



MANUAL FOR THE
AR PLATFORM

 **DOUBLESTAR**

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WHAT'S IN THIS MANUAL?

1. Important warning and safety precautions, which should be read and understood before using your DoubleStar rifle.
2. Directions and procedures for handling, loading, firing, unloading, disassembling and assembling your DoubleStar rifle.
3. Instructions for care, cleaning, repair and services of your DoubleStar rifle.

This instruction and safety manual is designed to help you in learning how to properly use and care for your DoubleStar rifle. Only when you are certain you have fully familiarized yourself with the function of your rifle should you practice loading, unloading and firing with live rounds of ammunition.

DISCLAIMER OF LIABILITY

DoubleStar Corp. 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, its criminal or negligent use, improper or careless handling, unauthorized modifications or alteration, use of defective, improper, hand-loaded or (replaced) ammunition, or from its use for purposes or subjection to treatment for which it was not designed. For your safety, use only original high quality commercially manufactured ammunition in good condition that is appropriate to the caliber of your rifle. DoubleStar shall not be responsible for the product or its result from use of defective, improper or reloaded ammunition.

WARNINGS! DANGEROUS PROCEDURES

Do not interchange bolt assemblies from one rifle to another. Doing so may result in personal injury or death to you and/or others and cause severe damage to your rifle.

If your rifle misfires with a live round in the chamber of a hot barrel, immediately remove the round keeping the barrel pointed in a safe direction. If you are unable to remove the live round, wait 10 seconds, remove the magazine keeping barrel pointed in a safe direction and wait 15 minutes for the barrel to cool. After cooling, try to remove the round. Continuous or rapid firing of your rifle can cause the barrel temperature to reach a "COOKOFF POINT" where the heat of the barrel can cause a live round to fire within 10 seconds of contact with a hot chamber. Always keep your face away from the ejection port when clearing a hot chamber.

If your bolt fails to unlock and you try to free it by banging the buttstock on the ground or mortaring it, keep clear of the muzzle in case of an accidental discharge.

Never fire your rifle with water in the barrel as this could cause the rifle to explode.

If you experience a noticeable difference in sound or recoil when firing, **STOP FIRING!** The cause for either condition could be incomplete powder burn or a bullet stuck in the bore. Immediately clear the rifle and check for unburned powder residue in the bore and the receiver or for a bullet stuck in the bore. Remove the unburned powder before you resume firing. If a bullet is stuck in the bore, have a qualified gunsmith take care of the issue. **FIRING WITH UNBURNED POWDER IN THE BARREL COULD CAUSE THE BARREL TO EXPLODE.**

WARNINGS! GENERAL SAFETY

Careless and improper handling of your DoubleStar rifle could result in unintended discharge causing injury, death or property damage. Safety must be the first and a constant consideration when handling a firearm and ammunition.

Your DoubleStar rifle was designed to function properly in its original condition. Do not alter any parts or replace parts.

Your DoubleStar rifle should always be carried with an empty chamber and with safety selector on "SAFE" to prevent accidental discharge.

Always handle and treat your firearm as if it were loaded. Never take another persons word that a firearm is unloaded. Always perform a CHECK with your fingers off of the trigger and the barrel pointed in a safe direction.

Never place your fingers inside the trigger guard area unless you are ready to fire.

Water, snow, mud, excessive lubricating oil, grease or any other material can obstruct the barrel of your firearm and cause the barrel to explode. Always check the barrel of your firearm for obstruction before loading and firing. Clean a fouled gun immediately to ensure its correct and safe function.

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 anything you do not intend to shoot. Always be sure of your target and what is behind it before firing.

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.

Always make sure your firearm is unloaded before cleaning, storing, or handing it to another person.

Always wear and encourage others to wear safety glasses while shooting to protect your eyes from injury by gun powder gas, lubricant, dirt, metallic particles, carbon residue, sparks or other debris.

Always wear and encourage others to wear ear protection when shooting especially at the gun range. Without ear protection, the noise from your firearm and other firearms close to you could leave a “ringing” in your ears for some time after firing. Repeated exposure to shooting noise could result in permanent hearing loss.

Never climb a tree, a fence or a wall while carrying a loaded firearm.

Do not shoot at a hard surface or at water. Doing so may result in a ricochet—sending the bullet in unpredictable directions and could cause property damage, injury or death.

If you have any doubts about your ability to safely handle or use your firearm, seek supervised, professional instruction.

Do not consume alcohol or take drugs before or while shooting as this constitutes criminal 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 you are fit to handle your firearm safely.

Do not horseplay around firearms. Doing so can result in injury or even death.

