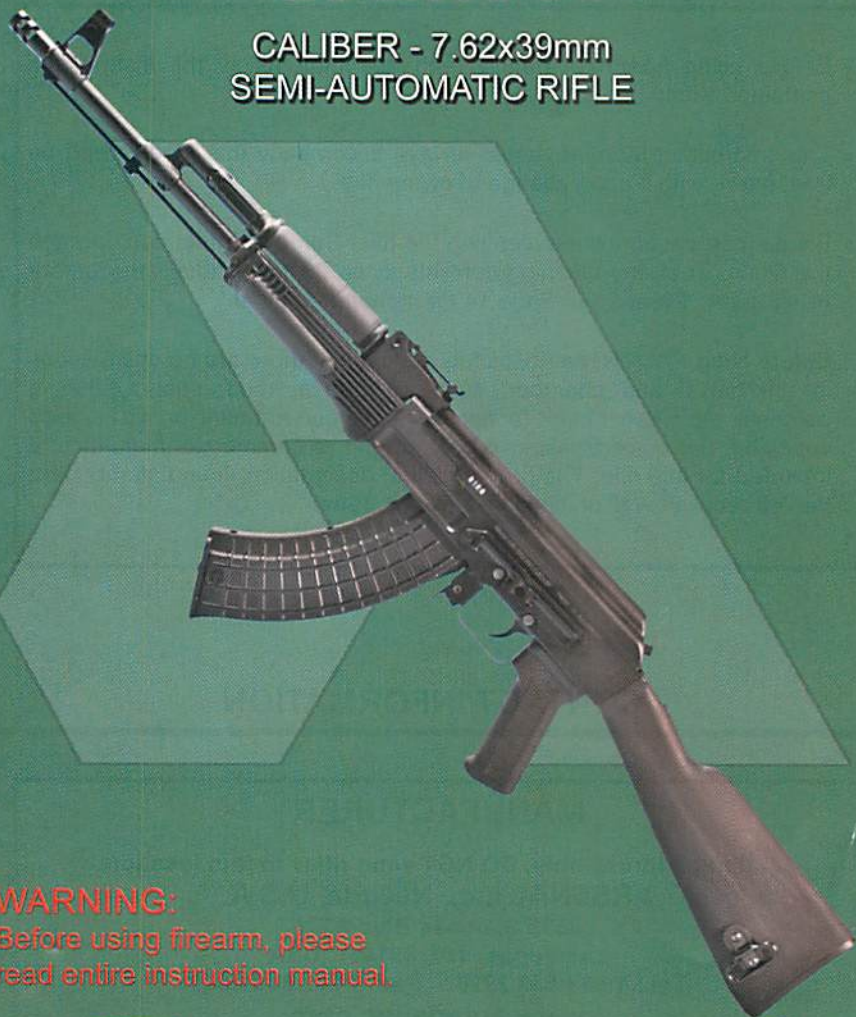


INSTRUCTION MANUAL

SAM7R

CALIBER - 7.62x39mm
SEMI-AUTOMATIC RIFLE



WARNING:

Before using firearm, please
read entire instruction manual.



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arsenal®

1-888-539-2220 LAS VEGAS, NEVADA

*30-rd. magazine shown for illustration purpose only. Rifle shipped with 10-rd. magazine.



IMPORTANT WARNING!

- Before using firearm, carefully read and then follow the instructions contained within this Manual.
- This Instruction Manual should always accompany this firearm and be transferred with it upon change of ownership.
- Please use caution when cleaning the rifle. Some solvents can damage the finish. Test any cleaning solvents in an inconspicuous area before using them. Please see Page 14 for more information.
- Before firing SAM7R, be absolutely certain that there are no obstructions in the barrel and chamber, such as grease, mud, snow, cleaning patches, etc. Also check to ensure that your ammunition is in good condition, the correct caliber and type, and of commercial manufacture intended for this rifle. The proper caliber designation, found stamped on the left receiver wall of this rifle, is 7.62 x 39mm.

