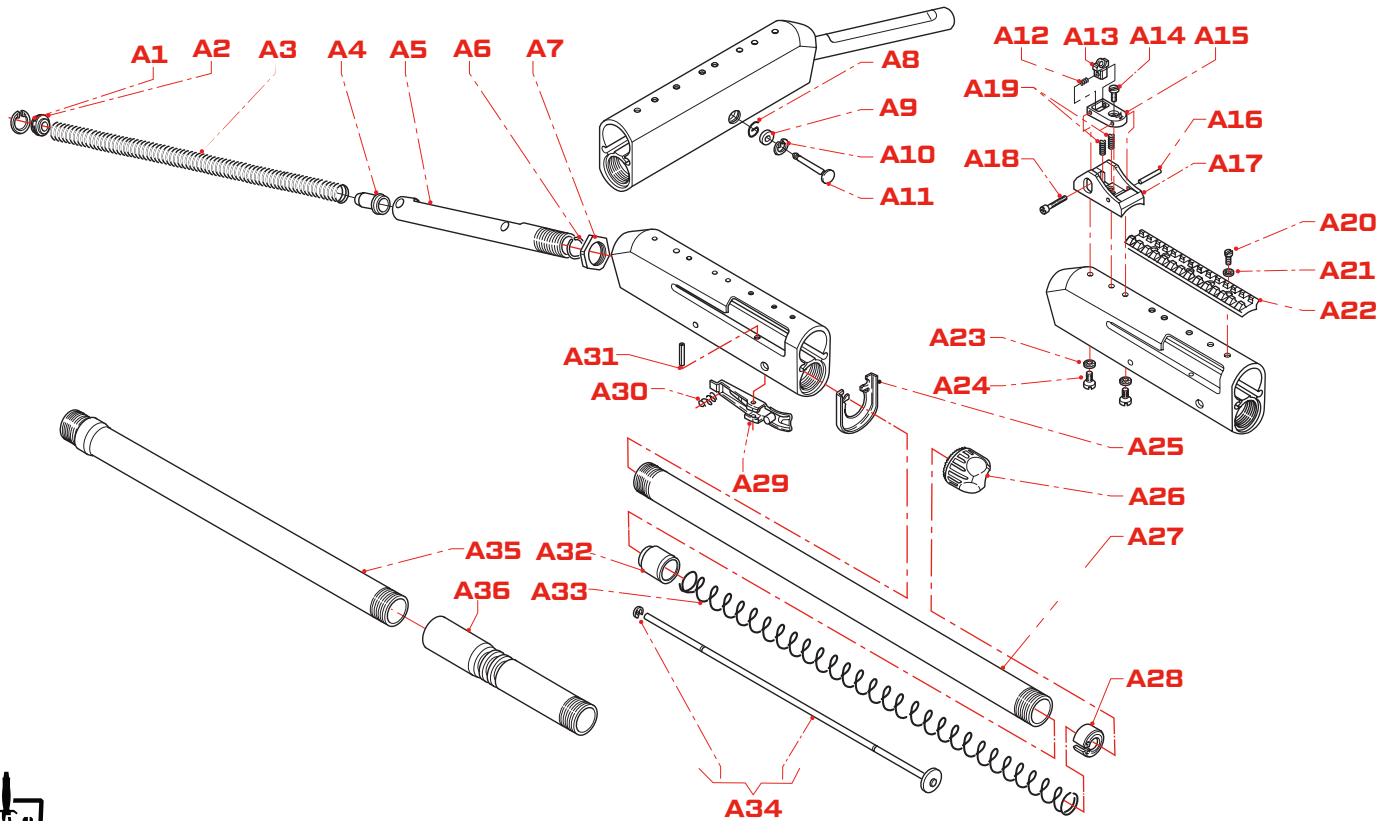
Learn to clean your firearm thoroughly and make certain no oil, grease, or other materials are blocking the barrel. Obstructions of any kind can cause damage to the firearm, and may result in serious personal injury to the shooter and/or others nearby. Practice proper firearm maintenance and safety. Make sure all exposed metal surfaces are coated with a thin film of oil, especially after exposure to damp weather. (See proper section of this manual for cleaning instructions. Do not plug barrel or store in a fabric-lined case which will absorb lubricants from the firearm. Before using after storage, follow complete instructions stated in this manual to refamiliarize with the firearm. A thorough inspection should be performed before going into the field. Have your firearm periodically checked by a qualified gunsmith. You are now the owner of the MAC 2 12 gauge shotgun. Your shotgun has an innovative design and is manufactured from high quality materials. With regularly performed maintenance and the use of proper ammunition it will provide you with many years of service. In order to achieve the best performance and reliability from your shotgun, please read and fully understand all of the instructions, safety guidelines, and warnings carefully in this manual. Your shotgun is reliable and safe unless it is handled in a careless or irresponsible manner.

