Thank you for buying an ADVANCED ARMAMENT CORP. (AAC) product.

PLEASE PRACTICE SAFE FIREARMS HANDLING!

WARNING: IF THIS FIREARM IS CARELESSLY OR IMPROPERLY HANDLED, UNINTENTIONAL DISCHARGE COULD RESULT AND COULD CAUSE INJURY, DEATH, OR DAMAGE TO PROPERTY.

CAUTION: CAREFULLY READ THIS INSTRUCTION MANUAL PRIOR TO LOADING AND FIRING THIS FIREARM. FOLLOW ALL INSTRUCTIONS ON THE PROPER HANDLING AND SAFE USE OF THIS FIREARM – LIVES MAY DEPEND ON IT!

CAUTION: USE ONLY CLEAN, DRY, HIGH QUALITY COMMERCIAL MANUFACTURED AMMUNITION IN GOOD CONDITION which is appropriate to the caliber of your firearm. AAC does not recommend the use of remanufactured or hand loaded ammunition because it may damage your rifle.

WARNING: THIS WEAPON COULD CHAMBER A ROUND if it is dropped or jarred with a loaded magazine in place – either with the Bolt Carrier Assembly locked to the rear, or in its forward position.

FUNDAMENTAL RULES FOR SAFE GUN HANDLING

ALWAYS KEEP THE GUN POINTED IN A SAFE DIRECTION.
NEVER LOAD THE GUN UNTIL READY TO USE.
KEEP YOUR FINGER OFF THE TRIGGER UNTIL READY TO SHOOT.

WARNING: BEWARE OF DANGEROUS PROCEDURES

• Be sure Cam Pin is installed in the Bolt Group. If it isn’t, your rifle can still fire and WILL EXPLODE.
• When using a Blank Firing Attachment, NEVER FIRE ANYTHING EXCEPT BLANKS! For your safety, we recommend the visible, military style blank firing attachment (for example, BUSHMASTER FIREARMS Part# RAY-008).
• If your rifle stops firing with a live round in the chamber of a hot barrel (a misfire), REMOVE THE ROUND FAST! However, if you cannot remove it within 10 seconds, remove magazine and wait 15 minutes with the Rifle Pointing in a SAFE DIRECTION! This way you won’t be hurt by a possible round “cooking-off” (i.e. the round detonating just from the heat of the barrel). In any event, keep your face away from the ejection port while clearing a hot chamber.
• If your bolt fails to unlock, and you try to free it by tapping the buttstock on the ground while pulling on the charging handle, keep yourself clear of the Muzzle!
• If there is water in the barrel, do not fire the rifle. IT COULD EXPLODE!
• If you hear a noticeable difference in sound or recoil is experienced, STOP FIRING! Either condition could indicate an incomplete powder burn and/or a bullet stuck in the bore.

NOTE: With the bolt carrier assembly locked to the rear, or in its forward position, if the weapon is dropped or jarred with a loaded magazine in place, a live round could be chambered.

ALWAYS PRACTICE SAFE FIREARMS HANDLING!

ABOUT YOUR AAC RIFLE

• This Operating Manual covers all AAC AR15-style rifles. They are lightweight, gas operated, air-cooled, magazine-fed rifles, carbines or pistols that are Semi-Automatic in operating mode (i.e., a single round will fire each time the trigger is pulled). Note: For Law Enforcement and Military markets, AAC makes similar models in either Full-Automatic (continuous fire as long as the trigger is pulled) or Three Round Burst (a group of 3 shots will fire as long as the trigger is pulled) configurations. Sales of these models require special permits and are regulated by ATF.

• On all models, the Upper and Lower Receivers are easily opened for cleaning and inspection. Rifle models have forged aluminum Upper and Lower Receivers.

• Specifications subject to change without notice.

• All models can be configured with either 6 position Telescoping Buttstocks or solid A2 “Trapdoor” Buttstocks. All models feature vertical pistol grips and detachable magazines.

RIFLE FEATURES & CONTROLS - IDENTIFICATION / LOCATION...

Note: ATF Regulations require a minimum barrel length of 16” on commercially available rifles and carbines. This 16” length can be a combination of barrel and permanently fixed (pinned & welded over) muzzle brake / flash suppressor as long as total length equals 16’.

