



FIREARMS

User's Manual

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Precautions

CAUTION:

Use only clean, dry, high-quality-commercially manufactured ammunition that is appropriate to the caliber of your firearm. We do not recommend the use of remanufactured or hand-loaded ammunition.

⚠ Read and understand all of the following precautions before removing this firearm from its package.

⚠ If this firearm is carelessly or improperly handled, unintentional discharge could result in serious injury, death, or damage to property.

⚠ Prior to loading and firing, carefully read this user's manual, which gives basic advice on the proper handling and functioning of this firearm. Your safety and the safety of others depends on your compliance with that advice. If you are unfamiliar with firearms, seek further advice through firearms-handling courses run by your local gun range, NRA-approved instructors, or similar qualified organizations.

⚠ Always use safe gun-handling practices and wear proper personal protective equipment when performing maintenance and/or firing this rifle.

NOTICE:

F-1 Firearms shall not be responsible for injury, death, or damage to property resulting from either intentional or accidental discharge of this firearm, or from its function when used for purposes or subjected to treatment for which it was not designed. F-1 Firearms will not honor claims involving this firearm that result from careless or improper handling, unauthorized adjustment or parts replacement, corrosion, neglect, or ammunition that's the wrong caliber, or the use of ammunition other than original high-quality commercially manufactured ammunition in good condition, or any combination thereof. F-1 Firearms will not honor claims involving this firearm for any reason or cause when such claims are made by the second or subsequent owners.

QUALITY CONTROL:

Before this firearm left the factory, it was tested, carefully inspected, and packaged. F-1 Firearms cannot control product handling after an individual firearm leaves the factory; therefore, please examine this firearm carefully at the time of purchase to ensure that it is unloaded and undamaged.

NOTICE:

The end user is responsible for knowledge of Local and Federal Laws and for adhering to all regulations. F-1 Firearms is not responsible for misuse of any products.

Safety Instructions

! Please follow the safety instructions for your safety and the safety of others.

WARNING: When you squeeze the trigger, you must expect the firearm to fire, and you must take full responsibility for firing it. Your care can avoid accidental discharge, and you will thereby avoid accidental injury and death.

GENERAL HANDLING PRACTICES:

Always handle your firearm as if it were loaded.

Never point your firearm at anything you do not intend to shoot.

Never take anyone's word that a firearm is unloaded. Check for yourself.

Always make sure your firearm is not loaded, and the bolt is latched open, before laying it down or handing it to another person.

Always keep and carry your firearm empty, with the hammer forward.

Except when you intend to shoot, so that your firearm cannot be fired when you do not intend to fire it.

Always be aware of possible risk from dropping your firearm.

Some parts of the mechanism could be damaged. You may not see the damage, but if it is severe, the firearm may discharge and cause injury, death, or damage to property. If your firearm has been dropped, have it examined by a competent gunsmith before using it again.

Never leave a firearm charged and ready to fire.

This condition is extremely dangerous, and the firearm could easily be accidentally discharged, causing injury, death, or damage to property.

Never leave a loaded firearm unattended.

Always instruct children and others in your household to respect firearms.

If you teach your children to shoot, teach them or get them trained by a qualified instructor to treat and use a firearm properly, and always supervise them closely. Always stress safety so that your children will not discharge a firearm when it is unsafe to do so.

Safety Instructions

RANGE CAUTIONS:

Always be sure your backstop is adequate.

Before beginning target practice, determine if your backstop will stop and contain bullets so that you do not hit anything outside the range shooting area.

Always put a knowledgeable and responsible person in charge (Range Officer) to maintain safety control when a group is firing on a range.

Obey the Range Officer's commands to reduce the likelihood of accidents.

Always carry your firearm empty with the bolt locked open while on a range.

Until you're prepared to fire, keep your firearm pointed toward the backstop when loading, firing, and unloading to eliminate the risk of injury, death, or damage to property from a premature discharge.

LOADING CAUTIONS:

Always be sure the barrel bore, chamber, and action are clean and clear of obstructions.

Clean a wet or fouled firearm immediately so that it will function correctly and safely.

Always use clean, dry, original, high-quality commercially-manufactured ammunition in good condition that is appropriate to the caliber of your firearm.

Always check that ammunition is clean and undamaged before using the forward assist.

Forcing damaged ammunition into the chamber could damage your firearm and could result in injury, death, or damage to property.

Safety Instructions

SHOOTING CAUTIONS:

Never consume alcoholic beverages or take drugs before or during shooting.

Always seek a doctor's advice prior to shooting if you are taking medication.
Certain medications may affect your fitness to shoot and handle your firearm safely.

Always wear ear protection and encourage others to wear ear protection when shooting.
Without ear protection, you may be injured by the noise from your firearm and other firearms close to you. Firearm reports can leave a “ringing” in the ears for some time after firing, and repeated exposure can result in permanent hearing loss.

