



DOUBLE BARREL VOLLEYFIRE<sup>®</sup> REVOLVERS

## INSTRUCTION MANUAL



**THUNDERSTRUCK<sup>®</sup>**

Designed, Engineered & Built in the USA



**READ THE INSTRUCTIONS AND  
WARNINGS IN THIS MANUAL CAREFULLY  
BEFORE USING THIS FIREARM**

**For Service on this model please email:  
[info@stdgun.com](mailto:info@stdgun.com)**

THIS INSTRUCTION MANUAL SHOULD ALWAYS ACCOMPANY THIS FIREARM AND BE  
TRANSFERRED WITH IT UPON CHANGE OF OWNERSHIP, OR WHEN THE FIREARM IS LOANED  
OR PRESENTED TO ANOTHER PERSON

[www.STDGUN.com](http://www.STDGUN.com)

## **State-By-State Warnings**

Certain states require by law that their own specified warning notices in larger-than-normal type be conspicuously included in this document by the manufacturer, distributor or retailer with firearms sold in that state. Standard Mfg. Co. sells its products in compliance with applicable laws and regulations. Because our products may be sold in these states, we include the following:

### **California:**

#### **WARNING**

“Firearms must be handled responsibly and securely stored to prevent access by children and other unauthorized users. California has strict laws pertaining to firearms, and you may be fined or imprisoned if you fail to comply with them. Visit the Web site of the California Attorney General at <https://oag.ca.gov/firearms> for information on firearm laws applicable to you and how you can comply.

Prevent child access by always keeping guns locked away and unloaded when not in use. If you keep a loaded firearm where a child obtains and improperly uses it, you may be fined or sent to prison.”

#### **ADVERTENCIA**

“Las armas de fuego deben manipularse de manera responsable y segura para evitar el acceso de niños y otros usuarios no autorizados. California tiene leyes estrictas relacionadas con armas de fuego, y usted puede ser multado o encarcelado si no las cumple. Visite el sitio web del Procurador General de California en <https://oag.ca.gov/firearms> para obtener información sobre las leyes de armas de fuego que le son aplicables y cómo puede cumplirlas.

A los niños los atraen las armas de fuego y las pueden hacer funcionar. Ellos pueden causarse lesiones graves y la muerte. Evite que los niños tengan acceso a las armas de fuego guardándolas siempre con llave y descargadas cuando no las esté utilizando. Si usted tiene un arma de fuego cargada en un lugar en que un niño tiene acceso a ella y la usa indebidamente, le pueden dar una multa o enviarlo a la cárcel.”

**Connecticut:**

“UNLAWFUL STORAGE OF A LOADED FIREARM MAY RESULT IN IMPRISONMENT OR FINE.”

**Florida:**

“IT IS UNLAWFUL, AND PUNISHABLE BY IMPRISONMENT AND FINE, FOR ANY ADULT TO STORE OR LEAVE A FIREARM IN ANY PLACE WITHIN THE REACH OR EASY ACCESS OF A MINOR UNDER 18 YEARS OF AGE OR TO KNOWINGLY SELL OR OTHERWISE TRANSFER OWNERSHIP OR POSSESSION OF A FIREARM TO A MINOR OR A PERSON OF UNSOUND MIND.”

**Maine:**

“ENDANGERING THE WELFARE OF A CHILD IS A CRIME. IF YOU LEAVE A FIREARM AND AMMUNITION WITHIN EASY ACCESS OF A CHILD, YOU MAY BE SUBJECT TO FINE, IMPRISONMENT OR BOTH. KEEP FIREARMS AND AMMUNITION SEPARATE. KEEP FIREARMS AND AMMUNITION LOCKED UP. USE TRIGGER LOCKS.”

**Maryland:**

“WARNING: Children can operate firearms which may cause death or serious injury. It is a crime to store or leave a loaded firearm in any location where an individual knew or should have known that an unsupervised minor would gain access to the firearm. Store your firearm responsibly!”

### **Massachusetts:**

“WARNING FROM THE MASSACHUSETTS ATTORNEY GENERAL: This handgun is not equipped with a device that fully blocks use by unauthorized users. More than 200,000 firearms like this one are stolen from their owners every year in the United States. In addition, there are more than a thousand suicides each year by younger children and teenagers who get access to firearms. Hundreds more die from accidental discharge. It is likely that many more children sustain serious wounds, or inflict such wounds accidentally on others. In order to limit the chance of such misuse, it is imperative that you keep this weapon locked in a secure place and take other steps necessary to limit the possibility of theft or accident. Failure to take reasonable preventive steps may result in innocent lives being lost, and in some circumstances may result in your liability for these deaths.”

“IT IS UNLAWFUL TO STORE OR KEEP A FIREARM, RIFLE, SHOTGUN OR MACHINE GUN IN ANY PLACE UNLESS THAT WEAPON IS EQUIPPED WITH A TAMPER-RESISTANT SAFETY DEVICE OR IS STORED OR KEPT IN A SECURELY LOCKED CONTAINER.”

### **New Jersey:**

“IT IS A CRIMINAL OFFENSE TO LEAVE A LOADED FIREARM WITHIN EASY ACCESS OF A MINOR.”

### **New York City:**

“THE USE OF A LOCKING DEVICE OR SAFETY LOCK IS ONLY ONE ASPECT OF RESPONSIBLE FIREARM STORAGE. FOR INCREASED SAFETY, FIREARMS SHOULD BE STORED UNLOADED AND LOCKED IN A LOCATION THAT IS BOTH SEPARATE FROM THEIR AMMUNITION AND INACCESSIBLE TO CHILDREN AND UNAUTHORIZED PERSONS.”