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CLEARING YOUR RIFLE

$\text{\textbullet}$ ALWAYS FOLLOW THE RULES OF SAFE GUN HANDLING. First, assume the gun you are handling is loaded, and then proceed according to the following steps - to CLEAR YOUR RIFLE

1. Point Rifle in a SAFE DIRECTION! Place Safety Selector Lever on SAFE. $\text{\textbullet}$ NOTE: If the rifle is not cocked, the Safety Selector Lever cannot be pointed toward SAFE. (Figure 1)
2. Press Magazine Catch Button and pull Magazine down to remove. (Figure 2)
3. To Lock Bolt Open, Pull Charging Handle rearward. Press bottom of Bolt Catch and allow Bolt to move forward until it engages Bolt Catch. Return Charging Handle to forward. If you haven’t before, now place Safety Selector Lever on SAFE. (Figure 3)

PREVENTATIVE MAINTENANCE CHECKS & SERVICES

1. Check to see that there is NO EXCESSIVE OIL in the Bore. If there is, swab it out with a patch and the cleaning rod. ALWAYS CLEAN A NEW RIFLE BEFORE FIRING. $\text{\textbullet}$ WARNING! If the rifle is fired with oil - or water - in the barrel, excessive pressure will be created causing the rifle to explode.
2. Retract the Bolt to ensure free movement between Bolt Carrier and Gas Tube. (Figure 4)
3. Perform Safety Function Check (below) to ensure that Safety Selector Lever works properly.

SAFETY FUNCTION CHECK

1. Remove Magazine if installed. Pull Charging Handle assembly to rear. Check that Chamber is clear. Let the Bolt and Bolt Carrier close. Do not pull Trigger. Leave Hammer in cocked position. $\text{\textbullet}$ WARNING: If Rifle fails any of the following tests, continued use of the Rifle could result in injury to, or death of, people around you.
2. Place Selector Lever in SAFE position, point rifle in a safe direction, and pull Trigger. (Figure 5) THE HAMMER SHOULD NOT FALL.

PREPARING TO FIRE - LOADING A MAGAZINE

1. Use only quality factory ammunition suitable for your firearm. Examine each Cartridge - particularly around the primer. Look for dents, scratches, and other signs of damage. DO NOT LOAD DAMAGED AMMUNITION!
2. With the Magazine facing forward as shown in figure 7, place a Round between the Feed Lips of the Magazine with the Bullet Tip forward. Push the Round down until it is held by the Magazine Feed Lips.
3. If necessary, give the Round a slight push backward to seat it against the inside back edge of the Magazine Feed Lips. Place next Round on top of the previous Round and repeat steps until desired number of Rounds are loaded into Magazine. CAUTION: Safe Firearms Handling dictates that you ONLY LOAD LIVE AMMUNITION INTO YOUR RIFLE WHEN YOU ARE ABOUT TO SHOOT.

OPERATION OF YOUR RIFLE - LOADING

CAUTION: ALWAYS POINT THE MUZZLE IN A SAFE DIRECTION!

1. With the Hammer cocked, place Selector Lever on SAFE. Open Bolt and check Firing Chamber. Make sure it is CLEAR! (Figure 8)
2. Return Charging Handle to forward, locked position. Push Magazine up into Magazine Well until Magazine Catch engages and holds the Magazine. (Figure 9)
3. Slap upwards on Magazine bottom to make sure it is seated correctly.
CHAMBERING A ROUND FROM AN OPEN BOLT

NOTE: The Magazine may be inserted into the Rifle with the Bolt Assembly Open or Closed.

1. Depress upper portion of Bolt Catch. Bolt should spring forward. This will chamber a round from the Magazine. (Figure 10)
2. TAP the Forward Assist with the heel of your hand to ensure that the Bolt is fully forward and locked. (Figure 11)
   RIFLE IS NOW READY TO BE AIMED AND FIRED!

CHAMBERING A ROUND FROM A CLOSED BOLT

1. With a Magazine in the Rifle, pull the Charging Handle fully to Rear. Then release the Charging Handle allowing the Bolt to spring forward – chambering the first round. (Figure 12)
2. NEVER “Ride” or push the Charging Handle forward (Figure 13). Let it move forward on its own.
   TAP the Forward Assist to ensure that the Bolt is fully forward and locked. (Figure 11)
   RIFLE IS NOW READY TO BE AIMED AND FIRED!

NOTE: If Rifle is not going to be fired immediately, make sure the Selector Lever is still on SAFE, and close the Ejection Port Cover to keep dirt out of the Chamber and Upper Receiver.

CONDITION: Rifle is now Loaded, a Round is Chambered, and Safety Selector should be on SAFE. CAUTION: ALWAYS POINT THE MUZZLE IN A SAFE DIRECTION!

FIRING THE RIFLE

To FIRE the Rifle in SEMI-AUTOMATIC MODE (one Round fired with each pull of the Trigger), move the Safety Selector from SAFE to FIRE. (Figure 14)

Aim at Target — Pull Trigger — Release. The Rifle will automatically eject the spent Cartridge and chamber another in preparation for the next shot. The cycle of pulling the Trigger to shoot, and the Rifle automatically reloading, can be continued until the Magazine is empty.

NOTE: If the last Round is fired, the Bolt Carrier will lock in the rear position. You can then push the Magazine Release Button to drop out the empty magazine, insert a fresh Magazine, release the Bolt Catch, and a new Round will be automatically chambered in preparation for the next firing sequence.