Always wear and encourage others to wear protective shooting glasses.
Protective shooting glasses can prevent flying particles from damaging eyes and causing blindness.

Always keep the safety selector lever set to SAFE when your firearm is loaded.
Flip the selector to FIRE only when you are aiming at a target and intend to fire. This will minimize the risk of an accidental discharge.

Always keep clear of the ejection port and warn others to stay clear of the ejection port as well.
Spent cases are hot and are ejected with enough force to cause injury. Keep your fingers out of the ejection port — they could be burned by hot metal or be injured by the bolt moving forward.

Never put your finger in the trigger guard or squeeze the trigger until you are aiming at a target you are ready and intend to shoot.

Always be absolutely sure of your target and the area behind and beyond it before you squeeze the trigger.

Never attempt to fire if water is in the barrel.
Water can accumulate if your firearm is exposed to heavy rain or fog. Open the bolt and allow water to drain before firing. Clean a wet firearm as soon as possible.

Never shoot at a hard surface, such as rock, or a liquid surface, such as water.
A bullet may ricochet and travel in any direction to strike you, others around you, or even an object you cannot see.

Never discharge a firearm near flammable material.
Flame and sparks exit the firearm when discharged. They can start a fire or cause flammable liquids and gases to explode.

Never walk, climb, or follow another person when your firearm is cocked and ready to fire.
To eliminate the risk of accidental discharge, hold your firearm so that you can always control the direction of the muzzle and keep the safety selector lever set to SAFE.

Safety Instructions

MALFUNCTIONS:

If you experience a failure to fire, always point the firearm toward the target or backstop and wait 30 seconds.

- If a misfire has occurred, the round will fire within 30 seconds.
- If a round does not fire, cycle the bolt, eject the round, and examine the primer. If the firing-pin indent on the primer is light, off center, or nonexistent, have your firearm examined by a competent gunsmith before continuing to use the firearm.
- If the firing-pin indent on the primer appears normal, assume it's a faulty round. Segregate the unfired round from all other live ammunition and empty cases, reload, and continue firing.

NOTE: It is normal for a light firing-pin indent to appear on the primer of cartridges that have been fed into the chamber but not fired.

NOTE: Dispose of any misfired rounds in accordance with the ammunition manufacturer's instructions.

Never use your firearm if it fails to function properly, and never force a jammed action closed. Forcing the action closed may cause a round to explode, causing serious injury, possible death, or severe damage to your firearm.

CLEANING & STORAGE:

Always make sure your firearm is not loaded before cleaning and storing.

Always keep and store your firearm and ammunition in a separate locked receptacle out of reach and sight of children and untrained people.

NOTICE:

Never abuse your firearm.

Don't use it for any purpose other than shooting.

Never dry fire when the upper and lower receivers are open.

The level of safety could be reduced.

Never alter parts.

The level of safety could be reduced.

Safety Features

TRIGGER GUARD

The Trigger Guard encircles the trigger and protects the trigger from damage and helps prevent accidental discharges. The Trigger Guard may have detachable bottom piece separate from the lower receiver. The rifle shouldn't be handled unless this piece is in position.

SAFETY SELECTOR LEVER

The Safety Selector Lever is located on the left side of the lower receiver and has two positions, FIRE and SAFE. When set to FIRE, the firearm will fire a single shot each time the trigger is squeezed without manually reloading. When set to SAFE, a cam bears upon the rear portion of the trigger, blocking the sear surface of the trigger and preventing the hammer from being released.

NOTE: The safety featured on the F-1 Firearms rifle is a mechanical safeguard. As with all mechanical systems, failures within this system are possible and may not be visible to the operator. Activating the safety selector lever to the SAFE position does not mean the firearm is incapable of firing if mishandled or dropped.

BOLT LOCKING SAFETY FEATURES

This firearm can fire only when the bolt is fully locked to the barrel and the firing pin is free to move forward. The firing pin is prevented from reaching the cartridge by the bolt carrier. Only when the bolt carrier moves forward over the bolt, rotating it to the fully locked position, can the firing pin move forward enough to fire the rifle. This design feature makes sure that the rifle will not fire before the cartridge is fully chambered and the bolt is fully rotated (locked) to the barrel.

Even with the bolt locked, if you do not use the proper ammunition, your rifle could blow up or blow down through the magazine. This is why we emphasize that you should use only clean, dry, original, high-quality, commercially-manufactured ammunition in good condition. Keep the bore of the barrel clear at all times.

DISCONNECT

The Disconnect, which is part of the firing mechanism, prevents the firearm from firing fully automatic. As the hammer is cocked after each shot by the rearward movement of the bolt carrier, the Disconnect engages the hammer to hold it rearward until the trigger is released. When the trigger is released, retention of the hammer passes from the Disconnect to the sear surface of the trigger ready for the next shot.

