

# VR-80 MAG FED SHOTGUN

## USER'S MANUAL



WARNING: READ THE INSTRUCTIONS AND SAFETY PRECAUTIONS  
IN THIS MANUAL CAREFULLY BEFORE USING THE FIREARM.

**RIA**  
**IMPORTS**

# ROCK ISLAND ARMORY

## USER'S MANUAL VR80 MAG FED SHOTGUN

### SAFETY, INSTRUCTION AND PARTS MANUAL



As a responsible owner of this firearm, you must read the instructions and warnings in this manual carefully. Before using this firearm, make sure you understand thoroughly the contents of this manual.

This manual must always be in the firearm's carrying case whenever the owner/user brings it or when it transfers ownership. A copy of this manual is available upon request from:

*ARMSCOR PRECISION INTERNATIONAL  
150 N Smart Way, Pahrump NV 89060  
E-mail: [support@armscor.com](mailto:support@armscor.com)*

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## MAINTENANCE



# 01 | STATEMENT OF LIABILITY

## STATEMENT OF LIABILITY

This shotgun is classified as a firearm or dangerous weapon. It is expressly understood that we assume no liability for its resale or unsafe handling under local laws and regulations. Armscor assumes no responsibility for physical injury or property damage resulting from either intentional or accidental discharge, or for the function of the firearm subjected to influence beyond their control. Armscor will honor no claims which may result from careless handling, unauthorized adjustments, defective or improper ammunition, corrosion or neglect. Examine your firearm carefully at the time of purchase. It should be forwarded immediately to the factory or its sales agent if any adjustment of any kind is required.

### State-By-State Warnings



#### CALIFORNIA STATE WARNING

*CHILDREN ARE ATTRACTED TO AND CAN OPERATE FIREARMS THAT CAN CAUSE SEVERE INJURIES OR DEATH. PREVENT CHILD ACCESS BY ALWAYS KEEPING FIREARMS 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. IT IS UNLAWFUL TO USE A MAGAZINE WITH A CAPACITY OVER 10 ROUNDS.*



#### MASSACHUSETTS STATE WARNING

*IT IS UNLAWFUL TO CARRY ANY MAGAZINE OR BELT WHICH HOLDS MORE THAN TEN ROUNDS, UNLESS AUTHORITY IS GRANTED BY THE BOSTON POLICE COMMISSIONER. IT IS UNLAWFUL TO STORE OR KEEP A FIREARM, RIFLE, SHOTGUN OR MACHINE GUN IN ANY PLACE UNLESS THAT WEAPON IS EQUIPPED WITH A TAMPER RESISTANT SAFETY DEVICE OR IS STORED OR KEPT IN A SECURELY LOCKED CONTAINER.*



#### NEW YORK STATE WARNING

*IT IS UNLAWFUL TO CARRY ANY MAGAZINE OR BELT WHICH HOLDS MORE THAN SEVEN ROUNDS, UNLESS AUTHORITY IS GRANTED BY THE STATE OF NEW YORK. THE USE OF A LOCKING DEVICE OR SAFETY LOCK IS ONLY ONE ASPECT OF RESPONSIBLE FIREARMS STORAGE FOR INCREASED SAFETY, FIREARMS SHOULD BE STORED UNLOADED AND LOCKED IN A LOCATION THAT IS BOTH SEPARATED FROM THEIR AMMUNITION AND INACCESSIBLE TO CHILDREN AND OTHER UNAUTHORIZED PERSONS.*



## 02 | SAFETY PRECAUTIONS

Safety must be the first and constant consideration of every person who handles firearms and ammunition. The person with a firearm in his possession has an important responsibility. He/she must know how to use his/her firearm safely:

1. Always keep the muzzle pointed at a safe direction. Watch the muzzle at all times. Never point a gun, accidentally or intentionally, at any person or anything you do not intend to shoot. Identify the target before shooting; do not shoot at sounds.
2. Always treat a gun as if it is loaded – it may be!
3. Keep your finger off the trigger while operating the action and at all other times until you are ready to shoot.
4. Keep the safety “on” or in the “safe” position at all times until you are ready to fire. Do not rely on your gun’s safety, the safety on any gun is a mechanical device and is not intended as a substitute for common sense or safe gun handling.
5. Learn how your gun functions and handles. If you do not thoroughly understand the proper use and care of your gun, seek the advice of someone who is knowledgeable.
6. Do not alter or modify any part of the firearm.
7. Store guns unloaded, separate from any ammunition, and out of the reach of children.
8. Be sure the barrels is clear of any obstructions before loading. Make it a habit to check the barrel every time before loading.
9. Be sure you have and use the proper ammunition. A 20 gauge shell will enter a 12 gauge chamber far enough so that a 12 gauge shell can be loaded behind it. Also, a 3 inch shell may fit into a 2  $\frac{3}{4}$  inch chamber, but the crimp at the mouth of the shell will unfold into the forcing cone. If either of these things occur and you fire the gun, the gun will explode, damaging the gun and possibly causing serious injury or death to you and those around you.
10. Wear protective shooting glasses and adequate ear protection when shooting.
11. Never climb or jump over anything, such as a tree, fence, or ditch, with a loaded gun. Open the barrel, remove the shells and hand the gun to someone else or place it on the ground on the other side of the obstacle before crossing it yourself. Do not lean a gun against a tree or other object; it could fall and possibly discharge.
12. Do not shoot at a hard surface or at water. Bullet shot can ricochet or bounce off and travel in unpredictable directions with great velocity.
13. Never transport a loaded gun. Do not place a loaded gun into a vehicle. The gun should be unloaded and placed into a case when not in use.
14. Never drink alcoholic beverages before or during shooting.

### **WARNING:**

*DO NOT ATTEMPT TO USE ANY FIREARM WITHOUT HAVING A COMPLETE UNDERSTANDING OF ITS PARTICULAR CHARACTERISTICS AND SAFE USE.*

### **WARNING:**

*YOU SHOULD NEVER DEPEND ON A SAFETY MECHANISM OR ANY OTHER MECHANICAL DEVICE TO JUSTIFY CARELESS AND IMPROPER HANDLING.*

### **WARNING:**

*THIS FIREARM WAS MANUFACTURED TO PERFORM PROPERLY WITH THE ORIGINAL PARTS AS DESIGNED. PLEASE MAKE SURE ANY PARTS YOU BUY ARE INSTALLED CORRECTLY AND THAT NEITHER REPLACEMENTS NOR ORIGINALS ARE ALTERED OR CHANGED. PUTTING A FIREARM TOGETHER INCORRECTLY OR WITH MODIFIED PARTS CAN RESULT IN DAMAGED FIREARM, DANGER, AND INJURY OR DEATH. ANY MODIFICATIONS TO FIREARM WILL VOID FACTORY WARRANTY.*

## 03 | SAFETY PRECAUTIONS

**WARNING:**

CHILDREN ARE ATTRACTED TO FIREARMS, AND MIGHT BE ABLE TO OPERATE THEM. THEY CAN CAUSE SEVERE INJURIES AND EVEN DEATH, TO THEMSELVES OR OTHERS. PREVENT CHILDREN FROM ACCESS, ALWAYS KEEP YOUR FIREARMS LOCKED AWAY, UNLOADED AND OUT OF REACH OF CHILDREN WHEN NOT IN USE AT ANY TIME.

**WARNING:**

THE FIREARM SHOULD BE STORED IN ROOMS WITH A DRY ATMOSPHERE AND MINIMUM HUMIDITY. IT SHOULD NOT BE STORED ENCASED IN LEATHER OR ANYTHING THAT WILL ATTRACT AND HOLD MOISTURE, CAUSING IT TO RUST.

**WARNING:**

DO ALL PROCEDURES (DISASSEMBLY, CLEANING AND OTHER MAINTENANCE) ONLY WHEN THE FIREARM IS UNLOADED. BE SURE THAT THE MAGAZINE TUBE, RECEIVER AND CHAMBER ARE EMPTY WHILE YOU ARE PROCEEDING. CHECK EJECTION PORT, LOADING PORT AND CHAMBER VISUALLY.