CONTACT INFORMATION

MANUFACTURER

Mailing address only, DO NOT send rifles to this location.

ARSENAL Inc. Nevada, U.S.A.

3395 S. Jones Blvd #331

Las Vegas, NV 89146 USA

Tel.: 1 888 539 2220 Fax: 1 702 643 8860

www.arsenalinc.com

BRIEF DESCRIPTION

The SAM7R is a gas operated, magazine fed, air cooled semi-automatic rifle. It operates via the time-proven and reliable direct impingement gas system.



CONGRATULATIONS

Thank you for purchasing the SAM7R and congratulations on acquiring something truly unique and collectable.

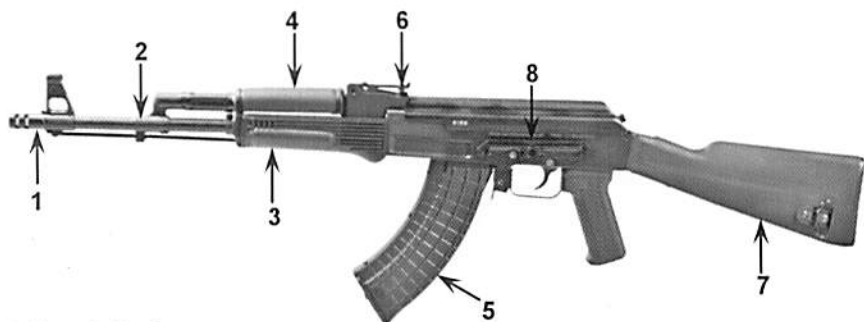
Production of the SAM7R is constructed using select parts with particular attention to fit and finish, ensuring the highest quality product.

Your SAM7R complies with section 922(r) of US code since it contains ten (10) or less foreign made parts, even when a foreign made magazine is installed. The foreign made parts used in your rifle are as follows:

- | | |
|-----------------|----------------------|
| 1. Receiver | 5. Gas Piston |
| 2. Barrel | 6. Trigger |
| 3. Bolt | 7. Muzzle Attachment |
| 4. Bolt Carrier | |

The above list of foreign parts applies only to the rifle that this manual accompanies. Other rifles of the same model type may contain a different number of foreign parts. The addition of foreign made items or the replacement of US made items with foreign made items may constitute a violation of section 922(r). For further information visit <http://www.arsenalinc.com/922r>

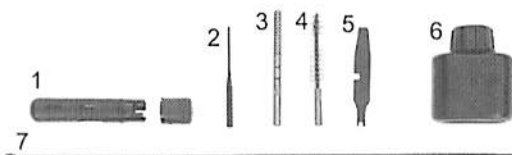
FEATURES



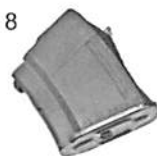
1. Muzzle Brake.
2. Gas cylinder with bayonet lug and Piston.
3. Lower Hand Guard Assembly.
4. Upper Hand Guard Assembly.
5. 30-rd. magazine (Rifle is shipped with 10-rd. magazine).
6. The rear sight adjusts from 100 to 800 meters.
7. Intermediate length buttstock assembly.
8. Scope rail mount

SAM7R ACCESSORIES

1. Accessory Case: Used for storing the jag, brush, and screwdriver. Also it is used as a cleaning rod handle during bore cleaning and lubrication.



2. Drift Pin.
3. Cleaning Jag: Used for cleaning and lubricating the barrel bore.
4. Bore Brush: Used for cleaning the barrel bore.
5. Combination tool: Used as a screwdriver, a front sight adjusting tool, and as an aid to rotate the gas tube lock.
6. Oil Bottle: Used for storing gun lubricants.
7. Cleaning Rod: Used for cleaning and lubricating the barrel bore.
8. 10-rd. Magazine: Holds the rifle's cartridges and feeds them into the receiver.
9. Sling: Used for carrying the rifle. May also be used for support during firing.