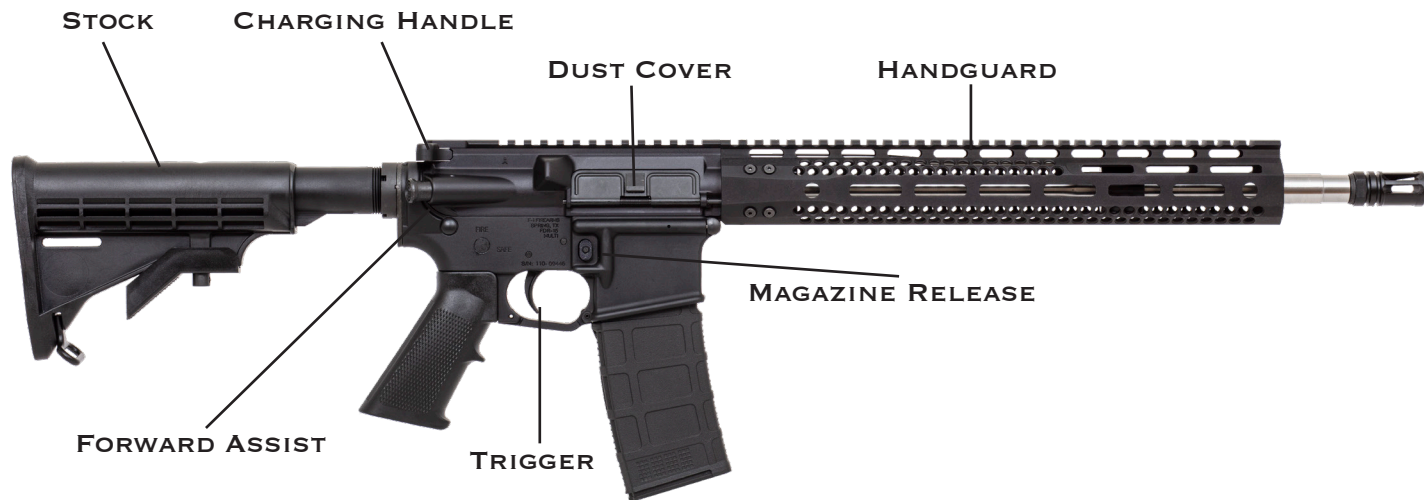
SEPARATION OF UPPER AND LOWER RECEIVERS

In the event of functional problems, the lower receiver can be separated from the upper receiver by pivoting it downward after pushing out the rear takedown pin. This provides access to the mechanism and separates the firing mechanism from other components so that the cocked hammer cannot strike the firing pin.

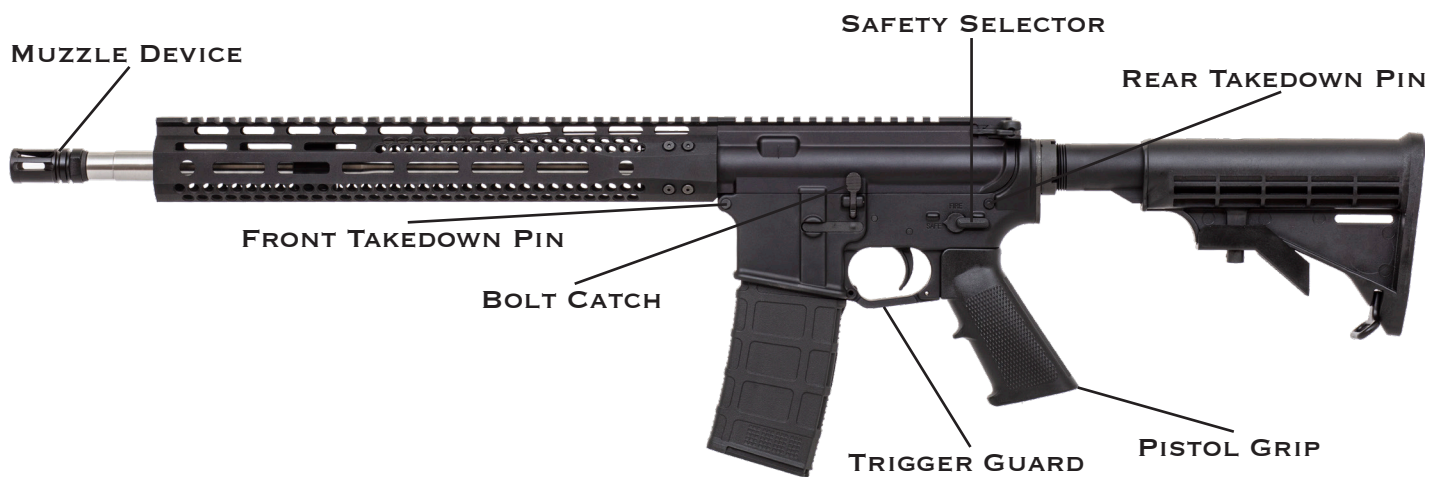
NOTE: The Bolt Carrier Group must be in the full forward position to separate the Upper Receiver from the Lower Receiver.