WARNING … IF A NOTICEABLE DIFFERENCE IN SOUND OR RECOIL IS EXPERIENCED, STOP FIRING.
Either condition could indicate an incomplete powder burn and/or a bullet stuck in the bore. Retract the Bolt slowly and remove the fired cartridge case. Clear the weapon and check for unburned powder grains in the Receiver or Bore, and for a Bullet stuck in the Bore (see Page 17). Clean out any unburned powder before resuming firing. If a Bullet is stuck in the Bore, do not attempt to remove it. Take the Rifle to a qualified Gunsmith.

IMMEDIATE ACTIONS — IN CASE OF TROUBLE!

IF YOUR RIFLE STOPS FIRING. Perform the following IMMEDIATE ACTIONS:

1. SLAP upward on Magazine to make sure it is properly seated. (Figure 15)
2. PULL Charging Handle all the way back. Observe the ejection of the Case or Cartridge. Check Firing Chamber for any obstruction. (Figure 16)
   WARNING: DO NOT LOAD WITH A HOT CHAMBER — A ROUND MAY “COOK OFF”. “Cooking Off” means that a Round may Detonate (Fire) unexpectedly just from being exposed to the heat of the Rifle’s Firing Chamber.
3. If Cartridge or Case is ejected, or Chamber is clear, RELEASE Charging Handle to feed a new Round. Don’t “ride” the Charging Handle forward. (Figure 17)
4. Tap Forward Assist to ensure Bolt is locked. (Figure 18)
5. Now FIRE. If the Rifle will not fire, look for trouble and apply the Remedial Actions described next. (Figure 19)
REMEDIAL ACTIONS

WARNING: IF YOUR RIFLE STOPS FIRING WITH A LIVE ROUND IN THE CHAMBER OF A HOT BARREL, REMOVE THE ROUND FAST. However, if you cannot remove it within 10 seconds, remove the magazine and wait 15 minutes with the rifle pointing in a safe direction (always check that the “SAFE” direction remains safe during that time). This way you and those around you won’t get hurt by the possibility of a round “cooking off”. KEEP YOUR FACE AWAY FROM THE EJECTION PORT WHILE CLEARING A HOT CHAMBER.

1. If your Rifle still fails to fire after performing Immediate Action Steps 1 through 5 on previous Page, check again for a jammed cartridge case.
2. If a cartridge case is in the chamber, open the receivers, remove the bolt carrier, and try to tap out the case with a cleaning rod.

IF RIFLE STILL FAILS TO FIRE, CHECK THE TROUBLESHOOTING SECTION IN THIS MANUAL — OR TAKE THE RIFLE TO A QUALIFIED GUNSMITH.

BULLET STUCK IN THE BORE...

WARNING: IF AN AUDIBLE “POP” OR REDUCED RECOIL IS EXPERIENCED DURING FIRING, IMMEDIATELY CEASE FIRE: Then, (1.) Remove the Magazine, (2.) Lock the Bolt to the rear, (3.) Place the Selector Lever on the SAFE and visually inspect and/or insert a Cleaning Rod into the Bore to ensure there is not a Bullet stuck in the Bore.

IF A BULLET IS STUCK IN THE BARREL OF THE WEAPON, DO NOT TRY TO REMOVE IT. TAKE THE RIFLE TO A QUALIFIED GUNSMITH.

FRONT AND REAR SIGHTS

AAC rifles are made to work with standard AR-compatible flip-up or fixed sights. Please refer to the documentation that comes with your chosen sights for information on mounting, adjusting, and zeroing the sights.

DISASSEMBLING YOUR RIFLE

1. CLEAR YOUR RIFLE! (as described on Page 4).
2. Push in Takedown Pin (a Bullet tip can help) as far as it will go.
   Pivot Upper Receiver from Lower Receiver. (Figure 20)
3. Push in Pivot Pin (a Bullet tip can help). (Figure 21)
4. Separate Upper and Lower Receivers. (Figure 22)
5. Pull back Charging Handle and Bolt Carrier. (Figure 23)
6. Remove Bolt Carrier and Bolt. (Figure 24)
7. Remove Charging Handle by pulling back and up until “Ears” clear cutouts in Receiver. (Figure 25)
8. Remove Firing Pin Retaining Pin. A Bullet tip can help push it out of the Bolt Carrier. (Figure 26)
9. Drop Firing Pin out of rear of Bolt Carrier. (Figure 27)
   NOTE: Do Not open or close split end of Firing Pin Retaining Pin, and Do Not substitute a common cotter pin on reassembly.
10. Push Bolt in to locked position. (Figure 28)
11. Remove Cam Pin by rotating 1/4 turn and lifting out. (Figure 29)
12. Remove Bolt Assembly from Bolt Carrier by pulling straight out. (Figure 30)

DISASSEMBLE USING STEPS 13 THRU 16 ONLY WHEN PARTS ARE DIRTY OR DAMAGED.