SPECIFICATIONS

Caliber	7.62x39
Total Length	927 mm (36.5")
Barrel Length	415 mm (16 1/4 in.)
Twist Rate	1 / 240 mm (9.44 in.)
Weight without Magazine	3.67 Kg (8 lbs.)
Muzzle Velocity	710 m/s (2,329 fps)
Rate of Fire	40 rds/min
Effective Range	400 m (438 yds)
Maximum Range	1350 m (1,480 yds)
Rear Sight Range	800 m (875 yds)

ARSENAL SERVICE POLICY

Prior to shipping, your firearm was thoroughly inspected and test fired in order to ensure that it meets and/or exceeds factory specifications and tolerance standards.

If there are any questions or concerns regarding the performance of your product, please contact our customer service department at 1-888-539-2220. Our customer service department will determine if your product requires factory service and/or repair and will give instructions for the proper return of your product.

Our qualified technicians will give your product a complete and thorough inspection to evaluate and determine the extent of the problem(s).

All products must be shipped to us prepaid. We will not under any circumstances accept collect shipments.

All shipments must be authorized by a factory customer representative and assigned an RMA Number. The RMA Number must be visible on the outside of the package and included in the note accompanying the package. Do NOT ship rifles without first obtaining an RMA Number first by calling 888-539-2220. No shipment without an RMA number will be accepted. All such shipments will be rejected and returned to the sender.



ARSENAL LIMITED WARRANTY

This warranty covers any service, repair and/or replacement of any product manufactured or imported by Arsenal Inc. This ensures that all Arsenal Inc. products are fully functional and free from manufacturing defects, according to factory standards.

The duration of this warranty covers any Arsenal Inc. product for, but not limited to, one year from the original purchase of the product.

This warranty does not cover, but not limited to, damage caused by failure to provide proper care and maintenance, abuse and/or misuse, improper ammunition and/or magazine, unauthorized adjustments, repairs, or modifications, normal wear, or cosmetic defects after one year from original purchase.

Failure to provide proper care and maintenance, abuse and/or misuse, improper ammunition and/or magazine, unauthorized adjustments, repairs, or modification, any replacement of factory installed component with any non-factory proved component will automatically void this warranty.

If you have any questions or would like to inquire about service, please contact:

Mailing address only, DO NOT send rifles to this location.

**ARSENAL INC. NEVADA, U.S.A.
3395 S. Jones Blvd #331
Las Vegas, NV 89146 USA
Tel.: 888-539-2220 Fax: 702-643-8860**

Note:

The SAM7R series rifles are manufactured in Bulgaria at a factory that produces weapons to an international military specification. They are guaranteed to function with accuracy and reliability. All components are installed according to factory guidelines for fit and function. Consequently, barrel and receiver elements on some rifles may not seem to be aligned. This is a normal appearance for rifles of this type. These cosmetic issues rarely affect accuracy or function.

For example, the front sight post may not appear centered between its protective ears after the rifle has been zeroed; the warranty would not cover this situation. However the warranty would cover the case in which insufficient adjustability of the sight prevents a rifle from being zeroed, for instance.