Components

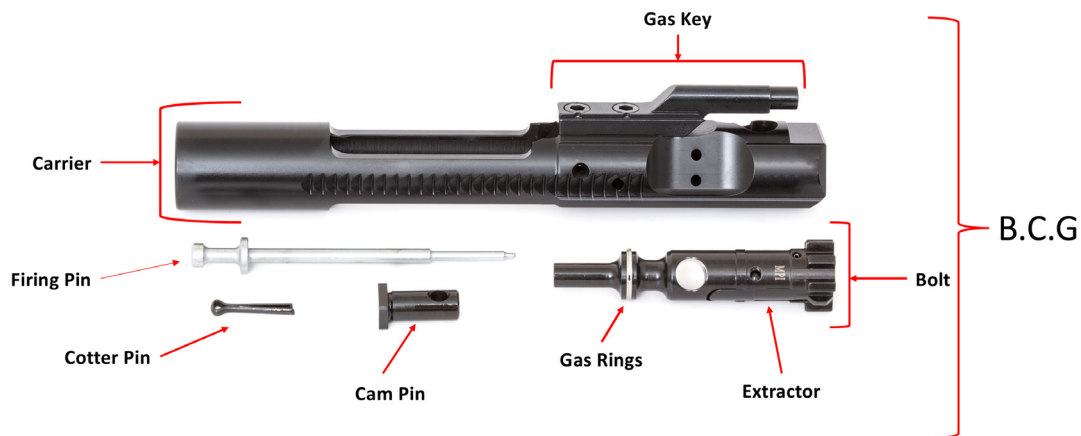
RIGHT SIDE VIEW



LEFT SIDE VIEW



BOLT CARRIER GROUP



Function/Operation

LOADING THE MAGAZINE

1. Use only quality ammunition suitable for your firearm.
2. With the magazine facing forward as shown at right, 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.
3. If necessary, slightly push the round backward to seat it against the back edge of the magazine lips. Place the next round on top of the previous round and repeat until the desired number of rounds are achieved.



! Make sure the rifle is pointed in a safe direction, and the safety is engaged at all times while loading the rifle. Never allow your fingers or other objects to contact the trigger while loading or unloading your rifle. Do not disengage the safety until you are ready to fire and have the rifle pointed safely downrange.

LOADING YOUR FIREARM

To remove an empty magazine, depress the magazine catch and pull the magazine from the magazine well.

1. To cock the hammer and leave the bolt and carrier latched open to the rear, press in on the bottom of the thumb piece of the bolt catch while grasping and pulling back on the charging handle.

NOTE: THE BOLT CARRIER GROUP BEING LATCHED OPEN IS NOT A SAFE CONDITION WHEN A LOADED MAGAZINE IS INSTALLED.

2. Return the charging handle fully forward until it locks (top arrow), and remove your finger from the bolt catch. Set the selector lever (bottom arrow) to SAFE. This will lock the trigger.



Function/Operation

3. With bullets pointing forward, insert the loaded magazine into the magazine well.



4. Push the magazine home until it stops and is locked by the magazine catch. When the magazine is inserted, pull down on the magazine to ensure it is fully seated in the magazine well.



5. Keeping fingers away from the ejection port and muzzle pointing in a safe direction, press in on the top of the thumb piece of the bolt catch. This will release the bolt carrier group to move forward and feed a round from the magazine into the chamber.



THE FIREARM IS NOW LOADED WITH A ROUND IN THE CHAMBER AND THE HAMMER IS COCKED.

6. You may now close the ejection port dust cover if you wish; it is located on the right hand side of the upper receiver and will open automatically when the first round is fired. Some F-1 Firearms Billet models do not have a dust cover.



⚠ Never leave your firearm cocked and locked, ready to fire without the selector lever being set to safe because this is the FIRE Condition. Firearms in this condition can easily be accidentally discharged, causing injury, death or damage to property.

Function/Operation

FIRING YOUR FIREARM

1. Always wear ear and eye protection when firing your weapon.
2. Load firearm as previously described.
3. With your firearm unloaded, before firing your rifle practice your stance, aim, rhythm, and breathing for steady aim. Practice firing on a range before going hunting or using your firearm for any other type of shooting.
4. Grasp the firearm with one hand on the Handguard and the other hand on the Pistol Grip with the trigger finger resting alongside of the Trigger Guard. Raise the firearm and pull the Buttstock firmly into the shoulder.
5. Keeping steady aim, place the trigger finger on the Trigger and squeeze gently until the Trigger releases the hammer. Do not jerk the Trigger because you will disturb your aim and ruin your accuracy.
6. This is a semi-automatic firearm, and it is immediately loaded and ready to fire after each shot until magazine is empty. To fire the next round and subsequent rounds, all that is necessary is to release the Trigger and squeeze it again after every shot until the magazine is emptied.
7. If the Bolt fails to lock fully forward automatically, press the Forward Assist button to lock it into battery position. If this action is necessary, it is usually a sign that your rifle needs to be cleaned, especially in the Lug area of the Upper Receiver.
8. Once the magazine is emptied, release the Trigger, remove the finger from the Trigger, and set the Selector lever to SAFE. If you have fired the last round from magazine, the Bolt Carrier will be held open to the rear so that you can quickly reload by replacing the Magazine. Or, in this condition, the chamber can be checked to ensure it is empty.



