


AMERICAN BUILT CUSTOM

ABC

RIFLE COMPANY

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WARNING!

SAFE GUN HANDLING IS YOUR RESPONSIBILITY!

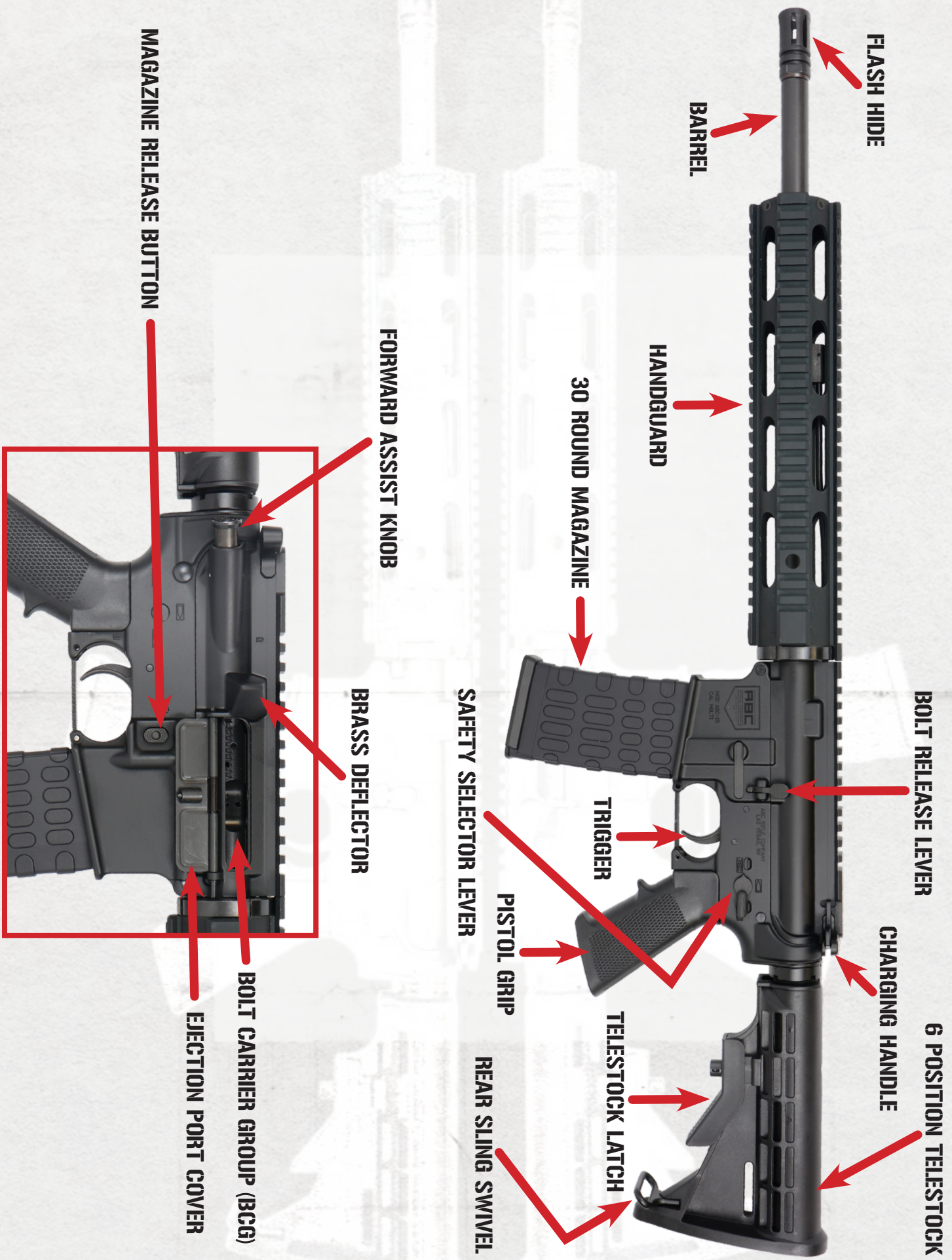
**IMPORTANT WARNING AND SAFETY PRECAUTIONS,
WHICH SHOULD BE READ AND UNDERSTOOD BEFORE USING THIS FIREARM.
DISREGARDING WARNING AND SAFETY PRECAUTIONS IN THIS MANUAL
MAY RESULT IN INJURY OR DEATH TO YOU AND OTHERS AND DAMAGE TO PROPERTY.
ONLY WHEN YOU ARE CERTAIN YOU HAVE FULLY FAMILIARIZED YOURSELF WITH THE FUNCTION OF YOUR FIREARM SHOULD
YOU PRACTICE LOADING, UNLOADING, AND FIRING WITH LIVE ROUNDS OF AMMUNITION.**

