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SAFETY, INSTRUCTION and PARTS MANUAL

**SUB-2000™**

 Warning: Read this manual carefully before loading or using the SUB-2000™.







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## A. SAFETY INFORMATION AND WARNINGS


Read this manual and the warnings contained in it before loading or using the SUB-2000™. This manual explains the function and the handling of the SUB-2000™ and warns of the potential dangers, including death or serious personal injury, that can result from the unsafe use of the SUB-2000™. This manual should always accompany the SUB-2000™ and be transferred with it if it is sold or loaned to another person.


Even if you are an experienced shooter, you must READ THIS ENTIRE MANUAL CAREFULLY before loading or firing the SUB-2000™. This manual gives basic instructions on the proper handling and functioning of the SUB-2000™. Your safety and the safety of others depends on you following the instructions and warnings in this manual and the constant use of safe firearms practices. If you are unfamiliar with firearms, take a course in the safe handling of firearms run by a qualified firearms instructor, your local gun club, or a similar qualified organization.


This manual contains several safety warnings and instructions preceded with , , or . These signal words are designed to draw your attention to important safety information.  indicates a hazardous situation which, if not avoided, could result in death or serious injury.  indicates a hazardous situation, which, if not avoided, could result in minor or moderate injury.  addresses safety practices not related to personal injury.


 Firearms can cause death or serious personal injury. Safety must be the prime consideration of anyone who handles firearms.


 The SUB-2000™ is designed to function reliably with proper care and knowledgeable use. Do not use your SUB-2000™ unless you fully understand how to safely operate it.


 Only safe firearm handling habits will ensure the safe use of your firearm. This is your responsibility. Accidents are the result of violating the rules of safe firearms handling noted below and common sense.

 Always seek a doctor's advice if you are taking medication to be sure that you are able to shoot and handle a firearm safely. Never drink alcoholic beverages or take drugs before or while shooting. Your vision and judgment could be seriously impaired, making your firearm handling unsafe.

 Always treat a firearm as though it were loaded.

 Always keep the muzzle pointed in a safe direction. Never point a firearm at anyone or anything you do not intend to shoot.

 Always keep your finger off the trigger and outside the trigger guard until you have made the decision to fire.

 Never accept or pick up a firearm without checking the magazine and the chamber to make sure that it is unloaded.

**⚠ WARNING** Do not trust the extractor to remove the cartridge from the chamber. Always check to confirm that it is empty.

**⚠ WARNING** Always make sure the SUB-2000™ is unloaded, on SAFE and the action is open before handing it to another person.

**⚠ WARNING** Never allow a firearm to be used by individuals who are not familiar with its safe operation and rules of firearm safety.

**⚠ WARNING** Never alter or modify the SUB-2000™ because this could cause it to malfunction and create a dangerous condition.

**⚠ WARNING** Be sure all accessories are compatible with the firearm. Be sure all accessories are properly installed on the firearm and that the accessories do not interfere with safe operation of the firearm. Follow the instructions provide by the accessory manufacturer to the extent those instructions are not inconsistent with the warnings and instructions contained in this manual.

**⚠ WARNING** If the SUB-2000™ is dropped or forcefully struck, it could be damaged and may not function properly. Have it inspected by Kel-Tec CNC Industries, Inc. before continuing to use it.

**⚠ WARNING** Never load a firearm except immediately before shooting. When transporting your firearm, be sure your firearm is unloaded, on SAFE and the action is open.

**⚠ WARNING** Never store or transport firearms and ammunition together, keep them locked up and away from children or other unauthorized persons.

**⚠ WARNING** Always secure firearms from children. You are responsible for the firearm's safety and security.

**⚠ CAUTION** Most ammunition contains lead in the projectile and/or primer. Discharging firearms in poorly ventilated areas, cleaning firearms, or handling ammunition may result in exposure to lead and other substances known to cause birth defects, reproductive harm, and other serious physical injury. Have adequate ventilation at all times. Wash hands thoroughly after exposure.

Before it left the factory, the SUB-2000™ was tested, carefully inspected, and packaged. Kel-Tec CNC Industries, Inc. cannot control what happens to the SUB-2000™ after it leaves the factory, therefore, carefully examine the SUB-2000™ when you acquire it to ensure that it is unloaded and undamaged. If you do not understand any of the warnings and instructions in this manual, have any problems operating the SUB-2000™, or need another copy of this manual, contact Kel-Tec CNC Industries, Inc. at:

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The current version of the instruction manual can also be downloaded at:

[www.keltecweapons.com/resources/downloads](http://www.keltecweapons.com/resources/downloads)



## B. OVERVIEW

### Description

This manual is for the second generation SUB-2000™ weapon (serial number on receiver tube). If you have a first generation weapon (serial number on the left grip), this manual will not apply. A copy of the first generation manual is available free of charge by contacting Kel-Tec CNC Industries, Inc. (address and phone number on page #4).

The SUB-2000™ is a semi-automatic rifle chambered for the 9mm Luger or the .40 cal. S&W cartridge. Different versions of the SUB-2000™ rifle will accept most double column handgun magazines, e.g. S&W, Glock or Beretta. By rotating the barrel upwards and back, the SUB-2000™ rifle can instantly be reduced to a size of 16.25 x 7 inches for ease of storage.

The SUB-2000™ is appropriately classified as a "sub-rifle" because of its small size, light weight, and the use of a pistol cartridge. The SUB-2000™ rifle is intended as a compliment to the handgun with which it would have full interchangeability in ammunition and magazines.

### Nomenclature

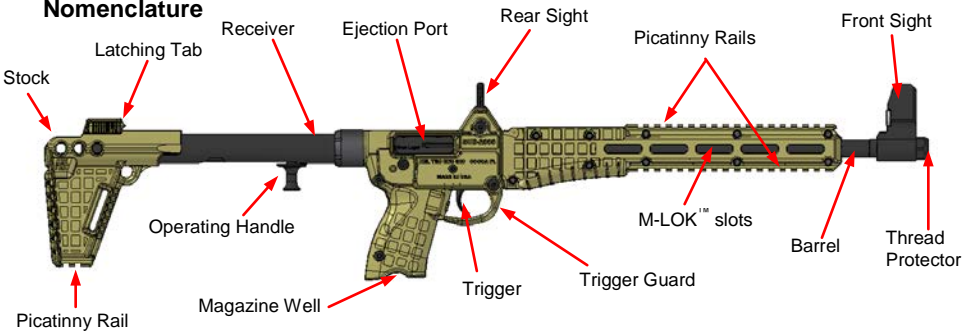


Figure B-1: Side View of SUB-2000™

The barrel has a spring loaded collar to ensure an accurate lock to the grip, a polymer forend and a fully adjustable front sight.