NOTE: Press rear of Extractor to check Spring function.

13. Remove Extractor Pin by pushing out with a punch or the tip of a Bullet. (Figure 31) PUSH EXTRACTOR PIN OUT... Don’t lose it!
ALWAYS CLEAN FROM CHAMBER TOWARD THE MUZZLE. Follow these steps:

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 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 – 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 out the Bore with a patch moistened with “CLP”.

4. Remove Patch Holder and attach Bore Brush (leaving it two turns short of tight).

5. Pull the Brush through the Bore and out the Muzzle. You should be able to see the Rod twisting as you pull it – this is the Brush “tracking” in the rifling. NEVER reverse the direction of the Bore Brush while it is in the Bore.

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 up and repeat the process.

7. Send a patch through the Bore occasionally to help clean out the crud that the brush is getting loose. Just replace the Bore Brush with the Rod Tip (Patch Holder) and a wet patch. Pull it through. If you leave the rods loose again, the patch will “track” in the rifling as before. But remember, always have the Bore wet with cleaner before trying to pull a brush through.

CLEANING THE BOLT, BOLT CARRIER & COMPONENTS

1. Clean out the Gas Key on top of the Bolt Carrier with a Q-Tip or a Pipe Cleaner. Also clean out all carbon/powder residue from vent holes in the Bolt Carrier. (Figure 35)

2. Clean and inspect Bolt, Cam Pin, Firing Pin, Firing Pin Retaining Pin, extractor and extractor spring thoroughly. (Figure 36)
CHECK THE BOLT: Look for cracks or fractures, especially in the Cam Pin hole area. Inspect Bolt Face – Bolts with any pitting extending into the firing pin hole should be replaced.

CHECK THE CAM PIN: If it is cracked, or chipped, it should be replaced. NOTE: Cam Pin can only be installed in Bolt from one side – so Ejector will be positioned correctly.

CHECK THE FIRING PIN: If it is bent, cracked, too blunted or too sharp, it should be replaced.

CHECK THE FIRING PIN RETAINING PIN: If it is bent, or badly worn, it should be replaced. Never use a “Cotter Pin” as a substitute for a real Firing Pin Retaining Pin. Cotter pins are not made of heat treated spring steel and their round head shape will cause damage.

⚠️ WARNING: IF THE CAM PIN IS MISSING, DO NOT FIRE THE RIFLE – IT WILL EXPLODE!

CHECK THE EXTRACTOR AND EXTRACTOR SPRING: If the Extractor is chipped, or has broken edges in the area of the lip that engages the cartridge rim, it should be replaced. Check that the rubber insert is inside the Extractor Spring and the Extractor Spring is inside the Green Rubber O-Ring (Figure 37). Clean off any Carbon buildup or powder residue.

REASSEMBLING YOUR RIFLE

1. Insert Action Spring and Buffer (the Spring will lock onto the Buffer if you slide it on – then push and twist counterclockwise). Depress Buffer Detent and push Buffer in past the Detent, then release.

2. Insert Extractor and Spring.

NOTE: Extractor Assembly has a Rubber Insert within the Spring. Be sure not to lose it. If the Spring comes loose, put the large end of the Spring in the extractor and seat it (a Bullet tip works well). (Figure 40)

CLEANING / LUBRICATING THE EJECTOR

NOTE: The design of the Ejector makes its disassembly for cleaning somewhat impractical (i.e. we don’t recommend it).

Make sure your Rifle ejects empty cases efficiently by following these steps on a monthly basis:

1. Take a fired or dummy case and place it under the lip of the Extractor. With a rocking motion, press the case down against the Ejector. Since the Ejector is spring loaded, some resistance will be felt. Press on the case until it stops against the bolt face. Ease off with your thumb slightly and press down again. Repeat several times. Replace the CLP frequently. Once the spring action of the Ejector is smooth and strong, dry off any excess lubricant.

2. Lightly lubricate the Charging Handle and it’s Carrier Key: The inside of the Carrier Key on the Bolt Carrier should be dried with a Q-Tip or Pipe Cleaner — if you slide it on – then push and twist counterclockwise). Depress Buffer Detent and push Buffer in past the Detent, then release.

3. Buttstocks may require cleaning as necessary. Telescoping Stock Latch can be pulled down to remove Stock.

CLEANING THE LOWER RECEIVER

1. Clean all areas of 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 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. Buttstocks may require cleaning as necessary. Telescoping Stock Latch can be pulled down to remove Stock.

Clean the 6 Position Lock Holes, and lightly lube the Receiver Extension and Latch Mechanism to ensure proper telescoping action. A2 Solid Buttstocks may require cleaning / lubrication of Storage Compartment Door Latch and Hinge, and interior of Storage Compartment.

