

# Operation and Safety Manual



BN36 30-06, BN36 25-06, BN36 270  
BN308, BN243

## Please Practice Safe Firearms Handling!

This manual should always accompany your  
NOREEN BN SERIES™.



Noreen Firearms LLC  
131 Jetway Dr.  
Belgrade, Mt 59714  
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## Please Practice Safe Firearms Handling

Our mission is to manufacture quality firearms, Made With Pride In The USA, and using the best American Made parts. We value our customers, and do our best to assure quality and friendly service. Noreen Firearms LLC is always striving to make great firearms even better.

This Operation Manual should always accompany this firearm. When you lend, give, or sell this firearm, be sure this manual goes with it. To obtain a replacement manual, log on to: [www.OnlyLongRange.com](http://www.OnlyLongRange.com) and print or download a new copy.

Note: For any information or details not covered in this Operating Manual, contact us at [technicalsupport@onlylongrange.com](mailto:technicalsupport@onlylongrange.com) or (406) 388-2200.

Model: \_\_\_\_\_

Serial Number: \_\_\_\_\_

Purchased From: \_\_\_\_\_

Date Purchased: \_\_\_\_\_

# Warranty Information Card

Customer  
Name:

Address:

\_\_\_\_\_

City: \_\_\_\_\_ State: \_\_\_\_\_ Zip: \_\_\_\_\_

Please Circle Model: Noreen ULR Single Shot Noreen Bad News Semi-Auto Noreen BN Series

Please Circle Caliber: 50 BMG 416 338 Lapua 300 Win Mag 30-06 25-06 270 308 243

Serial # \_\_\_\_\_ Date of Purchase \_\_\_\_\_ / \_\_\_\_\_ / \_\_\_\_\_

Purchased From: \_\_\_\_\_

**Return this completed card  
and a copy of original sales  
receipt to:**

Noreen Firearms LLC  
131 Jetway Dr.  
Belgrade, Mt 59714

44

Before disassembling, loading, or using this firearm, please  
**READ, UNDERSTAND, AND FOLLOW ALL THE INSTRUCTIONS**  
in this manual, regarding proper handling and safe use!



Caution:

If unfamiliar with firearms, seek further advice through Gun Safety Organizations, Local Gun Clubs, NRA Approved Instructors, or similar qualified organizations.



Warning:

**If this firearm is carelessly or improperly handled,** unintentional discharge could result and could cause **injury,**



Warning:

**This firearm could chamber a round if it is dropped or jarred with a loaded magazine in place** – with the bolt carrier assembly locked to the rear, or in its forward position.



Caution:

**Use only clean, dry, high quality commercially manufactured** ammunition. Use only ammunition that is appropriate for the caliber of your firearm.

## **WARNING: Before Using This Rifle, Read And Follow These Instructions!**

If there is anything you do not understand, get help from someone qualified in the safe handling of firearms.

- Be sure cam pin is installed in the bolt group. If it isn't, your rifle can still fire and will explode.
- If you are using a blank firing attachment, never fire anything except blank rounds (for safety, we recommend the visible military style blank firing attachment).
- If your rifle stops firing with a live round in the chamber of a hot barrel (a misfire), remove the round fast. However, if you cannot remove it within 10 seconds, remove magazine and wait 15 minutes with the rifle pointing in a safe direction. This way you won't get hurt by a possible round "cooking-off" (i.e. the round detonating just from the heat of the barrel). In any event, keep your face away from the ejection port while clearing a hot chamber.
- If your bolt fails to unlock, try to free it by banging the buttstock on the ground while pulling back on charging handle. Always keep yourself clear of the muzzle.
- If there's water in the barrel, do not fire the rifle. It could explode.
- If a noticeable difference in sound or recoil is experienced, STOP FIRING. Either condition could indicate an incomplete powder burn and/or a bullet stuck in the bore.
- Shooting from positions where the shooter is not completely and solidly behind the rifle may cause cycling problems. Some shooters experience problems when utilizing lead sleds, sand bags, bipods and other forms of shooting rests that inhibit solid positioning.
- Disassembly beyond removing the bolt handle, separating the upper and lower receivers, and removing the bolt carrier group should ONLY be done by Noreen Firearms, someone who has completed a Noreen Firearms armorer's certification course, or a qualified gunsmith. Qualified gunsmith is defined as someone who is employed in the firearms industry for the specific purpose of building or maintaining firearms and/or who has completed an accredited Gunsmithing education program.

## **WARNING: Beware of Dangerous Procedures. Always Practice Safe Firearms Handling!**

**2**

## **Limited Warranty.....**

Noreen Firearms LLC products are warranted to be free from defects in material and workmanship. Warranty cards are included with all firearms and should be completely filled out and sent to Noreen Firearms LLC to activate the terms of the warranty. You can find the warranty card on the following page of this manual. You will also need to send a copy of your original purchase receipt.