**North Carolina:**

“IT IS UNLAWFUL TO STORE OR LEAVE A FIREARM THAT CAN BE DISCHARGED IN A MANNER THAT A REASONABLE PERSON SHOULD KNOW IS ACCESSIBLE TO A MINOR.”

**Texas:**

“IT IS UNLAWFUL TO STORE, TRANSPORT, OR ABANDON AN UNSECURED FIREARM IN A PLACE WHERE CHILDREN ARE LIKELY TO BE AND CAN OBTAIN ACCESS TO THE FIREARM.”

**Wisconsin:**

“IF YOU LEAVE A LOADED FIREARM WITHIN THE REACH OR EASY ACCESS OF A CHILD YOU MAY BE FINED OR IMPRISONED OR BOTH IF THE CHILD IMPROPERLY DISCHARGES, POSSESSES, OR EXHIBITS THE FIREARM.”

\* \* \* \* \*

Please check with your licensed retailer or state police for additional warnings which may be required by local law or regulation. Such regulations change constantly, and local authorities are in the best position to advise you on such legal matters.

## **FIREARMS SAFETY IS YOUR RESPONSIBILITY**

### **SAFETY MUST BE THE FIRST AND CONSTANT CONSIDERATION OF EVERY PERSON WHO HANDLES FIREARMS AND AMMUNITION.**

This Instruction Manual is designed to assist you in learning how to use and care for your Standard Mfg. Co. S333<sup>®</sup> revolver properly. Please contact us if you have any questions.


Only when you are certain you fully understand the manual and can properly carry out its instructions should you practice loading, unloading, etc. with live ammunition. If you have any doubts about your ability to handle or use a particular type of gun safely, you should seek supervised instruction. Such personalized instruction often is available from local gun retailers, gun clubs or police departments. If none of these sources can help visit [www.nra.org](http://www.nra.org) or write to the following address:

National Rifle Association  
11250 Waples Mill Road  
Fairfax, VA 22030-7400

The person possessing a gun has a full-time job. You cannot guess; You cannot forget; You must know how to use your firearm safely. **Do not use any firearm without having a complete understanding of its particular characteristics and safe use.** Remember: There is no such thing as a foolproof gun. **TREAT EVERY GUN AS IF IT IS LOADED AT ALL TIMES.**

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**WARNINGS OF GREAT IMPORTANCE ARE FOUND ON THE FOLLOWING PAGES:**

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**OTHER CAUTIONS AND WARNINGS APPEAR THROUGHOUT THE MANUAL.**

# NOMENCLATURE

Figure 1

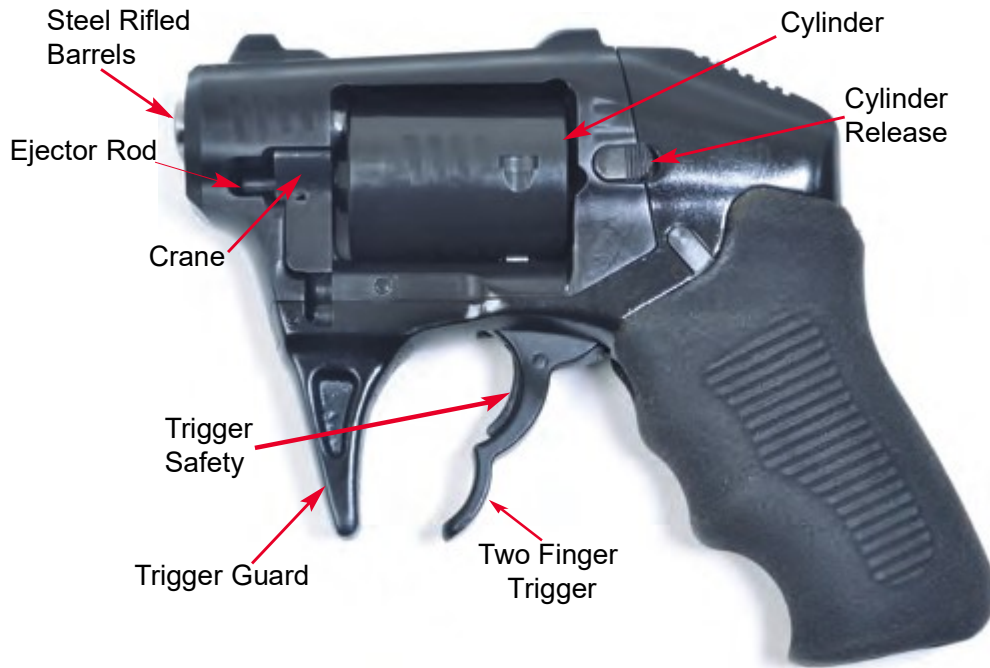




Figure 2





## LOCKING DEVICE INSTALLATION INSTRUCTIONS

 <b>WARNING – USE OF LOCKING DEVICES</b>	
 <p><b>Do not store keys in lock.</b></p>	<ul style="list-style-type: none"><li>• Always keep your firearm pointed in a safe direction, including when you are installing or removing your locking device.</li><li>• Always verify that your firearm is completely <b>unloaded</b> before installing your locking device.</li><li>• Do <b>not</b> install locking device around the trigger and always keep your fingers and locking device outside the trigger guard during device installation and removal.</li><li>• Store firearms, ammunition and keys separately and securely, away from children and careless adults; do <b>not</b> store your firearm with the keys in the locking device.</li><li>• Do not attempt to work the action of your firearm with the locking device in place; this may damage your firearm.</li><li>• While locking devices are an important aid to security measures, they are not a substitute for safe firearm handling and proper storage. Remember that any mechanical device can be bypassed with enough time, knowledge, determination and equipment.</li></ul>
<b>LOCKING DEVICES MUST BE USED SAFELY AND RESPONSIBLY</b>	

It is important to use the supplied cable lock on your Standard Mfg. Co. firearm when the firearm is stored or immediate use is not planned.