LUBRICATION – UPPER & LOWER RECEIVERS...

UPPER RECEIVER

LOWER RECEIVER EXTENSION: Lightly lubricate inside the Lower Receiver Extension (Buffer Tube), the Buffer and the Action Spring. Also lightly lubricate the Telescopelatch and exterior of the Receiver Extension.

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 (they can start the corrosion process). A black cloth is best as it won’t leave visible lint.

FIRING PIN: Lightly lubricate the Firing Pin with CLP – also the Firing Pin recess in the Bolt.

BOLT: Generously lubricate the Bolt, its Cam Pin area, the Bolt Gas Rings. A lighter application is good on the Extractor and it’s Pin.

CHARGING HANDLE: Lightly lubricate the Charging Handle and it’s Latch and Spring.

BOLT CARRIER: Lightly lubricate the inner and outer surfaces of the Bolt Carrier. Generously lubricate the Cam Pin area and the “Slide” Rail areas of the Bolt Carrier where they contact the inside of the Receiver. (Figure 39)

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.

RECEIVERS…”

LOWER RECEIVER EXTENSION: Lightly lubricate inside the Lower Receiver Extension (Buffer Tube), the Buffer and the Action Spring. Also lightly lubricate the Telescoping Stock Latch and exterior of the Receiver Extension.

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 (they can start the corrosion process). A black cloth is best as it won’t leave visible lint.
3. Then push down on Extractor to depress Spring, and reinsert Extractor Pin.

4. At the back end of the Bolt, stagger the Gas Ring Gaps to reduce gas pressure loss. Position the three ring gaps 120° apart around the bolt (3rd gap not seen at back side of bolt). (Figure 41) The rings will slide around in their groove by pushing them into position with a small sharp object.

5. Insert Bolt into Bolt Carrier. Twist into position so Cam Pin can be inserted (Figure 42) (Remember, the Cam Pin can only be installed in Bolt from one side, so if it doesn’t fit right away, twist the Bolt 180° and try again).

6. Once Cam Pin is inserted, twist it 90° (this will allow insertion of the Firing Pin).

**WARNING: THE CAM PIN MUST BE INSTALLED IN THE BOLT GROUP. IF IT ISN’T, YOUR RIFLE CAN STILL FIRE AND WILL EXPLODE!**

7. Drop in and seat Firing Pin. Pull Bolt out (Figure 43), then reinsert Firing Pin Retaining Pin. (Figure 44)

**NOTE:** After inserting Firing Pin Retaining Pin, Firing Pin should not fall out when Bolt Carrier Group is turned upside down.

**CAUTION:** AAC DOES NOT RECOMMEND THE PRACTICE OF SWAPPING BOLTS BETWEEN DIFFERENT RIFLES WITHOUT PROPERLY CHECKING HEADSPACE. DOING SO COULD RESULT IN DAMAGE, PERSONAL INJURY OR DEATH.

8. Insert Charging Handle into Upper Receiver and lower the “ears” at front end of Handle into cutouts in Receiver. Then slide Charging Handle partially into Receiver.

9. Lower complete Bolt Carrier Assembly into Upper Receiver. Gas Key will fit into groove in the Charging Handle. (Figure 45) **REMEMBER,** Bolt must be pulled to “out” position in the Carrier so Cam Pin will fit into the channel in the Upper Receiver.

10. Then slide the Bolt Carrier Assembly and Charging Handle all the way into the Upper Receiver until Charging Handle Latch locks onto the Receiver.

**NOTE:** If Ejection Port Cover is closed, you will feel some resistance as you push Carrier and Handle in until you pop the Cover open. If Cover is already open, Handle and Carrier should slide in easily.

11. To join Upper and Lower Receivers, position Pivot Pin Lug of Upper Receiver into slot at front of Lower Receiver and push Pivot Pin into place. (Figure 46)

**CAUTION:** ALWAYS place the Safety Selector Lever on SAFE before pivoting the Upper Receiver to a closed position on the Lower Receiver.

12. After Receivers are closed, push in Takedown Pin. (Figure 47)

**NOTE:** Pivot Pin and Takedown Pin are “captivated” in the Lower Receiver — meaning that they are held in by their Detents and Springs so they cannot fall out and get lost.