UNLOADING YOUR FIREARM

⚠ Make sure the rifle is pointed in a safe direction, and the safety is engaged at all times while loading the rifle. Never allow your fingers or other objects to contact the trigger while loading or unloading your rifle. Do not disengage the safety until you are ready to fire and have the rifle pointed safely down range.

1. Press the Magazine Release to remove the magazine from the rifle.
2. Press in on the bottom of the Bolt Catch while pulling back the Charging Handle. This will cock the hammer and lock the Bolt Carrier to the rear.
3. If there is a round or a spent cartridge in the chamber, it will be ejected.
4. Return the Charging Handle fully forward until it locks in place and remove your finger from the Bolt Catch.
5. Set the Selector to the SAFE position.
6. Inspect the chamber, making sure it is empty.
7. With the rifle pointed in a safe direction, press in on the top of the Bolt Catch. This will release the Bolt Carrier.
8. Close the Ejection Port Cover (dust cover).

Maintenance

FIREARM DISASSEMBLY

⚠ Before disassembly, remove the magazine, clear the chamber, and make sure the Safety Selector is in the SAFE position.

1. Make sure the Bolt Assembly is in the forward (battery) position.



2. Slide the rear takedown pin out; the firearm's Upper Receiver will now pivot forward.

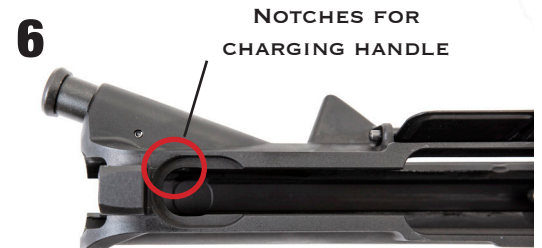


3. To completely separate the Lower Receiver from the Upper Receiver, slide the Front Pivot Pin out.

4. To disengage and remove the Bolt Assembly, pull the Charging Handle back and remove the Bolt Assembly.



5. Align the ears of the Charging Handle with the notch in the Upper Receiver (6) to remove the Charging Handle Assembly.



Maintenance

BOLT CARRIER DISASSEMBLY

1



1. Remove the Firing Pin Retainer.

2



2. Remove the Firing Pin.

3. To remove the Bolt Cam Pin, extend the Bolt completely, turn the Cam Pin 90° (1/4-inch turn either direction), push bolt back into the Carrier so that Cam Pin clears the Bolt Carrier Key, then slide the Cam Pin up and out.



3



4

4. Inspect the Cam Pin for wear.

5. Before removing the Bolt from the Bolt Carrier, note the orientation of the Extractor and Ejector.



5

6, 7



6. Once the Bolt is removed, inspect the Gas Rings and Lugs for wear. If excessive wear is present, take the parts to a certified armorer for replacement or repair.

7. Inspect the Bolt Carrier Key to ensure that it is tight. If loose, take it to a certified armorer for repair.

 **FURTHER DISASSEMBLY NOT RECOMMENDED.**

CLEANING YOUR FIREARM

Cleaning the Barrel Bore (using a standard multi-piece-rod cleaning kit)

- 1.) Attach three rod sections together but leave each one about two turns short of being tight. Attach the patch holder, but leave it two turns short of tight also.
- 2.) Point the muzzle down. Hold the upper receiver in one hand while inserting the end of the rod with patch holder attached into the chamber. Guide the rod carefully through the bore. CAUTION: Do not let the rod or its threaded end scratch the chrome lining of the bore or firing chamber. About 2 to 3 inches of the rod should protrude out of the muzzle.
- 3.) Attach the handle section of the cleaning rod to the end of the rod sticking out of the muzzle, and swab the bore with a patch moistened with “CLP” (Cleaner Lubricant & Preservative).
- 4.) Remove the patch holder and attach the bore brush, leaving it two turns short of tight.
- 5.) Pull the brush through the bore and out the muzzle.
- 6.) 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 and repeat the process.
- 7.) Pull a patch through the bore occasionally to help clean out the carbon that the brush is getting loose. Just replace the bore brush with the patch holder and a wet patch. If you leave the rods loose again, the patch will “track” in the rifling as before. Remember, always have the bore wet with cleaner before trying to pull a brush through. NEVER reverse the direction of the bore brush while it is in the bore.