GENERAL SAFETY

1. Always treat the SAM7R as if it were loaded.
2. Never point the SAM7R at anything you are not prepared to shoot.
3. Never put your finger inside the trigger guard until you are ready to fire.
4. When shooting, know what is behind your target.
5. Always empty the SAM7R before carrying it into a house or vehicle.
6. Never climb a tree or fence with a loaded gun.
7. Never horseplay with the SAM7R . Your SAM7R can't think, but you can. SAM7R safety depends upon you.
8. Always load and unload the SAM7R with the muzzle pointed at the ground.
9. Never rest the SAM7R against a tree, fence, or wall.
10. Never leave the SAM7R unattended. Never leave the SAM7R where it could fall and accidentally discharge.
11. Never assume that the SAM7R is unloaded.
12. Never accept the SAM7R without checking to ensure that it is unloaded.
13. Never take the SAM7R out of a vehicle by pulling it towards you by the muzzle.
14. Use only standard loads from reputable manufacturers.
15. Always load your SAM7R only when on the range or in the field and ready to fire. When you stop shooting, unload before leaving the field or range.
16. Store the SAM7R and ammunition separately and out of the reach of children.
17. Never shoot at flat hard surfaces or at the surface of water.
18. Never put your hand over the muzzle of the SAM7R.
19. Never squeeze the trigger unless shooting at a target or unless you have checked to ensure the firearm is unloaded and it is pointed in a safe direction.
20. Should the SAM7R fail to discharge after squeezing the trigger, keep it pointed in a safe direction and wait at least 60 seconds. Sometimes a slow burning primer will not ignite promptly and cause a hang fire.
21. Before using the SAM7R obtain instruction from a competent firearms instructor.
22. Always check your ammunition to verify that it matches your SAM7R.
23. Never take alcohol, drugs, or medication before or during shooting activities.
24. Improper alterations to the trigger pull can cause an accidental discharge.
25. Reloaded cartridges can be dangerous to yourself and your SAM7R.
26. Spectators should always be at least 10 feet behind and not in line with the breech of any SAM7R when you are shooting.
27. Never rely on a firearm's safety to compensate for unsafe gun handling. A safety is only a mechanical device. It is not a substitute for common sense.

PROPER OPERATION OF SAM7R

IMPORTANT: Before using your rifle ensure that the barrel and chamber are dry and free of any grease or fouling. Always keep your rifle pointed in a safe direction.

The SAM7R is equipped with a manual safety located on the right side of the rifle's receiver. When placed in the upper "SAFE" position a letter "S" on the receiver is visible just forward of the tip of the safety lever (fig. 1). In the "SAFE" position the trigger cannot release the hammer to fire the rifle.



Figure 1

In addition to preventing the rifle from being fired, it serves two other functions:

1. It prevents foreign matter and debris from entering the rifle's action through the bolt handle slot.
2. It prevents the bolt from being pulled far enough to the rear to load a cartridge from the magazine.

To set the rifle to the "FIRE" position the safety must be pushed downward until it clicks to a stop. In this position a letter "F" will be visible forward of the safety lever (fig. 2). Squeezing the trigger will fire a loaded rifle in this position.



Figure 2



LOADING YOUR SAM7R

Place the SAM7R on "SAFE". Remove the detachable magazine from the rifle by pushing forward on the magazine release and rocking the magazine forward and down. Load the magazine by pressing individual cartridges under the feed lips and pushing them back against the rear wall of the magazine. When the magazine is fully loaded insert the front of the magazine into the rifle's magazine well and rock the magazine up and back until it locks firmly in place. Point the rifle in a safe direction and move the safety to the "FIRE" position. Pull the bolt all the way to the rear and release it. The rifle is now loaded and ready to fire. If the rifle is not going to be fired immediately place the safety back to the "SAFE" position.

CAUTION: Unless you are actually firing, or plan to do so immediately, the safety should be kept in the "SAFE" position, regardless of whether the rifle is loaded or unloaded!

UNLOADING YOUR SAM7R

With the SAM7R pointed in a safe direction and the safety in the "SAFE" position remove the magazine. Hold the rifle by the handguard. With the other hand place the weapon on "FIRE", pull the bolt all the way to the rear and hold it in this position. This will extract and eject the cartridge in the chamber. While holding the bolt to the rear visually inspect both the chamber and bolt face to ensure no cartridges remain in the rifle. Once you have verified the rifle is empty, allow the bolt to go forward. Place the safety in the "SAFE" position.

To unload the magazine, place your thumb on the base of the top cartridge and push it forward until it is released by the feed lips. Remove all remaining cartridges in this manner.