### TROUBLESHOOTING

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<tr>
<td></td>
<td>CARBON IN CHAMBER OR ON GAS TUBE</td>
<td>Clean</td>
</tr>
<tr>
<td></td>
<td>DIRT, CORROSION, OR CARBON BUILDUP IN BARREL LOCKING LUGS</td>
<td>Clean Lugs</td>
</tr>
<tr>
<td>SHORT RECOIL</td>
<td>CORRECT ALIGNMENT OF GAPS IN BOLT GAS RINGS</td>
<td>“Gaps” in the 3 gas rings should be staggered 120° around the bolt body for maximum effectiveness</td>
</tr>
<tr>
<td></td>
<td>CARBON OR DIRT IN CARRIER KEY OR ON OUTSIDE OF GAS TUBE</td>
<td>Clean Carrier Key or around Gas Tube</td>
</tr>
<tr>
<td></td>
<td>Q-TIP, PIPE CLEANER PIECES, OR OTHER DEBRIS STUCK INSIDE CARRIER KEY</td>
<td>Clean out if possible or have rifle checked by gunsmith</td>
</tr>
<tr>
<td>BOLT FAILS TO LOCK AFTER LAST ROUND</td>
<td>DIRTY OR CORRODED BOLT LATCH</td>
<td>Clean – or replace – bolt catch check for buffer endcap backout or obstruction. Check for full travel of bolt carrier</td>
</tr>
<tr>
<td></td>
<td>FAULTY MAGAZINE</td>
<td>Replace</td>
</tr>
<tr>
<td>SELECTOR LEVER BINDS</td>
<td>NEEDS OIL</td>
<td>Lubricate with CLP</td>
</tr>
<tr>
<td></td>
<td>DIRT OR SAND UNDER TRIGGER</td>
<td>Clean</td>
</tr>
<tr>
<td>BOLT CARRIER “HUNG UP”</td>
<td>ROUND JAMMED BETWEEN BOLT AND CHARGING HANDLE AND/OR DOUBLE FEED</td>
<td>1. Remove magazine. 2. Push in on the bottom of the bolt latch. 3. While pulling down on charging Handle, tap the rifle butt on the ground. Bolt should lock to the rear. 4. While bolt is held to the rear, round Should fall through the magazine well. Note: if this procedure fails, use a section Of cleaning rod to push the bolt fully to REAR THROUGH THE EJECTION PORT</td>
</tr>
</tbody>
</table>

MAINTENANCE IN EXTREME WEATHER

EXTREME COLD: Clean and lubricate Rifle in a warm room with Rifle at room temperature. Do not lay a warm Rifle directly on snow or ice. Moving Rifle from cold into warmth will cause condensation which could keep Rifle from functioning.

HOT, WET CLIMATES: Clean and lube Rifle more frequently in moist climates. Inspect hidden surfaces of Bolt and Carrier Assembly, Upper Receiver, and Chamber / Barrel Extension (Locking Lugs), and Lower Receiver and Receiver Extension Assembly (Buffer Tube) for rust or corrosion. Also pay close attention to the Spring Loaded Detents on the rifle. Wipe off any hand / finger prints on the Rifle as they can accelerate the onset of rust or corrosion.

HOT, DRY CLIMATES: Take extra care with cleaning and lubrication as rifle will be exposed to blowing sand and fine dust, and extreme temperature shifts (hot in the daytime, freezing at night). Corrosion is less likely to form on metal parts in a dry climate. Lightly lube functional parts only – too much lubrication can attract and hold dust and sand.

RAINS: DO NOT FIRE THE RIFLE IF WATER IS PRESENT IN THE BARREL. Excess pressure can cause the Rifle to explode. ALWAYS drain any water from Barrel prior to firing. Dry the Bore with a Swab and Cleaning Rod if wet.

COMPONENT VARIATIONS

This manual is intended to instruct the AAC Rifle Operator in all necessary aspects of Maintenance, Disassembly, Reassembly, Operation and Troubleshooting of any AR15-style AAC Rifle. Within the AAC Weapon System family, there can be infinite variations of Barrel Length, Stock Type, Receiver, Forend and Sights. The rifle you own, or are using, may vary in appearance from the photographs and illustrations in this Manual, but the concepts, procedures and practices recommended in this Manual are universal to the AAC AR15-style weapon family.

300 AAC BLACKOUT PDW UPPER

The 300 AAC BLACKOUT (300 BLK) cartridge is highly efficient and in most cases outperforms 5.56mm with less powder and resulting blast. The included AAC BLACKOUT flash suppressor eliminates all secondary muzzle flash. These properties make it ideal for personal security.

MAGAZINES

AAC 300 BLACKOUT ammo can feed from standard USGI or Magpul P–Mags. A magazine with the standard MIL–STD 17–7 stainless spring may be stored fully loaded with 30 rounds indefinitely. Note that Chrome Silicon springs will not resist taking a set better than MIL–STD 17–7 magazine springs regardless of how they have been marketed.

SOUND SUPPRESSORS

The recommended sound suppressor is the AAC 762–SDN–6. This has been tested to provide a good balance between sound level, weight, accuracy, and reliable function. Suppressed SPL with AAC subsonic ammunition is approximately 126 dB both using MIL–STD measurements and at the shooter’s ear.