Two integrated Picatinny rails come standard on the SUB-2000™ forend for mounting compatible accessories. The forend also includes five mounting slots per side, configured for various M-LOK™ accessories. Always ensure accessories are compatible with this weapon, are secured to the weapon properly and do not cause any interference with the weapon or its function.

The grip is made of an impact modified glass reinforced Zytel. The front end houses a hinge block holding the barrel and rear sight. This block is securely locked in place by a rotating trigger guard. The grip rigidly attaches to the receiver by multiple lugs. The bottom forms the grip and also accepts specific magazines according to the version specified. The grip also houses the firing mechanism.

The tubular steel receiver contains the bolt assembly and is ended by the polymer stock.

The stock can be adjusted to three different positions for shooter's comfort. Each position adds approximately 5/8 of an inch to the overall length of the weapon, with a total extension of 1.25 inches in the further rearward position. The stock includes a single point sling loop attachment, a slot for adding a nylon sling loop (1.25" wide is ideal), and a Picatinny rail on

the bottom for adding small accessories. The stock can be adjusted by following field stripping instructions on pages 17-21.

The heavy two-piece machined steel bolt holds the firing pin, the extractor, and has the operating handle attached on the bottom. A captive recoil spring with buffer actuates the bolt.

The firing mechanism is a conventional single action type. It has a positive disconnecter and a push-bolt safety. The hardened steel ejector is internal.

Design Features	
Operating System	Blowback
Caliber	9mm Luger or .40 cal. S&W
Capacity	Varies by magazine and caliber
Barrel Length (Standard / Export)	16.25" (412.5 mm) / 18.52" (470.5 mm)
Barrel Twist Rate (9mm / .40 cal)	1:10 / 1:16
Barrel Threads (9mm / .40 cal)	1/2"-28 or 9/16"-24
Trigger Pull	9 - 10 lbs (~ 4 kg)
Accessory Mount (Top / Bottom)	Picatinny Rail (Forend / Stock)
Accessory Mount (Sides)	M-LOK™ (Forend)

Dimensions and Weight	
Length (Extended / Stock Collapsed)	30.5" (775 mm) / 29.25" (743 mm)
Folded length (Storage Mode)	16.25" (412.5 mm) by 7" (178 mm)
Length of Pull (Stock to Trigger)	14.5" (368 mm) / 13.25" (337 mm)
Max Width (at Grip)	1.25" (32 mm)
Max Height	7" (178 mm)
Weight (Unloaded, No Magazine)	4.25 lbs (1.9kg)

## C. OPERATION INSTRUCTIONS

### Safety

The SUB-2000™ features a push-bolt safety located behind the trigger on the grip assembly. The hammer must be cocked for the safety to engage. When the safety is engaged, the push-bolt safety blocks the sear from releasing and disengages the trigger bar.

For right-handed users, the safety is generally pressed with the right thumb until a noticeable “click” is heard and the red o-ring is visible on the safety, as seen in the following examples.

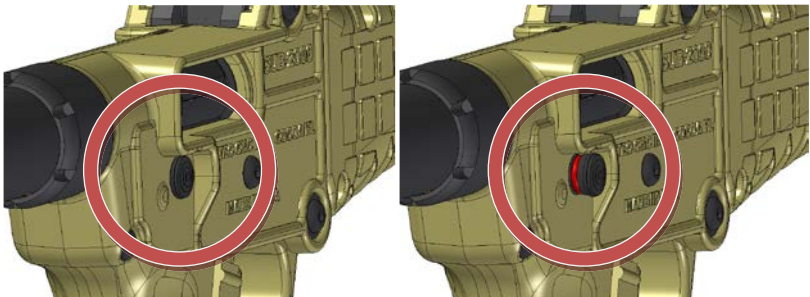


Figure C-1: Pressed to the left, SAFE Configuration; Pressed to right, Red for FIRE

**WARNING** Never totally rely on a mechanical safety as it can fail or become unintentionally disengaged. A mechanical safety is not a substitute for safe firearm handling practices.

### Storage Mode (Folding and unfolding Barrel Assembly)

The SUB-2000™ is designed to reduce its overall size down to 16.25 X 7 inches for ease of storage. This is accomplished by doing the following:

Ensure the weapon is unloaded (no magazine or ammunition in the weapon). Remove any accessories on the top Picatinny rail of the forend. Place weapon in SAFE configuration. Rotate the trigger guard on the weapon down, away from the trigger (1). Upon doing so, the barrel assembly is free to rotate around the rear sight axis (2).

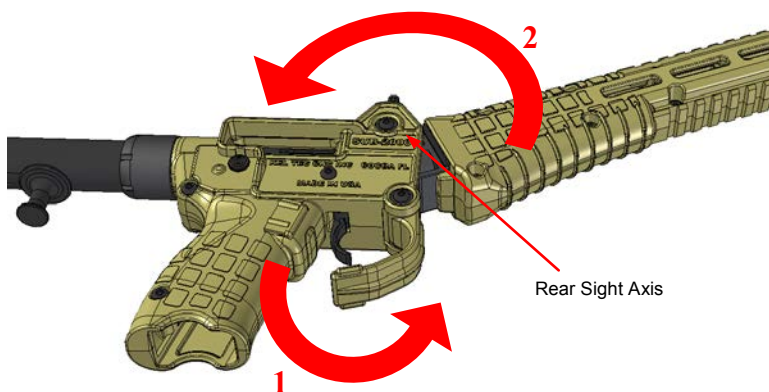


Figure C-2: Folding the Barrel Assembly

Rotate the barrel assembly until it latches into the latching tab in the buffer assembly.

**NOTICE** The latching tab is designed to assist the barrel assembly in remaining closed in storage mode for transportation; the latching tab is **NOT** designed as a lock or safety for this weapon.

