

chrome.

Unauthorized alterations or service not approved or performed by Double Star Corp., or the use of handloaded, reloaded or other non-SAAMI standard ammunition will also void all warranties. Double Star Corp. reserves the unconditional right to inspect any firearm before making any repairs or adjustments under this warranty.

Under no circumstance shall Double Star Corp. be liable for consequential or incidental damages or injury. Some states do not allow the exclusion of consequential or incidental damages so the above limitation may not apply to you.

To order parts call us at (859) 745-1757 or you may fax your order (859) 745-4638. You will be asked to provide your name, address, city, state, zip code, and phone number as well as the firearm model number, serial number, gauge/caliber, finish, part number, and part name. We have a minimum handling charge. We accept major credit cards, personal checks and money orders.

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## THIS MANUAL CONTAINS

1. Important warning and safety precautions, which should be read and understood before using this firearm. **SAFE GUN HANDLING IS YOUR PERSONAL RESPONSIBILITY AT ALL TIMES. Disregarding warning and safety precautions in this manual may result in injury or death to you and others and damage to property.**
2. Directions and procedures for handling, loading firing, unloading, disassembling, and assembling this rifle.
3. Instructions for care, cleaning, repair, and services of this rifle.

This instruction and safety manual is designed to help you in learning how to properly use and care for your Double Star Corp. rifle. 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.

This instruction manual should always accompany the firearm, and be transferred with the rifle on change of ownership. Should you ever need to replace it, this manual is available FREE upon request from Double Star Corp.

## DISCLAIMER OF LIABILITY

Double Star 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 or improper or hand-loaded or (replaced) ammunition, or from its use for purposes or subjection to treatment for which is 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. Double Star Corp. shall not be responsible for the product or its result from use of defective, improper or reloaded ammunition.

## SERVICE INSTRUCTIONS

### Limited Lifetime Repair Policy

Our Limited Lifetime Repair Policy covers this Double Star Corp. firearm. Double Star Corp. will repair it, at no cost to you, for as long as you own your Double Star Corp. firearm; provided you have registered your warranty with Double Star Corp. and that no service has been preformed on your firearm by anyone other than the Double Star Corp. service department.

If your Double Star Corp. firearm does require service, contact our service department by email, letter, fax or telephone. If you should ever have to send your firearm back for repair, please follow these instructions: make absolutely certain your firearm is unloaded. Do not send ammunition with your firearm or any accessories. Please package the gun securely (be certain gun and/or parts can not shift during shipment) in a suitable shipping container.