FIRING YOUR SAM7R

With the SAM7R loaded and on "SAFE" point the rifle at your target. Place the safety in the "FIRE" position. The rifle is now ready to fire. Aim at your target and press the trigger. The rifle will fire and automatically eject the spent cartridge case and load a fresh cartridge. To fire the next shot simply release the trigger and press it again. The rifle will continue to fire in this manner as long as there is ammunition in the magazine. When the rifle is empty pull the bolt back and visually inspect the rifle's chamber and magazine to ensure there is no remaining ammunition. Place the safety to the "SAFE" position. The magazine may now be removed for reloading, or replaced with another loaded magazine.



ZEROING YOUR SAM7R

The sights on your SAM7R have been zeroed at the factory for a distance of 100 meters using a proprietary laser bore sighting fixture. We strongly recommend that you first fire the rifle to determine if any sight adjustments are necessary. Should you desire to fine-tune the sight adjustment, use the following procedure:

1. Set up a suitably large target 100 meters from the firing line. The rear sight should be set to "1."

2. From a supported position, fire 5 carefully aimed shots at the center of the target.

3. Unload the rifle and place the safety lever to "S" (safe). Inspect the target. If the center of the group corresponds to the center of the target, the rifle is zeroed.

4. If the point of impact is above the aiming point, turn the front sight upward to correct the point of impact.

5. If the point of impact is below the aiming point, turn the front sight downward to correct the point of impact.

A full turn of the front sight moves it 0.8mm (1/32"). For the SAM7R, moving the front sight 0.8mm (1/32 inch) will move the point of impact 210mm (8.25 inches) at 100 meters (328 feet). Or, one inch (25.4mm) on the 100m target equals .004" (0.1mm) at the front sight.

It is not recommended that you attempt to alter the factory zero left or right. The windage slide in the front sight fits very tightly and requires a special tool to adjust. If adjustment is necessary, consult a qualified gunsmith and use this procedure:

6. If the point of impact is to the left of the aiming point, move the front sight to the left to correct the point of impact.

7. If the point of impact is to the right of the aiming point, move the front sight to the right to correct the point of impact.

Once you are satisfied with your zero, further adjustments to the front sight should not be necessary. However the rear sight is selectable for range, and can be set for targets up to 800 meters. The lowest setting (marked with a letter) is equivalent to 300 meters.

DISASSEMBLING YOUR SAM7R

CAUTION: Before attempting to disassemble the rifle verify that it is unloaded and the safety is in the "SAFE" position.

REMOVING THE MAGAZINE FROM YOUR SAM7R

Holding the rifle by the stock turn it so that the magazine will be facing you. Hold the magazine in your other hand, and pressing the magazine lock with the thumb of the same hand tilt the magazine forward and remove it from the receiver opening.



Figure 3

SAFETY LOCK RELEASE

With the thumb of the right hand, push the selector lever downwards to the limit position of "FIRE".

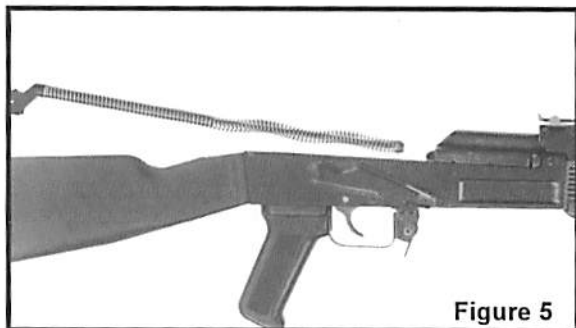
REMOVING THE RECEIVER COVER

To remove the receiver cover hold the rifle's butt stock firmly in one hand. Then with the thumb of the other hand push forward on the end of the recoil guide and lift the receiver cover upward and back from the receiver (Fig. 4).