DISCLAIMER OF LIABILITY

**ABC RIFLE COMPANY SHALL NOT BE RESPONSIBLE FOR PRODUCT MALFUNCTION OR FOR PHYSICAL INJURY, DEATH OR
DAMAGE TO PROPERTY RESULTING FROM EITHER INTENTIONAL OR ACCIDENTAL DISCHARGE OF THIS FIREARM, CRIMINAL
USE OR NEGLIGENCE, UNAUTHORIZED MODIFICATIONS OR ALTERATION, USE OF DEFECTIVE OR IMPROPER OR FAULTY RE-
MANUFACTURED AMMUNITION. ABC RIFLE COMPANY HIGHLY RECOMMENDS THE USE OF HIGH QUALITY COMMERCIALY
MANUFACTURED AMMUNITION IN NEW CONDITION THAT IS BEST SUITABLE TO THE CALIBER OF YOUR RIFLE. ABC RIFLE
COMPANY SHALL NOT BE RESPONSIBLE FOR THE DAMAGES RESULTING FROM USE OF DEFECTIVE,
IMPROPER OR RELOADED AMMUNITION.**

GENERAL SAFETY WARNINGS

- 1. CARELESS AND IMPROPER HANDLING OF THIS GUN COULD RESULT IN UNINTENDED DISCHARGE CAUSING INJURY, DEATH OR PROPERTY DAMAGE. SAFETY MUST BE THE FIRST AND CONSTANT CONSIDERATION WHEN HANDLING A FIREARM AND AMMUNITION.**
- 2. THIS RIFLE WAS DESIGNED TO FUNCTION PROPERLY IN ITS ORIGINAL CONDITION. DO NOT ALTER ANY PARTS OR REPLACE PARTS.**
- 3. THIS RIFLE SHOULD ALWAYS BE CARRIED WITH CHAMBER EMPTY AND WITH THE SAFETY ON "SAFE" TO PREVENT ACCIDENTAL DISCHARGE.**
- 4. ALWAYS HANDLE AND TREAT YOUR FIREARM AS IF IT WERE LOADED SO YOU WILL NEVER FIRE IT ACCIDENTALLY WHEN YOU THINK IT IS UNLOADED. NEVER TAKE ANYONE'S WORD THAT IT IS UNLOADED. ALWAYS CHECK IT YOURSELF WITH YOUR FINGERS OFF THE TRIGGER AND THE GUN POINTED IN A SAFE DIRECTION.**
- 5. NEVER PLACE YOUR FINGERS INSIDE THE TRIGGER GUARD AREA UNLESS YOU INTEND TO FIRE.**
- 6. KEEP THE GUN'S MUZZLE POINTED IN A SAFE DIRECTION AT ALL TIMES. NEVER LET THE MUZZLE OF A FIREARM POINT AT ANY PART OF YOUR BODY, ANOTHER PERSON OR AT ANYTHING YOU DO NOT INTEND TO SHOOT. ALWAYS BE SURE OF YOUR TARGET BEFORE FIRING.**
- 7. UNLOAD ALL FIREARMS WHEN NOT IN USE. NEVER STORE A LOADED FIREARM. FIREARMS AND AMMUNITION SHOULD BE SAFELY STORED SEPARATELY SO THAT THEY ARE INACCESSIBLE TO CHILDREN OR UNAUTHORIZED USERS.**
- 8. ALWAYS MAKE SURE YOUR FIREARM IS NOT LOADED BEFORE CLEANING, STORING, OR HANDING IT TO ANOTHER PERSON.**
- 9. ALWAYS WEAR AND ENCOURAGE OTHERS TO WEAR EAR PROTECTION AND SAFETY GLASSES WHEN SHOOTING, ESPECIALLY ON THE RANGE. REPEATED EXPOSURE TO SHOOTING NOISE COULD RESULT IN PERMANENT HEARING LOSS.**
- 10. DISREGARD FOR YOUR SAFETY AND THAT OF OTHERS. NEVER USE A FIREARM WHILE YOU ARE TAKING MEDICATION UNLESS YOU HAVE CHECKED WITH YOUR DOCTOR TO ENSURE YOUR FITNESS TO HANDLE YOUR FIREARM SAFELY.**



FLASH HIDE

BARREL

HANDGUARD

30 ROUND MAGAZINE

BOLT RELEASE LEVER

CHARGING HANDLE

6 POSITION TELESTOCK

TELESTOCK LATCH

REAR SLING SWIVEL

PISTOL GRIP

TRIGGER

SAFETY SELECTOR LEVER

FORWARD ASSIST KNOB

BRASS DEFLECTOR

BOLT CARRIER GROUP (BCG)