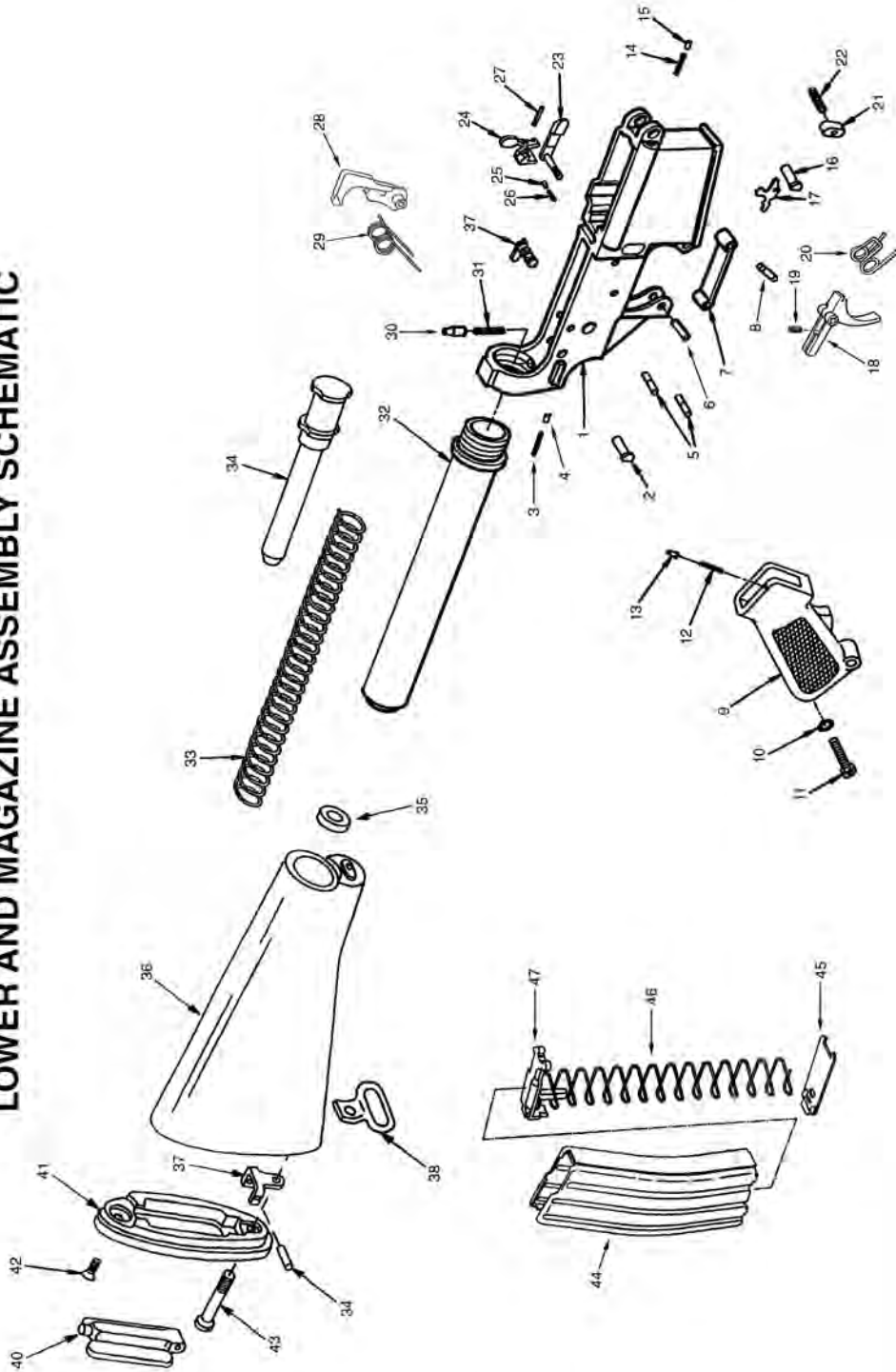
Include with your firearm a clear description of the problem and service you wish us to perform. Please give us a clear ship to address, (no P.O. Box numbers) your daytime phone number and if possible a fax number and email address. Please place your correspondence inside the package. If you have any questions, please call us at (859) 745-1757 or email us at [service@star15.com](mailto:service@star15.com).

The Limited Lifetime Repair Policy does not cover repairs related to unreasonable use, corrosion, failure to provide proper maintenance, damaged or shopworn display guns, gun barrels damaged by an obstructed bore, guns damaged in shipment due to improper packing and handling, or wear of any parts including finishes of metal, wood, camo, or chrome. You must mail in the warranty registration card that comes with your firearm, or register your warranty online to be covered under the Lifetime Repair Policy. If you do not register your warranty, your purchase will still be covered under our traditional Standard Warranty.

### Double Star Corp. Standard Warranty

Your Double Star Corp. firearm is warranted against defects in materials and/or workmanship for one year from date of original new gun retail purchase. This warranty does not cover repairs related to unreasonable use, corrosion, failure to provide proper maintenance, damage by an obstructed bore, guns damaged in shipment due to improper packing and handling, or wear of any parts including finishes of metal, wood, camo or

# LOWER AND MAGAZINE ASSEMBLY SCHEMATIC



## WARNINGS: DANGEROUS PROCEDURES

### ⚠️ WARNING

The Bolt Cam Pin must be installed in the bolt group or the rifle will blow up while firing the first round. If the Cam Pin is not installed, injury or death, and product damage will occur.