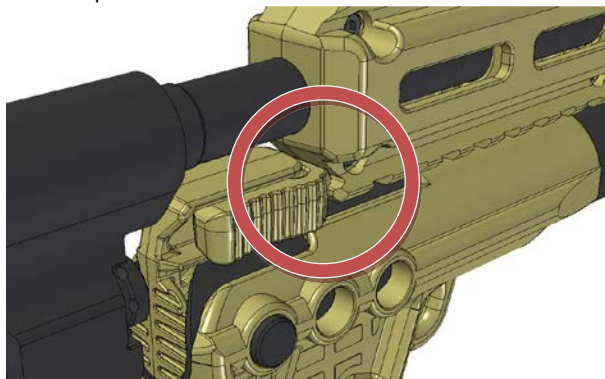


Figure C-3: Latching Tab detenting into Forend



To open the weapon from storage mode, press the latching tab rearward (away from the grip), to release the barrel assembly (1). The barrel assembly is now free to rotate to the chambering position (2).

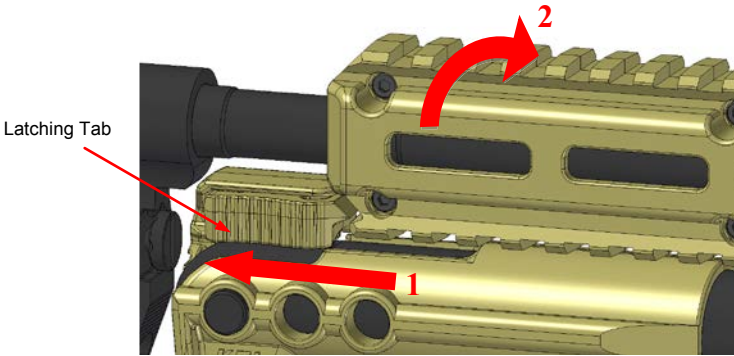


Figure C-4: Unfolding the Barrel Assembly

Upon rotating the barrel assembly down, ensure the barrel assembly positively engages into the trigger guard; there may be an auditory "snap" of the trigger guard re-engaging the barrel assembly.

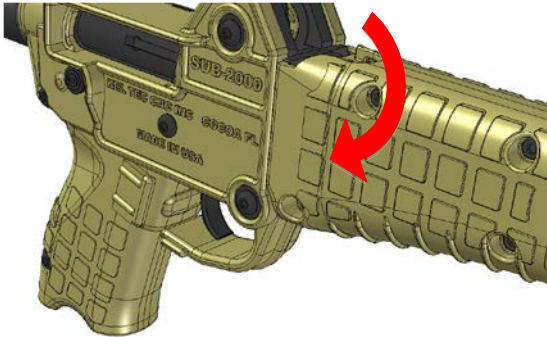


Figure C-5: Re-engage the Barrel Assembly into the Trigger Guard

### Loading the Magazine(s)

To load the magazine, fill the magazine by pressing a cartridge downward on the forward portion of the magazine, then slide the cartridge back.

Repeat the steps above for the number of cartridges you wish to load, up to the magazine capacity. Do not attempt to load your magazine with more than the specified number of rounds because doing so can cause a feeding malfunction.

### Chambering a round

Hold the rifle in one hand with the muzzle pointing in a safe direction and with your finger off the trigger and outside the trigger guard. Insert the loaded magazine into the grip until it is locked in place. Check to ensure that the magazine is secure. With your free hand, securely grab the operating handle and fully cycle the bolt back (away from the muzzle) and release. If the bolt is already locked back, pull the operating handle back a short distance, rotate it from the machined slot and allow the bolt to carry fully forward. This strips a round from the magazine and seats it in the barrel chamber.

If you wish to restore the magazine in your rifle to full capacity, press the magazine catch and remove the magazine to load the missing round.

**▲WARNING** Never load rounds directly into the chamber. Remember to keep your rifle pointed in a safe direction under all conditions and always keep your finger off the trigger and outside the trigger guard until ready to fire.

## Firing

With the muzzle pointed in a safe direction and your finger outside the trigger guard, take aim at a safe target, disengage the safety and squeeze the trigger until the round is fired. Release the trigger and you are ready to fire another round. Upon firing, the bolt moves rearward, extracting and ejecting the fired round and returns forward, feeding another round into the chamber automatically. This sequence can be repeated until the last round has been fired. The SUB-2000™ has no automatic bolt stop, but the bolt can be locked in the back position by rotating the operating handle in the machined slot.

## Unloading

To unload the SUB-2000™, press in the magazine catch, remove the magazine and briskly pull the bolt back to extract the round from the chamber. Do not obstruct the ejection port and keep fingers away from the trigger and muzzle. Lock the bolt in the back position and visually inspect the chamber to make sure it is empty. To unload the magazine, push the remaining cartridges in the magazine forward and out.

**▲WARNING** Before firing the SUB-2000™, run a clean patch through the barrel, from the chamber end, using a cleaning rod. Repeat this procedure until the patch comes out of the barrel with no gun oil or cleaner-lubricant-preservative on it because any obstruction in the barrel could prevent the SUB-2000™ from firing properly and result in death or serious personal injury and/or damage to the SUB-2000™.

**▲WARNING** Ensure the barrel is free of obstructions prior to firing. Open the action and clear the firearm of all ammunition before checking the barrel of the unloaded firearm. Any obstruction in the barrel could prevent the SUB-2000™ from firing properly and result in death or serious personal injury and/or damage to the firearm.

**▲WARNING** In case of a failure to fire, continue to hold the SUB-2000™ pointed towards the target for at least 30 seconds. If a hangfire (slow ignition) has occurred, the bullet should fire within approximately 30 seconds. If the bullet has not fired, cycle the operating handle to its rearmost position and remove the unfired shell from the chamber while keeping the SUB-2000™ pointed in a safe direction and engage the safety. (Note: Dispose of misfired shells in accordance with the ammunition manufacturer's instructions).

**▲WARNING** Never use the SUB-2000™ if it fails to function properly, and never force the bolt forward on a jammed casing because it could cause the casing to explode or damage the SUB-2000™.

**▲WARNING** Never pull the trigger if the bolt does not fully close to prevent a possible out of battery firing. If this happens, unload the SUB-2000™ as described in this manual, examine the casing that was in the chamber, and check the chamber to ensure that there are no obstructions or debris in it.

**⚠ WARNING** Never discharge a firearm without proper shooting glasses and ear protection.

**⚠ WARNING** Never shoot until you are sure of your backstop and what lies beyond it.

**⚠ WARNING** Never shoot at a hard surface, such as a rock, or a liquid surface, such as water, because a bullet may ricochet and travel in any direction, striking you or someone else.