EJECTION PORT COVER

MAGAZINE RELEASE BUTTON

FUNCTION OVERVIEW

ABC RIFLE COMPANY RIFLES ARE GAS OPERATED SEMIAUTOMATIC FIREARMS CHAMBERED IN 5.56MM NATO FOR USE WITH 5.56 NATO OR 223 REM CALIBER AMMUNITION. WHEN A ROUND IS FIRED, THE PRIMER IGNITES THE PROPELLANT IN THE ROUND. THE GAS PRESSURE FROM THE BURNING PROPELLANT PUSHES THE BULLET THROUGH THE BARREL OF THE RIFLE. STABILITY DURING THE FLIGHT TO THE TARGET IS OBTAINED BY THE ROTATION OF THE BULLET CAUSED BY THE RIFLING IN THE BARREL. ONCE THE BULLET NEARS THE END OF THE BARREL, THE GAS PRESSURE FROM THE BURNING PROPELLANT GOES THROUGH THE GAS PORT IN THE BARREL TO THE GAS KEY ON THE CARRIER AND FORCES THE CARRIER ASSEMBLY REARWARD. THIS ACTION EJECTS THE SPENT ROUND AND CHAMBERS A NEW ROUND.

IMPORTANT NOTICE

ALL RIFLES ARE FUNCTION TESTED AND TEST FIRED BEFORE BEING SHIPPED. THEREFORE, AT THE TIME OF PURCHASE CAREFULLY EXAMINE THE RIFLE TO BE SURE IT IS UNLOADED AND UNDAMAGED AND ALL COMPONENTS ARE INCLUDED.

SEEK YOUR DEALERS HELP FOR ASSISTANCE IN EXAMINING THE FIREARM AND TO ANSWER YOUR QUESTIONS.

ALWAYS CLEARING YOUR RIFLE BEFORE USE

ALWAYS HANDLE AND TREAT YOUR FIREARM AS IF IT IS LOADED!
NEVER ASSUME THAT A FIREARM IS UNLOADED. KEEP THE MUZZLE POINTED IN A SAFE DIRECTION.

TO CLEAR YOUR RIFLE OF AMMUNITION ASSURING IT IS UNLOADED

1. PLACE THE SAFETY SELECTOR LEVER TO THE "SAFE" POSITION (FIG. 1). NOTE: IF THE RIFLE IS NOT COCKED, THE SAFETY LEVER SELECTOR CANNOT BE MOVED TO THE "SAFE" POSITION
2. PRESS THE MAGAZINE CATCH BUTTON AND PULL THE MAGAZINE DOWN AND OUT OF THE RIFLE (FIG. 2).
3. LOCK THE BOLT OPEN BY PULLING THE CHARGING HANDLE REARWARD. PRESS THE BOTTOM OF THE BOLT CATCH AND SLOWLY RELEASE THE CHARGING HANDLE UNTIL IT CATCHES THE BOLT CATCH (FIG. 3). IF THE SAFETY SELECTOR LEVER WAS NOT PUT IN THE "SAFE" POSITION IN STEP 1, DO SO AT THIS TIME.



IMPORTANT

CHECK THE RIFLE TO MAKE SURE THERE IS NOT EXCESSIVE OIL IN THE BORE. ALWAYS CLEAN A NEW RIFLE BEFORE FIRING!

SAFETY SELECTOR LEVER FUNCTION AND CHECK

THE SAFETY SELECTOR IS LOCATED ON THE LEFT SIDE ON THE LOWER RECEIVER OF YOUR RIFLE AND HAS 2 POSITIONS: "FIRE" AND "SAFE."

NOTE: IF THE RIFLE IS NOT COCKED, THE SAFETY SELECTOR LEVER CANNOT BE MOVED TO THE SAFE POSITION. HOWEVER, WITH THE CHARGING HANDLE LOCKED IN THE REARWARD POSITION, THE SAFETY SELECTOR LEVER CAN BE MOVED TO EITHER POSITION.

WITH THE SAFETY SELECTOR LEVER IN THE HORIZONTAL POSITION ON THE LEFT SIDE AND POINTING TO "SAFE" THE FIREARM IS IN THE SAFE POSITION (FIG. 4). ON THE RIGHT SIDE OF THE LOWER RECEIVER THE "--" WITNESS MARK WILL BE POINTING TO "SAFE" (FIG 5).

IN THIS POSITION A CAM BEARS ON THE TRIGGER BLOCKING THE MOVEMENT AND PREVENTS THE HAMMER FROM BEING RELEASED.