Always keep the muzzle pointed in a safe direction and your fingers outside the trigger guard area at all times!

### **To Install the Factory-Supplied Locking Device:**

1. Be sure the firearm is completely unloaded and contains no cartridges or cartridge cases!
2. Completely swing out the cylinder.

3. Apply the cable through the cylinder opening as shown in Figure 3.  
: Apply the lock by placing the cable through the frame as shown in Figure 3.  
**Only apply cable as shown in Figure 3.**
4. To lock: With the key turned to the farthest clockwise position, insert the loose end of the cable into the lock. Turn the key counterclockwise and remove the key.
5. Once the lock is securely closed, pull firmly on the lock to test the connection and be sure it is locked. **Do not leave or store your firearm with the key in the lock!** Store your locked, unloaded firearm and the key in secure, separate locations, away from ammunition, children, and unauthorized adults.



*Correct Installation of  
Lock For S333® Volleyfire®  
Standard Mfg. Co.  
Revolvers*

**FIREARMS ARE DANGEROUS WEAPONS**  
**READ THE INSTRUCTIONS AND WARNINGS IN THIS**  
**MANUAL THOROUGHLY AND CAREFULLY BEFORE USING.**

	<b>WARNING-ALTERATIONS</b>
	This product was designed to function properly in its original condition. Alterations can make it unsafe. Do not alter any part or add or substitute parts or accessories not made by Standard Mfg. Co.
	<b>DO NOT ALTER ANY GUN</b>

**GENERAL INFORMATION**  
**AND MECHANICAL CHARACTERISTICS**

The *Standard Mfg. Co. S333*<sup>®</sup> is a double-action revolver that incorporates many features found in the famous STANDARD MFG. CO. amazing products as well as several new innovative features. The unique hammer housing incorporates the ability for a grip extension as an option.

The craned cylinder assembly of the S333<sup>®</sup> locks into the frame in the rear of the cylinder and at the front via the massive crane arm.

The internal parts are installed through the top of the hammer housing or through the bottom and back of the frame. Therefore, no side plate is needed.

The *Standard Mfg. Co. S333*<sup>®</sup> has a transfer bar which is connected directly to the trigger. The transfer bar safety system provides that the hammer blow can be transmitted to the firing pin only when the trigger is pulled all the way to the rear. This is a positive internal safety feature. NOTE: The transfer bar is allowed some movement within the fire control mechanism so that the trigger pull is not affected. Due to this necessary “play” in the transfer bar, a shooter will sometimes hear the transfer bar “rattle” when the revolver is shaken. This rattle caused by the play in the transfer bar is completely normal in the S333<sup>®</sup>. The *Standard Mfg. Co. S333*<sup>®</sup> model features an internal hammer that allows it to be fired in double-action mode only.

Despite their many highly desirable features, this Standard Mfg. Co. revolver – as with all firearms – must at all times be handled with strict attention to correct safety practices, and be inspected frequently to assure the gun is working properly.

# AMMUNITION

*Standard Mfg. Co. S333*® firearms are designed for use with cartridges of the correct caliber which are manufactured in accordance with the U.S. Industry Standards. Be certain to use proper cartridges of the correct caliber. See page 23 (“Care and Cleaning”) for important information on chamber cleaning.

The 8-shot *Standard Mfg. Co. S333*® has the same basic operational characteristics as all other double action revolvers, and is chambered for the **.22 Winchester Magnum** cartridge.

NOTE: Rimfire ammunition manufacturers use different types of brass for their cases and different lubricants on their bullets. As a result of these variations, some rimfire ammunition can cause problems in double-action revolvers. If you are experiencing extraction problems, clean the gun in accordance with this instruction manual. If you are experiencing light firing pin strikes, clean the gun in accordance with this instruction manual and be sure to fully seat the cartridges in the cylinder when loading. If either of these issues persist, try another brand or type of rimfire ammunition; try to avoid ammunition with heavy coatings of bullet lubricant.



## WARNING—.22 WMR SHOTSHELLS

USE OF .22 WMR SHOTSHELLS WITH PLASTIC CAPSULE PAYLOADS MAY RESULT IN MELTED PLASTIC DEBRIS DEPOSITED IN CYLINDER BORES. CONTINUED BUILD-UP OF DEBRIS IN THE CYLINDER WILL KEEP AMMUNITION FROM SEATING CORRECTLY IN THE CHAMBERS, STALLING CYLINDER ROTATION.





## WARNING – LEAD EXPOSURE




Discharging firearms in poorly ventilated areas, cleaning firearms, or handling ammunition may result in exposure to lead and other substances known to the State of California to cause birth defects, reproductive harm, and other serious physical injury. Have adequate ventilation at all times. Wash hands thoroughly after exposure.