Cleaning the Upper Receiver, Bolt, Carrier and Components

- 1.) Using a CLP-type product, clean all areas that have powder fouling, corrosion, or dirt. Never use a wire brush or any type of abrasive to clean the aluminum upper receiver; you’ll scratch and damage the finish. A toothbrush is good for loosening any dirt buildup, and it won’t scratch the receiver.
- 2.) Clean the firing chamber. Dip the larger chamber 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 contaminated solution or loosened crud.
- 3.) Use the bore brush wet with CLP to 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. Clean out the gas key on top of the bolt carrier with a Q-Tip or a pipe cleaner. Also, clean out any carbon/powder residue from vent holes in the bolt carrier. Clean and inspect the bolt, cam pin, firing pin and firing pin retaining pin thoroughly.
- 4.) Wipe all components clean and dry, and inspect for excessive wear, corrosion or mechanical damage. Have your armorer replace any worn or defective parts before firing.

Maintenance

Cleaning the Lower Receiver

- 1.) Clean all areas that have 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. Carefully clean the magazine release button and the cavity for the magazine catch on the left side of the receiver. Also inspect and clean the bolt catch mechanism and the receiver's takedown and pivot pins. Clean the buffer, action spring, and inside the lower receiver extension (the buffer tube). A piece of rag attached to the cleaning rod and patch holder can be used to wipe inside the buffer tube.
- 3.) If the rifle has been used in very dirty/muddy conditions, the vent hole in the telestock receiver extension may need to be cleaned out. Use a pipe cleaner or piece of wire to ensure that the vent hole is clear.
- 4.) Buttstocks may require cleaning. The telescoping stock latch can be pulled down to remove the stock. Clean the 6-position lock holes and lightly lube the receiver extension and latch mechanism to ensure proper telescoping action.

Lubricating the BCG (Bolt Carrier Group)

Firing Pin: Lightly lubricate the firing pin and the firing pin recess in the bolt with CLP.

Bolt Carrier: Lightly lubricate the inner and outer surfaces. Generously lubricate the cam-pin area and the "slide" rail areas of the bolt carrier where they contact the inside of the receiver.

Bolt: Generously lubricate the bolt, its cam-pin area, the bolt gas rings. A lighter application is good on the extractor and its pin.

Charging Handle: Lightly lubricate the charging handle and its latch and spring.

Carrier Key: The inside of the carrier key on the bolt carrier should be dried with a Q-Tip or pipe cleaner. Then place one drop of CLP inside.

Lubricating the Upper and Lower Receivers

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 the barrel and front sight, and surfaces under the handguards. Be sure you lubricate in and around all the locking lugs. The forward assist should also be lightly lubed inside the receiver and checked for function.

Front Sight Detent (if equipped): Depress and apply two or three drops of CLP to it. Depress the detent several times to work the lubricant down into the spring.

Lower Receiver: Generously lubricate ALL MOVING PARTS INSIDE THE LOWER RECEIVER including the trigger, hammer, safety, bolt catch, magazine release, etc., and their various pins and detents. Don't forget the takedown and pivot pins and their detents. Use an oiled rag to wipe off any fingerprints on the exterior surfaces. A black cloth is best because it won't leave visible lint.

Lower Receiver Extension: Lightly lubricate inside the lower receiver extension (more commonly known as buffer tube), the buffer and the action spring. Also lightly lubricate the telestock latch and exterior of the receiver extension.

Maintenance

REASSEMBLING THE BOLT ASSEMBLY

1. Reinsert the bolt into the bolt carrier. Note the orientation of the ejector and extractor.
2. Reinsert the cam pin and rotate 90°.
3. Reinsert the firing pin, making sure it is seated completely forward toward the bolt face.
4. Reinsert the firing pin retainer.
5. After assembly, make sure the bolt moves freely and that the firing pin is captured correctly.

RIFLE ASSEMBLY

1. Reinsert the charging handle into the upper receiver by aligning the ears of the charging handle with the notch in the upper receiver. The charging handle must be seated at the bottom of the slot in the upper receiver. Slide the charging handle forward approximately 1/4 inch.
2. With the bolt fully extended, reinstall the bolt assembly into the upper receiver using the slot in the charging handle as a guide.
3. Slide the bolt assembly into the forward (battery) position. Note that the charging handle moves with the bolt carrier.
4. Line up the upper and lower receiver pivot pin holes and slide the front pivot pin into the locked position.
5. Pivot the receivers together and slide the takedown pin into the locked position.

The firearm is now assembled.

FUNCTION TEST

1. Pull the charging handle fully to the rear and release. Make sure the bolt assembly returns to the forward (battery) position.
2. Move the Selector to the SAFE position.
3. Pull the trigger to check that the safety is working correctly.
4. Move the Selector to the FIRE position.
5. Pull the trigger to check that the hammer is falling properly. Note that dry-firing this rifle will not damage it in any way.