Any such defect of which Noreen Firearms LLC is given written notice, as provided below, within one year from the date of first purchase by a customer will be remedied by Noreen Firearms LLC. This warranty is granted by Noreen Firearms LLC.

To initiate a warranty claim: email [techsupport@onlylongrange.com](mailto:techsupport@onlylongrange.com). Warranty claims should state the model and serial number of the gun, a description of the difficulty you are experiencing, and the date of purchase. It is recommended that shipment be insured by the owner, since Noreen Firearms LLC will accept no responsibility for loss or damage in transit. Transportation and insurance charges for return to owner will be paid by Noreen Firearms LLC, if the related claim is a proper claim for warranty work. The firearm should then be sent to Noreen Firearms LLC.

\*The following actions will render your Noreen Firearms Factory Warranty null and void:

- Using hand loaded or reloaded ammunition
- Using steel cased ammunition, regardless of the coating on the case
- Using military surplus ammunition
- Disassembling the rifle beyond the level detailed in this Owner's Manual
- Replacing, switching, swapping, or tampering with any parts of the rifle or magazine

**43**

## Troubleshooting (continued).....

PROBLEM: Short Recoil

Check For:

Too little gas to operate

Turn adjusting screw counter-clockwise 1/4 turn.

Clean out if possible or have it checked by a qualified gunsmith.



## Facts About Your Noreen BN Series rifle...

The Noreen BN Series rifle consists of a rifle, one magazine, and case. It is a direct gas impingement, air-cooled, magazine-fed, shoulder-fired weapon that can be fired in a semi-automatic mode – i.e., a single shot each time the trigger is pulled.

- The upper and lower receivers are easily opened for cleaning and inspection.
- The bolt group and barrel extension are designed with locking lugs that lock the bolt group to the barrel extension.

- The aluminum upper and lower receivers reduce the weight of the rifle.
- Weight: (depends upon model) 22" Bbl. Rifle = 8 lbs.
- Length: (depends upon model, plus muzzle brake) 22" Bbl. Rifle = 43.5"
- Barrel Rifling: R.H. twist; 1 turn in 10"
- Muzzle Brake-Noreen Custom Muzzle, not considered flash hider.
- Trigger: Standard Mil-Spec Trigger
- Maximum effective rate of fire: 45 rounds per min. / semi-automatic.
- Max effective range: 2000 meters (individual / point targets).
- Maximum range: 4500 meters.

- Although bearing an undeniable resemblance and using some similar parts, your Noreen Firearms rifle is not what is commonly referred to as an "AR" nor is it "Milspec". It is not a battle rifle. As such, some features commonly associated with what are commonly termed "ARs" or "AR-type rifles" may not be present (including but not limited to the bolt locking open after the last round in the magazine has been fired, the rifle cycling more than one type of ammunition on a given gas block setting, and the ability to interchange parts with other rifles).

## Table of Contents

<b>Owners Information</b>		Safety Function Checks	23
Before Using This Firearm	1	Loading a Magazine	24
Warnings	2	Operation of Your Rifle	25
Facts About Your Noreen BN Series	3	Operation - Inserting a Magazine	26
Rifle Parts and Where to Find Them	5	Operation - Chambering a Round	27
Clearing Your Rifle	7	Immediate Action in Case of Trouble	29
Disassembling Your Rifle	8	Remedial Action	30
Cleaning - Inspection - Lubrication	10	Gas Block Setup	31
Detailed Cleaning Techniques	11	Troubleshooting	33
Cleaning the Upper Lower Receivers	12	Limited Warranty	43
Inspection before Lubrication	14	Warranty Card	44
Lubrication of Upper & Lower Receivers	15		
Lubrication of Bolt Carrier Group	16		
Reassembly	17		

**BEFORE USING THIS FIREARM, READ AND FOLLOW THESE INSTRUCTIONS.**

If there is anything you do not understand, get help from someone qualified in the safe handling of firearms.