**SHOOTING OR CLEANING GUNS  
MAY EXPOSE YOU TO LEAD**

		<b>WARNING – AMMUNITION</b>
	Death, serious injury, and damage can result from the wrong ammunition, bore obstructions, powder overloads or incorrect cartridge components. <u>Always</u> wear shooting glasses and hearing protection.	
		<b>IMPROPER AMMUNITION DESTROYS GUNS</b>

- \* PLEASE CHECK THAT YOU ARE USING THE CORRECT **.22 MAGNUM CALIBER** CARTRIDGES.
- \* THESE DIFFER FROM .22 LONG AND .22 SHORT RIFLE CARTRIDGES.
- \* THESE GUNS ARE SHOT, TESTED AND REGULATED USING STANDARD AMMUNITION MANUFACTURED TO SAAMI SPECIFICATIONS.
- \* ALWAYS MAKE SURE THE CYLINDER IS LOCKED IN PLACE BEFORE FIRING.
- \* **DO NOT DRY FIRE THIS GUN FREQUENTLY.** IF YOU MUST DRY FIRE THE GUN, ENSURE THE GUN IS UNLOADED BY USING THE PLASTIC SNAP CAP INSERT SUPPLIED WITH THE GUN.
- \* **DO NOT ASSUME ALL 8 ROUNDS WENT OFF, YOU COULD HAVE HAD A MISFIRE WITH LIVE ROUNDS STILL IN SOME CHAMBERS.**

	<b>WARNING – .22 WMR SHOTSHELLS</b>
READ ALL NOTATIONS AND WARNINGS ON SHOTSHELL AMMUNITION BOXES BEFORE USE IN THIS REVOLVER.	

## AMMUNITION CHECK

Due to the light weight of the S333<sup>®</sup>, inertial forces to ammunition during firing could possibly unseat a bullet from its crimp in the cartridge casing. The S333<sup>®</sup> has been tested with a variety of popular ammunition manufactured to SAAMI industry standards and has not demonstrated any tendency to unseat bullets. However, before placing the S333<sup>®</sup> into service, it is recommended that you:

1. At a range or other suitable location, fully load your revolver with the ammunition you wish to test in accordance with the safety and loading instructions in this manual.
2. Fire 3 of the 4 double shot rounds in accordance with the safety and firing instructions in this manual.
3. Unload the six fired cases and the 2 unfired rounds in accordance with the safety and unloading instructions in this manual. Closely inspect the unfired rounds for signs that the bullet has moved forward out of the case. For jacketed and lead bullets with a cannelure or crimp groove, check to see if the bullet has moved forward enough so that the case mouth is no longer located in the bullet cannelure or crimp groove. For lead bullets without a cannelure or crimp groove, there should be no detectable movement of the bullet. If the bullet has moved as just described, do not use that brand of tested ammunition, and repeat this test with another brand until one is found that the bullet does not unseat during this test.
4. .22 WMR SHOTSHELLS; Be sure to read carefully all notes on the shotshell box for revolvers and capsule movement due to recoil.
4. After the test is completed, unload and store the revolver in accordance with the safety and storage instructions in this manual.

### AMMUNITION (CARTRIDGES) NOTICE



WE SPECIFICALLY DISCLAIM RESPONSIBILITY FOR ANY DAMAGE OR INJURY WHATSOEVER OCCURRING IN CONNECTION WITH, OR AS THE RESULT OF, THE USE IN THE S333 REVOLVER OF FAULTY, OR NON-STANDARD, OR "REMANUFACTURED", OR HAND LOADED (RELOADED) AMMUNITION, OR OF CARTRIDGES OTHER THAN THOSE FOR WHICH THE FIREARM WAS ORIGINALLY CHAMBERED.

**CHAMBERED FOR .22 MAGNUM ONLY**

## HANDLING

**CARRYING:** The S333® can be carried with all chambers loaded. When the hammer and trigger are fully forward, the transfer-bar is lowered out of its firing position and the hammer rests directly on the frame unable to activate the firing pins.

### SPECIAL HANDLING WARNING FOR S333®

 <b>WARNING – HANDLING</b>	
	<p>If the trigger is held to the rear, the gun can fire if the hammer strikes the transfer bar. Note that it need not be a deliberate effort to pull the trigger. Any situation where the trigger attains its rearward position and permits the transfer bar to be interposed between the hammer and the firing pin can cause the cartridge under the firing pin to discharge.</p> <p><b>NEVER DROP OR STRIKE THE REVOLVER – COCKED OR UNCOCKED. CARRY AND HANDLE THE REVOLVER IN SUCH A MANNER THAT THE HAMMER AND TRIGGER WILL NOT BE STRUCK.</b></p>
	<p><b>NEVER CARRY ANY REVOLVER WITH THE HAMMER COCKED OR THE TRIGGER HELD TO THE REAR</b></p>

## DRY FIRING

“Dry Firing” is pulling the trigger of an unloaded revolver for practice and familiarity. The S333® should not be continuously dry-fired without damage to the firing pin or internal components, we recommend using the snap cap ring supplied.




**Be sure that the revolver is unloaded before handling.** Be sure of your target or back stop, even when dry firing for practice. Continued dry firing is not recommended and may leave marks on the cylinder face. Dry firing on the snap cap ring will wear the plastic bullet ring instead of the firearm. It is best to install the snap cap ring to eliminate cylinder marking and to insure there are no live rounds in a chamber.

## TO LOAD AND FIRE

**Be sure the revolver is pointed in a safe direction while loading.**

1. Press the crane latch button and guide cylinder out of frame to the left to its loading position.
2. Insert cartridges completely making sure the **rim is seated against the cylinder face.**
3. Snap the cylinder closed, checking that the crane arm is locked and making sure the cylinder is securely latched.
4. Check that the cylinder rotation is locked by the cylinder bolt.
5. **DO NOT TOUCH THE TRIGGER UNTIL YOU ARE READY TO FIRE.**
6. **DO NOT HOLD THE REVOLVER BY THE BARREL OR CYLINDER WHEN FIRING. KEEP ALL HANDS AND FINGERS BEHIND AND UNDER THE ROTATING CYLINDER.**