### ⚠️ WARNING

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

### ⚠️ WARNING

If your rifle misfires with a live round in the chamber of a hot barrel; Immediately remove the round and always keep the barrel pointed in a safe direction. If unable to remove the live round in 10 seconds, remove the magazine, keeping the gun pointed in a safe direction, and wait 15 minutes for the barrel to cool. Then 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 to a hot chamber. Always keep your face away from the ejection port when clearing a hot chamber.

### ⚠️ WARNING

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

### ⚠️ WARNING

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

### ⚠️ WARNING

When firing and you experience a noticeable difference in sound or recoil; **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 a bullet stuck in the bore. Remove the unburned powder before resuming firing. If a bullet is stuck in the bore, have a qualified gunsmith take care of the problem. **Firing with unburned powder in the barrel could cause the barrel to explode.**

**FIREARMS SAFETY IS YOUR RESPONSIBILITY.**



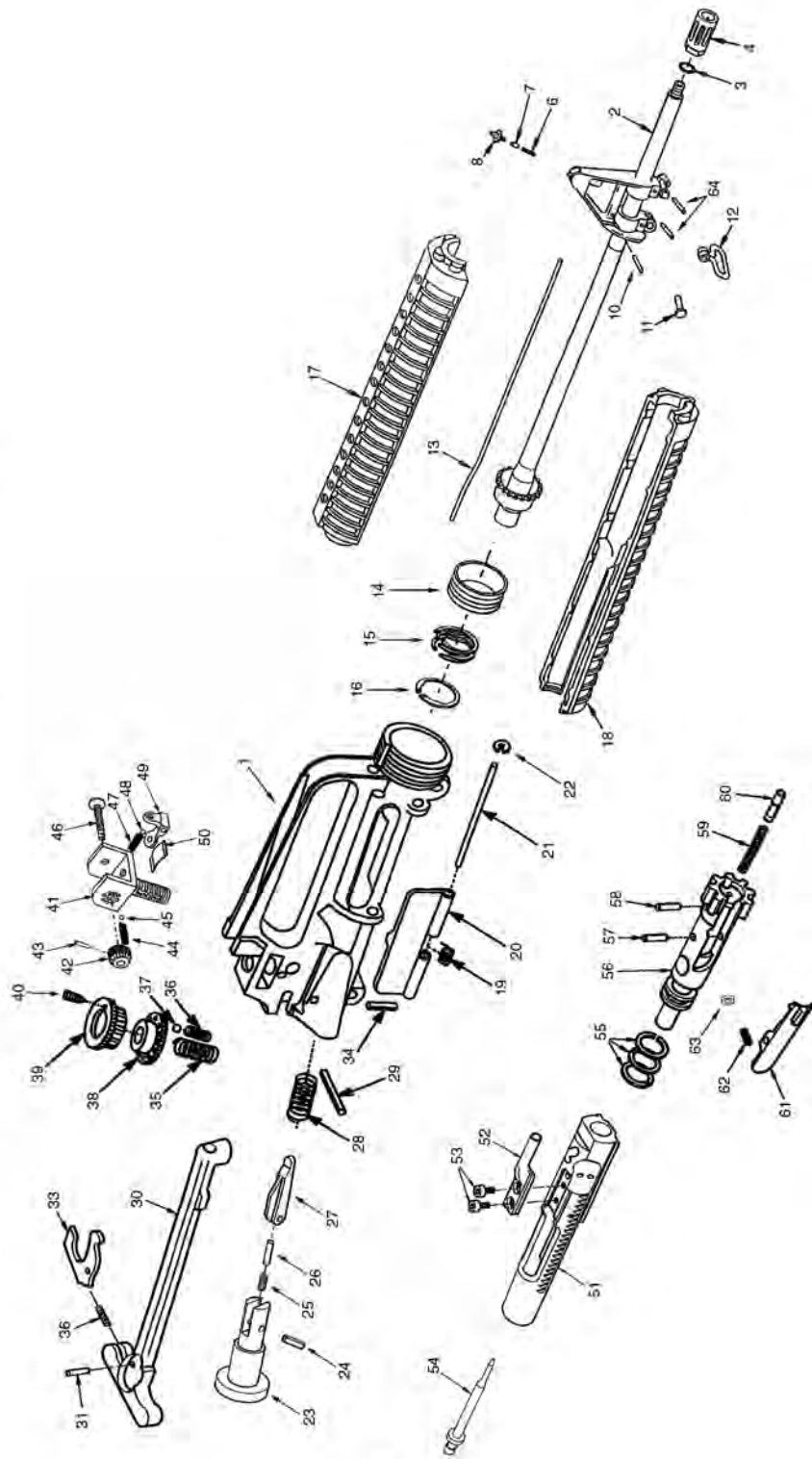
## GENERAL SAFETY WARNINGS

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. 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.
7. **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.
8. **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.
9. Always make sure your firearm is not loaded before cleaning, storing, or handing it to another person.
10. Always wear and encourage others to wear safety glasses while shooting to protect your eyes from injury by gun powder gas, lubricant, dirt or metallic particles, carbon residue, sparks or other debris.
11. Always wear and encourage others to wear ear protection when shooting, especially on the range. Without ear protection the noise from your gun, and other guns close to you could leave a "ringing" in the ears for some time after firing. Repeated exposure to shooting noise could result in permanent hearing loss.
12. Never climb a tree, fence or wall while carrying a loaded firearm.
13. Do not shoot at a hard surface, or at water. The bullet may ricochet

## LOWER ASSEMBLY PARTS LIST

- |                                 |                            |