**⚠ WARNING** When firing on a target range, be alert and follow the range officer's commands. Always be aware of other people so that they cannot accidentally walk into the line of fire. Make sure your "audience" is always 5 feet in back of you, not next to you, when firing.

**⚠ WARNING** Always carry the SUB-2000™ unloaded with the action open while on a range until preparing to fire. Always keep the SUB-2000™ pointed towards the backstop when loading, firing, and unloading it.

**⚠ WARNING** After firing several rounds, the exterior metal parts of the SUB-2000™ get very hot and can cause severe burns if touched.

## Sight Adjustment

**WARNING** Always ensure the SUB-2000™ is unloaded and in SAFE configuration when adjusting the sight.

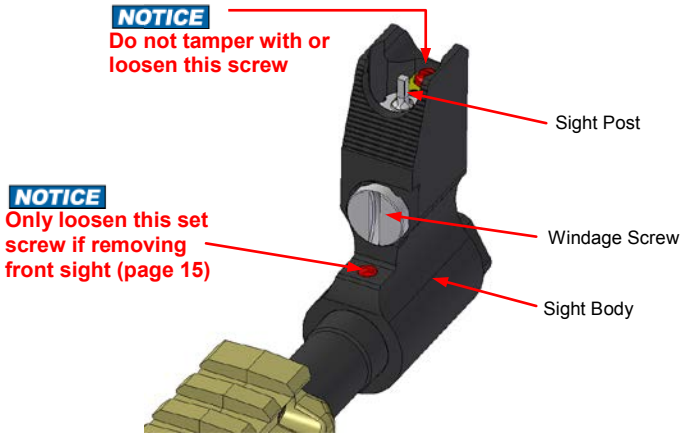
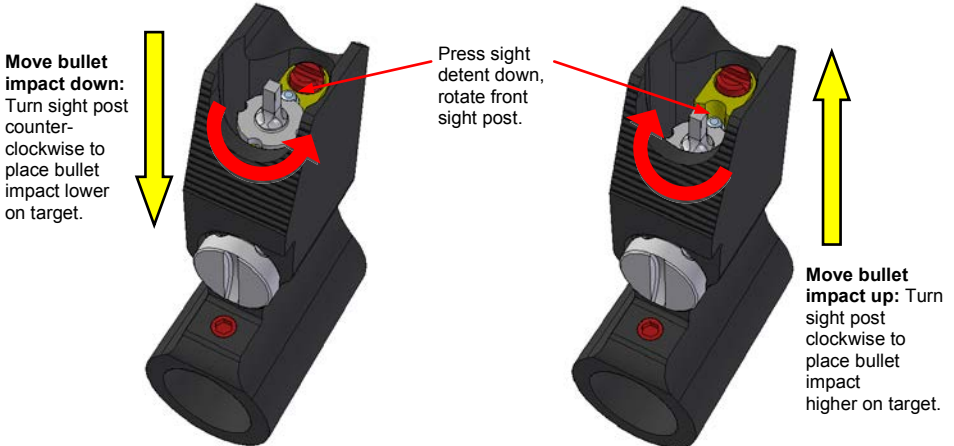


Figure C-6: Example of Front Sight

The SUB-2000™ is equipped with a front sight which controls both the windage and elevation of the sight alignment. The two (2) red colored screws in the following pictures are **NOT** used in the adjustment of the front sight;



The elevation adjustment on the front sight is very similar to a standard AR-15 style front sight post with four detents, or "clicks", per full turn. Each "click" is approximately 1" of bullet movement at 100 yards. The elevation is controlled by pressing the sight detent down and rotating the front sight post, either clockwise or counter-clockwise. This can be accomplished with a small hex key or with a sight adjustment tool (not included).



# Kel-Tec® SUB-2000™

\* PARTS #410L, #410R, #205 ARE MODEL SPECIFIC FOR REPLACEMENT

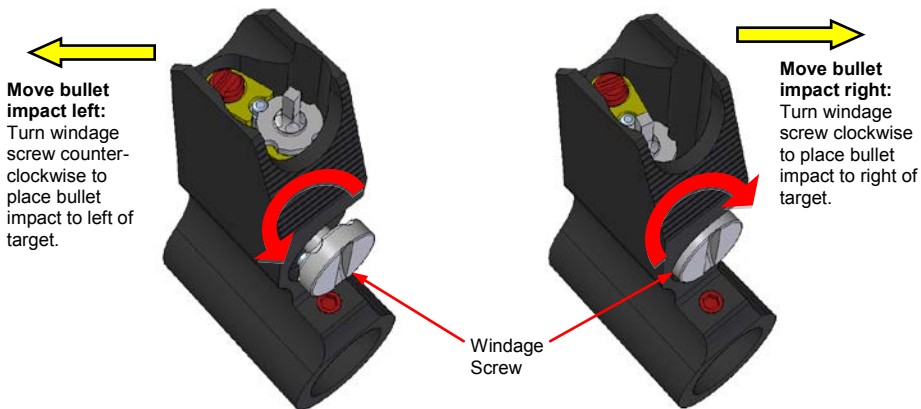
\*\* PARTS #100-9, #100-40, #151-9, #151-40, #503-9, #503-40 ARE CALIBER SPECIFIC FOR REPLACEMENT