REMEMBER: it is imperative that the firearm handler be fully educated and conscious of the importance of executing proper gun safety rules when operating any firearm.

Before using or firing with any live ammunition you should know and fully understand your shotgun's parts, function, and operating mechanisms. So carefully read and fully understand all of the information about the parts and procedures of using the shotgun safely and effectively.



DIAGRAM OF MAC 1014 RECEIVER ASSEMBLY

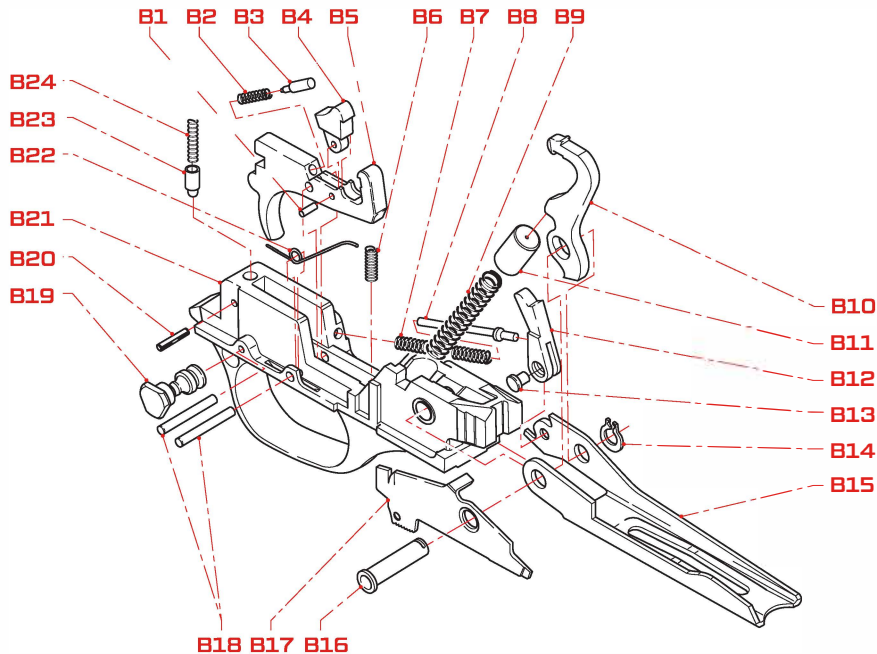


A1 STOCK RETAINING PIN
A2 STOCK RETAINING SCREW
A3 RECOIL SPRING
A4 RECOIL SPRING PLUNGER
A5 RECOIL SPRING TUBE
A6 FLEXIBLE RING
A7 TUBE RETAINER NUT
A8 F.G.P RETAINING SPRING
A9 F.G.P RETAINING SPACER
A10 F.G.P RETAINING RING
A11 FCG RETAINING PIN
A12 WINDAGE ADJUSTMENT SPRING
A13 REAR SIGHT APERTURE
A14 ELEVATION ADJUSTMENT
A15 SCREW ELEVATION PLATFORM
A16 REAR SIGHT PIN
A17 REAR SIGHT BASE
A18 WINDAGE ADJUSTMENT SCREW

A19 ELEVATION SPRINGS
A20 RAIL MOUNT SCREW
A21 RAIL WASHER
A22 PICATINNY RAIL
A23 REAR SIGHT WASHER
A24 REAR SIGHT MOUNT SCREW
A25 HAND GUARD RETAINING BAND
A26 MAGAZINE NUT
A27 MAGAZINE TUBE
A28 MAGAZINE SPRING RETAINER
A29 SHELL CATCH
A30 SHELL CATCH SPRING
A31 SHELL CATCH PIN
A32 MAGAZINE FOLLOWER
A33 MAGAZINE SPRING
A34 SHELL LIMITER
A35 MAGAZINE TUBE
A36 MAGAZINE FAUX EXTENSION