|---------------------------------|----------------------------|
| 1. Lower Receiver               | 25. Bolt Catch Plunger     |
| 2. Takedown Pin                 | 26. Bolt Catch Spring      |
| 3. Takedown Pin Spring          | 27. Bolt Catch Roll Pin    |
| 4. Takedown Pin Detent          | 28. Hammer with J Pin      |
| 5. Hammer & Trigger Pin         | 29. Hammer Spring          |
| 6. Trigger Guard Pivot Roll Pin | 30. Buffer Retainer        |
| 7. Trigger Guard                | 31. Buffer Retainer Spring |
| 8. Trigger Guard Pin            | 32. Receiver Extension     |
| 9. Pistol Grip                  | 33. Action Spring          |
| 10. Lock Washer                 | 34. Buffer Assembly        |
| 11. Pistol Grip Screw           | 35. Buttcap Spacer         |
| 12. Safety Detent Spring        | 36. Buttstock              |
| 13. Safety Detent               | 37. Access Door Hinge      |
| 14. Pivot Pin Spring            | 38. Rear Sling Loop        |
| 15. Pivot Pin Detent            | 39. Access Door Hinge Pin  |
| 16. Takedown Pivot Pin          | 40. Access Door Assembly   |
| 17. Disconnecter                | 41. Buttplate              |
| 18. Trigger                     | 42. Buttplate Screw        |
| 19. Disconnecter Spring         | 43. Rear Swivel Screw      |
| 20. Trigger Spring              | 44. Magazine Body          |
| 21. Magazine Release Button     | 45. Magazine Floor Plate   |
| 22. Magazine Catch Spring       | 46. Magazine Spring        |
| 23. Magazine Catch              | 47. Magazine Follower      |
| 24. Bolt Catch                  |                            |

## UPPER ASSEMBLY SCHEMATIC



and travel in unpredictable directions to strike you or another unintended object or an object that you can not see.

14. If you have any doubts about your ability to handle or use this rifle safely, seek supervised instruction.
15. Firearms and alcohol do not mix. Never drink alcoholic beverages or take drugs before or during 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 your fitness to handle your firearm safely.
16. **Horseplay has no place around firearms. Guns can't think – you can!**
17. **Remember, safety is your responsibility, be a safe shooter.**
18. FOLLOW THE LAW. Obey all local, state and federal laws regarding storage, shooting and transporting your firearm.

