



AR15 / AR10 Rifle Owner's Manual



This is not a Safety Manual.

If you need help with the safe handling of your new rifle, Contact a certified firearms instructor.

Fundamental Firearm Safety Rules

1. Always keep the firearm pointed in a safe direction.
2. Always keep your finger off the trigger until ready to shoot.
3. Always keep the firearm unloaded until ready to use.
4. Be sure the firearm is safe to operate.
5. Know how to use the firearm safely.
6. Use only the correct ammunition for the firearm.
7. Know the target and what is beyond
8. Wear appropriate eye and ear protection
9. Never use alcohol or drugs before or while shooting.
10. Store firearms so that they are not accessible to unauthorized persons.
11. Be aware that certain types of firearms and many shooting activities require additional safety precautions.

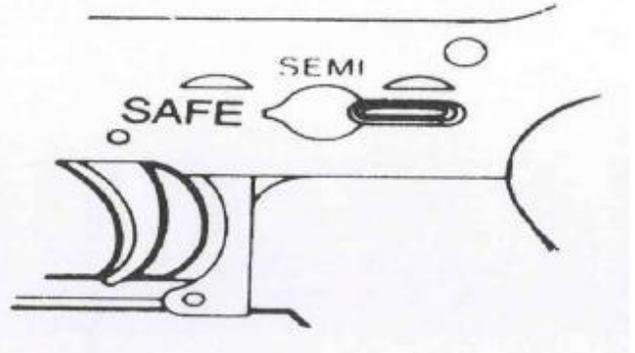
Failure to follow these rules can result in damage to property, injury or death. Always follow these

instructions and carefully read and refer to this manual before loading firearm.

Unloading and Clearing Your Rifle

To unload your rifle:

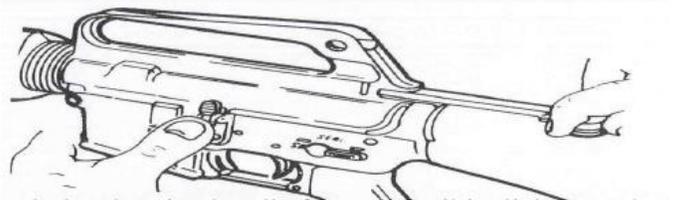
1. Keep your rifle pointed in a safe direction for the duration of this procedure
2. Place your selector on "SAFE". You cannot select "SAFE" unless the hammer is cocked.



3. Depress the magazine catch button and remove the magazine.
4. Eject the chambered cartridge by retracting the charging handle until it stops. Let the ejected cartridge fall to the ground.

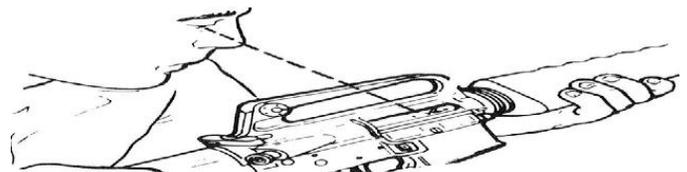
Unloading and Clearing Your Rifle

5. Lock the bolt open by depressing the bottom of the bolt catch.



If you cannot manipulate the charging handle and the bolt catch at the same time, you can use an empty magazine, which will activate the bolt catch for you.

6. Push the charging handle forward until it clicks to re-latch the charging handle.
7. Inspect the chamber and receiver to ensure you have removed all cartridges from the action.



Your rifle is now unloaded and Clear. It may now be loaded or prepped for transportation or storage.

Loading and Firing Your Rifle

To Load and fire your rifle: Begin with a rifle that has been verified to be unloaded using the preceding directions.