**WARNING:**

ALL PRODUCTS HAVE 3" (76MM) CHAMBERS (EXCEPT OTHERWISE STATED). YOU CAN SEE MARKS ABOUT GAUGES AND CHAMBER LENGTH ON THE GUN. EVERY SHOTGUN HAS PASSED DURABILITY TEST WITH SPECIAL HIGH PRESSURE CARTRIDGES.

**WARNING:**

WHEN STORING THE GUN FOR A PROLONGED PERIOD OF TIME, IT IS NECESSARY TO OIL IT HEAVILY WITH AN ACID-FREE LUBRICANT. THE EXTERNAL PARTS MUST BE COATED WITH AN ANTI-RUST OIL OR GREASE TO PREVENT MOISTURE CAUSING THE PARTS TO RUST AND MALFUNCTION. BEFORE USAGE, THE SHOTGUN MUST BE CLEANED AND WIPED DRY AGAIN.

## 04 | TECH SPECS

Model	VR-80
Caliber	12 Gauge
Chamber	2.75in / 3in
Action	Semi Automatic
Capacity	5 Rounds
Choke	Full, Modified, and Improved Cylinder
Barrel	Contoured
Barrel Length	500mm / 20in
Overall Length	990mm / 39in
Overall Width	40mm / 1.6in
Overall Height	230mm / 9in
Rear Sight	Serration on receiver
Weight, Empty	3.35kg / 7.39lbs
Weight, Loaded	3.85kg / 8.49lbs
Finish	Black Chrome
Stock	Polymer buttstock with rubber buttpad