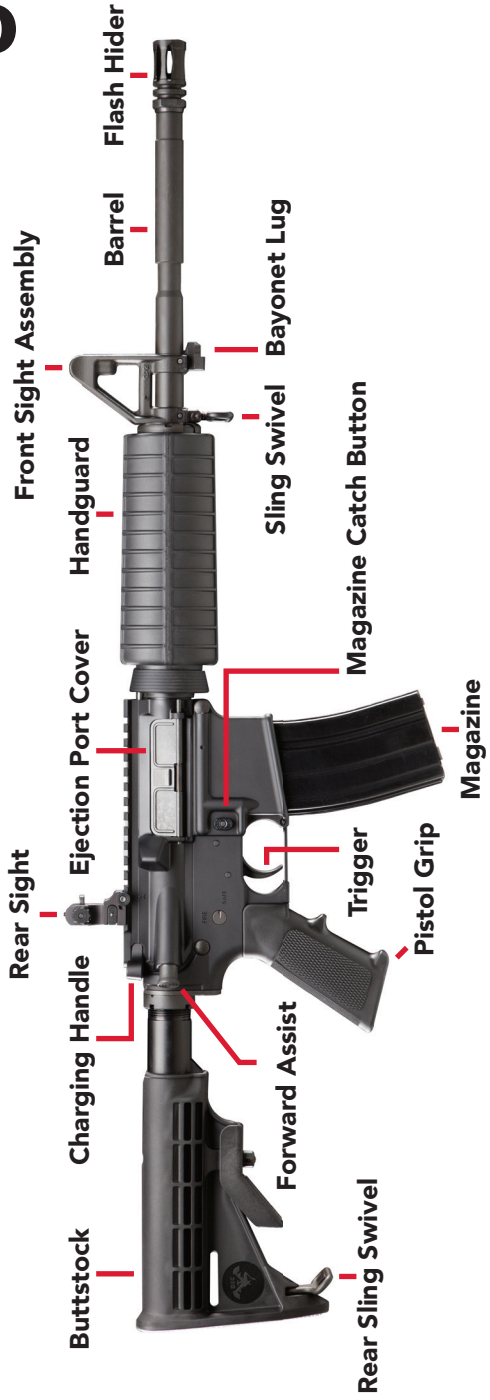
Follow the law. Obey all local, state and federal laws regarding storage, shooting and transporting your DoubleStar rifle.

TERMS TO KNOW



Bolt Catch

Safety Selector



Rear Sight

Front Sight Assembly

Buttstock

Charging Handle

Ejection Port Cover

Handguard

Barrel

Flash Hider

Forward Assist

Trigger

Magazine Catch Button

Sling Swivel

Bayonet Lug

Rear Sling Swivel

Pistol Grip

Magazine

MAIN FEATURES AND OVERVIEW

DoubleStar rifles and carbines feature:

1. Forged 7075-T6 aluminum alloy upper and lower receivers which are hard coat anodized per Mil-Spec.
2. T-Marked flattop uppers.
3. Gas key staking and castle nut staking.
4. Enhanced Extraction System™.
5. Safety selector position engraved on the right side of the receiver with the witness mark.
6. Dust cover, brass deflector and forward assist.
7. Radiused aluminum magazine release button.
8. Radiused aluminum trigger guard.
9. Mil-Spec aluminum magazine with self-leveling follower.

FUNCTION OVERVIEW

DoubleStar rifles, carbines and AR pistols are gas operated semi-automatic firearms. 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!

Before your firearm left the factory, it was function tested, inspected and packaged. DoubleStar Corp. cannot control the product handling after it has left our factory. 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.

CLEARING YOUR RIFLE

WARNING!

Always handle and treat your firearm as if it is loaded! Never take anyone's word that it is unloaded. Keep the muzzle pointed in a safe direction.

To clear your rifle of live ammunition or to make sure it is unloaded, keep the muzzle pointed in a safe direction while performing the following steps:

1. Place the safety selector to the "SAFE" position (Fig. 1).

Note: if the rifle is not cocked, the safety selector cannot be moved to the "SAFE" position and proceed to step 2.

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 was not put in the "SAFE" position in step 1, do so at this time.

FIG. 1



FIG. 2



FIG. 3



IMPORTANT!

Check the rifle to make sure there is not excessive oil in the bore. Always clean a new rifle before firing!

SAFETY SELECTOR FUNCTION AND CHECK

WARNING!

Always keep the muzzle pointed in a safe direction.

The safety selector is located on the left side of the lower receiver and has two positions: "FIRE" and "SAFE". The safety selector position is also visible from the right side of the lower receiver and features a witness mark pointing to the "FIRE" and "SAFE" engravings.

Note: If the rifle is not cocked, the safety selector cannot be moved to the Safe position. However, with the bolt carrier locked in the rearward position, the safety selector can be moved to either position.

With the safety selector 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.

FIG. 4



FIG. 5



With the safety selector 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 to the safe position when loading and unloading your rifle!

FIG. 6



FIG. 7



SAFETY SELECTOR FUNCTION TEST

WARNING!

Make sure the magazine has been removed and the chamber is clear before performing the safety selector function test. Keep muzzle pointed in a safe direction.

1. Pull the charging handle to the rear and release. Place the safety selector to the "SAFE" position (Fig. 4). Pull the trigger. The hammer should not fall.

2. Move the safety selector 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 to the "SAFE" position. The safety selector should not be able to move to the "SAFE" position with thumb pressure.

If the rifle fails any of the above tests; DO NOT USE the rifle and have it serviced.

AMMUNITION

WARNING!

Discharging firearms in poorly ventilated areas, cleaning firearms, or handling ammunition may result in exposure to lead and other substances that may cause birth defects, reproductive harm, and other serious physical injury. Have adequate ventilation at all times. Wash your hands thoroughly after exposure. Shooting or cleaning guns may expose you to lead.