1. Keep your rifle pointed in a safe direction for the duration of the procedure.
2. Load your magazine with .223 Remington, 5.56x45 NATO (or 308 for BCA 10) cartridges. Place cartridge between the magazines feed lips and push down to seat.
3. Using firm and steady pressure insert the loaded magazine into the magazine well until the magazine catch locks the magazine in place. Do not slam the magazine into position; it will damage your magazine and rifle. Pull the magazine down to verify that it is locked in place.
4. Get into the shooting position you plan to use. Grasp the pistol grip in one hand and the hand guard in the opposite hand with the butt stock to your shoulder.
5. To chamber a cartridge you may depress the bolt catch or retract the charging handle until the bolt is no longer being held by the bolt catch. Release the charging handle. Do not maintain control of the charging handle while chambering a cartridge; this will cause the rifle to jam.

Your Rifle is now Loaded

Firing Your Rifle

The following is a description of the sequence for one complete firing cycle; beginning after a cartridge is chambered. Knowing the correct function of your rifle will help you with the diagnosis of any malfunctions or failures to fire. The trigger is pulled releasing the hammer; which strikes the firing pin. The firing pin impact the primer in the chambered cartridge igniting the primer which ignites the powder. As the powder is burned it creates a high volume of gas, which propels the bullet down the bore of the barrel. The exhaust gas is also vented out of the bore

through the gas tube and into the carrier key on the bolt carrier. The gas pushed the bolt carrier back unlocking your bolt from the barrel extension allowing the bolt carrier to recoil completely. The underside of the bolt will push the hammer down where it is caught and held by the disconnecter. The bolt will pull the spent cartridge out of the chamber and eject it from the rifle. At full recoil the carrier has pushed the buffer and buffer spring back into the receiver extension. The magazine will present a new cartridge, which will be stripped from the magazine by the bolt as the recoil spring pushes the bolt carrier group back into battery. The new cartridge is now chambered. The fire control group will reset once you have released the trigger allowing the disconnecter to release the hammer and re-engage the trigger's sear. The rifle is ready to be fired again.

**Safety always comes first.
Respect your rifle and it will respect you.**

Under no circumstance shall AJ Guns LLC be responsible for incidental or consequential damages with respect to economic loss or injury to property, whether as a result of express or implied warranty, negligence or otherwise. Altering or modifying parts is dangerous and will void the warranty. This rifle was manufactured to perform properly with original parts as designed. It is your duty to make sure any parts you buy are made for this rifle and are installed correctly and that neither replacements nor original parts are altered or changed.



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TROUBLESHOOTING	
Selector will not engage "SAFE"	
UNLOAD Rifle First	
INSPECT FOR	RESOLUTION
Fire control group is not cocked.	Fire control must be cocked.
Primer in fire control group.	Remove and Discard.
Selector frozen on "FIRE".	Disassemble, Clean, Lubricate and assemble correctly.
Too many cartridges in magazine.	Remove excess cartridges.
Magazine fails to lock into magazine well	
INSPECT FOR	RESOLUTION
Dirty or corroded magazine catch.	Disassemble, Clean, Lubricate and assemble correctly.
Worn or broken magazine catch.	Replace magazine catch.
Defective magazine	Replace magazine catch.
Defective magazine catch spring.	Replace magazine catch spring.
Ammunition will not feed into chamber.	
INSPECT FOR	RESOLUTION
Magazine not fully seated.	Seat magazine with firm pressure.
Too many cartridges in magazine.	Remove excess cartridges.
Incorrect caliber cartridges.	Replace with correct caliber cartridges.
Carbon in chamber, carrier key or on gas tube.	Clean.
Dirt, corrosion, or carbon buildup in barrel locking lugs.	Clean locking lugs on barrel and bolt.
Dirty or defective magazine.	Clean and lubricate or replace.
Dirty or corroded ammo.	Clean.
Damaged ammo.	Replace.
Action of buffer assembly is restricted.	Take out buffer and spring and clean.
Ejector or extractor is frozen.	Clean and oil or replace.