4

## Troubleshooting (continued).....

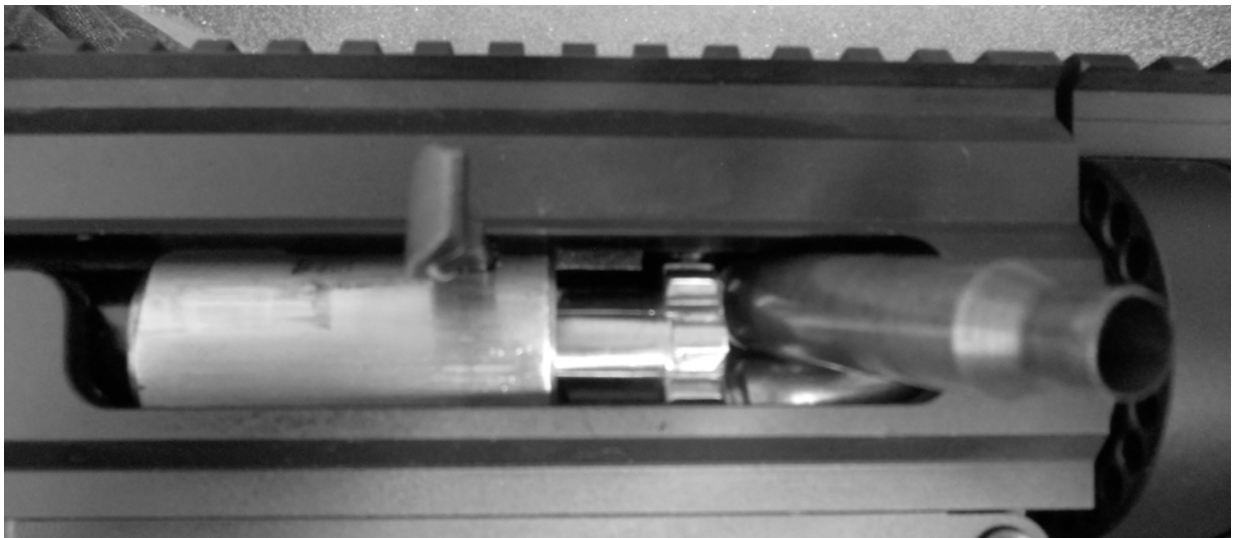
**PROBLEM:** Torn Rim of Case  
Harsh felt recoil  
Stove piping

Check For:

Rifle is over gassed.

What To Do:

Turn adjusting screw clockwise 1/4 turn.



41

## Troubleshooting (continued).....

PROBLEM: Bolt carrier "Hung Up"

Check For:

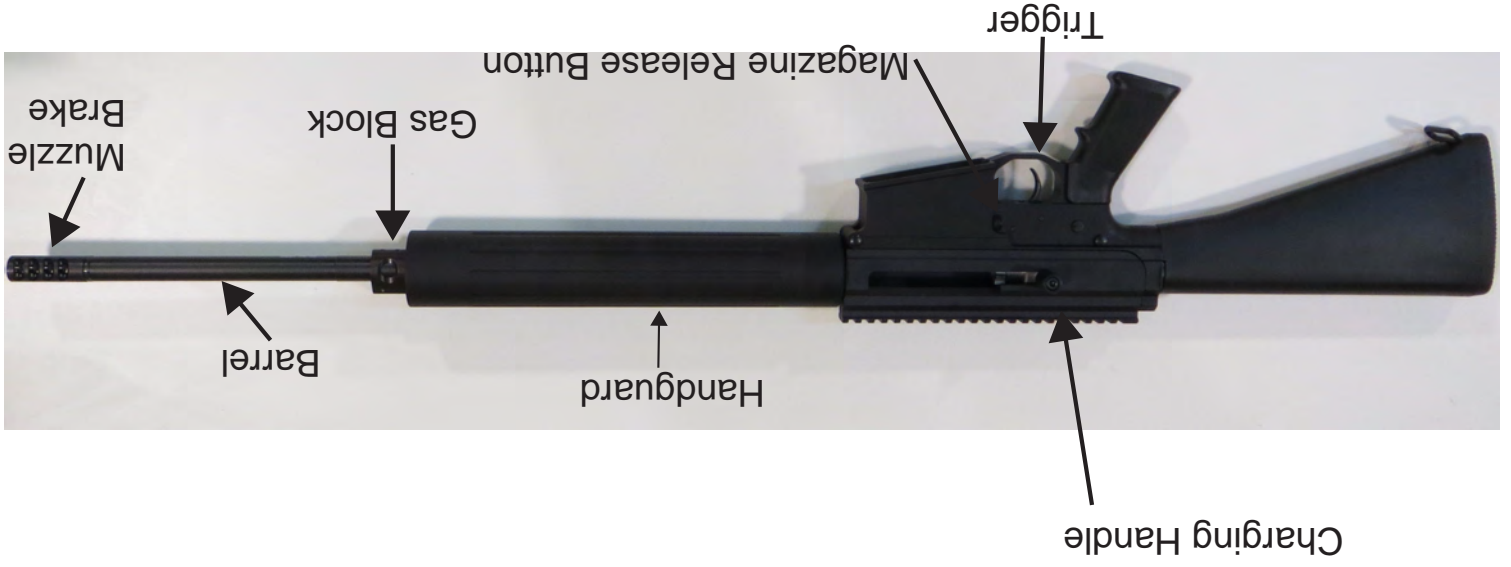
Round jammed between bolt and charging handle and/or double feed.