 <b>WARNING-FIRING</b>	
	<p>When firing the S333<sup>®</sup>, be sure all persons are a safe distance to the rear of the shooter. When fired, all revolvers discharge hot gas and particles of lead, powder grains, or lubricant through the clearance gap between the cylinder and the rear of the barrel. These high-speed discharges can injure a person who is standing too close to the revolver.</p> <p>When firing the S333<sup>®</sup> (or any revolver), always be certain that nothing – including your hands – is in the path of the hot gas and particles which are discharged from the front and sides of the cylinder.</p> <p>When shooting, adequate eye protection is essential. Shooters and bystanders must wear shooting glasses. Hearing protection must also be worn. Exposure to shooting noise can damage hearing.</p>
	
<b>WEAR EYE AND EAR PROTECTION</b>	<b>HOT GASES EXIT BARREL/CYLINDER GAP</b>

**\*NO FINGERS OR HANDS NEAR CYLINDER FRONT\***



## TO LOAD AND FIRE THE S333®

**Be sure the revolver is pointed in a safe direction while loading.**

Follow steps 1 - 6 on pg. 16. The revolver is now ready to fire, “double-action” by pulling the trigger through its complete arc for each shot. The trigger pull is somewhat long and must travel to rear position to cock and release the hammer.

Be sure to securely grip the firearm with your lower two fingers allowing two fingers on the trigger.

**NEVER ACTIVATE  
TRIGGER WHILE  
CYLINDER IS OPEN**

**WHEN LOADING - MAKE SURE  
ALL SHELLS ARE FULLY SEATED  
AGAINST THE CYLINDER FACE.**

DO NOT ASSUME ALL  
8 ROUNDS WENT OFF,  
YOU COULD HAVE  
HAD A MISFIRE WITH  
LIVE ROUNDS STILL IN  
SOME CHAMBERS.



## SIGHTS

The S333® revolvers are provided with fixed sights.



Suggested sight picture

Top of front sight even with top of rear sight. Front sight centered in notch of rear sight. Target bullseye centered on top of front sight.

## TO UNLOAD OR EJECT CARTRIDGE CASES



**KEEP THE REVOLVER POINTED IN A SAFE DIRECTION!**

1. Press the cylinder release button. Guide the cylinder out to left of the frame as for loading. The revolver now cannot be fired.
2. Push the head of the ejector rod smartly toward the rear of the cylinder until it stops. This action will extract cartridges or fired cases. Do not eject live cartridges onto any surface where a primer might strike a solid object and discharge the cartridge.
3. **Check to be sure all chambers are empty.**  
It is recommended to install the snap cap ring to insure safety.

NOTE: When ejecting fired cartridge cases, position the revolver at a high angle so the cases will come fully out of the chambers and not slip under the ejector. This high angle positioning is not necessary when extracting unfired cartridges for removal. Visually check to ensure each of the 8 chambers are empty before you close the cylinder.

### CORRECT UNLOADING SEQUENCE



 <b>WARNING – DISASSEMBLY</b>	
	<p>Always unload a firearm before cleaning, lubrication, disassembly or assembly.</p> <p>Never remove or install a loaded cylinder – it can fire if dropped or struck.</p>
<b>UNLOAD BEFORE CLEANING</b>	

## DISASSEMBLY

Read instructions before disassembling a gun.

1. **BE CERTAIN THE REVOLVER IS UNLOADED BEFORE DISASSEMBLY.**



2. Using a properly fitting screwdriver, remove the grip retaining screw from bottom of grip. Slide the grip down off hammer housing (see Figure 10).

3. Further disassembly is not required for normal cleaning purposes. Any further disassembly should only be undertaken by trained factory service personnel.

## REASSEMBLY

**AGAIN, BE CERTAIN REVOLVER IS UNLOADED!**

Before starting reassembly, be certain that all components and the inside of the frame are thoroughly clean. Read instructions before re-assembling the firearm.

1. Slip the grip over the grip post. Insert the grip screw into bottom of the grip and tighten.

## CARE AND CLEANING

**ALWAYS BE CERTAIN THE REVOLVER IS UNLOADED BEFORE CLEANING.**

**General:** All the components of the S333<sup>®</sup> were designed with corrosion resistance and ease of cleaning in mind. The aluminum frame of the Standard Mfg. Co. S333<sup>®</sup> has been coated with a hard black anodized coating that is specially formulated to prevent corrosion..

The barrel, cylinder, crane, and numerous other components are blackened or tumbled 4140 steel. Other components like the hammer and trigger have been coated to increase their corrosion resistance and to improve their performance. The hammer housing is also made of aluminum for proven durability above and beyond polymer.

**External Cleaning:** Any standard commercial, polymer-safe gun cleaning solvent can be used to clean the exterior surface of your *Standard Mfg. Co. S333<sup>®</sup>*. Care should be taken to avoid any harsh abrasives, as this could dull the finish of the frame over time.

To clean the barrel after firing, release and swing out the cylinder. Be sure to unload all cartridges and cartridge cases.

1. Clean the barrel from the muzzle end, taking care to avoid damaging the muzzle crown.
2. Using a cleaning rod run a properly sized, solvent-soaked cleaning patch through the bore several times in order to soak the bore with solvent.
3. Using a cleaning rod and a bronze wire bore brush of correct size, push the bore brush completely through the barrel several times.
4. After brushing the bore, swab the bore again with a solvent-soaked cleaning patch.
5. Now wipe the cleaning rod and swab the bore several times with clean patches until the barrel bore is clean.

To clean the chambers of the cylinder, follow the same steps used for cleaning the barrel. Repeat for each of the chambers on the cylinder. Also, clean the underside of the ejector (the “star”) and the area on the cylinder where the ejector seats. Failing to do this can allow powder residue to become trapped between the underside of the ejector and the cylinder and prevent the ejector from fully seating in the cylinder. This condition can cause hard closing of the cylinder and interfere with proper cylinder rotation resulting in a slow sluggish trigger pull.