\*\*\* PART #310 IS CALIBER AND MODEL SPECIFIC FOR REPLACEMENT



100-40	BARREL (.40 CAL S&W)	174	FIRING PIN PIN	246	RECEIVER (EXCHANGE ONLY)	272	SEAR SPRING	503-9	THREAD PROTECTOR (9MM)
100-9	BARREL (9MM)	180	EXTRACTOR	247	UPPER FEEDRAMP	273	HAMMER BUSHING	504	FOREND LEFT
102	HINGE	182	EXTRACTOR SPRING	248	EJECTOR	275	HAMMER SPRING	505	FOREND RIGHT
103	LOCKNUT	184	EXTRACTOR PIN	250	TRIGGER GUARD SPRING	276	HAMMER AXIS	511	RECEIVER GRIP SCREW
105	WASHER	190	RECOIL SPRING	251	TRIGGER GUARD	309	LOCK SPRING	512	RECEIVER GRIP PIN LONG
121	FEEDRAMP	191	RECOIL SPRING LUG	252	TRIGGER	315	E-CLIP	513	RECEIVER GRIP PIN SHORT
144	OPERATING HANDLE	192	RECOIL SPRING GUIDE	254	TRIGGER AXIS	355	FRONT SIGHT POST	525	SIGHT BODY
148	COLLAR	205	MAG CATCH	255	TRIGGER BAR PIN	357	FRONT SIGHT DETENT PIN	526	SIGHT HOLDER
151-40	BOLT HEAD (.40 CAL S&W)	207	RED O'RING	256	TRIGGER SPRING	384	FRONT SIGHT DETENT PIN SPRING	527	SHOULDER BOLT
151-9	BOLT HEAD (9MM)	208	MAG CATCH SPRING	260	TRIGGER BAR	404	LOCKNUT WASHER	528	WINDAGE SPRING
152	BOLT	210	M3-10 SOCKET HEAD	264	SAFETY SPRING	410L	GRIP LEFT	529	WINDAGE SCREW
158	REAR SIGHT	211	M3-16 SOCKET HEAD	266	SAFETY	410R	GRIP RIGHT	530	10-32 SET SCREW
164	WINDAGE DETENT	212	M3 NUT	267	SEAR AXIS	411	GRIP SNAP		
165	WINDAGE DETENT SPRING	214	WASHER	269	SAFETY PIN	500	STOCK		
170	FIRING PIN	222	BUFFER	270	SEAR	502	STOCK PIN		
172	FIRING PIN SPRING	225	LATCHING TAB	271	HAMMER	503-40	THREAD PROTECTOR (.40 CAL S&W)		

NOTE:  
Exploded view of weapon is for reference only.  
Design is subject to change without notice.



The windage is controlled by the windage screw which has six detents, or "clicks", per full turn. Each "click" is approximately 1" of bullet movement at 100 yards. The windage screw cams the front sight post from side-to-side. The windage screw is adjusted by using a flat tool (possibly a coin, not included) and rotating the screw either clockwise or counter-clockwise.

**NOTICE** Do not completely unscrew the windage screw (counter-clockwise) as there are small parts which may go missing; stop turning when sight stops moving.

## Removal of Thread Protector

The thread protector on the SUB-2000™ is removable, if the shooter desires to replace the thread protector with a compatible accessory for the 1/2"-28 threads (9mm model) or 9/16"-24 threads (.40 cal S&W). To do so, you will need a vice, and wrench (or socket with breaker bar); these tools are not included.

Ensure the weapon is unloaded (no magazine or ammunition in the weapon). Place the weapon in SAFE configuration. Lock the weapon securely down, possibly in a vice, so the weapon will not move. Add the wrench to the thread protector and turn counter-clockwise to loosen and remove the thread protector. Once removed, a compatible accessory for the specific caliber thread can be added to the exposed barrel threads.

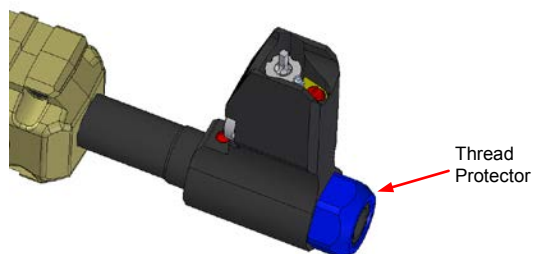


Figure C-7: Example of Thread Protector.

Maximum torque on barrel is 25 foot - pounds. Do NOT tighten accessories onto barrel beyond this torque; doing so, may damage weapon.



## Removal of Front Sight (Optional)

The front sight is also removable if the shooter desires to remove the front sight or replace the forend with any aftermarket accessories, which requires the front sight removal for installation. To do so, you will need a vice, wrench (or socket with breaker bar), 1/8" hex key, and a heat gun (optional); these tools are not included.

Ensure the weapon is unloaded (no magazine or ammunition in the weapon). Place the weapon in SAFE configuration. Lock the weapon securely down, preferably in a vice, so the weapon will not move. Add the wrench to the thread protector (unless already removed) and turn counter-clockwise to loosen and remove the thread protector.

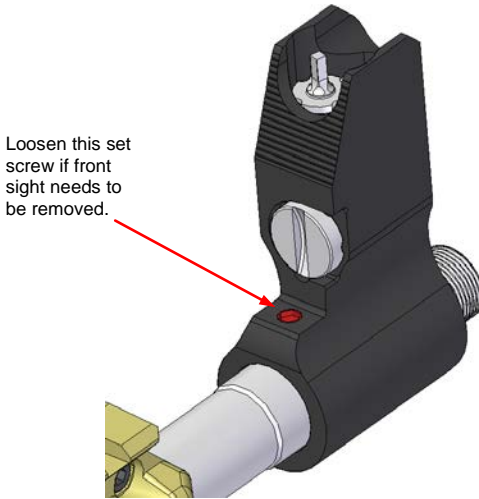


Figure C-8: Example of Front Sight with no Thread Protector

Turn the windage screw clockwise until the screw bottoms out on the front sight, clearing space for the set screw to be loosened. Add 1/8" hex key to set screw and loosen set screw.

Once the set screw is loosened, rotate the front sight clockwise until the front sight is removed from barrel assembly; this will take several rotations to remove the sight. This also may take a small amount of heat to loosen any thread-locking compounds which were used during assembly.

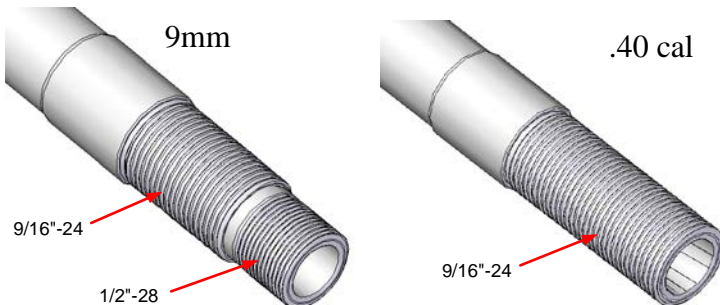


Figure C-9: Different threads on different models.

Once the front sight is removed, there are two exposed threads on the 9mm model and one exposed thread on the .40 cal S&W model for attaching caliber appropriate accessories (Figure C-9). Always ensure accessories are compatible with this weapon, are secured to the weapon properly and do not cause any interference with the weapon or its function.

To add the front sight back to the weapon, you will need the sight, the thread protector, a vice, adjustable wrench, small bubble level, 1/8" hex key, and thread-locking compound (optional); these tools are not included.