**WARNING:** Keep clear of muzzle.  
**Caution:** After round is removed, bolt is under tension.

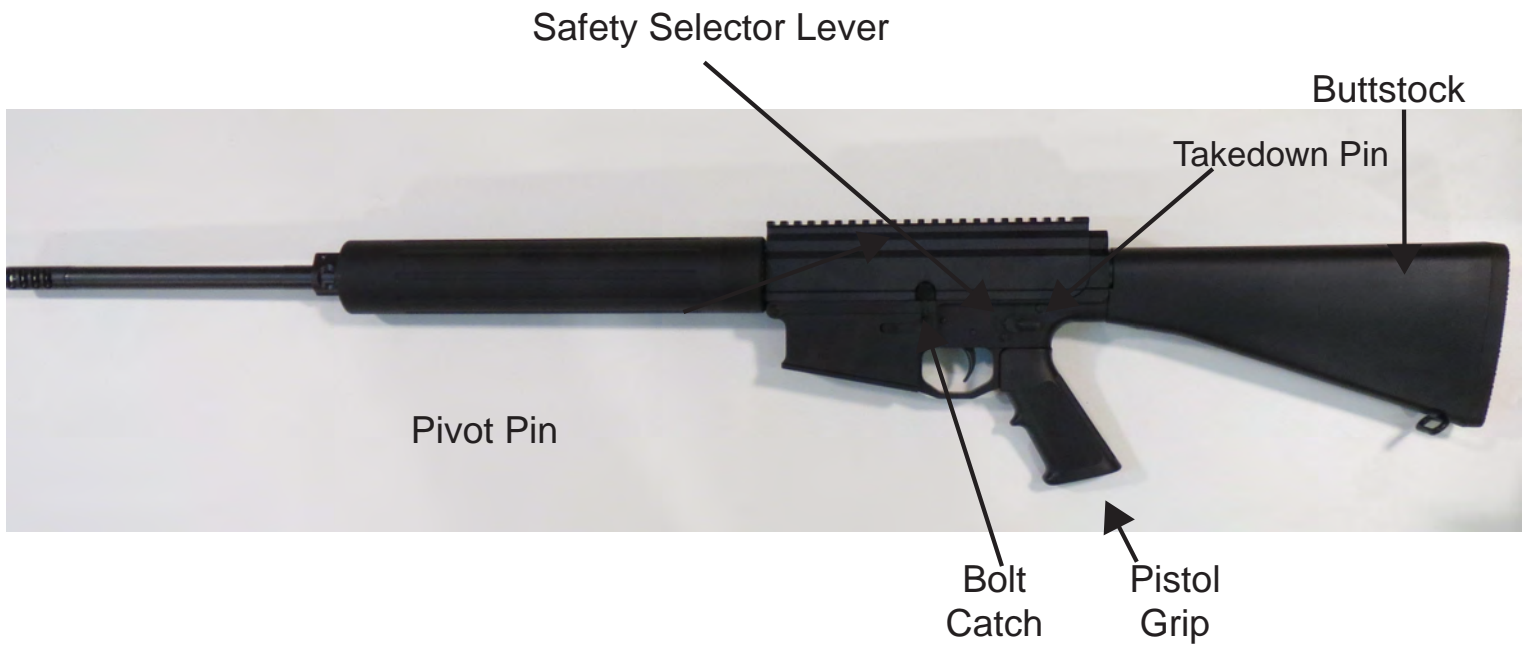
What To Do:

Remove magazine.  
Point muzzle in safe direction. Engage safety if possible by pushing out take-down pin and manually cocking hammer. Close receivers.  
While pulling down on the charging handle, bang the rifle butt on the ground.  
Round should eject.

40



5



6

## Troubleshooting (continued).....

PROBLEM: Selector lever binds

Check For:

Needs oil.

Dirt or sand under trigger.

What To Do:

Lubricate with CLP.

Clean.



**POINT RIFLE IN A SAFE  
DIRECTION!!**

Place safety selector lever on SAFE. (If the rifle is not cocked, the selector lever cannot be pointed toward SAFE.)



**Clearing Your Rifle....**

**Troubleshooting (continued).....**

PROBLEM: Won't extract (continued)

Check For:

Frozen extractor.

Restricted buffer assembly.

Restricted movement of bolt carrier group.

To little gas to operate

What To Do:

Remove and clean.

Remove and clean.

Remove and clean and lube.

Turn adjusting screw on gas block counter-clockwise 1/4 turn.

## Steps To Disassemble Your Rifle....

Clear your rifle and disconnect the sling, if so equipped.

Push in rear takedown pin. Pivot upper receiver away from lower.

Push in front pivot pin.

Separate upper and lower receivers.

Un-screw charging handle and remove from bolt carrier.

Remove bolt carrier and bolt.

Remove firing pin retaining pin. Slide firing pin to back of bolt carrier.

Remove bolt cam pin.

Slide firing pin and bolt assembly out of carrier.

8

## Troubleshooting (continued).....

PROBLEM: Won't lock

Check For:

Dirt, corrosion or carbon buildup in barrel locking lugs.

What To Do:

Clean lugs.

PROBLEM: Won't extract

Broken extractor spring.

See a qualified gunsmith.

Carbon in chamber.

Clean chamber.