WITH THE SAFETY SELECTOR LEVER IN THE VERTICAL POSITION AND POINTING TO "FIRE" ON THE LEFT SIDE OF THE LOWER RECEIVER, THE FIREARM WILL FIRE A SINGLE SHOT EACH TIME THE TRIGGER IS PULLED (FIG. 6). IN THE FIRE POSITION THE "--" WITNESS MARK WILL POINT TO THE "FIRE" MARK ON THE RIGHT SIDE OF THE RECEIVER (FIG. 7)



ALWAYS POSITION THE SAFETY SELECTOR LEVER IN THE SAFE POSITION WHEN LOADING AND UNLOADING THE RIFLE!

FUNCTION TEST OF SAFETY SELECTOR LEVER

- 1. PULL THE CHARGING HANDLE TO THE REAR AND RELEASE. PLACE THE SAFETY SELECTOR LEVER TO THE "SAFE" POSITION (FIG. 4). PULL THE TRIGGER. THE HAMMER SHOULD NOT FALL.**
- 2. MOVE THE SAFETY SELECTOR LEVER TO THE "FIRE" POSITION (FIG. 6). PULL THE TRIGGER. THE HAMMER SHOULD FALL.**
- 3. HOLD THE TRIGGER TO THE REAR. PULL THE CHARGING HANDLE TO THE REAR AND RELEASE. RELEASE THE TRIGGER WITH A SLOW AND SMOOTH MOTION UNTIL THE TRIGGER IS FULLY FORWARD.**

NOTE: AN AUDIBLE CLICK SHOULD BE HEARD. THE HAMMER SHOULD NOT FALL.

- 4. WITH THE HAMMER IN THE FORWARD POSITION (FIRED POSITION), ATTEMPT TO PLACE THE SAFETY SELECTOR LEVER TO THE "SAFE" POSITION. THE SAFETY SELECTOR LEVER SHOULD NOT BE ALLOWED TO MOVE TO THE "SAFE" POSITION WITH THUMB PRESSURE.**

AMMUNITION

USE ONLY HIGH QUALITY COMMERCIALY MANUFACTURED AMMUNITION IN GOOD CONDITION OF THE APPROPRIATE CALIBER.

THE CALIBER OF YOUR RIFLE IS MARKED ON THE BARREL. ABC RIFLE COMPANY RIFLES CHAMBERED IN 5.56 NATO WILL ALSO FIRE 223 REM CALIBER AMMUNITION. NOT ALL AMMUNITION PRODUCE THE SAME RESULT.

ABC RIFLE COMPANY DOES NOT RECOMMEND USING STEEL CASED, IMPORTED, HAND LOADED OR RE-MANUFACTURED AMMUNITION AND THE USE OF THIS AMMUNITION MAY VOID WARRANTY.

LOADING YOUR MAGAZINE

ALWAYS CHECK THAT THE AMMUNITION IS CLEAN AND UNDAMAGED. FORCING DAMAGED AMMUNITION INTO THE CHAMBER COULD RESULT IN DISASTER CAUSING INJURY, AND OR DAMAGE TO YOUR RIFLE.



FIG 8

LOAD THE MAGAZINE

USING ONLY HIGH QUALITY COMMERCIAL 5.56MM OR 223 REMINGTON AMMUNITION; LOAD THE MAGAZINE. WITH THE FRONT OF THE MAGAZINE FORWARD (FIG. 8), PLACE A ROUND BETWEEN THE MAGAZINE LIPS WITH THE ROUND POINTED FORWARD. PUSH THE ROUND DOWN INTO THE MAGAZINE UNTIL IT IS RETAINED BY THE MAGAZINE LIPS. PLACE THE NEXT ROUND ON TOP OF THE PREVIOUS ROUND AND PRESS DOWN AGAIN. REPEAT UNTIL THE DESIRED NUMBER OF ROUNDS ARE LOADED.

LOADING YOUR RIFLE

WITH THE BOLT IN THE CLOSED POSITION AND THE SAFETY SELECTOR LEVER ON "SAFE," INSERT THE LOADED MAGAZINE IN THE MAGAZINE WELL AND PUSH IT UP UNTIL IT IS RETAINED BY THE MAGAZINE CATCH. TAP THE BOTTOM OF THE MAGAZINE TO ENSURE THAT IT IS SEATED PROPERLY (FIG. 9). PULL THE CHARGING HANDLE REARWARD AND RELEASE AND THIS WILL CHAMBER A ROUND. TAP THE FORWARD ASSIST WITH THE HEEL OF YOUR HAND TO ENSURE THE BOLT IS FULLY FORWARD AND LOCKED (FIG 10).