Billet Models

PROPRIETARY BILLET FEATURES



In this section we will cover all the proprietary features of our billet receivers. This information pertains only to the following models:

BDR-15

BDR-15-3G

UDR-15-3G

80M

BDRx-15

BDRx-10

PROPRIETARY SCREWS

The following screws should be included with your billet rifle, chassis, or receiver. If for some reason you are missing any of the screws, please contact support@f-1firearms.com.

4-48 x 1/2" Bolt Catch Screw (1)



COMES INSTALLED IN ALL SETS

8-32 x 5/8" - BUFFER RETAINING SCREW (1)



COMES INSTALLED IN ALL SETS

4-48 x 1/8" - TAKEDOWN SPRING SCREW (1)



COMES INSTALLED IN ALL SETS



8-32 x 5/8" - RECEIVER TENSION SCREW (1)



NYLON TIP

COMES INSTALLED IN ALL SETS

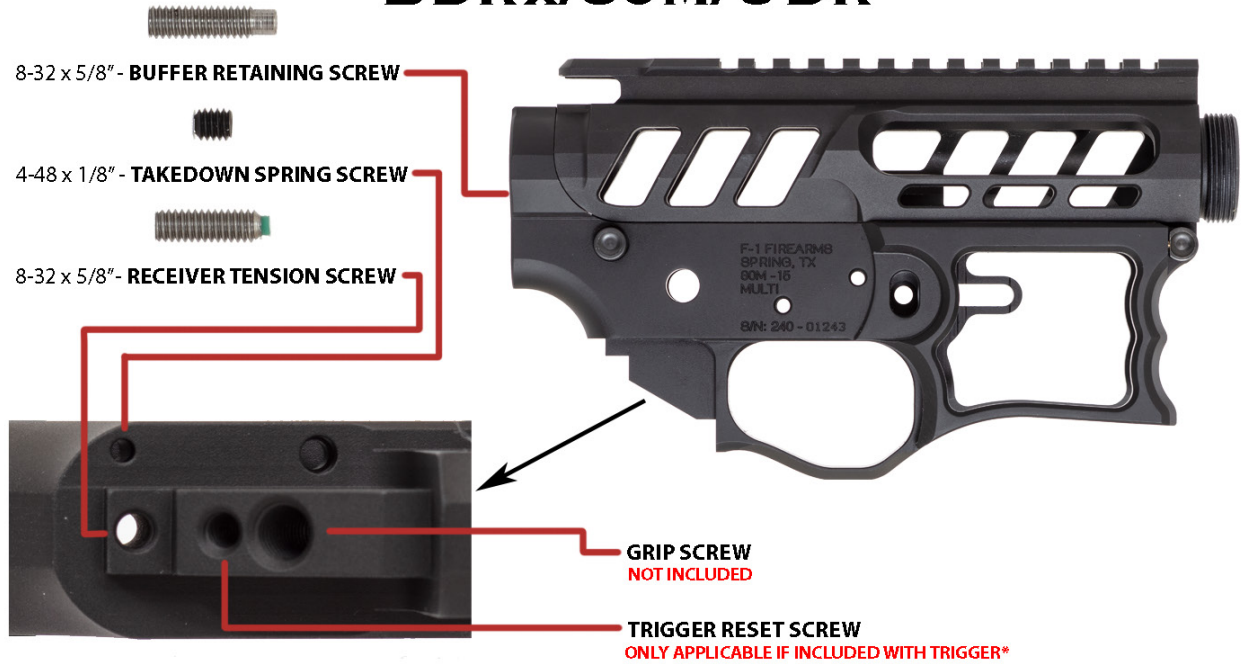
.050" ALLEN KEY (1)



Billet Models

RECEIVER DIAGRAM

BDRx/80M/UDR



DO NOT USE ROLL PIN



4-48 x 1/2" **Bolt Catch Screw**

BDRx/80M/UDR

These receiver sets utilize a threaded bolt catch screw which is included. If you did not receive a hardware bag please call 832-299-6100 or email Support@f-1firearms.com

⚠ Warning: Do not use an upper vise block on any of our billet upper receivers. We recommend a reaction rod. Any damage caused using an upper vise block will not be covered under warranty.

STOP!!!

Read Before Installation

This product has a lifetime guarantee. However, if proper installation procedure is not followed, damage will not be covered. All F-1 Firearms uppers must be assembled using a “Reaction”-style rod pictured below:



DO NOT USE AN UPPER VISE. Using a vise can cause the upper to bend or break and will not be covered by warranty.

DO NOT USE ANY LOCTITE on the Barrel Nut. This can cause a fracture in the upper if ever attempted to be removed.

DO NOT USE RED LOCTITE anywhere on your f-1 Firearm. Blue Loctite is suggested and supplied for handguard screws.