Fouling or carbon in extractor recess or lip.

Clean extractor.

Lightly clean as per instructions for aluminum upper and lower receivers. (see page 15)

We do not recommend any further disassembly!



Remove buffer and buffer spring.

Press in buffer, depress retainer and release buffer.

Remove extractor plunger and spring. (CAUTION: Extractor spring may pop out and get lost!)

Remove extractor pin by pushing out with a drift punch. You may need to use a small hammer to drive the pin out.

### Steps To Disassemble Your Rifle (continued).....

Try pressing magazine catch button on right side.

<u>Check For:</u>	<u>What To Do:</u>
Dirty or corroded ammo.	Clean.
Dirty magazine.	Clean.
Defective magazine.	Replace.
Too many rounds in magazine.	Take out excess.
Action of buffer assembly is restricted.	Take out buffer and spring. Clean.
Magazine not fully seated.	Adjust magazine catch.

### Troubleshooting (continued).....

PROBLEM: Won't feed

## Cleaning - Inspection - Lubrication.....

**After firing:** Clean your rifle as soon as possible to make the job easier and to avoid allowing the development of any corrosion.

**When your firearm has not been fired:** You should clean it at least once or twice a year if you live in a temperate climate, or as often as once a week in a tropical climate.

**If you get your firearm wet:** Clean it as soon as possible.

Use a high quality rifle cleaning kit that includes a cleaning rod; swab holder; cotton flannel bore patches; pipe cleaners; a small toothbrush; brass wire bristle bore and chamber brushes and a Cleaner/Lubricant/Preservative (aka CLP).

After you have disassembled the rifle, thoroughly clean, inspect and lubricate all parts according to the techniques described on the following pages.

10

## Troubleshooting (continued).....

PROBLEM: Bolt won't unlock

Check For:

Dirty or burred bolt.

To little gas to opperate

Defective magazine.

What To Do:

Clean or see a qualified gunsmith.

Open Gas Valve

Replace.

PROBLEM: Won't Chamber

Dirty or corroded ammo.

Damaged ammo.

Carbon in chamber or on gas tube.

Clean.

Replace.

Clean.

35

## Troubleshooting .....

PROBLEM: Won't Fire

Check For:

Selector lever on SAFE.

Improper assembly of firing pin.

Too much oil in firing pin recess.

Defective ammunition.

NOTE: **DO NOT** use Surplus ammunition.

What To Do:

Put it on FIRE.

Assemble correctly. Retaining pin goes in back of large shoulder on firing pin.

Wipe out with pipe cleaner.

Remove and Discard.

34

## Cleaning Techniques.....

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

CLEANING THE BORE: The bore of your Noreen rifle has lands and grooves called rifling. Rifling makes the bullet spin very fast as it moves down the bore and down range. It is difficult to push a new, stiff bore brush through the bore. You will find it much easier, and more effective, to pull your bore brush through the bore. Also, because the brush will clean better if the bristles follow the grooves (this is called tracking), you want the bore brush to be able to turn as you pull it through. Always clean from from chamber toward the muzzle. This is how it's done:

- 1.) Swab out the bore with a patch moistened with "CLP".
- 2.) Attach three rod sections together but leave each one about two turns short of being tight.
- 3.) Attach the bore brush but leave it two turns short also.
- 4.) Point muzzle down. Hold the upper receiver in one hand while inserting the end of the rod without the brush into the chamber. Guide the rod carefully through the bore. CAUTION: do not let the rod or its threaded end scratch the Bore or Firing Chamber. About 2 - 3 inches of the rod should protrude out of the muzzle.



11

## Cleaning Techniques (continued).....\*

- 5.) Attach the handle section of the cleaning rod to the end of the rod sticking out of the muzzle.
- 6.) Pull the brush through the bore and out the muzzle. You should be able to see the rod twisting as you pull it - this is the brush "tracking" in the rifling.
- 7.) After one pull, take off the handle section and repeat the process. After three or four pulls, the three rod sections and the bore brush may become screwed tightly together. Loosen them up and repeat the process.
- 8.) Send a patch through the bore occasionally to clean out any debris that the brush is getting loose. Just replace the bore brush with the rod tip (patch holder) and a wet patch. Pull it through. If you leave the rods loose, the patch will also "track" in the rifling. Always have the bore wet with cleaner before pulling a brush through.

### Cleaning the upper receiver...

NOTE: Check to ensure that there is no looseness between the barrel and the upper receiver - if you detect any movement by twisting with your hands, the barrel nut must be re-torqued. Bring the rifle to a qualified gunsmith.

- 1.) Using a "CLP" product, clean all areas of powder, corrosion, dirt and rust. Never use a wire brush or any type of abrasive to clean the aluminum upper receiver - you'll scratch and damage the finish.



12

## Immediate Action In Case Of Trouble.....

WARNING: If an audible "POP" or reduced RECOIL is experienced during firing, immediately CEASE FIRE. Then...