CALIBER



12 Gauge

# 05 | BASIC PARTS

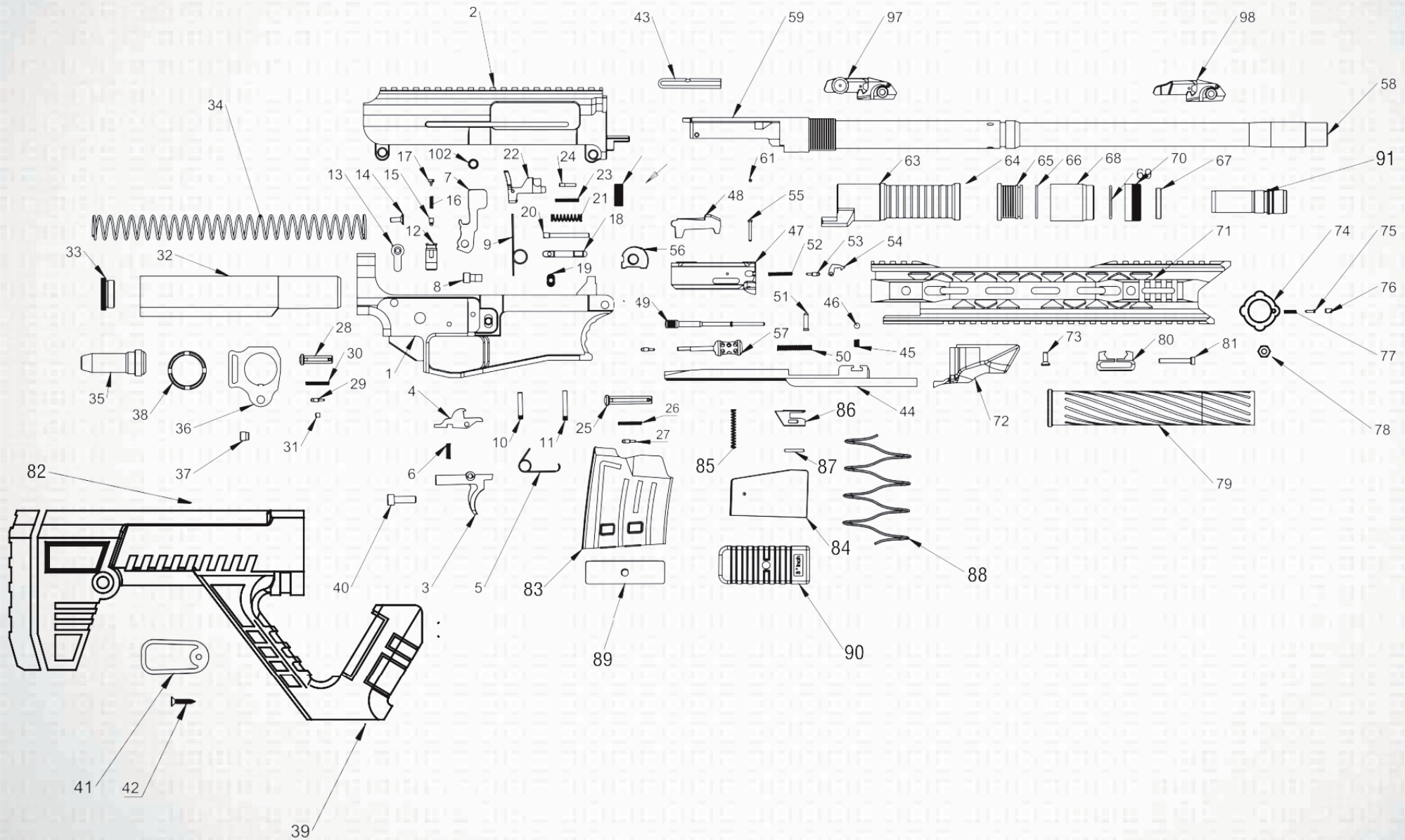
## VR 80 MAG FED SHOTGUN BASIC PARTS

PART NUMBER	PART NAME	PART NUMBER	PART NAME	PART NUMBER	PART NAME	PART NUMBER	PART NAME
1	Trigger Mechanism Housing	28	Takedown Pin	55	Extractor Pin	82	Fixed Buttstock
2	Receiver	29	Takedown Catch	56	BufferBolt System	83	Magazine Body
3	Trigger	30	Takedown Catch Pin	57	Cocking Handle	84	Magazine Follower
4	Disconnecter	31	Takedown Catch Screw	58	Barrel	85	Bolt Catch Actuator Spring
5	Trigger Spring	32	Stock Support	59	Barrel Extension	86	Bolt Catch Actuator
6	Disconnecter Spring	33	Lock Ring	60	Barrel Retaining Screw	87	Bolt Catch Actuator Pin
7	Hammer	34	Bolt Return Spring	61	Ejector Rivet	88	Magazine Spring
8	Hammer Pin Sleeve, Male	35	Bolt Buffer	62	Barrel Retaining Rings	89	Magazine Base Plate Retainer
9	Hammer Spring	36	Sling Plate	63	Slide	90	Magazine Base Plate
10	Trigger Pin	37	Detent Ball	64	Slide Extension	91	Mobile Choke
11	Hammer Pin	38	Pivot Nut	65	Gas Piston		
12	Safety	3	Fixed Buttstock	66	Sealing Ring		
13	Safety Lever	40	Buttstock Screw	67	Split Ring		
14	Safety Retaining Screw	41	Buttstock Cap	68	Gas Block		
15	Safety Detent	42	Buttstock Cap Screw	69	Gas Block O-Ring		
16	Safety Detent Spring	43	Pin	70	Gas System Retaining Nut		
17	Safety Detent Retaining cSrew	44	Slide Carrier	71	Fore End		
18	Magazine Catch	45	Cocking Handle Retainer Spring	72	Handguard		
19	Magazine Catch Button	46	Cocking Handle Retainer Ball	73	Handguard Retaining Screw		
20	Magazine Catch Screw	47	Bolt	74	Handguard Pivot Nut		
21	Magazine Catch Spring	48	Lock	75	Handguard Retainer		
22	Bolt Catch	49	Firing Pin	76	Handguard Retainer Pin		
23	Bolt Catch Spring	50	Firing Pin Return Spring	77	Handguard Retainer Spring		
24	Bolt Catch Pin	51	Firing Pin Retaining Pin	78	Handguard Pivot Screw		
25	Pivot Pin	52	Extractor Spring	79	Barrel Shroud		
26	Pivot Pin Detent Spring	53	Extractor Spring Detent	80	Sling Swivel		
27	Pivot Pin Detent	54	Extractor	81	Sling Swivel Screw		