# NOMENCLATURE



# UPPER ASSEMBLY PARTS LIST

- |  |  |
|--|--|
| 1. Upper Receiver                      | 33. Charging Handle Latch              |
| 2. Barrel Assembly                     | 34. Forward Assist Spring Pin          |
| 3. Peel Washer                         | 35. Rear Sight Elevator Spring         |
| 4. Flash Suppressor                    | 36. Elevation Index Spring             |
| 5. Front Sight                         | 37. Ball Bearing                       |
| 6. Front Sight Detent Spring           | 38. Elevation Knob                     |
| 7. Front Sight Detent                  | 39. Rear Sight Elevation Index         |
| 8. Front Sight Post                    | 40. Index Screw                        |
| 9. Handguard Cap                       | 41. Rear Sight Base                    |
| 10. Gas Tube Roll Pin                  | 42. Rear Sight Windage Knob            |
| 11. Front Swivel Rivet                 | 43. Rear Sight Windage Knob Pin        |
| 12. Front Sling Swivel                 | 44. Rear Sight Index Spring            |
| 13. Gas Tube                           | 45. Rear Sight Ball Bearing            |
| 14. Delta Ring                         | 46. Rear Sight Windage Screw           |
| 15. Weld Spring                        | 47. Rear Sight Spring                  |
| 16. Handguard Snap Ring                | 48. Rear Sight Ball Bearing            |
| 17. Handguard, Top with Heat Shield    | 49. Rear Sight Aperture                |
| 18. Handguard, Bottom with Heat Shield | 50. Rear Sight Flat Spring             |
| 19. Ejection Port Cover Spring         | 51. Bolt Carrier                       |
| 20. Ejection Port Cover                | 52. Bolt Carrier Key                   |
| 21. Ejection Port Cover Pin            | 53. Bolt Carrier Key Screw (2)         |
| 22. Pin Retaining Ring                 | 54. Firing Pin                         |
| 23. Forward Assist Plunger             | 55. Bolt Gas Ring (3)                  |
| 24. Pawl Spring Pin                    | 56. Bolt                               |
| 25. Pawl Spring                        | 57. Extractor Pin                      |
| 26. Pawl Spring Detent                 | 58. Ejector Roll Pin                   |
| 27. Forward Assist Pawl                | 59. Ejector Spring                     |
| 28. Forward Assist Spring              | 60. Ejector                            |
| 29. Rear Sight Elevation Spring Pin    | 61. Extractor                          |
| 30. Charging Handle                    | 62. Extractor Spring with Black Insert |
| 31. Charging Handle Roll Pin           | 63. Black O-Ring                       |
| 32. Charging Handle Latch Spring       | 64. Front Sight Pin (2)                |

- Mate the Upper Receiver to the Lower Receiver. Position the Takedown Pin Lug of the Upper Receiver into the slot at the front of the Lower Receiver and push the Takedown Pin into place (Fig. 49).



Fig. 49

- Make sure the Safety Selector Lever 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.

## MAGAZINE DISASSEMBLY / CLEANING / ASSEMBLY

- To disassemble the Magazine, use a punch to lift up the bottom of the Baseplate past the Magazine body (Fig. 50).
- Slide the Baseplate out of the Magazine body (Fig. 51).
- Remove the Magazine Spring and Follower out of the body (Fig. 52). **Do not detach the Follower from the Spring.**



Fig. 50



Fig. 51

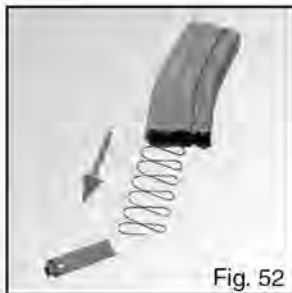


Fig. 52

Clean all the dirt from inside and outside of the Magazine body. Also, clean the Spring, Baseplate, and Follower.

Lightly lubricate the Spring and reassemble.

To reassemble, position the Spring and Follower in the Magazine body, and slide the Baseplate under all 4 tabs.

## MAIN FEATURES AND OVERVIEW

STAR-15 rifles and carbines features include:

- Upper and lower receivers are forged 7075-T6 aluminum alloy, hard coat anodized per Mil-Spec and Teflon coated.
- Chambered for 5.56mm NATO which allows the use of .223 Rem ammunition.
- T-Marked flattop uppers.
- Mil-Spec gas key staking and castle nut staking.
- Black extractor insert with O-ring.
- Safety selector position engraved on the right side of the receiver with the witness mark painted in red.
- Dust cover, brass deflector and forward assist.
- Radiused aluminum magazine release button.
- Radiused aluminum trigger guard.
- Mil-Spec aluminum magazine with Magpul self-leveling follower.