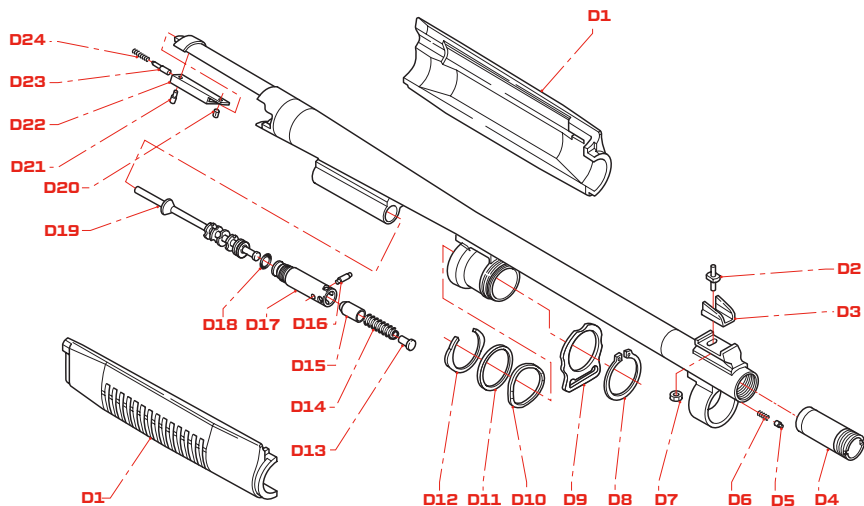
DIAGRAM OF MAC 1014 **FIRE CONTROL GROUP**



- B1 DISCONNECTOR PIN
- B2 DISCONNECTOR SPRING
- B3 DISCONNECTOR PLUNGER
- B4 DISCONNECTOR
- B5 TRIGGER
- B6 TRIGGER SPRING
- B7 LIFTER ACTUATOR SPRING
- B8 LIFTER ACTUATOR SPRING PLUNGER
- B9 HAMMER SPRING
- B10 HAMMER
- B11 HAMMER SPRING CAP
- B12 LIFTER ACTUATOR LEVER
- B13 LIFTER ACTUATOR LEVER PIN
- B14 LIFTER PIN SNAP RING
- B15 LIFTER
- B16 LIFTER PIN
- B17 MAGAZINE RELEASE LEVER
- B18 TRIGGER PIN
- B19 SAFETY BUTTON
- B20 SAFETY SPRING RETAINER PIN
- B21 TRIGGER GUARD
- B22 MAGAZINE RELEASE LEVER SPRING
- B23 SAFETY PLUNGER
- B24 SAFETY PLUNGER SPRING



DIAGRAM OF MAC 1014 BARREL ASSEMBLY



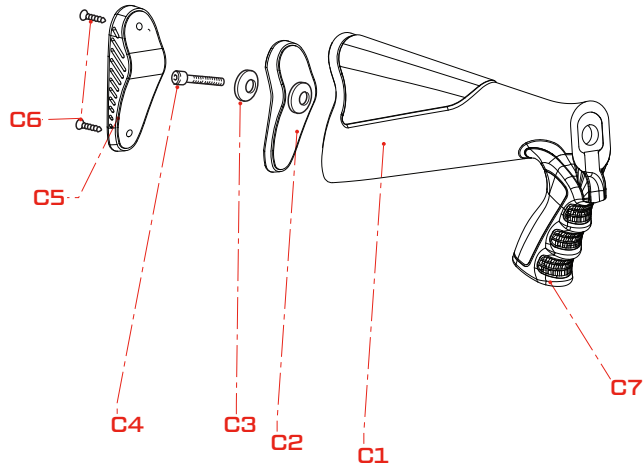
- | | | | |
|-----|----------------------------|-----|-----------------------------|
| D1 | HAND GUARD | D13 | GAS PLUG SPACER |
| D2 | FRONT SIGHT POST | D14 | GAS PLUG SPRING |
| D3 | FRONT SIGHT GUARD | D15 | GAS PLUG CAP |
| D4 | CHOKE TUBE | D16 | GAS PLUG PIN |
| D5 | MAGAZINE NUT DETENT | D17 | GAS PLUG |
| D6 | MAGAZINE NUT DETENT SPRING | D18 | GAS PLUG O RING |
| D7 | FRONT SIGHT RETAINING NUT | D19 | GAS PISTON |
| D8 | SLING PLATE SNAP RING | D20 | EJECTOR RETAINING RIVET |
| D9 | SLING ATTACHMENT PLATE | D21 | EJECTOR SPRING RETAINER PIN |
| D10 | SPRING WASHER | D22 | EJECTOR HOUSING |
| D11 | WASHER | D23 | EJECTOR |
| D12 | RETAINING RING | D24 | EJECTOR SPRING |