# 06 | EXPLODED VIEWS

## VR-80 MAG FED SHOTGUN



# 07 | OPERATING INSTRUCTIONS

## DISSEMBLY OF THE FIREARM



1) Remove the magazine



2) Unscrew the barrel shroud by turning in arrow direction



3) Pull the fore end in arrow direction



4) Push the detaching pin and pull from the other side until it sets



5) Push the other detaching pin and pull from the other side until it sets



6) Detach upper from lower

## 08 | OPERATING INSTRUCTIONS



7) Unscrew the gas system retaining nut by turning in arrow direction



8) Remove the split ring



9) Remove the piston by pulling in arrow direction



10) Remove the charging handle by pulling it



11A) Remove both barrel screws with a wrench  
11B) Remove both barrel retaining rings with the MK12 multi tool.



12) Pull out the assembly in arrow direction



## DAXOS® (Dual Axis Operation System): Ambidextrous Cocking Handle Operation



1) Pull the charging handle



2) Insert the charging handle from the other side



3) Make sure the handle is set

## BufferBolt™ System



1) Specially developed system to avoid damages in the receiver, caused by recoil. Patented by DERYA®.

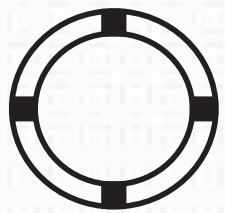
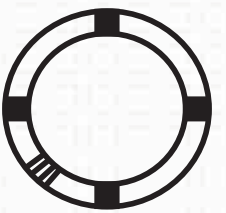
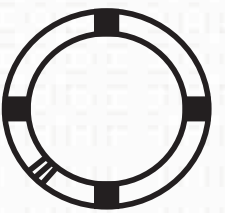
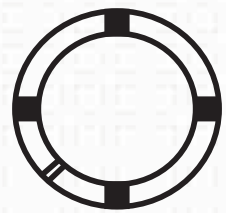
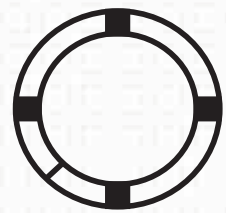
Marking	USAGE OF CHOKE TUBES	NOTCHES
*	Suitable for longer ranges (DONT USE SLUGS!)	
***	Suitable for medium ranges (DONT USE SLUGS!)	
*****	Suitable for short ranges	



# 10 | MAINTENANCE

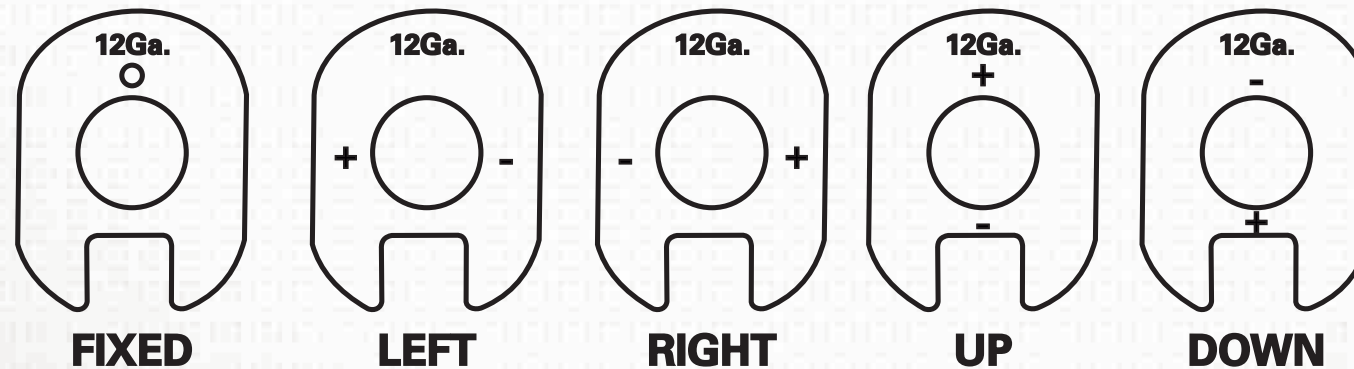
## USAGE OF CHOKE TUBES

The choke is what controls the openness or tightness of the pattern of your shotgun. The chart below lists the choke available (from open to tight), and the corresponding marks that indicate the choke of your specific shotgun.