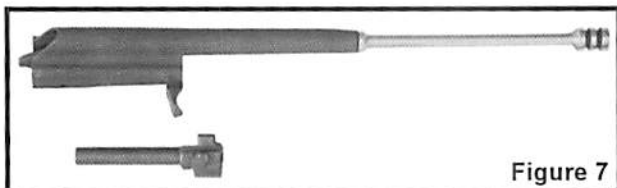
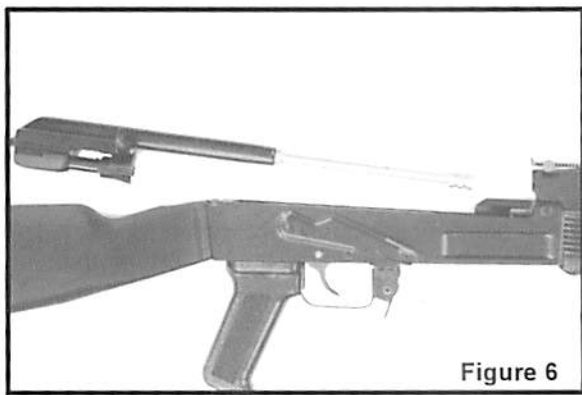
REMOVING THE RECOIL GUIDE

With the receiver cover off, grip the end of the recoil guide and spring unit, then push it forward until it clears its slot in the receiver. Lift it up slightly and pull it straight back out of the bolt carrier (Fig. 5).



REMOVING THE BOLT CARRIER ASSEMBLY

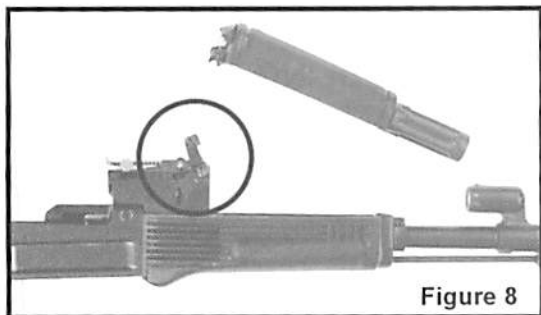
Ensure that the safety is in the "FIRE" position. Grasp the bolt handle and pull it back to the full rear of its travel. Lift the bolt carrier assembly up from the receiver and draw it to the rear and out of the gas tube/hand guard assembly (Fig. 6).



REMOVING THE GAS TUBE/HAND GUARD ASSEMBLY

Using the proper slot in the combination tool/accessory box rotate the gas tube take down lever clockwise to the position shown. Then lift up on the rear of the hand guard and pull it back and off the rifle (Fig. 8).

This completes what is commonly known as field stripping. No further disassembly is recommended except by a qualified gunsmith.





CLEANING YOUR SAM7R

Field strip the rifle. using a suitable cleaning rod and brush, saturate the brush with CLP and run the brush from the muzzle end through the length of the bore and out the chamber end. Repeat this several times. Then follow this same procedure but substitute CLP soaked cleaning patches for the brush. When the bore and chamber are clean, run dry cloth patches through to remove the CLP film.

If you do not intend to fire the rifle soon, run a patch with a small amount of CLP through the bore to preserve it from rusting.

The stripped action parts should be wiped clean of any residue from firing with CLP and then dried. These parts should then receive a light film of CLP to protect and lubricate them. However, the gas piston and tube should NOT be applied with CLP. Instead just clean and dry. Before firing ensure that the bore is clean.

All exterior metal surfaces should be periodically wiped clean and lightly applied with CLP.

WARNING: Modern gun cleaning solvents can be very aggressive. Before use, test solvents on a small portion of each part to check for possible damage to the finish of all the various metal and plastic parts. Keep in mind that more than one type of finish may exist on metal parts. Any damages caused by such aggressive solvents will not be covered under warranty.