Use only high quality commercially manufactured ammunition in good condition of the appropriate caliber. The caliber of your rifle is marked on the barrel. Not all ammunition produces the same result. DoubleStar recommends that once you find a brand that functions well, keep using it. DoubleStar does not recommend using hand loads or remanufactured ammunition and the use of this ammunition will void the warranty.

LOADING YOUR RIFLE

WARNING!

Always check that the ammunition is clean and undamaged. Forcing damaged ammunition into the chamber could result in injury, death, damage to property, and/or damage to your rifle.

FIG. 8



1. Load the magazine. Using only high quality commercial 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.

FIG. 9



2. Load the rifle. With the bolt in the closed position and the safety selector on "SAFE", insert the loaded magazine into 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

FIG. 10



a round. 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. 10 (previous page)]. Put the safety selector to the "SAFE" position. Insert the loaded magazine into the magazine well and push it up until it is retained by the magazine catch. Tap the bottom of the magazine to ensure it is properly seated [Fig. 9 (previous page)]. Press the top of the bolt release lever and the bolt will close and chamber a round.

FIRING YOUR RIFLE

WARNING!

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 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 side the trigger guard. Do not put your finger on the trigger at this time.

2. Aim by aligning the front and rear sights to the target.

3. Move the safety selector to the "FIRE" position (Fig. 11).

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

FIG. 11



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 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.

SIGHTS AND ZEROING

SIGHTS

Most DoubleStar models feature flattop upper receivers without a carrying handle or a detachable carry handle. These models have picatinny rails for mounting rings, scopes and other accessories. The mounting rails are marked to allow accessories to be removed and reinstalled in the same location. Models with "F" front sight and A2 (fixed carry handle) or A3 (removable carry handle) rear sight are explained below.

FRONT SIGHT

The front sight has a sight post which can be moved up or down for elevation [Fig. 12 (next page)]. This is accomplished by depressing the spring loaded detent with a front sight tool, punch or dummy bullet and rotating the sight up or down [Fig. 13 (next page)]. The rotation direction to move the point of impact UP is marked on the sight base. Reverse the direction to move the point of impact down. Each graduation or notch on the front sight post will move the bullet 3/8" at 25 meters. Zeroing procedures are explained later in the manual. After zeroing, the front sight post should not be moved.

FIG. 12**FIG. 13**

REAR SIGHT

The rear sight (if applicable) is adjustable for windage and elevation and consists of a windage knob on the right side and an elevation dial under the sight apertures. The sight also consists of two apertures—one for short range of 0 to 200 meters and one for normal range of 300 to 800 meters for fixed carry handle and 300 to 600 meters for removable carry handle (Fig. 14).

FIG. 14

The short range aperture is the larger aperture and when in the “up” position, the markings “0-2” are visible. This aperture is only used when the 8/3 or 6/3 marking on the elevation dial aligns with the vertical mark on the upper receiver which is the lowest setting. *Note that the 8/3 or 6/3 setting can be obtained with the sight raised to its highest point, but this is the 800 or 600 meters setting. On flat top models with detachable carry handle, the setting will be marked 6/3 instead of 8/3 and the range is 300 to 600 meters instead of 300 to 800 meters.*

The normal range aperture is the smaller aperture and when in the “up” position is unmarked. Use this aperture for zeroing your rifle. The windage knob on the right side of the sight will move the point of impact of the round from 1/8” at 25 meters to 4” at 800 meters for

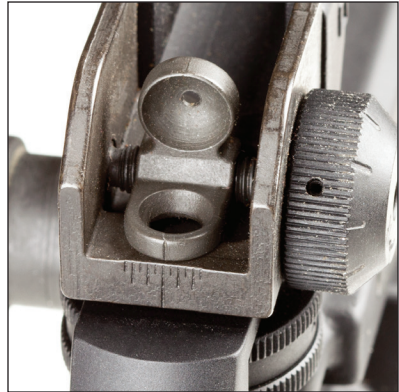
each click. The windage knob is marked with an "R" and a direction arrow (clockwise) for moving the point of impact to the right. To move the point of impact to the left, move the knob counterclockwise.

ZEROING SIGHTS

To establish zero with your mechanical sights, use the following procedure to zero at 25 meters:

1. With the normal range aperture in the "UP" position, align the windage indicator mark on the short range aperture with the center line of the windage scale (Fig. 15) on the carry handle by turning the windage knob.

FIG. 15



2. Rotate the elevation dial down (counterclockwise) until the range scale 8/3 or 6/3 (300 meters) mark is aligned with the vertical mark on the left side of the receiver. From this point on the elevation dial should not be moved, as changes in elevation will be accomplished by raising or lowering the front sight post.

3. The front sight post was set at the factory and should be very close to zero, so it is not necessary to adjust the sight post at this time.