FIG 9



FIG 10

THE RIFLE CAN ALSO BE LOADED WITH THE BOLT IN THE REAR POSITION. PULL THE CHARGING HANDLE REARWARD AND HOLD; DEPRESS THE BOTTOM OF THE BOLT RELEASE LEVER AND THEN SLOWLY RELEASE THE CHARGING HANDLE UNTIL IT CATCHES THE BOLT RELEASE LEVER (FIG 11). PUT THE SAFETY SELECTOR LEVER TO THE "SAFE" POSITION. INSERT THE LOADED MAGAZINE INTO THE MAGAZINE WELL AND PUSH IT UP UNTIL IS RETAINED BY THE MAGAZINE CATCH.

ENSURE IT IS PROPERLY SEATED (FIG. 9). DEPRESS THE TOP OF THE BOLT RELEASE LEVER AND THE BOLT WILL CLOSE AND CHAMBER A ROUND. TAP THE FORWARD ASSIST WITH THE HEEL OF YOUR HAND TO ENSURE THE BOLT IS FULLY FORWARD AND LOCKED (FIG. 10).

YOUR RIFLE IS NOW READY TO BE FIRED WITH A ROUND IN THE CHAMBER AND THE SAFETY SELECTOR LEVER ON "SAFE."

TAP THE BOTTOM OF THE MAGAZINE TO



FIG 11

FIRING YOUR RIFLE

DO NOT CHAMBER A ROUND UNTIL YOU ARE READY TO FIRE THE RIFLE. ALWAYS KEEP THE MUZZLE POINTED IN A SAFE DIRECTION. DO NOT DISENGAGE THE SAFETY UNTIL YOU ARE READY TO FIRE. ALWAYS WEAR EYE AND HEARING PROTECTION WHEN FIRING YOUR RIFLE.

1. WITH THE RIFLE LOADED AND SAFETY SELECTOR LEVER ON "SAFE," FIRMLY POSITION THE BUTTSTOCK TO YOUR SHOULDER WITH ONE HAND ON THE HANDGUARD AND THE OTHER HAND ON THE PISTOL GRIP WITH THE TRIGGER FINGER ALONG THE SIDE OF THE TRIGGER GUARD. DO NOT HAVE YOUR TRIGGER FINGER ON THE TRIGGER AT THIS TIME.

2. ALIGN THE FRONT AND REAR SIGHTS TO THE TARGET.

3. MOVE THE SAFETY SELECTOR LEVER TO THE "FIRE" POSITION (FIG. 12).

4. GENTLY PULL THE TRIGGER UNTIL THE HAMMER RELEASES AND THE RIFLE FIRES. RELEASE THE TRIGGER. THE SEMI-AUTOMATIC RIFLE WILL AUTOMATICALLY EJECT THE SPENT ROUND AND LOAD THE NEXT ROUND FROM THE MAGAZINE INTO THE CHAMBER. REPEAT PULLING THE TRIGGER AND RELEASING TO FIRE THE NEXT ROUND AND SUBSEQUENT ROUNDS. THIS CAN BE CONTINUED UNTIL THE MAGAZINE IS EMPTY.

5. WHEN FINISHED FIRING, REMOVE THE FINGER FROM THE TRIGGER AND MOVE THE SAFETY SELECTOR LEVER TO THE "SAFE" POSITION. AFTER THE LAST ROUND IS FIRED FROM THE MAGAZINE, THE BOLT CARRIER WILL LOCK IN THE REAR POSITION.

6. THE EMPTY MAGAZINE CAN BE REMOVED BY PUSHING THE MAGAZINE RELEASE BUTTON. TO CONTINUE THE FIRING SEQUENCE, INSERT ANOTHER LOADED MAGAZINE, RELEASE THE BOLT CATCH AND A NEW ROUND WILL BE CHAMBERED.



FIG 12

DISASSEMBLING YOUR RIFLE

MAKE SURE YOUR RIFLE IS UNLOADED BEFORE STARTING DISASSEMBLY.

THE DISASSEMBLY PROCEDURE IS AS FOLLOWS:

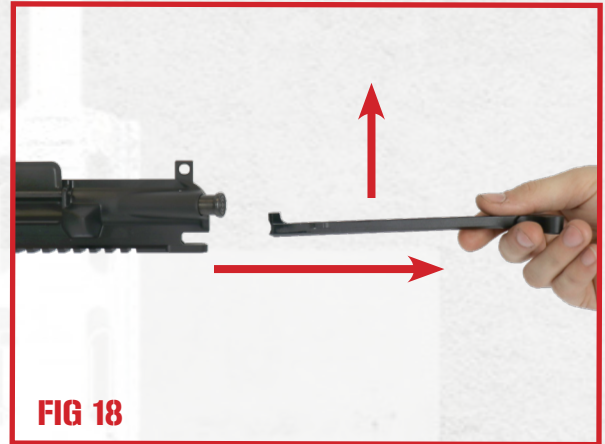
PUSH THE REAR TAKEDOWN PIN FROM THE LEFT SIDE OF THE RECEIVER AS FAR AS IT WILL GO TO THE RIGHT (FIG. 13).
PIVOT THE UPPER RECEIVER FROM THE LOWER RECEIVER.