AMMUNITION

There are two special considerations for the AAC upper – gas port pressure, and reliable feeding from a magazine.

300 AAC BLACKOUT (300 BLK) ammo from Advanced Armament Corp. is designed for reliable function in self-loading firearms. Visit www.300AACBLACKOUT.com for ammunition information.

HANDLOADING

If you load your own ammo, pay special attention to all of the normal safety practices. Hodgdon H110 is the recommended supersonic powder. For subsonic, there are special requirements and nearly all published loads are non-optimal for the 300 BLK upper. Many existing loads were developed for Thompson Center® single-shot pistols, or for ARs by people not aware of the magazine limitations. These loads pay no attention to automatic rifle function and should not be used. Look for a load which results in a cyclic rate of 700 rpm or more. AA1680 is recommended because its bulk density matches the case capacity and it will generate enough gas pressure to cycle the weapon.

Sugg. subsonic load: 300 AAC BLACKOUT (300 BLK) ammo from Advanced Armament Corp. is designed for reliable function in self-loading firearms. Visit www.300AACBLACKOUT.com for ammunition information.
Existing AR magazines have a rib which normally contacts the 5.56mm case-neck. With 300 BLK ammo, the contact is on the bullet. Because the bullet is a larger diameter, the rib will push the cartridges out of alignment, and can lead to binding potentially resulting in Failures to Feed. For this reason, it is important to load ammunition so that the contact point with the magazine rib is on the bullet ogive in an area of about 0.250 inch diameter. Here are some suggested OAL for popular bullets:

- Hornady 110 V-Max, OAL: 2.000
- Barnes 110 TTSX, 2.015 OAL
- Sierra 155 Palma, 2.150 OAL
- Sierra 220, 2.089 OAL
- Lapua B416 200 grain, 1.940 OAL
- Hornady 150 FMJ-BT 3037, 2.065 OAL
- Nosler Ballistic Tip 125 grain, OAL: 2.085
- Remington AccuTip 125 grain, OAL: 2.085
- Hornady 130 SP #3020, OAL: 2.010
- Sierra H2120 125 ProHunter, OAL: 1.950
- Speer TNT 125 1986, OAL: 2.010

**USER MODIFICATIONS**

The gas-port diameter was selected after thousands of rounds of function testing and high-speed video analysis. We do not recommend you enlarge your gas-port to aid subsonic function because then supersonic ammunition will hyper-cycle the upper which will reduce the reliability and part life durability of the system. AAC has developed subsonic and supersonic ammo that both function reliably (with and without an AAC 762-SDN-6 sound suppressor) without the need for an adjustable gas block.

If your subsonic ammunition is not cycling the upper, consider using a powder which generates more gas-port pressure. AA1680 seems ideal for this use.

**BARREL LIFE**

The barrel of the AAC BLACKOUT upper is made from 4150 CMV and specially processed to have up to 60% more life than a chrome-lined barrel and without the potential loss in accuracy from uneven coating. This processing also results in extreme corrosion resistance.

**ACTION SPRING/BUFFER**

Use either the standard USGI M4 or the HK 416 spring. For buffers, select a 4.6 oz (130 gm) H2 or an HK-416 buffer—though a 5.5 oz (155 gm) H3 buffer may be a good choice if you don’t intend to shoot subsonic without a sound suppressor or typically shoot supersonic ammo. Do not use a solid 9mm buffer as it may cause bolt bounce.

**EXTRACTOR SPRINGS**

We have 5.56mm test data for the Bushmaster ‘4 coil’ extractor spring with an o-ring. Four uppers completed a 12,000 round test with no extractor spring related failures. Two uppers completed an 18,000 round test with no extractor spring related failures.

We do not recommend using extra–power extractor springs because they are under higher stress and will likely break sooner. The included green o–ring adds the desired extra extractor force without requiring a spring which would have more force and hence more stress. Extra–power springs, when combined with an o–ring, may make the extractor harder to snap over the case rim and may lead to function problems. If you do use such a spring, please don’t use an o–ring and change the spring every 1500 rounds for mission–critical use. The green color of the o–ring signifies that it meets AAC specifications for endurance and elasticity at low temperatures.

**CLEANING/LUBE**

Recent US Army testing has shown that ARs work best with heavy lubrication. This is even true when used in a sandy environment. While many have said to avoid heavy lube to keep sand from sticking to the parts, this has been proven to be incorrect. Lube keeps the sand in suspension and allows the gun to function. Even if you do not have time to clean the weapon, add lube (such as CLP) every 300–500 rounds. Shooting with a suppressor requires more frequent lubrication.

**PARTS REPLACEMENT**

The Gas block is press-fit and may not be removable or replaceable without a press. Additionally, set screws are secured with both torque and Rocksett. If you remove the gas block, reset the set– screws to 30–35 inch/lbs of torque and one drop of Rocksett.