4. Place an appropriate target 25 meters downrange. Caution: Make sure that it is safe to shoot and the range is clear.

5. Carefully aim and fire each shot of a 3 shot group.

6. Inspect your target.

7. If your shots are not striking the point of aim, then adjust your sights. The elevation is adjusted by the front sight post and the windage by the windage knob on the rear sight. To raise the point of

impact, rotate the front sight post in the direction marked “up”. To lower the point of impact, rotate the front sight post in the opposite direction. To move the point of impact left, turn the windage knob counterclockwise. To move the point of impact to the right, turn the windage knob clockwise marked on the knob as “R” and arrow.

8. Fire another 3 shot group and adjust the sights, if required.
9. Repeat steps 7 and 8 until your shot group is on bullseye.
10. The normal range aperture is now automatically zeroed for all ranges. To shoot at 400 meters, turn the elevation dial to the 4 mark.

RIFLE DISASSEMBLY

WARNING!

Make sure your rifle is unloaded before starting disassembly!

For lubrication instructions, follow steps 1–8. If your rifle is dirty, damaged or wet, follow all 11 steps.

1. Make sure bolt carrier is closed in the forward position. Push the rear takedown pin from the left side of the receiver as far as it will go to the right (Fig. 16). Pivot the upper receiver from the lower receiver.
2. Push the front takedown pin from the left side of the receiver as far as it will go to the right. Separate the upper and lower receiver assemblies. (Fig. 17 & Fig. 18).
3. 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. 19 & 20). Then remove the charging handle (Fig. 21).

FIG. 16



FIG. 17



FIG. 18



FIG. 19

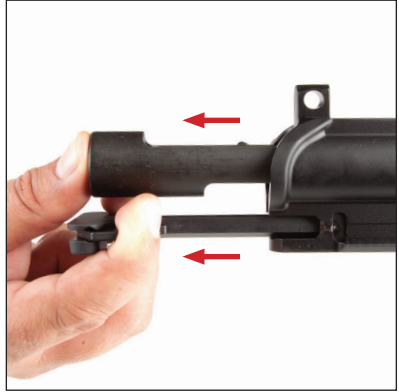
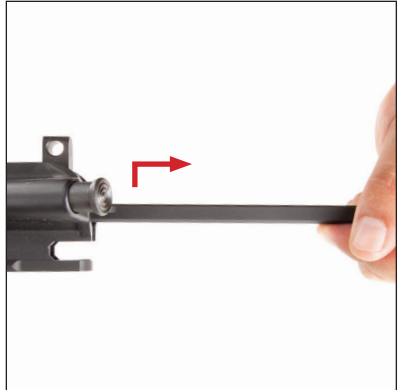


FIG. 20



FIG. 21



4. Remove the firing pin retaining pin from the bolt carrier (Fig. 22). Be careful to not open or close the split end of the retaining pin and never substitute a common cotter pin for this part.

5. Remove the firing pin from the rear of the bolt carrier (Fig. 23).

6. Push the bolt to the closed and locked position (Fig. 24).

7. Rotate the cam pin $\frac{1}{4}$ turn and lift out of the bolt carrier (Fig. 25).

8. Pull the bolt assembly straight out from the bolt carrier (Fig. 26).

9. With a punch, remove the extractor pin (Fig. 27).

10. Remove extractor, extractor spring, black insert, and black O-ring (Fig. 28 & 29).

11. Make sure the hammer is in the cocked position then depress the buffer retainer pin with a punch (Fig. 30). Remove the buffer and action spring from the lower receiver.

If any further disassembly is required, it should be done by a qualified gunsmith.

FIG. 22



FIG. 23



FIG. 24



FIG. 25



FIG. 26



FIG. 27



FIG. 28



FIG. 29



FIG. 30



CLEANING AND LUBRICATION

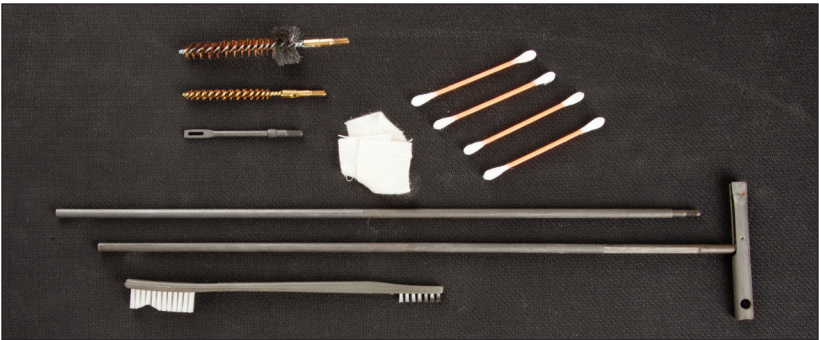
WARNING!

Always keep the muzzle pointed in a safe direction!

WHEN TO CLEAN

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. If your firearm gets wet, clean it as soon as possible. When your rifle has not been fired, clean it once or twice a year in a dry climate. In a tropical climate your rifle should be cleaned every week.

MATERIALS REQUIRED



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. Other items include a small tooth brush, a good quality gun oil/cleaner/preservative, and cotton swabs.