PUSH THE FRONT TAKEDOWN PIN FROM THE LEFT SIDE OF THE RECEIVER AS FAR AS IT WILL GO TO THE RIGHT, AND
SEPARATE THE UPPER AND LOWER RECEIVER ASSEMBLIES (FIG. 14 & 15).



WITH THE UPPER RECEIVER IN THE UPSIDE DOWN POSITION, PULL THE CHARGING HANDLE AND BOLT CARRIER OUT AND
REMOVE BOLT CARRIER AND BOLT ASSEMBLY (FIG. 16 & 17). THEN REMOVE THE CHARGING HANDLE (FIG. 18).



REMOVE THE FIRING PIN RETAINING PIN FROM THE BOLT CARRIER (FIG. 19).



REMOVE THE FIRING PIN FROM THE REAR OF THE BOLT CARRIER (FIG. 20).



FIG 21

PUSH THE BOLT TO THE CLOSED AND LOCKED POSITION (FIG. 21).



FIG 22

ROTATE THE CAM PIN 1/4 TURN AND LIFT OUT OF THE BOLT CARRIER (FIG. 22).



FIG 23

PULL THE BOLT ASSEMBLY STRAIGHT OUT FROM THE BOLT CARRIER (FIG. 23).

CLEANING

ALWAYS CHECK THAT THE BARREL IS CLEAN AND DRY BEFORE FIRING YOUR RIFLE.

AFTER FIRING YOUR RIFLE, CLEAN IT AS SOON AS POSSIBLE TO PREVENT CORROSION AND MAKE THE JOB EASIER.

WHEN YOUR RIFLE HAS NOT BEEN FIRED, CLEAN IT ONCE OR TWICE A YEAR.

THE FOLLOWING ITEMS ARE RECOMMENDED FOR PROPER MAINTENANCE OF YOUR RIFLE: A HIGH QUALITY CLEANING KIT THAT INCLUDES A CLEANING ROD, BRASS BRISTLE BORE BRUSH AND CHAMBER BRUSH, SWAB HOLDER AND COTTON PATCHES (FIG. 24). GUN OIL/CLEANER/PRESERVATIVE, AND COTTON SWABS.



FIG 24

LUBRICATION

1. LIGHTLY LUBRICATE THE INSIDE OF THE UPPER RECEIVER, THE OUTER SURFACES OF THE BARREL, FRONT SIGHT SURFACES, REAR SIGHT WINDAGE KNOB AND ELEVATION DIAL, EJECTION PORT COVER LATCH AND SPRING, AROUND THE LOCKING LUGS AND THE FORWARD ASSIST. DEPRESS THE FRONT SIGHT DETENT AND APPLY 2 OR 3 DROPS OF OIL.

2. ON THE LOWER RECEIVER, LIGHTLY LUBRICATE THE INSIDE OF THE BUFFER TUBE, THE BUFFER, AND ACTION SPRING.

3. ON THE LOWER RECEIVER, GENEROUSLY LUBRICATE THE TRIGGER, HAMMER, SAFETY, BOLT CATCH, MAGAZINE RELEASE, AND TAKEDOWN PINS.

4. ON THE BOLT CARRIER GROUP, LIGHTLY LUBRICATE THE FIRING PIN, THE CHARGING HANDLE AND LATCH SPRING, BOLT CARRIER, EXTRACTOR, AND EXTRACTOR PIN.

ON THE BOLT, GENEROUSLY LUBRICATE THE BOLT, THE CAM PIN HOLE, AND THE GAS RINGS.

CLEANING PROCEDURE

ALWAYS CLEAN FROM THE BARREL BORE CHAMBER END TO THE MUZZLE. ATTACH A COTTON PATCH TO THE CLEANING ROD, INSERT IT IN THE CHAMBER AND PASS IT THROUGH THE BORE. CONTINUE UNTIL THE PATCH COMES OUT CLEAN. IF THE GUN HAS BEEN FIRED, ATTACH A BRASS BRISTLE BORE BRUSH TO THE CLEANING ROD AND DIP THE BRUSH IN GUN CLEANING SOLUTION AND THOROUGHLY SCRUB OUT THE BARREL (FIG 25). MAKE SURE TO GO ALL THE WAY THROUGH THE BARREL AND OUT THE MUZZLE END BEFORE REVERSING DIRECTION. (FIG. 26).