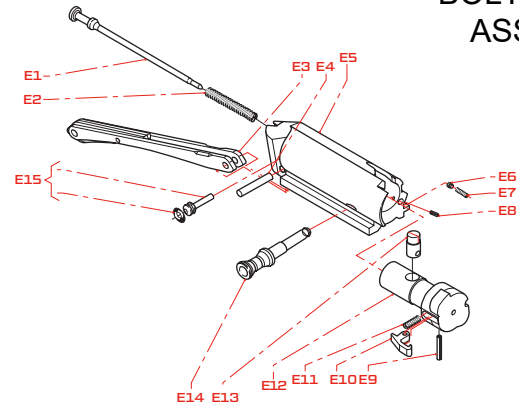
DIAGRAM OF MAC 1014

BOLT CARRIER ASSEMBLY

STOCK ASSEMBLY



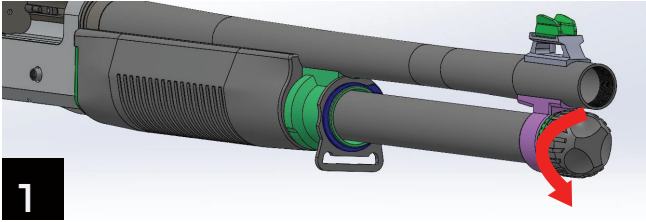
- C1 STOCK
- C2 STOCK RETAINING PLATE
- C3 STOCK RETAINING PLATE WASHER
- C4 STOCK RETAINING SCREW
- C5 STOCK RETAINING PLATE
- C6 RECOIL PAD SCREW
- C7 RUBBERIZED PISTOL GRIP



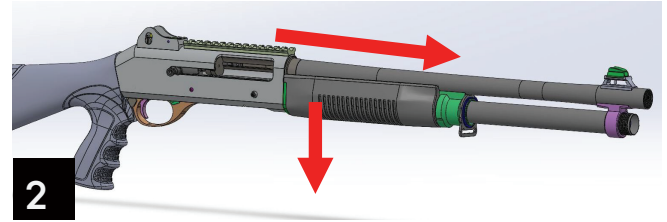
- E1 FIRING PIN
- E2 FIRING PIN SPRING
- E3 BOLT LINK
- E4 BOLT LINK PIN
- E5 BOLT
- E6 CHARGING HANDLE DETENT
- E7 CHARGING HANDLE DETENT SPRING
- E8 CHARGING HANDLE SPRING RETAINING PIN
- E9 EXTRACTOR PIN
- E10 EXTRACTOR
- E11 EXTRACTOR SPRING
- E12 BOLT HEAD
- E13 CAM PIN
- E14 CHARGING HANDLE
- E15 FIRING PIN RETAINING



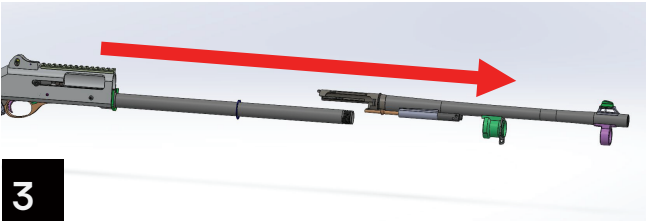
DISASSEMBLY



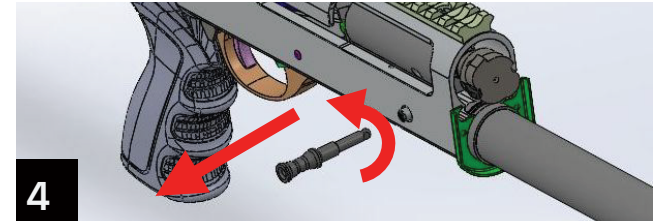
1- Unscrew the magazine cap nut. (fig. 1)



2- Pull the barrel slightly out of the receiver then separate and remove the handguard. (fig. 2)