- 1.) Remove the Magazine.



- 2.) Lock the bolt to the rear.



- 3.) Put selector lever on the SAFE position.



- 4.) Check for a bullet in the bore with a cleaning rod.



33

**Cleaning the lower receiver...**

1.) Clean all areas of powder fouling, corrosion, dirt and rust. Again, never use a wire brush or any type of abrasive to clean the aluminum lower receiver.

2.) Wipe any dirt from the trigger mechanism. Clean the buffer, action spring, and inside the lower receiver extension (the buffer tube).

2.) Clean the firing chamber - dip the chamber cleaning brush in CLP and use at least five plunge strokes and three 360 clockwise rotations. Then swab out the bore as described previously to remove any contaminated solution or loosened debris.

3.) Use the bore cleaning brush, still wet with CLP, and clean carbon and powder residue from around the gas tube, run a pipe cleaner into the gas tube, clean the bolt locking lugs, bolt rings, firing pin, bolt cam pin, lip of the extractor, and inside the bolt carrier from both front and rear.

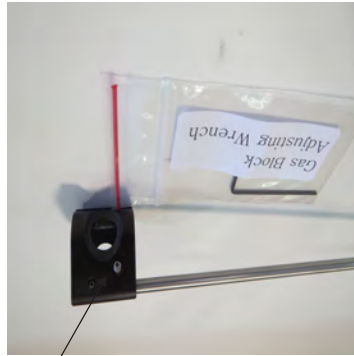
4.) Wipe all components clean and dry, and inspect for excessive wear, corrosion or mechanical damage. Replace any defective parts before firing.

## Cleaning Upper Receiver (continued).....

\*More often than not there is too much gas and this is due to the rifle breaking in and loosening up. An easy test to check full travel is to install masking tape on upper receiver to see if bolt handle is traveling far enough to cut tape.

\*Gas Adjustment Lock Screw must be loosened prior to any adjustment and tightened after any adjustment.

Gas Adjustment Lock Screw



Adjustment Screw

## Gas Block Adjustment.....

- Problem:**
- Stove piping
  - Pressure signs
  - Bolt traveling faster than magazine can react
- Resolution:**
- Close Gas Valve by turning it clockwise
- Problem:**
- Bolt not traveling far enough back to chamber next round
- Resolution:**
- Open Gas Valve by turning it counter-clockwise

## Inspection Before Lubricating.....



Check the bolt: Look for cracks or fractures, especially in the cam pin hole area. Bolts with any pitting extending into the firing pin hole should be replaced



Check the firing pin; if it is bent, cracked, too bunted or too sharp, it should be replaced.

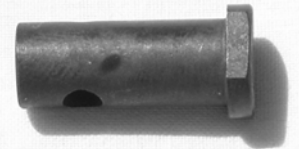


**WARNING: If cam pin is missing, DO NOT FIRE RIFLE!! It will EXPLODE!**

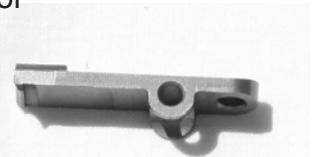
Check the firing pin retaining pin: If it is bent, or badly worn, it should be replaced.



Check the cam pin: If it is cracked, or chipped, it should be replaced.



Check the extractor and extractor spring: If the extractor is chipped, or has broken edges in the area of the lip that engages the cartridge rim, it should be replaced.



14

## Gas Block Setup

To get the best performance in our gas operated semi automatic rifles, we have installed an adjustable gas system. Due to the longer duration of peak pressure produced by certain performance ammunition (hand loads), the post peak/declining port pressure at common gas port locations is still higher than that produced by standard propellant. This has a tendency to flood the system and causes the bolt to open faster. This is what they call a timing issue. The cartridge case is swollen from the application of pressure from firing the gun while it is simultaneously trying to extract the case before it has had the opportunity to settle back to its original size. When this happens it can cause pressure signs on the brass best described as marring, cratered primers, flat primers, "popped primers", or even rupture the cartridge case. If any of these pressure signs are apparent, STOP FIRING IMMEDIATELY. It is advisable to reduce the amount of gas flowing through the system by closing the gas port (clockwise) to slow the system down. If the rifle bolt is not traveling far enough back to chamber the next round, there is not enough gas in the system and you will need to open the gas port up more (Counter-Clockwise). If you must use untried ammo, try it with current setting and then adjust accordingly.

Loctite or other adhesive should be applied on the valve screw to keep it set in the desired location.

It is also possible to shut the valve completely if you want to cycle the rifle manually for any reason.

Noreen Firearms direct impingement gas operated rifles operate best with the gas block set at the lowest setting that achieves ejection of the fired cartridge case and feeding the next cartridge from the magazine. Over gassing the rifle can cause cycling problems and damage the rifle or harm the shooter. \*\*During the action break-in period (50-100rds) the gas block may need to be set at a slightly higher setting than was preset when the rifle was test fired at the factory. As the action breaks in typically less gas is required to cycle the rifle.