Ensure the weapon is unloaded (no magazine or ammunition in the weapon). Place the weapon in SAFE configuration. Lock the weapon securely down, preferably in a vice, so the weapon will not move.

Rotate the sight onto the barrel until the sight stops moving. There should be approximately 3/8" of exposed threads at the muzzle end of the barrel. Add the bubble level to the top of the sight body to check the level compared to the weapon and adjust the sight as needed. When the sight is level to the weapon, tighten the set screw with 1/8" hex key until the set screw does not move. Add the thread protector to the exposed thread end of the barrel; prior to doing so, a small amount of thread-locking compound can be added to the barrel threads, but is not required. Tighten the thread protector until it bottoms out against the sight.

## D. FIELD STRIP

For regular maintenance of the SUB-2000™, it will be necessary that you become familiar with field stripping the weapon (disassembly). The following sections should be followed in sequential order and continued as needed depending on desired maintenance.

**⚠ WARNING** If the SUB-2000™ has been fired, wait a sufficient amount of time for the components to cool before attempting field stripping; failure to do so may result in burns.

**⚠ WARNING** Never rely on your memory to determine whether the weapon is loaded or unloaded. Always open the action and then visually and physically (with your finger) check to make sure there is not a round in the chamber.

**⚠ WARNING** Never alter or modify the SUB-2000™ because this could cause it to malfunction and create a dangerous condition.

**⚠ WARNING** Always wear safety glasses when disassembling the SUB-2000™ to protect your eyes from components that are under pressure, such as springs.

**NOTICE** The stock pin is **NOT** held captive in the stock once it is removed. **DO NOT LOSE THE STOCK PIN.**

Rotate the barrel assembly into the forward position (if the barrel assembly was folded) and make sure the SUB-2000™ rifle is unloaded. Make sure the bolt assembly is in the forward (closed) position, hammer is cocked and push-bolt safety is engaged.

Press the buffer assembly in, towards the front of the weapon. The buffer assembly will move forward approximately 3/32" before bottoming out on the stock pin (1). Release a small amount of tension on the buffer assembly (away from the front of the weapon) so the stock pin can begin to be removed (2). This is needed as the stock pin is held captive by the buffer assembly.

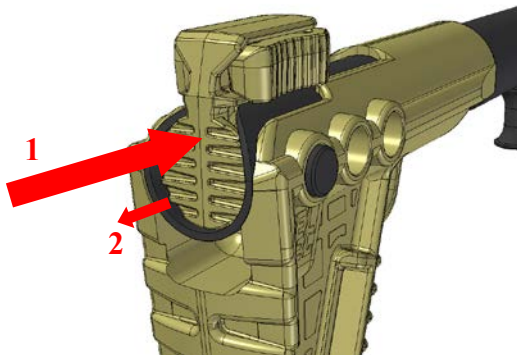
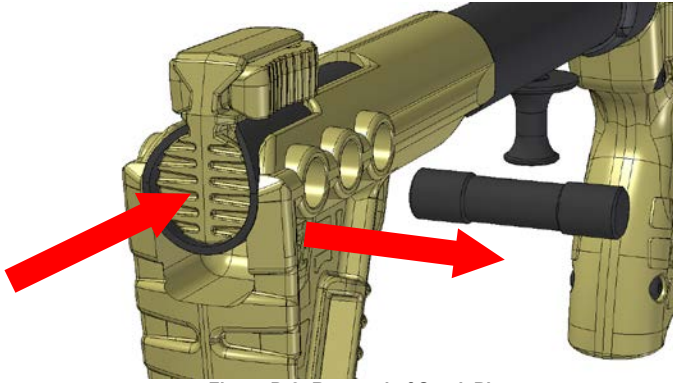


Figure D-1: Press in Buffer Assembly

With a cartridge or other pointed object, press the stock pin from either side until the stock pin is removed.

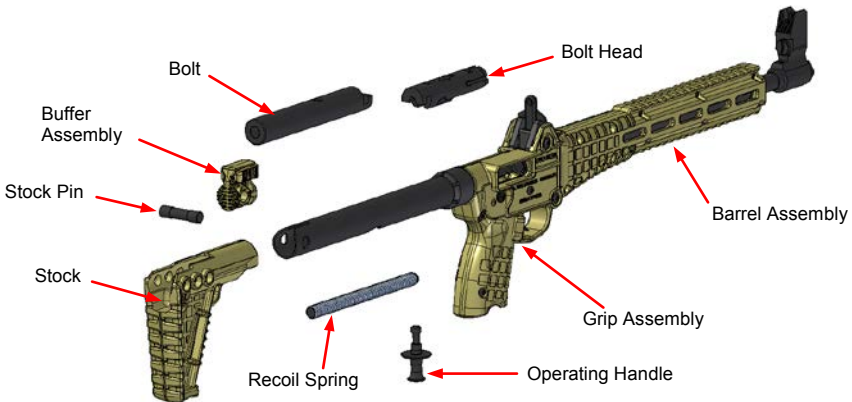
**⚠ CAUTION** The buffer assembly is under tension from the recoil spring. Keep positive contact with the buffer assembly while the stock pin is removed as parts may fly loose.



**Figure D-2: Removal of Stock Pin**

Place the stock pin in a safe location. Remove buffer assembly and place it in a safe location.

Pull the bolt assembly back by the operating handle and pull out the recoil spring. The operating handle can now be pulled out downwards, allowing the bolt assembly to slide out of the rear of the receiver tube. The bolt assembly can be separated by lifting the bolt head off of the bolt. The stock can be removed or adjusted in this position as well, once the stock pin has been removed.



**Figure D-3: SUB-2000™ General Field Strip**

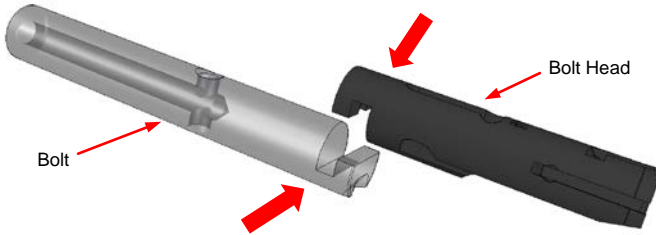
The barrel assembly can be rotated up for cleaning or inspection at this point; further field stripping is not required for normal operation.