## FUNCTION OVERVIEW

Double Star Corp. STAR-15 rifles and carbines are gas operated semi-automatic 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

Before your firearm left the factory, it was function tested, inspected and packaged. Double Star Corp. can not 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 BEFORE USE

### ⚠️ 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 from 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 lever to the "SAFE" position (Fig. 1). **Note: if the rifle is not cocked, the Safety Lever Selector can not 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 Lever 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!**

7. 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. 46). Then slide the Charging Handle partially into the Receiver.



Fig. 46

8. Insert the complete Bolt Carrier assembly into the Upper Receiver so that the Gas Key fits into the groove of the Charging Handle (Fig. 47). Note: The bolt must be in the out position in the Carrier for installation.



Fig. 47

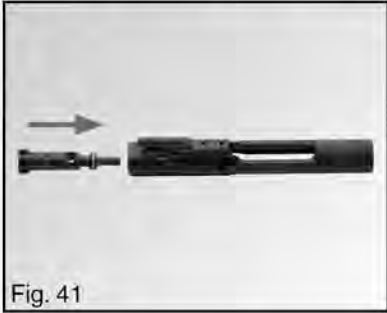
9. Push the Bolt Carrier assembly and Charging Handle all the way into the Upper Receiver until the Charging Handle Latch locks onto the Receiver (Fig. 48).



Fig. 48



4. Insert the bolt into the Bolt Carrier (Fig. 41). Insert the Cam Pin (Fig. 42). 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.



5. Once the Cam Pin is installed, rotate it 90° to allow Firing Pin installation.
6. Install the Firing Pin (Fig. 43), pull the Bolt out (Fig. 44) and install the Firing Pin Retaining Pin (Fig. 45).



## SAFETY SELECTOR LEVER FUNCTION AND CHECK

**Safety is first and foremost when handling any firearm. Always keep the muzzle pointed in a safe direction!** The safety selector is located on the left side on the lower receiver of your rifle and has 2 positions: “Fire” and “Safe.” The safety selector position is also visible from the right side of the lower receiver with a “red” witness mark pointing to the “FIRE” and “SAFE” engravings. **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 “red” 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 “red” 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

### ⚠️ WARNING

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

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.

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. The STAR-15 rifles are chambered in 5.56 NATO which will also fire .223 Rem caliber ammunition. Not all ammunition produces the same result. Double Star Corp. recommends that once you find a brand which functions best, keep using it. Double Star Corp. does not recommend using hand loads or remanufactured ammunition and the use of this ammunition will void the Double Star Corp. warranty.

## ASSEMBLING YOUR RIFLE

### ⚠️ WARNING

**THE CAM PIN MUST BE INSTALLED IN THE BOLT GROUP OR YOUR RIFLE WILL EXPLODE UPON FIRING.**

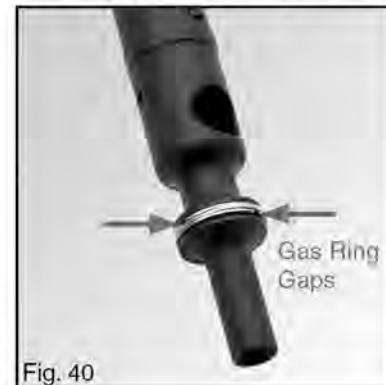
1. Install the Buffer into the Action Spring. Depress the Buffer Detent and push the Buffer past the Detent, then release the Detent (Fig. 38).



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 the on Extractor to depress the Spring and install Extractor Pin (Fig. 39).



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.40). Position the ring gaps 120° apart around the bolt.



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

## 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 damage to your rifle.**

#### 1. LOAD THE MAGAZINE



Using only high quality commercially 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.