TROUBLESHOOTING	
Bolt Fails to Lock Open on Last Round	
Inspect For	Resolution
Dirt, Corrosion, or Carbon Buildup in Bolt and Carrier	Clean
Dirt, Corrosion, or Carbon Buildup in barrel locking lugs	Clean
Ejector Frozen	Clean and Oil
Defective Magazine	Replace
Dirty or corroded Bolt Catch	Clean or Replace
Burred or Broken Bolt	Contact Warranty Consultant
Rifle recoil spring in carbine stock	Install correct spring. Carbine spring should be 36 coils versus 44 for the A1 or A2 Rifle
Gas System is short stroking	See section on short stroking.
Short Stroking	
Inspect For	Resolution
Gaps in gas rings (not staggered)	Stagger gas rings
Gas rings worn	Replace gas rings
Carbon or dirt in carrier or on outside of gas tube	Clean
Obstruction inside of carrier key	Remove obstruction and clean
Weak or reloaded ammunition	Replace with factory fresh ammunition
Dirty Rifle	Clean
Improper Lubrication	Lubricate generously
Loss of gas power	Check and Clean entire gas path
Defective Magazine	Procedure for immediate action on next page

TROUBLESHOOTING	
Failure to FIRE	
UNLOAD Rifle First	
Inspect For	Resolution
Selector on "Safe"	Move Selector to "Fire"
Selector frozen on "Safe"	Disassemble, Clean, Lubricate and assemble correctly
Excess fouling or carbon on firing pin or in firing pin recess.	Disassemble, Clean, Lubricate and assemble correctly
Excess oil in firing pin recess.	Remove excess oil with pipe cleaner
Improper assembly of firing pin.	Assemble Correctly
Hammer spring installed incorrectly.	Assemble Correctly
Weak or broken hammer spring	Replace
Broken Firing Pin or Hammer	Replace
Defective Ammunition	Remove and Discard
Bolt not locked in battery	Extract Cartridge, clean area
Failure to Extract	
Inspect For	Resolution
Fouling or carbon in chamber	Clean
Fouling or carbon in extractor tip or recess.	Clean
Damaged or missing extractor spring.	Replace
Damaged or missing extractor spring insert.	Replace
Dirty or corroded ammunition.	Remove and Discard
Frozen or worn extractor	Disassemble and Clean or Replace
Restricted buffer assembly	Disassemble and Clean
Restricted movement of bolt carrier group	Remove, Clean, and Lube. When reinstalling the bolt carrier group check to insure it moves freely in the upper receiver
Clogged gas tube	Replace
Gas system is short stroking	See section for short stroking

TROUBLESHOOTING	
Cartridge Jammed in Action	
Inspect For	Resolution
Cartridge jammed between bolt and magazine or feed ramps.	
Double Feed.	
1. Remove Magazine	
2. Pull back and hold charging handle	
3. With the rifle positioned muzzle up; strike the butt stock on the ground.	
4. When the bolt is free of the cartridge lock the bolt open with the bolt catch.	
5. Remove and discard damaged casings or cartridges.	
6. Inspect the rifle for damage	
Spent casings lodged between bolt and charging handle.	
1. Remove Magazine	
2. Push in on bottom of bolt	
3. With the rifle positioned muzzle up strike the buttstock on the ground.	
4. The impact should dislodge the bolt from the casing and lock open.	
5. Remove and discard damaged casings if they did not fall out of the action on their own.	
6. Inspect the rifle for damage.	
Warning: If either of these procedures fail, do not attempt to disassemble the rifle and consult a qualified gunsmith.	

Before Firing Any Ammunition, inspect each cartridge for defects.

Dispose of cartridges that exhibit any of the following defects:

- Deformed brass. Including burrs, cracks, dents, scratches, bent or bowed cases.
- Deformed bullet. Including burrs, dents and scratches.
- Improperly seated bullets. The case neck should be uniform with no deformations and the bullet should be seated tightly in the case.
- Check overall length to ensure the bullet is not seated too deeply or has been pushed in from an impact.
- Improperly seated primers. The primer should be flush with the base of the case with no visible damage to the primer cup. Some ammunition may have a colored sealant around the primer.
 - Corroded cartridges. Any amount of metal that is corroded and eaten away.
- Do not fire cartridges exposed to extreme heat (135 F°) until they have cooled.