**NOTICE** Do not release the hammer with the bolt assembly removed. This will make the SUB-2000™ rifle inoperable.

**NOTICE** We strongly discourage unscrewing the collar or barrel. These parts are assembled with special tools and compounds and may cause damage if removed improperly.

## E. ASSEMBLY FROM FIELD STRIP

Rotate the barrel assembly into the forward position (if the barrel assembly was folded). Slide the bolt and bolt head together by aligning the machined slots in the parts.

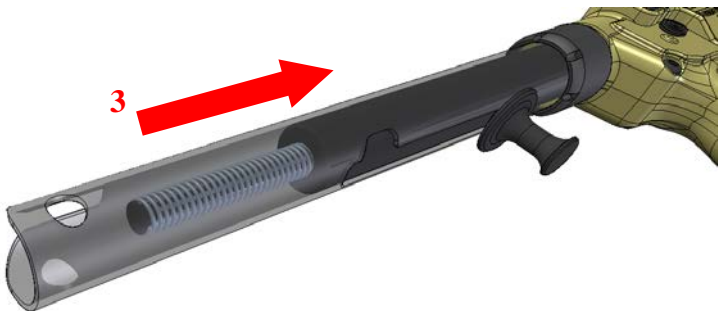


**Figure E-1: Assembly of the Bolt and Bolt Head**

Insert the combined bolt and bolt head into the receiver. Line up the operating handle hole with the operating handle slot below, then fully insert the operating handle (1). Put the recoil spring into the bolt (2), then slide the bolt assembly forward (3).



**Figure E-2: Bolt Assembly in Receiver with Recoil Spring**



**Figure E-3: Sliding Bolt Assembly forward**

Add the stock to the receiver and set the stock position. Position 1 is the shortest overall length of the weapon. Position 2 adds 0.625" to the overall length and position 3 adds 1.25" to the overall length of the weapon.



Figure E-4: Attaching the Stock

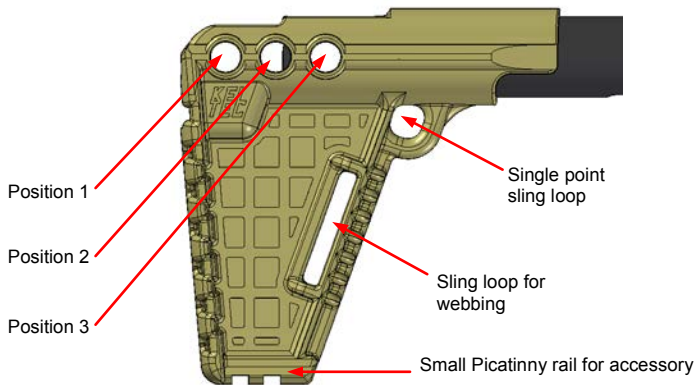


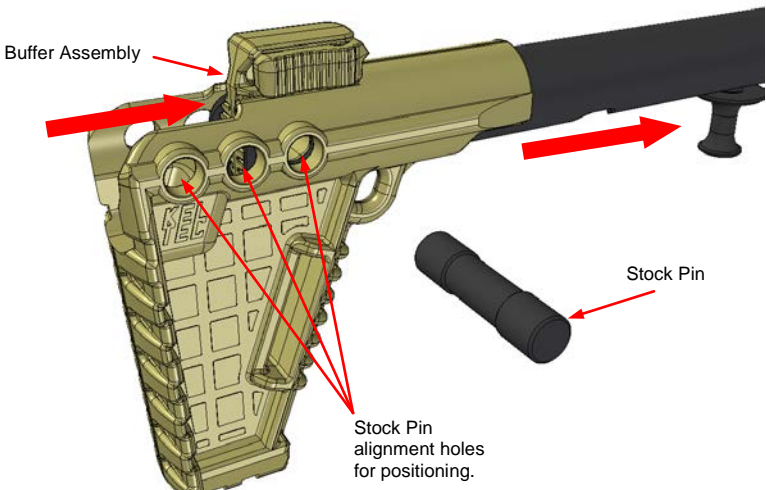
Figure E-5: Explanation of Stock

After aligning the stock to the desired position, add the buffer assembly. Figure E-6 shows the stock in Position 3.

**NOTICE** The bolt assembly may need to be pressed towards the rear of the weapon slightly to make certain that the recoil spring and buffer assembly are aligned when inserting the buffer assembly. After doing so, press the buffer assembly towards the front of the weapon.

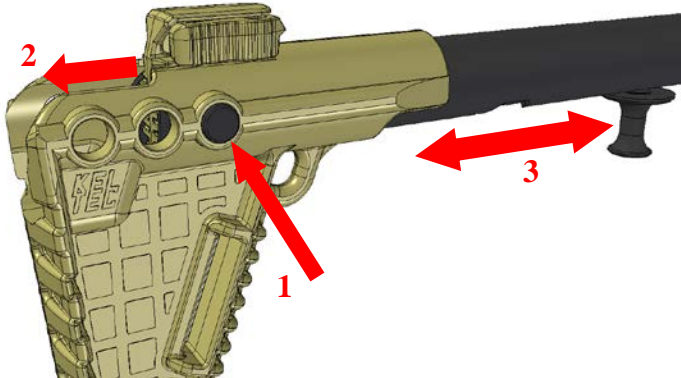
**CAUTION** The buffer assembly is under tension from the recoil spring.





**Figure E-6: Insert the stock pin into the assembly**

Line up the slot in the buffer assembly with the desired stock position and receiver. Push the stock pin completely in, which may take some adjusting of the parts for complete alignment (1). After the stock pin is pressed in, release the tension on the buffer assembly (2) and cycle the bolt assembly a few times to check the action (3).



**Figure E-7: Testing function of weapon**

## F. CLEANING AND MAINTENANCE

### Maintenance

**⚠ WARNING** Remove the magazine, verify that the chamber is unloaded, and remove all live ammunition from the area before working on the SUB-2000™ to reduce the chance of a negligent discharge.

**⚠ WARNING** Always wear safety glasses when cleaning the SUB-2000™ to protect your eyes from cleaning materials.

**⚠ WARNING** Always make sure that no ammunition is located in the area where you clean the SUB-2000™. Cleaning solvents can affect the primer and powder in ammunition and cause it to malfunction. This could result in a bullet being pushed into the barrel of the SUB-2000™ and getting stuck. Firing another round with a bullet stuck in the barrel could cause the barrel to burst and result in death or serious personal injury and/or damage to the SUB-2000™.