IMPORTANT INFORMATION: The paint finish on your rifle is identical to the finish applied on military rifles. Arsenal, Inc. highly recommends using cleaning products approved by the military for such finishes. Your rifle has been effectively tested with a Mil Specification product Break-Free® CLP (Clean, Lubricate, Protect). This product is known to be harmless to your rifle's finish while being an effective cleaner and lubricant. Break-Free® CLP is available commercially and is the only product tested and recommended for use by Arsenal, Inc. Any damages caused by other solvents will not be covered under standard warranty.

REASSEMBLING YOUR SAM7R

To reassemble the rifle reverse the disassembly steps. To ensure this is trouble free it is recommended that you pay close attention to the exact location and position of all parts during disassembly.

K-VAR HAS PARTS FOR YOUR SAM7R

	AK-601	Bulgarian barrel for 7.62x39mm caliber Pre-Ban. This barrel has been imported before the barrel ban and can be legally used for assembling a new non-importable rifle.
	AK-332	Bulgarian 7.62x39 23mm diameter brand new barrel.
	AK-016B	Brand new Bulgarian slant cut compensator for 7.62x39mm caliber rifles with 14x1mm left hand threads.
	AK-058BWS	Bulgarian 7.62x39mm caliber bolt head assembly. This is a complete assembly with spring loaded firing pin.
	AK-133BU	Bulgarian flash hider with 24x1.5 right hand thread. Will work on 5.45x39.5mm, 5.56x45mm & 7.62x39mm caliber rifles.
	AK-046B	Bulgarian bolt carrier assembly with gas piston. This is a semi-automatic carrier for 7.62x39mm and 5.56x45mm caliber rifles.
	KR-004B	Military issue Bulgarian magazine pouch.

ORDER PARTS ONLINE AT WWW.K-VAR.COM



K-VAR

K-Var Corporation Tel.: 1 702 364 8880

Top Quality Parts and Accessories for your 7.62 caliber rifle



AK-403USP

U.S. made PLUM color upper and lower hand guards for stamped receivers with new design U.S. made PLUM color matte pistol grip, and stainless steel heat shield. The whole set counts as 2 U.S. made parts for sec. 922r compliance.



AK-403GUS

U.S. made OD Green color upper and lower hand guards for stamped receivers with new design U.S. made OD Green color matte pistol grip, and stainless steel heat shield. The whole set counts as 2 U.S. made parts for sec. 922r compliance.



K-VARAK1

MAINTENANCE KIT - For 7.62x39mm caliber.
A must have springs collection for all collectors and shooters!
Will only work with SLR-95, and SA-93 type rifles.
Includes: a Recoil spring, Trigger/hammer spring, Disconnector spring, Firing pin, Extractor, and Extractor spring.

M-47US10

Arsenal Inc.,
10-round 100% U.S. made magazine for 7.62x39. For the first time ever, a U.S. made magazine with a steel lug insert. The steel lug allows for a precision fit and longevity. It will not wear over time do to rubbing against the mag. catch. (also available in plum, M-47US10P)



Shown with SGL25 SERIES rifle with AK-405USPR (Durable aluminum Upper and Lower handguards set with Picatinny Rails) and M-47US10 when you need to be Low profile and compact AK magazine!

*optional accessories shown if applicable, are available for purchase at www.K-VAR.com

AK-331

CLEANING ROD

for 7.62x39mm caliber, Bulgarian made.



KV-04S

KV-04S optimized AK Scope Mount
New and improved Scope Mount with Picatinny rail for AK Variants



AA1401

Made to fit the front sight post of weapons of the Kalashnikov design. This precision tool is divided into 32 micrometer numbers and is strategically marked for better visibility and adjustment. It comes complete with a step-by-step operator's manual.

M-47W402US

7.62 x 39MM Waffle Magazine, AK-47, 40 rd. Original Bulgarian Black Polymer Body with a U.S. Made Floor Plate and U.S. made Follower. Brand New!



Visit our website at www.K-VAR.com for more parts & accessories!