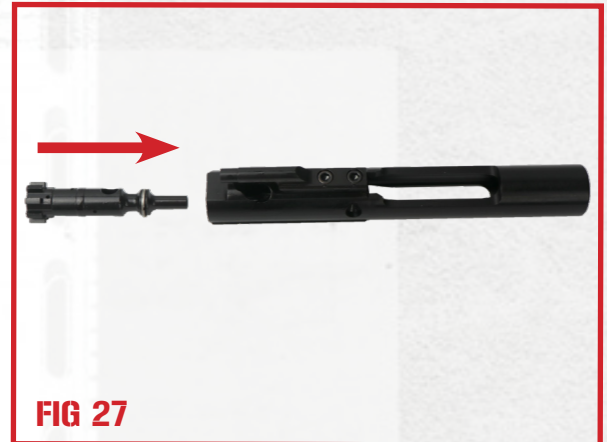
- 1. CLEAN THE CARBON AND POWDER RESIDUE AROUND THE GAS TUBE IN THE UPPER RECEIVER, THE BOLT ASSEMBLY AND INSIDE THE BOLT CARRIER.**
- 2. WIPE COMPONENTS CLEAN AND INSPECT DAMAGE, EXCESSIVE WEAR, AND CORROSION. CLEAN OUT THE GAS KEY AND CARRIER VENT HOLES WITH A COTTON SWAB**
- 3. CLEAN THE LOWER RECEIVER. NEVER USE A WIRE BRUSH OR ANY ABRASIVE TO CLEAN THE ALUMINUM LOWER OR UPPER RECEIVER. CLEAN THE TRIGGER MECHANISM, MAGAZINE RELEASE BUTTON, THE CAVITY OF THE MAGAZINE CATCH ON THE LEFT SIDE OF THE RECEIVER, BOLT CATCH, TAKEDOWN PINS, BUFFER, ACTION SPRING, AND INSIDE OF THE BUFFER TUBE.**



ASSEMBLING YOUR RIFLE

1. INSTALL THE BUFFER INTO THE ACTION SPRING. DEPRESS THE BUFFER DETENT AND PUSH THE BUFFER PAST THE DETENT, THEN RELEASE THE DETENT (FIG. 27).

2. INSERT THE BOLT INTO THE BOLT CARRIER (FIG. 41). INSERT THE CAM PIN (FIG. 28). NOTE: THE CAM PIN CAN ONLY BE INSTALLED IN THE BOLT FROM ONE SIDE, IF THE CAM PIN DOES NOT FIT, ROTATE THE BOLT 180° AND TRY AGAIN.



3. ONCE THE CAM PIN IS INSTALLED, ROTATE IT 90° TO ALLOW FIRING PIN INSTALLATION.

4. INSTALL THE FIRING PIN (FIG. 29), PULL THE BOLT OUT (FIG. 30) AND INSTALL THE FIRING PIN RETAINING PIN (FIG. 31).





5. INSERT THE CHARGING HANDLE INTO THE UPPER RECEIVER AND LOWER THE HANDLE UNTIL THE SIDE TABS ON THE FRONT END OF THE HANDLE FIT INTO THE CUTOUTS IN THE RECEIVER. THEN SLIDE THE CHARGING HANDLE PARTIALLY INTO THE RECEIVER.



6. INSERT THE COMPLETE BOLT CARRIER ASSEMBLY INTO THE UPPER RECEIVER SO THAT THE GAS KEY FITS INTO THE GROOVE OF THE CHARGING HANDLE (FIG. 32).

NOTE: THE BOLT MUST BE IN THE OUT POSITION IN THE CARRIER FOR INSTALLATION.



7. PUSH THE BOLT CARRIER ASSEMBLY AND CHARGING HANDLE ALL THE WAY INTO THE UPPER RECEIVER UNTIL THE CHARGING HANDLE LATCH LOCKS ONTO THE RECEIVER (FIG. 33).

8. MATE THE UPPER RECEIVER TO THE LOWER RECEIVER. POSITION THE PIVOT PIN LUG OF THE UPPER RECEIVER INTO THE SLOT AT THE FRONT OF THE LOWER RECEIVER AND PUSH THE PIVOT PIN INTO PLACE (FIG. 34).



9. MAKE SURE THE SAFETY SELECTOR LEVER IS IN THE "SAFE" POSITION BEFORE PIVOTING THE UPPER RECEIVER DOWN TO THE LOWER RECEIVER.

10. AFTER THE RECEIVERS ARE CLOSED, PUSH IN THE REAR TAKEDOWN PIN.

STATEMENT OF LIMITED LIFETIME WARRANTY

HOW LONG IS THE WARRANTY PERIOD?

LIMITED LIFETIME FROM THE DATE OF PURCHASE (ORIGINAL PURCHASER ONLY)

WHAT IS COVERED?