**⚠ WARNING** If the SUB-2000™ has been fired, wait a sufficient amount of time for the components to cool before attempting disassembly, failure to do so may result in burns.

Your SUB-2000™ is a precision instrument and will provide a lifetime of faithful service if it is properly cleaned and maintained. It is recommended that you clean your SUB-2000™ after every shooting session or more frequently if needed. Be sure to unload your SUB-2000™ before performing any cleaning or maintenance procedures.

**NOTICE** Only use commercially available gun solvent and gun oil or a cleaner-lubricant-preservative. Use of improper cleaning fluids could damage the SUB-2000™ and void your warranty.

### Lubrication

After cleaning the entire gun, use a cloth to apply a light coating of high quality gun oil to all internal and external metal surfaces and wipe clean.

Manually cycle the action back and forth to check the function of the firearm. If any parts are damaged or badly worn or the firearm does not work correctly, the firearm should not be fired and should be returned to Kel-Tec for servicing immediately.

**⚠ WARNING** Discharging a firearm with oil, grease, or any other material even partially obstructing the bore could result in serious injury or death and serious damage to your firearm.

## Troubleshooting

Proper function of your SUB-2000™ is directly related to maintenance and care, and to the ammunition you use. Some of the more common types of malfunctions which may occur are as follows:

**Misfire:** Failure of the cartridge to ignite when the hammer falls. If this occurs, keep the firearm pointed in a safe direction, wait 30 seconds to avoid hangfires. Remove the magazine from the weapon by pressing the magazine release and ensuring the magazine ejects from the weapon. Cycle the bolt assembly manually to eject the casing. Place the weapon in SAFE configuration, fold the barrel assembly and check for any obstruction in the barrel. The most common cause of misfire is faulty ammunition.

**Failure to Feed:** This occurs when a cartridge has been fed from a magazine but not fully chambered. If this occurs, keep the firearm pointed in a safe direction. Remove the magazine and the round from the ejection port of the weapon. Inspect the round and magazine for any issues. If necessary, change the magazine. The most common causes are dirt or foreign objects impeding the magazine follower; improperly crimped cartridges are another cause.

**Failure to Eject or Extract:** A fired case is not fully extracted from the chamber or ejected from the rifle. If this occurs, keep the firearm pointed in a safe direction, remove the magazine and the round from the ejection port of the weapon. If necessary, change the magazine. The most common causes are a damaged extractor, ejector or ammunition; improperly loaded or sized cartridges can cause this also.

If any of the above problems are not solved by cleaning or by use of other brands of ammunition, stop firing, unload and return the weapon to our service department.

## H. SERVICE, REPAIR, AND WARRANTY



Always make sure the SUB-2000™ is unloaded before sending it in for service.

If your SUB-2000™ ever requires adjustment, refinishing or repair, it should be returned to Kel-Tec CNC Industries, Inc.'s service department. The unloaded firearm should be sent with prepaid shipping to:

KEL-TEC CNC INDUSTRIES INC  
Service Department  
1505 Cox Road  
Cocoa, FL 32926

Contact your chosen carrier to determine its requirements for shipping firearms. In certain states, your firearm may have to be returned to you through a local federally licensed firearms dealer. Be sure to securely package your firearm and insure it for its full value because Kel-Tec CNC Industries, Inc. is not responsible for firearms lost or damaged during shipment.

To ensure prompt service and handling, include a brief letter including your name, address, telephone number, the serial number of your SUB-2000™, and what you would like to be done with it, or the issue that you would like to be addressed. No return authorization number is required. Once your firearm has been received, we will provide a quotation of all charges (unless the repairs are covered by the warranty) and will not begin work until we receive your approval. Charges for adjustments, refinishing, and repairs are payable by money orders, Master Card, Visa, and American Express. No COD or personal checks are accepted.

## LIMITED LIFETIME WARRANTY

Subject to the terms, conditions and limitations outlined below, Kel-Tec CNC Industries, Inc. guarantees your SUB-2000™ against defects in materials and workmanship for the lifetime of the original consumer purchaser.

To make a claim under this warranty, return your SUB-2000™ pursuant to the instructions above and include a copy of a bill of sale in your name, or a copy of the 4473 form, showing that you are the original consumer purchaser. For repairs that are covered by the warranty, Kel-Tec CNC Industries, Inc. will pay the transportation and insurance charges to return your SUB-2000™.

## LIMITATIONS OF WARRANTY

The warranty will be void if any of the following occur:

- (1) the instructions in the Instruction Manual are not followed;
- (2) the SUB-2000™ or any of its parts are altered or modified from their original state;
- (3) damage is caused by misuse, abuse or improper maintenance; or
- (4) the SUB-2000™ is disassembled beyond the instructions in the Instruction Manual.

There are no warranties which extend beyond the description on the face hereof.

The sole and exclusive remedy pursuant to this warranty is the repair or replacement of the SUB-2000™, at the sole discretion of Kel-Tec CNC Industries, Inc.

The implied warranties of merchantability and fitness for a particular purpose are expressly disclaimed.

All disclaimers and limitations of liability shall still apply even if the limited remedy of repair and replacement fails of its essential purpose.

In states where permitted, Kel-Tec CNC Industries, Inc. assumes no liability for incidental or consequential damage or for incidental expenses.

Any action against Kel-Tec CNC Industries, Inc. based on an alleged breach of this warranty must be brought within one (1) year of the claimed breach.

Kel-Tec CNC Industries, Inc.'s liability for breach of warranty shall be limited to repair or replacement of the SUB-2000™, at the sole discretion of Kel-Tec CNC Industries, Inc.

The SUB-2000™ is a dangerous weapon. The purchaser assumes all liability resulting from unsafe handling or any action that constitutes a violation of any applicable laws or regulations. Kel-Tec will not be responsible for injuries or damages resulting from careless handling, unauthorized or unsafe adjustments or modifications, the use of non-standard, defective, or improper ammunition, the use of incompatible or improperly installed accessories, corrosion, neglect, fire damage, water damage, theft, abuse, ordinary wear and tear, or unreasonable use of the SUB-2000™. Under no circumstances shall Kel-Tec be responsible for incidental or consequential damages with respect to economic loss or injury or property damage, whether as a result of breach of express or implied warranty, negligence or otherwise.