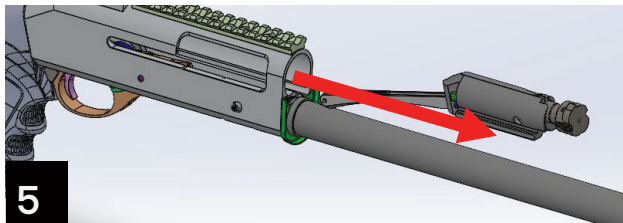


3- Remove the barrel from the receiver. (fig. 3)

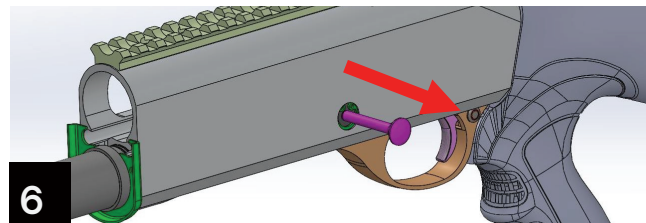


4- Remove the charging handle by twisting and pulling out on the charging handle. (fig. 4)

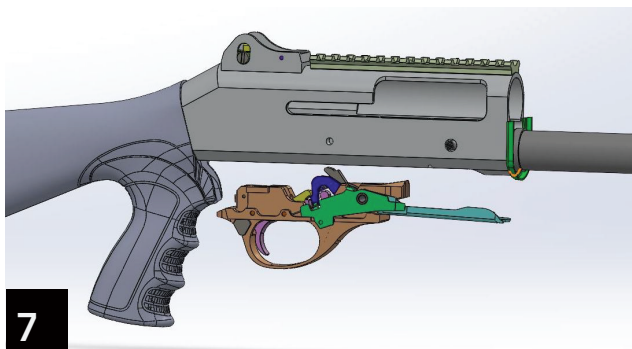




5- Remove the bolt carrier assembly from the receiver. (fig. 5)



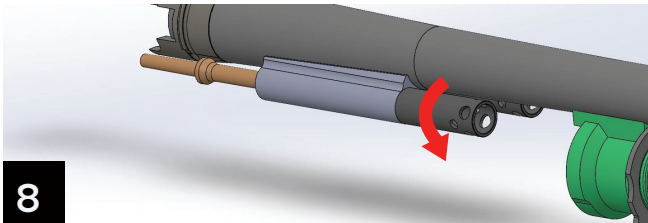
6- To remove the fire control group, start by punching out the fire control group retention pin. (fig. 6)



7- Push and hold down the bolt release button, then pull the fire control group out of the bottom of the receiver. (fig. 7)

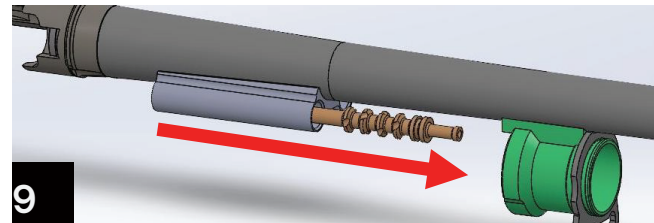
Your shotgun is now ready for easy cleaning and maintenance . Your gun normally cleans its gas system automatically and we do not suggest to disassemble gas system of your gun!!! If you need to clean your gas system you can follow the steps below.





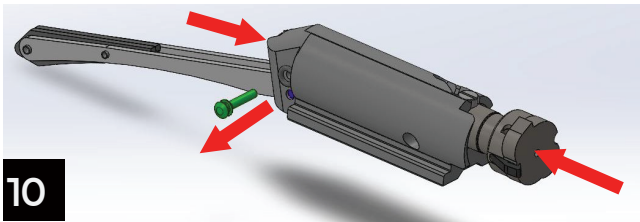
8

8- To remove the gas cylinder plugs, take a punch and turn them counterclockwise until you can finish removing them by hand. (fig. 8)



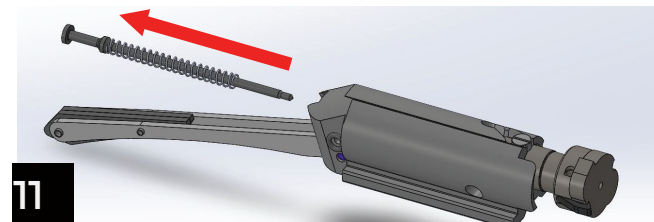
9

9- Using your hand, hand push the gas piston out the front side of the housing. (fig. 9)