ANY DEFECT IN MATERIALS OR WORKMANSHIP (PERFORMED BY ABC RIFLE COMPANY) ENCOUNTERED DURING NORMAL USE.

ABC RIFLE COMPANY RESERVES THE RIGHT TO DETERMINE WHAT CONSTITUTES THE UNREASONABLE OR EXCESSIVE USE OF THE FIREARM.

THIS LIFETIME WARRANTY COVERS FUNCTIONAL DEFECTS ONLY; IT DOES NOT INCLUDE THE FIREARM'S FINISH, GRIPS, MAGAZINES, SIGHTS, FIRING PINS, BOLT ASSEMBLY OR ACCESSORIES ETC.

WHAT IS NOT COVERED?

ABC RIFLE COMPANY SHALL NOT BE LIABLE FOR CONSEQUENTIAL OR INCIDENTAL DAMAGES OR INJURY. PERSONAL INJURY, PROPERTY DAMAGE, AND/OR DAMAGE TO THE FIREARM CAUSED BY: NORMAL WEAR AND TEAR /RUST OR CORROSION BLEMISHES, SCRATCHES, AND OR DISCOLORATION IN FINISH DAMAGE DUE TO IMPROPER MAINTENANCE AND OR NEGLIGENCE TO PROVIDE PROPER CARE AND MAINTENANCE. 'BARREL OBSTRUCTIONS, BOLT ASSEMBLIES, FIRING PINS.

IMPORTANT NOTE:

ANY UNAUTHORIZED ALTERATION,REPAIR OR MODIFICATION OF THE FIREARM OR USE OF PARTS OR COMPONENTS NOT ORIGINALLY MANUFACTURED AND OR INSTALLED BY ABC RIFLE COMPANY SHALL VOID THIS WARRANTY. ABC RIFLE COMPANY SHALL NOT BE RESPONSIBLE FOR ANY CLAIMS INVOLVING THIS FIREARM THAT RESULT FROM THE USE OF FAULTY, NONSTANDARD, RE-MANUFACTURED, RELOADED AND OR IMPORTED STEEL CASED AMMUNITION AND THE USE OF SUCH AMMUNITION SHALL ALSO VOID THIS WARRANTY.

ABC RIFLE COMPANY WILL, AT ITS SOLE DISCRETION, REPAIR OR REPLACE ANY FIREARM MANUFACTURED BY ABC RIFLE COMPANY THAT FAILS DUE TO A DEFECT IN MATERIALS OR WORKMANSHIP. PARTS AND LABOR ARE INCLUDED. REPAIRS ARE WARRANTED FOR THE DURATION OF THE WARRANTY. ABC RIFLE COMPANY RESERVES THE RIGHT TO SUBSTITUTE PARTS NEEDED TO COMPLETE A WARRANTY REQUEST IF THE MODEL OF FIREARM IS NO LONGER OFFERED OR PARTS NEEDED FOR REPLACEMENT AND OR REPAIR ARE NOT AVAILABLE. ABC RIFLE COMPANY ADVISES THAT THE CUSTOMER REMOVE ALL OPTICS, LASERS, ETC. PRIOR TO SHIPPING AND WILL NOT BE HELD RESPONSIBLE FOR LOST OR DAMAGED ACCESSORIES.

RETURN SHIPPING

RETURNED FIREARMS MUST BE PACKAGED SECURELY IN AN UNMARKED STURDY BOX. ABC RIFLE COMPANY SHALL NOT BE HELD LIABLE FOR RETURN SHIPPING COST ON WARRANTY CLAIMS AFTER 30 DAYS FROM DATE OF PURCHASE. IT IS RECOMMENDED THAT YOU SEND YOUR RETURN USING A RELIABLE CARRIER AND A METHOD THAT CAN BE TRACKED AND INSURED. WE ARE NOT RESPONSIBLE FOR ANY RETURN PACKAGES LOST OR DAMAGED IN TRANSIT. ALL RETURNS MUST BE PRE-AUTHORIZED BY ABC RIFLE COMPANY AND YOU MUST BE ISSUED A RMA # BEFORE RETURNING ANY PART AND OR FIREARM. ALL ACCESSORIES MUST BE REMOVED FROM FIREARM PRIOR TO RETURNING AND ABC RIFLE COMPANY SHALL NOT BE HELD LIABLE FOR DAMAGED AND OR MISSING ACCESSORIES IF SHIPPED ALONG WITH A RETURN FIREARM.

EMAIL: WARRANTY@ABCRIFFLE.COM FOR RETURN AUTHORIZATION NUMBER

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AMERICAN BUILT CUSTOM

AAC

RIFLE COMPANY

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USA**