If lead bullets are used extensively, it is possible that lead build-up may cause cylinder binding. It is recommended that extra care and attention be paid to cleaning the area where the cylinder and crane are joined and also pay close attention to cleaning the breech end of the barrel. To help prevent binding, one can lubricate the cylinder/crane gap with Break-Free® CLP or other lubricant that meets or exceeds MIL-L-63460, however this is not required for proper functioning.

Clean all other exterior surfaces of the frame, cylinder, crane, etc. with standard commercial, polymer-safe gun cleaning solvent and cloth. Wipe off all excess cleaner/solvent with a clean dry cloth. It is not necessary to leave an oil residue on the frame for storage.

**Internal Components:** Your *Standard Mfg. Co. S333®* revolver is designed with special coatings on the trigger, hammer, and other internal components in order to minimize the need to clean and lubricate the components of a properly maintained firearm.

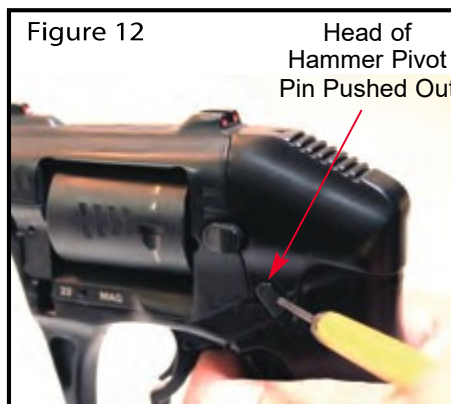
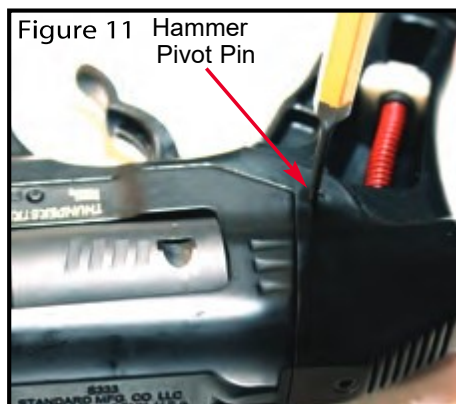
 <b>WARNING – LUBRICATION</b>	
	<p>Firing a revolver with oil, grease, or any other material even partially obstructing the bore may result in damage to the revolver and injury to the shooter and those nearby.</p> <p>Do not spray or apply lubricants directly on ammunition. If the powder charge of a cartridge is affected by the lubricant, it may not be ignited, but the energy from the primer may be sufficient to push the bullet into the bore where it may become lodged. Firing a subsequent bullet onto the obstructed bore may damage the revolver and cause injury to the shooter and those nearby. Use lubricants properly. You are responsible for the proper care and maintenance of your firearms.</p>
	<b>IMPROPER LUBRICATION DESTROYS GUNS</b>

**Lubricating Hammer and Hammer Pivot Pin:** It is recommended that the hammer and hammer pivot pin be lubricated approximately every 1,000 rounds of firing (live or dry fire). To lubricate the hammer and hammer pivot pin, perform the following steps:

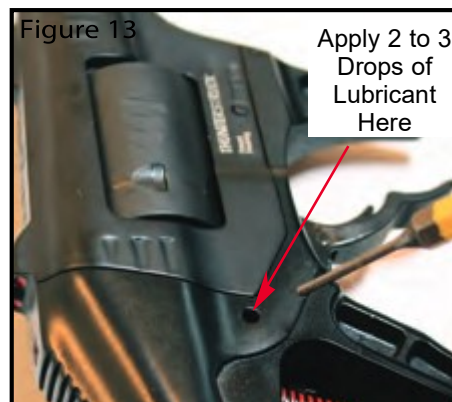
1. **Check to make sure gun is unloaded.**
2. Open cylinder.
3. Remove grip (see Disassembly section of this manual at page 22).
4. Orient gun so the shooter's right hand side of the gun is up.

5. With grip off, using a small (1/8" or smaller) punch, gently push on hammer pivot pin until the pin is only slightly recessed about 1/32" deep (see Figure 11). The pin has been pushed deeply enough when the bottom of the head of the hammer pivot pin on the shooter's left hand side of the gun will just clear its pocket on the fire control housing (see Figure 12).

**CAUTION: DO NOT COMPLETELY REMOVE PIN OR YOUR REVOLVER WILL CEASE TO FUNCTION. IF IT IS PUSHED TOO FAR MAINSPRING FORCE WILL AFFECT PIN TO HOLE ALIGNMENT IN REASSEMBLY**



6. Apply 2 to 3 drops of any standard commercial, polymer-safe gun oil or standard commercial, polymer-safe cleaner-lubricant-protectant to the hammer pivot hole on the shooter's right hand side of the gun (see Figure 13). Allow oil to drain down around the hammer pivot pin and into the action. Rotating the hammer pivot pin using the exposed head on left hand side may facilitate this.



7. Align the head of the hammer pivot pin with its pocket on the shooter's left hand side of the hammer housing and push head of hammer pivot pin back into its recess to fully seat the pin.
8. Replace the grip (see Reassembly section of this manual on page 19).
9. Close the empty cylinder with snap cap ring installed.
10. While pointing the gun in a safe direction, dry fire the gun 5-10 times to help work the lubricant into the action.
11. Open the empty cylinder.
12. Wipe down any excess oil around both sides of the hammer pivot.
13. Check the crane pivot screw and hammer housing retaining screw to ensure tightness.

Disassembly beyond the level indicated in the Disassembly Section of this manual should only be undertaken by trained factory service personnel.