10

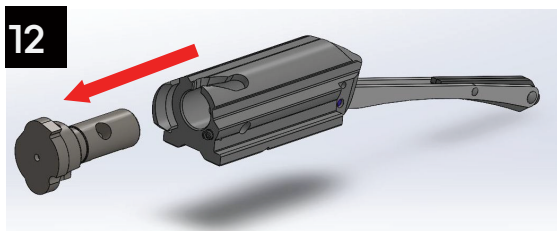
10- To disassemble the bolt, locate the head of the firing pin at the rear of the bolt carrier and cover it with your finger. Then with another finger push in the locking head of the bolt. While holding both simultaneously, remove the firing pin retaining pin. (fig. 10)



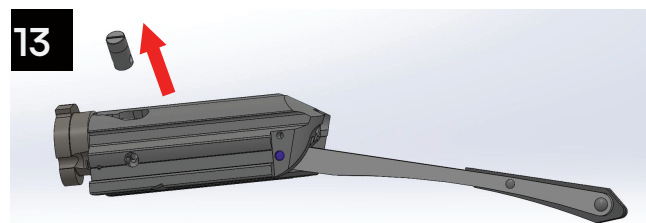
11

11- Slowly ease your finger back off of the firing pin. The firing pin is under spring tension so gently back off of it until the tension is gone. Then remove the firing pin and firing pin spring out of the back of the bolt. (fig. 11)





12- Turn the bolt over and dump out the cam pin. Have the pin in the rear of the channel when dumping out so it can be removed. (fig. 12)

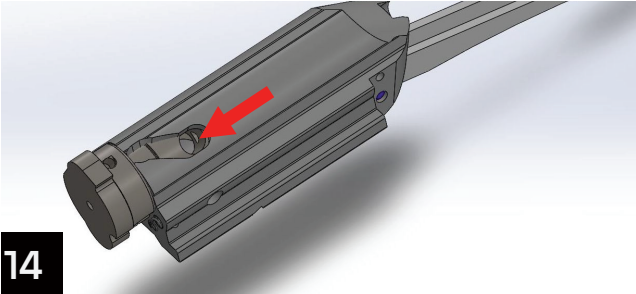


13- Remove the locking head by pulling it out of the bolt. (fig. 13)

Your shotgun is now completely disassembled for cleaning and maintenance.

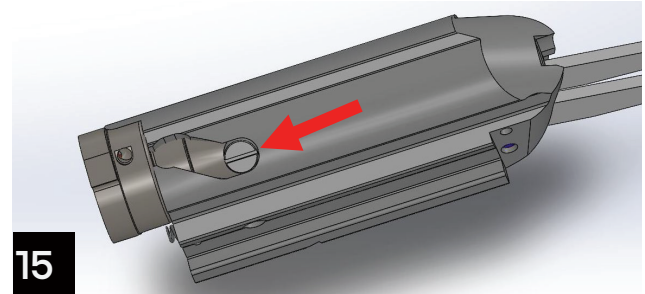


ASSEMBLY



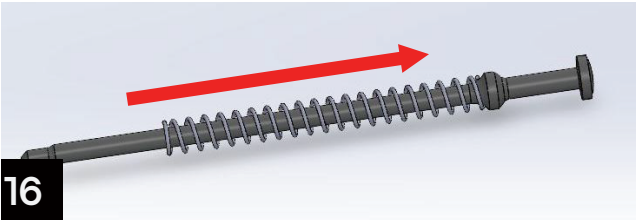
14

14- To assemble the bolt, insert the locking head into the bolt making sure to line up the hole in the locking head with the end of the channel in the bolt. (fig. 14)



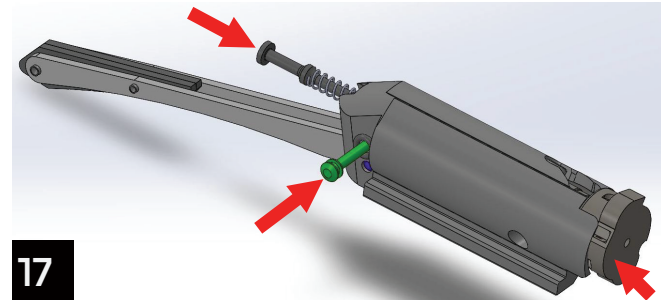
15

15- Insert the cam pin so that the line in the head of the pin is parallel with the bolt to allow a clear path for the firing pin. (fig. 15)