CLEANING PROCEDURE

1. Clean the barrel bore and chamber. Always clean from the chamber end to the muzzle. If the gun has not been fired, attach a cotton patch

to the cleaning rod, insert it in the chamber and pass it through the bore. Continue this procedure 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 guncleaning solution and thoroughly scrub out the barrel (Fig. 31). Make sure to go all the way through the barrel and out the muzzle end before reversing direction. Never reverse the direction of the bore brush while it is in the bore. Attach the chamber brush to the cleaning rod, dip the brush in bore cleaning solution and clean the chamber (Fig. 32). Use a minimum of 5 plunge strokes and 3 rotational strokes of 360 degrees. Then swab out bore and chamber with a cotton patch on the cleaning rod.

FIG. 31

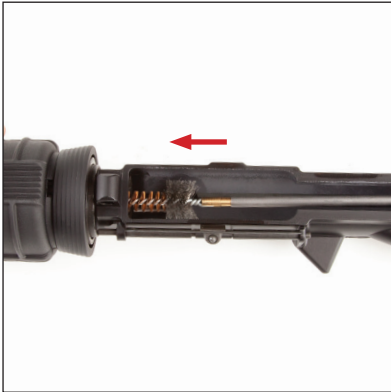


FIG. 32



2. With the bore brush still wet with gun cleaning solution, clean the carbon and powder residue around the gas tube in the upper receiver, bolt locking lugs, bolt rings, firing pin, bolt cam pin, lip of the extractor, and inside the bolt carrier from both the front and rear.

3. Wipe all components clean and dry and inspect for any mechanical damage, excessive wear and/or corrosion.

4. Clean out the gas key and carrier vent holes with a cotton swab (Fig. 33).

FIG. 33



5. 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.

6. Clean the buttstock as necessary. The 6-position adjustable stock can be disassembled by pulling down the adjustment trigger and pulling the stock off (Fig. 34). Clean the 6-position lock holes, and lightly lubricate the receiver extension and trigger. Reassemble stock.

FIG. 34



IMPORTANT PART INSPECTION

1. Check the bolt for cracks or fractures, especially in the cam pin hole area. Inspect for bolt face pitting. Any pitting extending into the firing pin hole should be replaced.

2. Check the cam pin for cracks or chips. Replace if any cracks or chips are found.

3. Check the firing pin. If bent, cracked or blunted, replace it.

4. Check the firing pin retaining pin. Replace if it is bent or severely worn. Never substitute a "cotter pin" as their round shaped head will cause damage.

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. Lightly lubricate the inside of the buffer tube, the buffer, and action spring.

3. Generously lubricate the trigger, hammer, safety, bolt catch, magazine release, and takedown pins.

4. Lightly lubricate the firing pin, the charging handle and latch spring, bolt carrier, extractor, and extractor pin.

5. Generously lubricate the bolt, the cam pin hole, and the gas rings.

RIFLE ASSEMBLY

1. Install the Buffer into the Action Spring. Depress the Buffer Detent and push the Buffer past the Detent, then release the Detent (Fig. 35).

2. Install Extractor and Spring to the Bolt. Note: extractor assembly has a rubber insert within the spring and an o-ring around the spring. If the spring comes loose, put the large end of the spring in the extractor and seat it with a punch or dummy bullet. Push down on the extractor to depress the spring and install extractor pin (Fig. 36).

FIG. 35



FIG. 36



- 3.** On the bolt, stagger the gas ring gaps so the gaps are not in alignment with each other to prevent gas pressure loss (Fig. 37).
- 4.** Insert the bolt into the bolt carrier (Fig. 38).
- 5.** Insert the cam pin (Fig. 39). *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.*
- 6.** Once the cam pin is installed, rotate it 90° to allow firing pin installation.
- 7.** Install the firing pin (Fig. 40)
- 8.** Pull the bolt out (Fig. 41). Install the firing pin retaining pin (Fig. 42).
- 9.** 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 (Fig. 43). Slide the charging handle partially into the Receiver.
- 10.** Insert the bolt carrier group into the upper receiver so that the gas key fits into the groove of the charging handle (Fig. 44).
Note: The bolt must be in the out position in the carrier for installation.
- 11.** 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. 45).
- 12.** 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. 46).
- 13.** Make sure the safety selector is in the "SAFE" position before pivoting the upper receiver down to the lower receiver. After the receivers are closed, push in the rear takedown pin.