**Frame Finish Touch-up:** The hard-coat treatment applied to your S333® frame and hammer housing is designed to provide a hard, durable, wear and corrosion-resistant surface to the frame to allow many years of use. However, like any hard-coat or anodize finish, the finish may chip if an impact occurs on corners, and a bright spot may occur. If this happens and you wish to restore a black finish to those areas, it is recommended that you use an aluminum blackening compound such as Birchwood Casey® Aluminum Black® touch-up solution in order to restore the black finish to your S333 frame/hammer housing. Follow the manufacturer's directions.

In use wear line on the cylinder from the bolt or other finish blemishes are not covered under warranty.



## STORAGE

**GUNS SHOULD NOT BE STORED LOADED!**

**USE THE LOCKING DEVICE SUPPLIED  
WITH THE REVOLVER TO RENDER IT  
INOPERATIVE FOR SAFE STORAGE.**

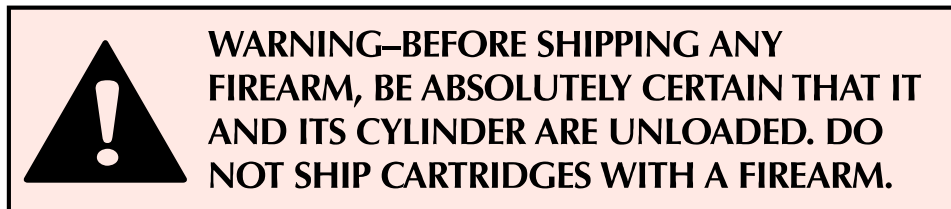
**(See Page 9)**

Do not keep your revolver in a leather, fabric or canvas holster when it is stored. These materials attract moisture, even though the holster may appear to be perfectly dry.

 <b>WARNING – STORAGE</b>	
	<ul style="list-style-type: none"><li>• <b>Never place or store any firearm in such a manner that it may be dislodged. Firearms should always be stored securely and unloaded, away from children and careless adults.</b></li><li>• <b>Use the locking device supplied with the revolver for storage. The use of a locking device or safety lock is only one aspect of responsible firearms storage.</b></li><li>• <b>For increased safety, firearms should be stored unloaded in a location that is both separate from their ammunition and inaccessible to children and any other unauthorized person.</b></li></ul>
<b>STORE SECURELY &amp; UNLOADED</b>	

## SERVICE AND PARTS POLICY

If you have any questions with regard to the performance of your *Standard Mfg. Co. S333*<sup>®</sup> please write or email our Customer Service Department at [info@stdgun.com](mailto:info@stdgun.com) fully describing all circumstances and conditions involved. If you should return your revolver to the factory for repair, or order parts for it, please comply with the following suggestions for prompt service:



### SHIPPING FIREARMS FOR REPAIR

*Standard Mfg. Co. S333*<sup>®</sup> revolvers returned to the factory for repair should be sent to: Standard Mfg. Co., 100 Burritt Street, New Britain, CT 06053.

1. Ground UPS ONLY.
2. NO Insurance - As we cover any guns coming in to us on our own insurance policy.
3. DO NOT use a 3rd party shipper - as they add unnecessary fees - go DIRECTLY to UPS.
4. You DO NOT need an FFL - tell them it is your gun going back to the licensed manufacturer/dealer. \*However, you may want to ship through your local FFL dealer if you will not be home, or do not have someone who is at least 21 at home during the day to sign for the firearm.
5. Whatever address is listed on the return address is the address we MUST send it back to, or a licensed FFL dealer. For example, if it comes in from 123 Lazy Lane - we can't send it back to 456 Lazy Lane.
6. Please be sure to include a note stating your contact information, as well as a brief description of the issue you're experiencing. Not including this information will just delay your repair.
7. In most cases we will get your firearm sent back out to you within 1 business day from the date we receive it.
8. If you have any other questions, please contact us at [info@standardmfgllc.com](mailto:info@standardmfgllc.com)

DO NOT SEND GUN BOXES OR LITERATURE THAT YOU CONSIDER TO BE COLLECTOR'S ITEMS – THESE WILL NOT BE RETURNED

Please do not include holster, grips, or other accessories with a firearm being shipped to the factory for service.



All work performed is subject to a minimum labor charge and charges for shipping and handling. Custom gunsmithing service or nonstandard alterations are NOT AVAILABLE from Standard Mfg. Co. Customer Service Departments. Please contact the Customer Service Department for pricing information.

 <b>WARNING – PARTS PURCHASERS</b>	
	<ul style="list-style-type: none"><li>• It is the purchaser's responsibility to be absolutely certain that any parts ordered from the factory are correctly fitted and installed.</li><li>• Firearms are complicated mechanisms and <b>IMPROPER FITTING OF PARTS MAY RESULT IN A DANGEROUS MALFUNCTION, DAMAGE TO THE FIREARM, AND SERIOUS INJURY TO THE SHOOTER AND OTHER PERSONS.</b></li><li>• The purchaser and installer of parts must accept full responsibility for the correct adjustment and functioning of the firearm after such installation.</li></ul>
<b>PARTS MUST FIT CORRECTLY</b>	