16

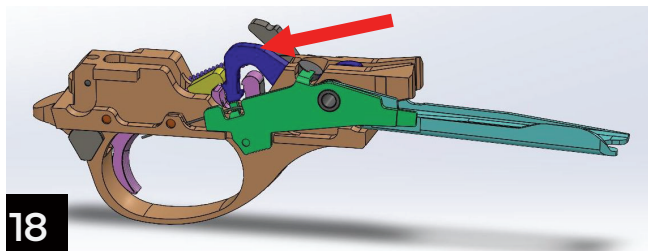
16- Take the firing pin spring and place it over the firing pin. (fig. 16)



17

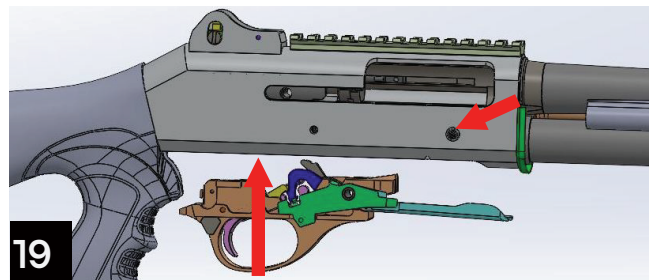
17- While holding the locking head into the bolt insert the firing pin and hold it flush with the back of the bolt. While holding the firing pin and locking head simultaneously, insert the firing pin retaining pin. (fig. 17)





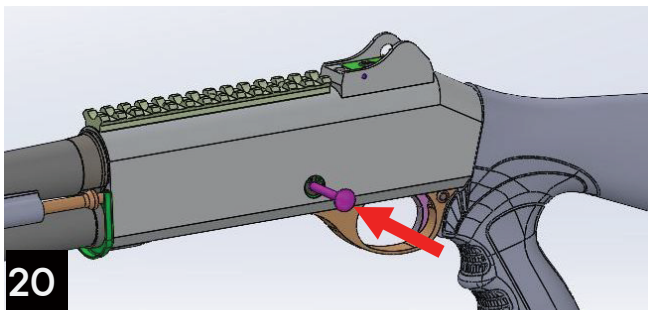
18

18- Take the fire control group and make sure the hammer is cocked with the safety on. (fig. 18)



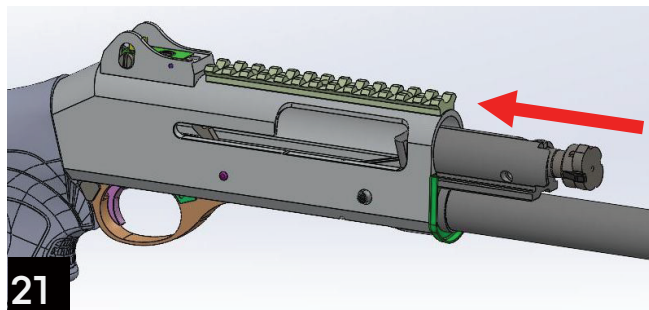
19

19- While holding the bolt release button, insert the fire control group into the shotgun and ensure the hole in the fire control group is lined up with the hole in the receiver. (fig. 19)



20

20- Insert the fire control group retaining pin.(fig. 20)

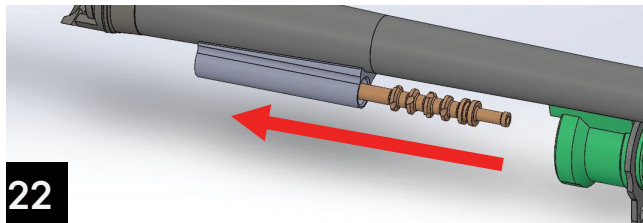


21

21- Insert the bolt by sliding it along the rails of the receiver (fig. 21)

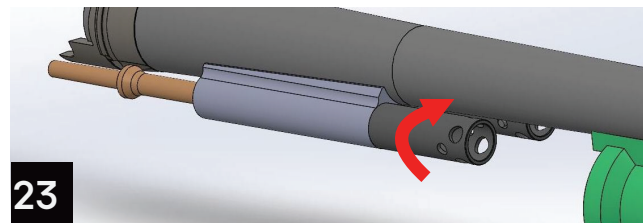


If you disassembled gas system of your gun you can reassemble the system by following the Figure 8 and Figure 9