If you have any questions or concerns please contact us at Support@f-1Firearms.com

RECEIVER TENSIONING SCREW

The receiver tensioning screw is located under the pistol grip of your firearm. This screw removes any play between the upper and lower, leaving the rifle with a very snug fit.

You may have to loosen the receiver tensioning screw to remove your rear takedown pin.

⚠ Do not over-tighten the receiver tensioning screw. Hand tight should suffice.

Billet Models

BUFFER RETAINING SCREW REMOVAL/INSTALLATION

Remove the upper from the lower.

1. Then place your finger over the buffer and spring, slightly pushing tension backward away from the buffer-retaining screw.



2. With your free hand, use a .050-inch allen key to rotate the buffer-retaining screw counter-clockwise.



3. Once the screw is removed, slowly release the buffer and spring from the receiver extension (buffer tube).

You can now clean your buffer, spring, and buffer tube. Reverse steps to reinstall.



Suppressor User Information

⚠️ WARNINGS

- ⚠️ **BEFORE USING THIS SUPPRESSOR: BE SURE YOU HAVE READ AND UNDERSTAND THIS MANUAL. FAILURE TO DO SO COULD RESULT IN PROPERTY DAMAGE, SERIOUS INJURY AND/OR DEATH. USE CAUTION AND SAFE FIREARM HANDLING PRACTICES.**
- ⚠️ **ALWAYS WEAR PROPER PERSONAL PROTECTIVE EQUIPMENT.**
- ⚠️ **ONLY USE FACTORY AMMUNITION WITH THIS SUPPRESSOR.**
- ⚠️ **BEFORE PERFORMING MAINTENANCE ON YOUR FIREARM, ENSURE IT IS UNLOADED BY REMOVING THE MAGAZINE, ENSURING THE ACTION IS OPEN, AND DOING A VISUAL AND PHYSICAL INSPECTION OF THE CHAMBER.**
- ⚠️ **DO NOT THREAD THE TOMBSTONE INTO THE SUPPRESSOR BEFORE PROPERLY INSTALLING ON THE BARREL.**

TOMBSTONE INSTALLATION

1. REMOVE ANY EXISTING MUZZLE DEVICES FROM YOUR FIREARM.
2. CLEAN AND DEGREASE MUZZLE THREADS WITH SOLVENT.
 - ⚠️ **DO NOT USE STEEL TOOLS TO CLEAN. WE RECOMMEND USING A BRASS OR NYLON BRUSH.**
3. APPLY A FEW DROPS OF ROCKSETT THREAD LOCK TO THE BARREL THREADS.
4. THREAD TOMBSTONE CLOCKWISE.
5. USING AN ARMORERS WRENCH TIGHTEN THE TOMBSTONE CLOCKWISE ONTO YOUR BARREL TO 20-30 FT LBS.
 - ⚠️ **DO NOT USE SHIMS, JAM NUTS, OR WASHERS WHEN INSTALLING THE TOMBSTONE. THEY CAN CAUSE MISALIGNMENT AND THE TOMBSTONE WAS DESIGNED TO NOT REQUIRE TIMING.**



SUPPRESSOR INSTALLATION

1. THREAD THE SUPPRESSOR CLOCKWISE ONTO THE OUTER THREADS OF THE TOMBSTONE.
2. TIGHTEN CLOCKWISE ONTO THE TOMBSTONE UNTIL FULLY SEATED AND HANDTIGHT.
 - ⚠️ **DO NOT USE THREAD LOCK WHEN INSTALLING A SUPPRESSOR TO THE TOMBSTONE**



REMOVAL

- ⚠️ **BEFORE REMOVING THE SUPPRESSOR FROM YOUR FIREARM, ENSURE IT IS UNLOADED BY REMOVING THE MAGAZINE, ENSURING THE ACTION IS OPEN, AND DOING A VISUAL AND PHYSICAL INSPECTION OF THE CHAMBER.**
 - ⚠️ **IF YOU'VE JUST FINISHED SHOOTING, ALLOW THE SUPPRESSOR TO COOL DOWN UNTIL SAFE TO TOUCH.**
1. TURN THE SUPPRESSOR COUNTER-CLOCKWISE TO REMOVE.

CLEANING & MAINTENANCE

1. CLEAN THE TOMBSTONE'S TAPER AND THREADS AS WELL AS THE CORRESPONDING SUPPRESSOR FEATURES OF ANY FOULING USING A BRASS OR NYLON BRUSH.
2. IF YOU WISH TO CLEAN THIS SUPPRESSOR, WE RECOMMEND AN ULTRASONIC CLEANER.
 - ⚠️ **WHEN REMOVED FROM THE CLEANER, RINSE AND ENSURE THE SUPPRESSOR IS FULLY DRAINED BEFORE FIRING. DO NOT USE STEEL TOOLS TO CLEAN.**

THANK YOU
FOR CHOOSING
F-1 FIREARMS!



PLEASE SEND ALL INQUIRIES TO:
SUPPORT@F-1FIREARMS.COM