If the gas block gets too hot, you may experience some cycling problems with your rifle. If you have been firing your Noreen rifle rapidly or for an extended period of time, you may have better results if you allow the gas system to cool before resuming firing.

**A new rifle or bolt assembly will have a great deal of friction and may require a break-in period during which the gas block must be run with more gas for complete cycle.**



## Remedial Action.....

**WARNING:** If your rifle stops firing with a live round in the chamber of a hot barrel, remove the round fast. However, if you cannot remove it within 10 seconds, remove the magazine and wait 15 minutes with the rifle pointing in a safe direction (always make sure that the "SAFE" direction remains safe during this time period). This will prevent injury by a round cooking off.

Regardless, keep your face away from the ejection port while clearing the hot chamber.

If your rifle still fails to fire after performing steps 1 through 4 on the previous page, check again for a jammed cartridge case.

If your rifle still fails to fire, check the troubleshooting section in this manual, or take the rifle to a qualified gunsmith.

30

## Lubrication Of Upper Receiver.....

### Lightly Lubricate:

- The inside of the upper receiver, the bore and chamber (using the cleaning rod and a patch), the outer surfaces of barrel, front sight, and surfaces under the handguard.
- Be sure you lube in and around all the locking lugs (see illustration).
- The firing pin and the firing pin recess in the bolt with CLP.
- The charging handle, the inner and outer surfaces of the bolt carrier, the extractor and its pin.

### Generously Lubricate:

- The slide and cam pin area of the bolt carrier, and the bolt.



## Lubrication Of Lower Receiver.....

### Lightly Lubricate:

- Inside the lower receiver extension (buffer tube), buffer and the action spring.

### Generously Lubricate:

- All moving lower receiver parts trigger, hammer, safety, bolt catch, etc), and their various pins and detents. Don't forget the takedown and pivot pins and detents. Clean fingerprints (they can start the corrosion process) off the exterior surfaces with a oiled black rag (black rags leave no visible lint).

15

## Lubrication Of Bolt Carrier Group.....

### Lightly lubricate:

- The firing pin with CLP; also the firing pin recess in the bolt.



### Generously lubricate:

- The bolt and its cam pin area. A lighter application is good on the extractor and its pin.



### Generously lubricate:

- The slide and cam pin area of the bolt carrier.



16

## Immediate Action In Case Of Trouble.....

IF YOUR RIFLE STOPS FIRING: Perform the following immediate actions....

**WARNING: DO NOT LOAD WITH A HOT CHAMBER. A ROUND MAY "COOK OFF"**  
(meaning it may fire from the heat of the chamber)

1.) SLAP upward on magazine to make sure it's seated properly.



2.) PULL charging handle all the way back observe ejection of case or cartridge. Check chamber for any obstructions.



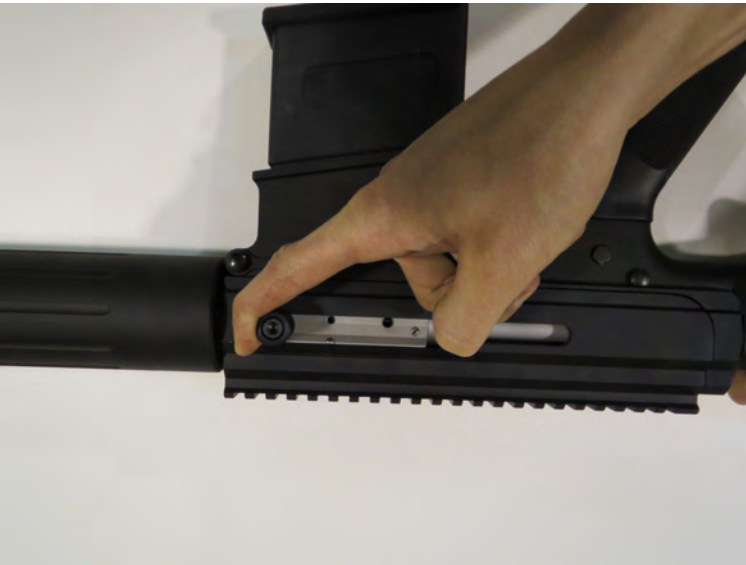
3.) If cartridge or case is ejected or chamber is clear, RELEASE charging handle to feed a new round.

4.) Now FIRE... If the rifle won't fire, look for trouble and apply remedial action.

29

## Operating Your Rifle (continued)..... Chambering A Round With Bolt Assembly Closed

Pull charging handle full to rear. Release the charging handle.



NEVER "ride" the charging handle. Let it move forward on its own.

Note: If the rifle is not going to be fired immediately, make sure the selector lever is still on safe. Always keep muzzle pointed in safe direction.

28

## Reassembly.....

Insert action spring and buffer. Depress buffer detent and push buffer in past the detent, then release.