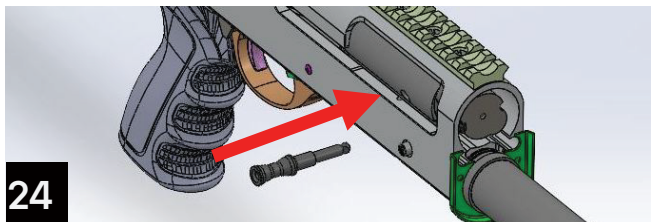
22

22-Insert the gas piston into the housing. (fig. 22)



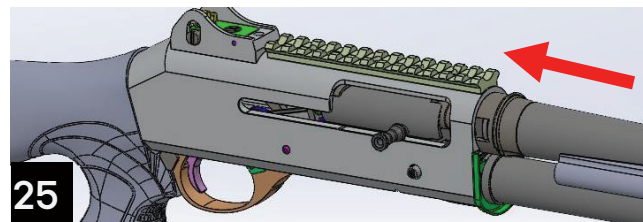
23

23- Take the gas cylinder plugs and screw them in clockwise by hand. Then take a punch and tighten to a snug fit. (fig. 23)



24

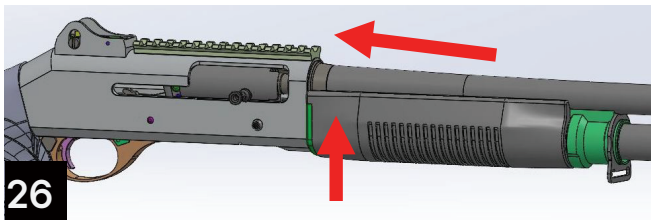
24-Insert the charging handle into the bolt. (fig. 24)



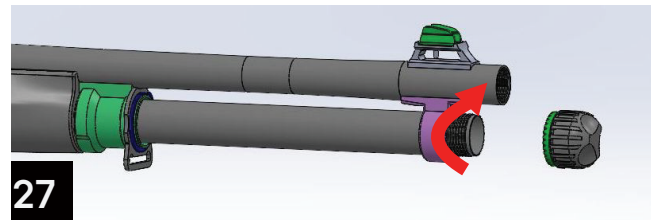
25

25-Insert the barrel into the receiver and put the maga-zine tube through the barrel ring. Push the barrel into the receiver but stop short of inserting it all the way and leave a small gap between it and the receiver. (fig. 25)





26- Take the two handguard pieces and insert them into the retaining bands. Then push the barrel and hand guard flush with the receiver. (fig. 26)



27- Hand screw down and tighten the magazine nut until it is snug. (fig. 27)

Your shotgun is now completely assembled.



MAINTENANCE AND CLEANING

LUBRICATION WARNING: Firing a shotgun with oil, grease, or other debris partially obstructing the bore may result in damage to the firearm or injury to the shooter and those nearby. Before firing make sure the bore and chamber of the barrel is unobstructed and dry. Never spray or apply lubricant on shotshells. Firing another shotshell behind an obstruction may damage the shotgun and cause death or injury. Only use lubricants properly and sparingly. You are responsible for the proper care and maintenance of your shotgun.

1. Disassemble your shotgun.
2. Using a proper cleaning rod, run a solvent-wetted patch through the bore several times. This will then be followed by running dry patches through the bore to remove any debris or residue.
3. If the bore is leaded to the extent that the above patch cleaning procedure did not remove the lead, then scrub the bore full length with a solvent-wetted brass bristle brush. When the leading is loose then repeat step #2.
4. The surfaces the bolt carrier, ejector and inside surfaces of the receiver should be coated very lightly with non-penetrating lubricating oil.
5. Reassemble the shotgun and wipe the exterior metal surfaces sparingly with an oiled cloth. Swab the bore with an oily patch before storing the firearm.
6. Place the shotgun in a safe, locked storage space where unauthorized persons cannot access the firearm. Never store the shotgun in a leather case as leather attracts moisture even though it may appear dry.
7. Never fire your gun without choke tubes snugly tightened in barrels. Do not over tighten choke tubes. Wipe all exposed metal surfaces with an oiled cloth **before** storing. Do not squirt or pour oil into the inside mechanism because it may cause deformation.







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 CORP.

114 SHERLAKE LANE SUITE 18 KNOXVILLE, TN 37922

TEL: 865-604-6894 / INFO@MILARMAMENTCORP.COM / WWW.MILARMAMENTCORP.COM