### ⚠ 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 damage to your rifle.**

#### 2. LOAD THE 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).

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 it is retained by the Magazine Catch. Tap the bottom of the magazine to 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"

## 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 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 side the trigger guard. **Do not have your trigger finger on the trigger at this time.**
2. Aim by aligning 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.



strokes and 3 rotational strokes of 360 degrees. Then swab out bore and chamber with a cotton patch on the cleaning rod.

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, the 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 mechanical damage, excessive wear, and corrosion.
4. Clean out the gas key and carrier vent holes with a cotton swab (Fig. 36).
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 telestock can be disassembled by pulling down the telestock latch and pulling the stock off (Fig. 37). Clean the 6 position lock holes, lightly lubricate the receiver extension and latch and reassemble.



## 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



## CLEANING AND LUBRICATION

### 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



Fig. 33

The follow 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. 33). 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 gun cleaning solution and thoroughly scrub out the barrel (Fig 34). 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. 35). Use a minimum of 5 plunge



Fig. 34



Fig. 35

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.

## SIGHTS AND ZEROING PROCEDURES

### SIGHTS

Some models are flat top uppers without carrying handle or a removable carry handle. These models have a Weaver style rail for mounting rings, scopes and other accessories. The mounting rails (T-Marked) 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. 13). This is accomplished by depressing the spring loaded detent with a punch or dummy bullet and rotating the sight up or down (Fig. 14). 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.

### REAR SIGHT



Fig. 13



Fig. 14

The rear sight 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 2 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. 15).



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 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 inch at 25 meters to 4 inches 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. 16) on the carry handle by turning the windage knob.
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



9. With a punch, remove the extractor pin (Fig. 28).



10. Remove extractor, extractor spring, black insert, and black O-ring (Fig. 29 & 30).

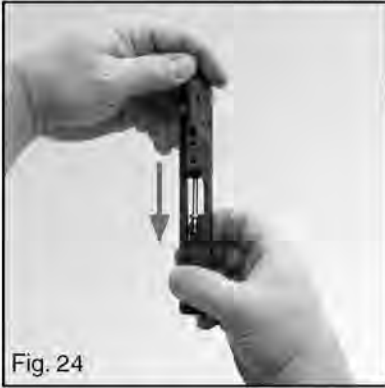


11. From the lower assembly, remove the buffer and action spring. Make sure the hammer is in the cocked position, and then depress the buffer retainer pin with a punch (Fig 31). Remove the buffer and action spring (Fig 32).



**Double Star Corp. does not recommend any further disassembly unless done by a qualified gunsmith.**

- Remove the firing pin from the rear of the bolt carrier (Fig. 24).



- Push the bolt to the closed and locked position (Fig. 25).



- Rotate the cam pin 1/4 turn and lift out of the bolt carrier (Fig. 26).



- Pull the bolt assembly straight out from the bolt carrier (Fig. 27).



in elevation will be accomplished by raising or lowering the front sight post.

- 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.
- Place an appropriate target 25 meters downrange. Caution: Make sure that it is safe to shoot and the range is clear.
- Carefully aim and fire each shot of a 3 shot group.
- Inspect your target.
- If your shots are not striking the point of aim, then adjust your sights. Remember that 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 which is marked on the knob as "R" with arrow.
- Fire another 3 shot group and adjust the sights, if required.
- Repeat steps 7 and 8 until your shot group is on bullseye.
- The normal range aperture is now automatically zeroed for all ranges. To shoot at 400 meters, turn the elevation dial to the 4 mark.

## DISASSEMBLING YOUR RIFLE

### ⚠ WARNING

**Make sure your rifle is unloaded before starting disassembly.**

Follow the below disassembly steps 1 through 8 for lubrication. If your rifle is dirty, damaged, or wet, follow all 11 steps.

The disassembly procedure is as follows:

1. Push the rear takedown pin from the left side of the receiver as far as it will go to the right (Fig. 17). 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, and separate the upper and lower receiver assemblies (Fig. 18 & 19).



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. 20 & 21). Then remove the charging handle (Fig. 22).



4. Remove the firing pin retaining pin from the bolt carrier (Fig. 23). **Be careful to not open or close the split end of the retaining pin and never substitute a common cotter pin for this part.**