The replacement schedule for parts depends on the intensity of use and the intended use. After any parts replacement, give weapons a safety/function check before use.

<table>
<thead>
<tr>
<th>PART</th>
<th>RECREATIONAL USE</th>
<th>HARD USE / COMPETITION</th>
<th>MISSION-CRITICAL USE</th>
</tr>
</thead>
<tbody>
<tr>
<td>Gas Tube</td>
<td>When fails</td>
<td>10,000 rounds</td>
<td>5,000 rounds</td>
</tr>
<tr>
<td>Extractor</td>
<td>When fails</td>
<td>10,000 rounds</td>
<td>5,000 rounds</td>
</tr>
<tr>
<td>Gas rings</td>
<td>10,000 rounds</td>
<td>5,000 rounds</td>
<td>5,000 rounds</td>
</tr>
<tr>
<td>Bolt</td>
<td>When fails</td>
<td>10,000 rounds</td>
<td>5,000 rounds</td>
</tr>
<tr>
<td>Extractor spring/o-ring</td>
<td>15,000 rounds</td>
<td>5,000 rounds</td>
<td>5,000 rounds</td>
</tr>
<tr>
<td>Ejector spring</td>
<td>15,000 rounds</td>
<td>5,000 rounds</td>
<td>5,000 rounds</td>
</tr>
<tr>
<td>Barrel</td>
<td>50,000 rounds</td>
<td>35,000 rounds</td>
<td>20,000 rounds</td>
</tr>
<tr>
<td>Action spring</td>
<td>15,000 rounds</td>
<td>10,000 rounds</td>
<td>5,000 rounds</td>
</tr>
</tbody>
</table>

**ALWAYS CHECK HEADSPACE AFTER CHANGING A BOLT, BARREL, OR BARREL EXTENSION.**

**REPLACEMENT PART NUMBERS**

- Assembly, Bolt, AR, 5.56mm/300 BLK. AAC part #101256
- Assembly, Bolt Carrier, Complete, FA, AR, 5.56mm/300 BLK. AAC part #101261
- Assembly, Barrel, AR, 9”, 1.8”, Gas System. SCARmor, 300 BLK. AAC part #100903
- 3-pack extractor spring/o-ring/bumper, AAC part 101687
- Firing pin retaining pin, Bushmaster part 8448504
- M16* Chromed Steel Firing Pin, Bushmaster part 8448503
- Extractor pin, Bushmaster part 8448513
- Extractor, Bushmaster part 8448512
- Ejector assembly, Bushmaster part A EJECT ASS
- Cam pin, Bushmaster part 8448502
- Bolt Gas Rings (set of 3), Bushmaster part 8448511K.
- Charging Handle, Bushmaster part 8448617

*Purchase AAC parts from AAC. Bushmaster parts from Bushmaster.
LIMITED ONE YEAR WARRANTY

ADVANCED ARMAMENT CORP. (AAC) Firearms and accessories are warranted to be free from defects in materials and workmanship. Any such defect of which AAC is given written notice, as provided below, within one year and ten days from the date of first purchase by a customer will be remedied by AAC. This warranty is granted by ADVANCED ARMAMENT CORP. 2408 Tech Center Parkway, Suite 150, Lawrenceville, GA 30043, USA.

To initiate a Warranty claim, call AAC (1-770-925-9988) to get a “Return Merchandise Authorization” (RMA) number. Warranty claims should state (in writing) the model and serial number of the product concerned, a description of the difficulty experienced, and the date of purchase. The product concerned should be shipped (transportation charges prepaid), to the Warranty Service Department, ADVANCED ARMAMENT CORP. 2408 Tech Center Parkway, Suite 150, Lawrenceville, GA 30043, USA. Shipment should be insured by the owner, as AAC will accept no responsibility for loss or damage in transit. Shipping and insurance charges for the return of a product to its owner will be paid by AAC if the related claim is a proper claim for warranty work.

Under no circumstances shall ADVANCED ARMAMENT CORP. 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. Some states do not allow the exclusion of limitation of incidental or consequential damages, so the above limitation may not apply to you. ADVANCED ARMAMENT CORP. will not be responsible for the results of careless handling, unauthorized adjustments, defective, low quality, reloaded, or improper ammunition, corrosion, neglect, ordinary wear and tear, or unreasonable use. Furthermore, the liability of ADVANCED ARMAMENT CORP. under this warranty shall be limited solely to the obligation to repair or replace the firearm or accessory, and to pay transportation and insurance charges for return of the firearm or accessory to owner.

NOTE: Handguns and long guns are classified as FIREARMS or DANGEROUS WEAPONS. Guns are surrendered by ADVANCED ARMAMENT CORP. with the express understanding that it assumes no responsibility for resale handling under local laws and regulations.