FIG. 37

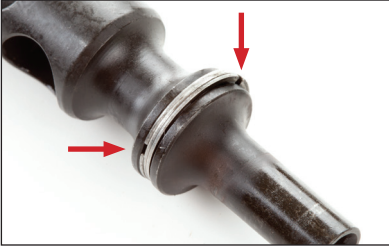


FIG. 38

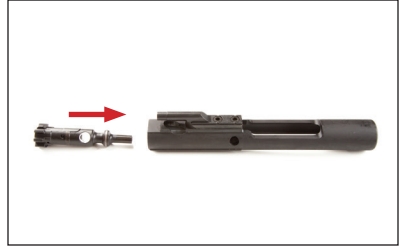


FIG. 39

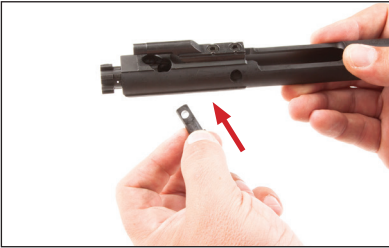


FIG. 40



FIG. 41

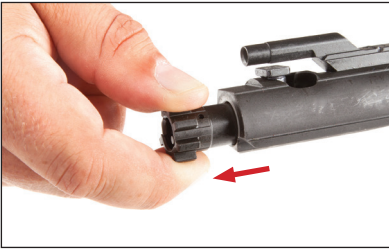


FIG. 42

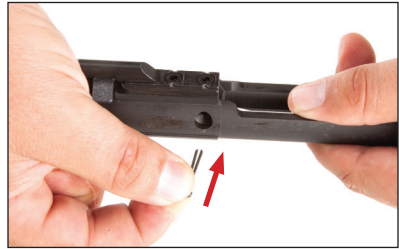


FIG. 43

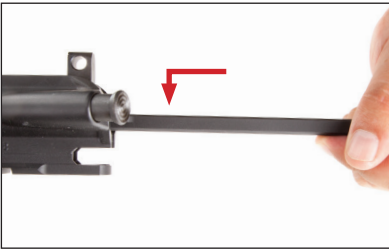


FIG. 44

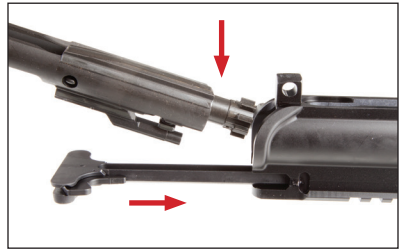


FIG. 45

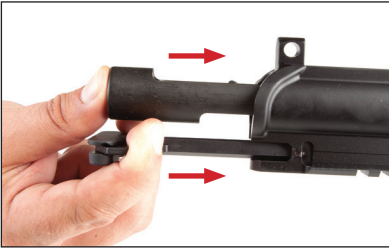


FIG. 46



MAGAZINE MAINTENANCE

DISASSEMBLY

1. To disassemble the magazine, use a punch to lift up the bottom of the baseplate past the magazine body (Fig. 47).

2. Slide the baseplate out of the magazine body (Fig. 48).

3. Remove the magazine spring and follower out of the body (Fig. 49). **Do not detach the Follower from the Spring.**

CLEANING

1. Clean all the dirt from inside and outside of the magazine body.

2. Clean the spring, baseplate and follower.

3. Lightly lubricate the spring and reassemble.

REASSEMBLY

To reassemble, position the spring and follower in the magazine body, and slide the baseplate under all 4 tabs.

FIG. 47

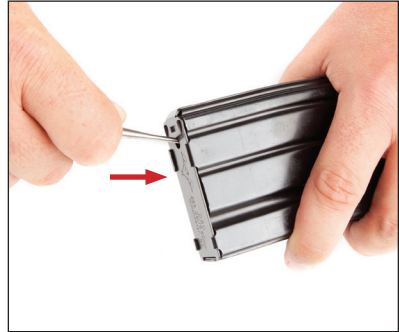


FIG. 48



FIG. 49



UPPER AND LOWER RECEIVER PARTS LISTS

UPPER RECEIVER PARTS LIST

UPPER RECEIVER ASSEMBLY

1. Stripped Upper Receiver // AR221M
2. Charging Handle // AR460
3. Forward Assist // AR171
4. Ejection Port Cover // AR161
5. Charging Handle Latch // AR462
6. Charging Handle Latch Spring // AR463
7. Charging Handle Latch Roll Pin // AR464
8. Forward Assist Spring // AR172
9. Forward Assist Spring Pin // AR173
10. Ejection Port Cover Spring // AR163
11. Ejection Port Cover Pin // AR162
12. Ejection Port Cover Pin Retaining Ring // AR164

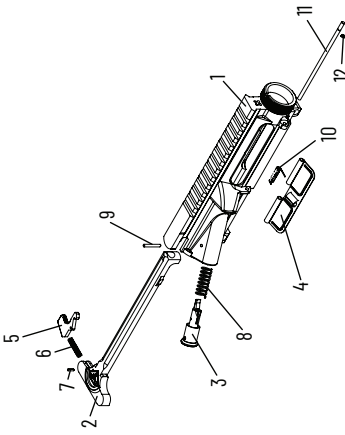
BARREL ASSEMBLY

1. Stripped Barrel
2. Handguard
3. Front Sight // AR448F
4. Muzzle Device
5. Gas Tube
6. Barrel Nut // AR435
7. Barrel Indexing Pin // AR438
8. Delta Ring // AR433
9. Weld Spring // AR432
10. Handguard Snap Ring // AR431
11. Gas Tube Roll Pin // AR413
12. Front Sight Swivel Rivet // AR446
13. Front Sight Taper Pins // AR444
14. Front Sight Sling Swivel // AR445
15. Front Sight Detent Spring // AR443
16. Front Sight Detent // AR442
17. Front Sight Post // AR441
18. Crush Washer // AR472
19. Handguard Cap // AR436