	SKEET	IC	M	IM	F
CHOKETUBE					
BBLS	CL	****	***	**	*

Never fire or gun cleaning tools through a barrel that uses choke tubes without having tube installed. The threads of the choke tube and the internal threads of the barrel should be cleaned after each use and before installation of the tube.

To install a tube, insert the tube into the barrel and tighten with your fingers. Once the tube is finger-tightened, tighten with the appropriate choke-tube wrench until the tube is snug. DO NOT over tighten or forcefully tighten with wrench.



There are five (5) Shim Sets as Up, Down, Right, Left and fixed kinds in Armscor productions, in order to accommodate all shooters preferences.

## ORDERING PARTS

Visit RIA website to browse, learn more about and purchase parts and ammunition for all of your Rock Island Armory products.

 [www.advancedtactical.com](http://www.advancedtactical.com)



## WARRANTY REGISTRATION

Armstrong's warranty covers its firearms and parts. We offer limited lifetime warranty on our products for their intended purpose. As with any product, abuse, gunsmithing by an unqualified person and normal wear and tear are excluded. Additionally, if the firearm was modified and/or repaired by an unqualified gunsmith without permission from Armstrong, then the warranty will be void. If warranty work should be required, return the firearm to the address listed below. There is no refund for the shipping cost. Gunsmithing services are available by registered Armstrong Gunsmithers. Please email the address below.

To register your firearm, please go to [www.rockislandarmory.com/support-center/warranty/](http://www.rockislandarmory.com/support-center/warranty/) and complete online warranty form. In comments section, write warranty registration and press submit. You can also go to [www.rockislandarmory.com](http://www.rockislandarmory.com) and press warranty section at the bottom.

For more information on warranty, visit [www.rockislandarmory.com](http://www.rockislandarmory.com), or email [support@armstrong.com](mailto:support@armstrong.com)

Armstrong Precision International  
150 North Smart Way  
Pahrump, NV 89060  
Email: [support@armstrong.com](mailto:support@armstrong.com)

## IMPORTANT WARRANTY INFORMATION

Our Rock Island Armory shotguns are warranted to function only with Factory Ammo and the Original Factory Magazine. Use of Handloads is not covered in Warranty of Repair for the function of the Firearm.

DUE TO THE FIT AND TIGHTNESS OF FIREARM, RIA RECOMMENDS A BREAK-IN PERIOD OF 500 ROUNDS.

### THIS IS HOW YOU VOID YOUR WARRANTY

- \* Refinishing your RIA firearm
- \* Misuse, Mishandling, Dropping your RIA Firearm
- \* Firing Remanufactured or Reloaded Ammunition
- \* Not properly reassembling your RIA Firearm resulting in damage, ie reverse plugs!
- \* Any addition of after market parts
- \* Unauthorized repairs done by any other than Rock Island Armory

### LIMITS ON WARRANTY (will not cover)

- \* Finish, Holster wear, Scratches, Chemical damage
- \* After Market Magazines
- \* Damage to Factory Magazines
- \* Sights not installed by Rock Island Armory
- \* Recoil Springs

WE RESERVE THE RIGHT TO CHARGE FOR LABOR, PARTS AND SHIPPING TO RETURN YOUR RIA FIREARM BACK TO FACTORY SPECIFICATIONS IF IT HAS BEEN ALTERED.





**RIA**  
IMPORTS

[WWW.ROCKISLANDARMORY.COM](http://WWW.ROCKISLANDARMORY.COM)