Insert extractor, spring, and pin.



17

## Reassembly (continued).....

Push in firing pin retaining pin.



Slide bolt into carrier.



18

## Operating Your Rifle (continued)..... Chambering A Round With Bolt Assembly Open

Note: The magazine may be inserted into the rifle with bolt assembly open or closed.

Depress upper portion of bolt catch.  
Bolt should spring forward.



27

## Operating Your Rifle (continued).....

### Inserting a Magazine

Push magazine up into magazine well until magazine catch engages and holds the magazine. Tap upward on magazine bottom to make sure it's seated correctly.



26

## Reassembly (continued).....

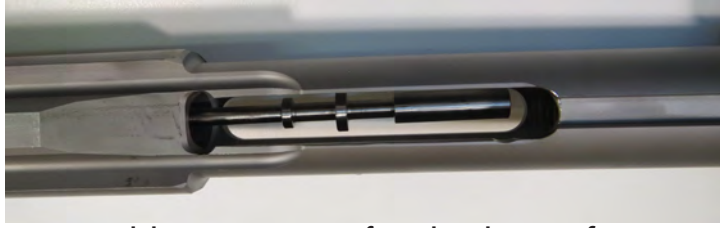
WARNING: If cam pin is missing, DO NOT FIRE THE RIFLE! It will explode!

Note: The bolt is machined so as to allow insertion of the cam pin from one side only. This provision aligns the extractor and ejector properly within the upper receiver.

Drop in and seat the firing pin.

Replace bolt cam pin.

Pull bolt forward.



19

## Reassembly (continued).....

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

Replace firing pin retaining pin.



**CAUTION:** Noreen Firearms LLC does not recommend the practice of swapping bolts between different rifles, to do so could result in damage, personal injury, or death.

20

## Operating Your Rifle.....

**WARNING:** If a noticeable difference in sound or recoil is experienced, STOP FIRING. Either condition could indicate an incomplete powder burn and/or a bullet stuck in the bore. Retract the bolt slowly and remove the fired cartridge case. Clear the weapon and check for unburned powder grains in the receiver or bore, and for a bullet stuck in the bore. Clean out any unburned powder before resuming firing. If a bullet is stuck in the bore, do not attempt to remove it. Take the rifle to a qualified gunsmith.

## Loading Your Rifle.....

**CAUTION:** Always point the muzzle in a safe direction!

1.) With hammer cocked, place selector lever on SAFE.



2.) Open bolt and check chamber. Make sure it is clear.



25

CAUTION: Selector lever should be on SAFE before closing Upper Receiver.



- 1. Push carrier group into receiver together.
- 2. Join Upper and Lower Receivers.
- 3. Engage receiver pivot pin.

### Reassembly (continued).....

**Do Not Use Surplus Ammunition.**

- Use only quality ammunition suitable for your firearm. Examine each cartridge – particularly around the primer.
- Look for dents, scratches, and other signs of damage. Do not load damaged ammunition.
- With the magazine facing forward as shown in the illustration, place a round between the lips of the magazine with the bullet tip forward. Push the round down until it is held by the magazine lips.
- If necessary, give the round a slight push backward to seat it against the back edge of the magazine lips. Place next round on top of previous round and repeat steps until desired number of rounds are loaded.
- CAUTION: If using hand loads, Noreen Firearms LLC is not responsible for damage to rifle or personnel.
- CAUTION: Safe firearms handling dictates that you load live ammunition into your rifle only when you are ready to shoot.
- CAUTION: Make sure your ammunition is clean and undamaged. Forcing dirty or damaged ammunition into the chamber could damage your rifle and could result in injury, death or property damage.

## Reassembly (continued).....

Close the upper and lower receiver groups and push in the takedown pin.



22

## Safety Function Check.....

UNLOAD RIFLE - REMOVE MAGAZINE - CHECK CHAMBER

1.) Remove magazine if installed. Pull charging handle assembly to rear. Check that the chamber is clear. Let bolt and bolt carrier close. **DO NOT PULL TRIGGER.** Leave hammer in cocked position.

**WARNING: If rifle fails any of the following tests, continued use of the rifle could result in injury to, or death of, personnel.**

2.) Place Selector Lever in SAFE position and pull trigger. The hammer should not fall.

3.) Place Selector Lever in FIRE position. Pull trigger. The hammer should fall.

**NOTE: For the purpose of the following check, "SLOW" is defined as one fourth to one half the normal rate of trigger release.**

4.) Hold trigger to the rear, pull charging handle to the rear and release charging handle. Let off pressure on the trigger with a slow, smooth motion, without hesitations or stops, until the trigger is fully forward. An audible click should be heard – the hammer should not fall.

5.) Repeat the FIRE position test five times. The rifle must not malfunction during any of these five tests. If the rifle malfunctions during any of these five tests, have the rifle checked by a qualified gunsmith.

23