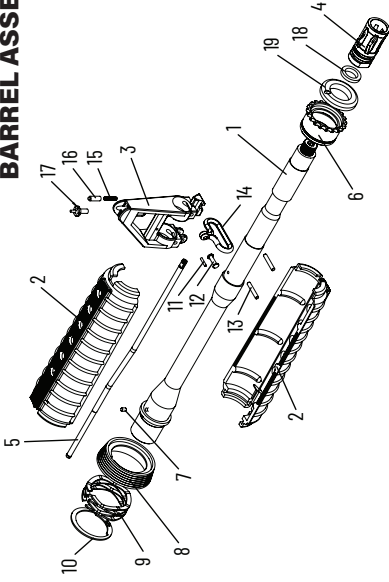
BOLT CARRIER GROUP

1. Bolt Carrier // AR101
2. Bolt // AR111
3. Firing Pin // AR106
4. Bolt Carrier Key // AR104
5. Ejector // AR113
6. Ejector Spring // AR114
7. Ejector Roll Pin // AR115
8. Extractor Pin // AR123
9. Extractor // AR121
10. Extractor Spring and Insert // AR122
11. Gas Rings (x3) // AR112
12. Cam Pin // AR103
13. Firing Pin Retaining Pin // AR107
14. Bolt Carrier Key Screw (x2) // AR105

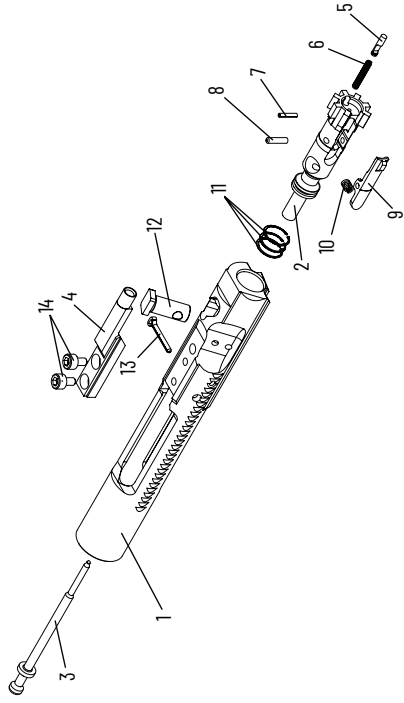
UPPER RECEIVER ASSEMBLY



BARREL ASSEMBLY



BOLT CARRIER GROUP

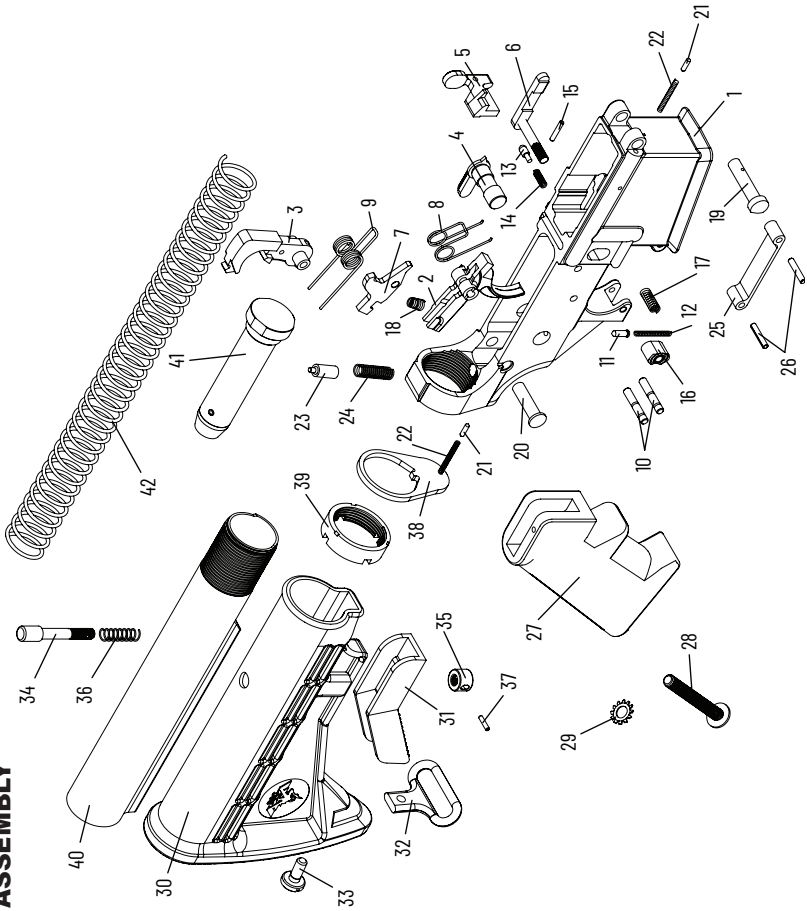


LOWER RECEIVER PARTS LIST

UPPER RECEIVER ASSEMBLY

1. Stripped Lower Receiver // D5CL101
2. Trigger // AR300
3. Hammer // AR271
4. Selector // AR273
5. Bolt Catch // AR281
6. Mag Catch // AR291
7. Disconnect // AR298
8. Trigger Spring // AR301
9. Hammer Spring // AR272
10. Trigger/Hammer Pin (x2) // AR302
11. Selector Detent // AR274
12. Selector Spring //AR283
13. Bolt Catch Detent // AR274
14. Bolt Catch Spring //AR283
15. Bolt Catch Roll Pin // AR282
16. Mag Catch Button // AR292
17. Mag Catch Spring // AR293
18. Disconnect Spring // AR299
19. Front Pivot Pin // AR294
20. Takedown Pin // AR295
21. Takedown Detent // AR296
22. Takedown Detent Spring // AR297
23. Buffer Detent // AR306
24. Buffer Detent Spring // AR307
25. Trigger Guard // AR304
26. Trigger Guard Pin // AR305
27. A2 Pistol Grip // AR310
28. Pistol Grip Screw // AR308
29. Pistol Grip Lock Washer // AR309
30. M4 Stock // AR390B
31. M4 Stock Lever // AR358
32. Stock Swivel // AR356
33. Stock Swivel Screw // AR357
34. Stock Plunger // AR348
35. Stock Plunger Cap // AR349
36. Stock Plunger Spring // AR350
37. Stock Plunger Cap Retaining Pin // AR351
38. Receiver End Plate // AR345
39. CAR Castle Nut // AR346
40. 6-Position Buffer Tube (Comm.) // AR355
41. CAR Buffer // AR343
42. CAR Buffer Spring // AR344

LOWER RECEIVER ASSEMBLY



LIMITED LIFETIME WARRANTY

DoubleStar will warranty all firearms manufactured by DoubleStar against any and all manufacturer's defects in material and workmanship which affect reasonable operation for the lifetime of the firearm to the purchaser. Parts and accessories are warranted for 90 days.

The following are specifically excluded from coverage under this warranty and will cause said warranty to become null and void:

Damage or malfunction resulting from accident, negligence, misuse or unauthorized repair or alteration; barrel obstruction; use of ammunition other than NATO and/or SAAMI specification new production ammunition; use of any hand loaded, reloaded, imported or factory re-manufactured ammunition; failure to provide reasonable and necessary maintenance as described in the Operation Manual accompanying the firearm; rust or corrosion; use of replacement parts other than parts authorized by DoubleStar for use in DoubleStar firearms; any unauthorized repair or any alteration, including of a cosmetic nature, performed on the firearm by an individual, organization, company or entity other than DoubleStar, unreasonable or excessive use of the firearm.

Any finished products that are not assembled at our facilities, or are assembled using imported or used parts. This includes complete rifle kits, upper receivers, lower receivers, barrel assemblies, etc.

No implied warranties of any kind are made herein. Limited lifetime warranty does not apply to any accessory items.

DoubleStar assumes no liability for accidental or consequential damages. Some states do not allow the exclusion or limitation of accidental or consequential damages and therefore this limitation may not apply to you.

RETURN POLICY

This policy applies to all domestic accessory purchases made directly from DoubleStar. The policy applies only to original purchaser with receipt.

The original purchaser of DoubleStar accessories may return unused and undamaged products within 30 days of the invoice date and receive a full refund of the amount paid for the returned product, excluding shipping costs. Refunds will be credited to the credit card used in the transaction within seven to ten business days after the product is received by DoubleStar.

The original purchaser of a DoubleStar accessory may return unused and undamaged products more than 30, but fewer than 60, days of the invoice date and receive a store credit in the amount of the amount paid for the returned product, less a 20% re-stocking fee.

After 60 days of the invoice date, no returns or exchanges will be accepted unless DoubleStar determines that the product is defective in accordance with the defective product policy.

All product returns must be pre-authorized by DoubleStar Customer Service and be accompanied by a Return Material Authorization ("RMA") Number. Customers must have the original purchase paperwork, including receipt or other proof of purchase and must be willing to provide these documents to DoubleStar. Return shipping is at the customer's expense. All returns are subject to inspection by DoubleStar for use, misuse, missing components, damage, or abuse. Refunds may be denied if DoubleStar determines that the product fails the return inspection. Products that fail inspection will be returned to the customer. Any returns without the RMA # on the outside of the package will be refused.

Any modifications such as: cuts/grinds/welding/paint/drilling etc. will void any and all warranties associated with DoubleStar products.

RMA requests can be submitted by phone at (859)745-1757 or email at returns@star15.com.

If you do not receive your RMA# by the next business day, please call (859)745-1757.

RETURN OF DEFECTIVE GOODS

All DoubleStar products are manufactured in the USA using the finest quality materials. All DoubleStar products are warranted against defects in material and workmanship. DoubleStar will repair or replace a defective product (or part/component). This warranty is limited to repair or replacement of the defective product, part or component. DoubleStar will determine in its sole and exclusive discretion whether to repair or replace a product, part or component. DoubleStar also reserves the right to determine the means and materials by which such repair or replacement will be made. This warranty is in lieu of all other warranties, expressed or implied. This warranty only applies to the original purchaser, purchasing through DoubleStar, or a DoubleStar authorized dealer or distributor. All defective product returns must be pre-authorized by DoubleStar customer service and be accompanied by a RMA Number. You must contact customer service to receive an RMA Number prior to returning any product. You must have your original purchase paperwork, including your receipt or other proof of purchase and be willing to provide these documents to DoubleStar. This warranty and return of defective goods policy applies to all purchasers, including but not limited to dealer, distributors and retail customers.



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