ANY PARTS REPLACEMENT NOT SERVICED BY STANDARD MFG. CO.  
WILL VOID THE WARRANTY

<b><u>WARRANTY</u></b>
TO ACTIVATE YOUR WARRANTY YOU MUST REGISTER YOUR S333 ONLINE WITHIN 10 DAYS OF PURCHASE OTHERWISE IT IS NOT VALID.
<b>IMPORTANT:</b> BE SURE TO REGISTER YOUR S333® ON LINE AT: <a href="http://STANDARDMFGLLC.COM">STANDARDMFGLLC.COM</a> . FILL OUT YOUR WARRANTY CARDS AND RETURN. THIS MAY VALIDATE THE PROOF OF PURCHASE DATE WHEN MAKING ANY REPAIR SERVICE CLAIM.
<b><u>LIMITED WARRANTY POLICY</u></b>
The manufacturer provides only to the original retail purchaser, a LIMITED WARRANTY for a period of one (1) year from the date of purchase against defects in material or workmanship. It will be at the discretion of the manufacturer as to whether the parts/labor or replacement and shipping will result in a charge to the customer. The manufacturer has the right to research, inspect, and test the weapon to assess any claim made under the warranty.
<b><u>WARRANTY EXCLUSIONS</u></b>
The warranty is VOID if the firearm has been altered, abused, misused, damaged by accident, fired with hand-loaded or reloaded ammunition, obstructions in the barrel, or damage due to failure to provide regular and necessary maintenance. Also this warranty is VOID if any unauthorized repair or alteration is performed on the firearm or there are defects due to the incorrect installation of accessories.
<b><u>WARRANTY REPAIR SERVICE INFORMATION</u></b>
Contact Standard Mfg. Co. for further instructions on how to get your S333® serviced during the warranty period.

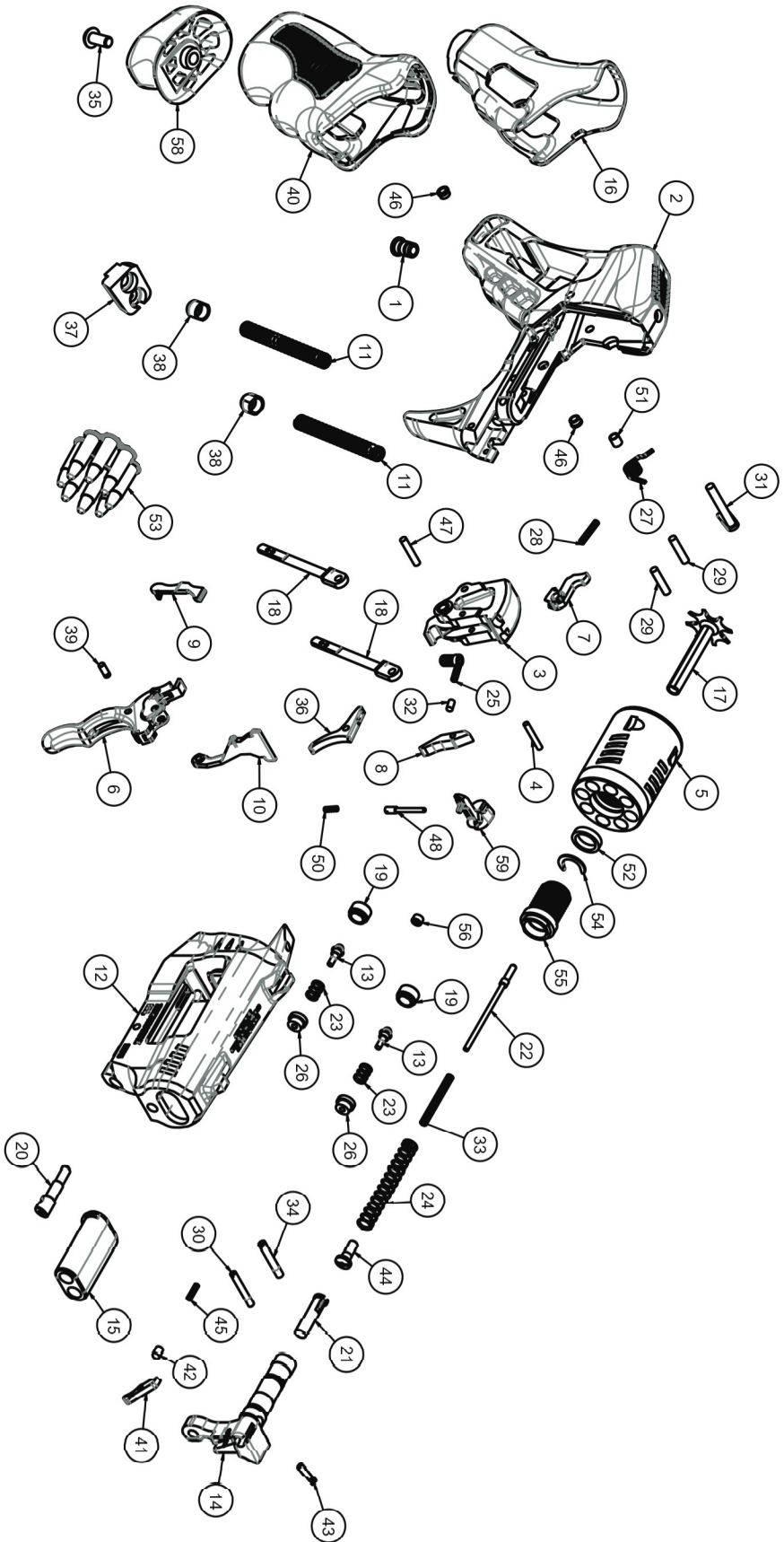
ITEM NO.	PartNo	DESCRIPTION	QTY.
1	N/A	DODGE INSERT INCLUDED WITH 22001	1
2	SR 22001	S333R HAMMER HOUSING	1
3	SR 22002	S333R HAMMER	1
4	SR 22003	S333R HAMMER STRUT PIN	1
5	SR 22004	S333 R 8 CHAMBER CYLINDER	1
6	SR 22005	S333R TRIGGER	1
7	SR 22006	S333R CYLINDER LATCH BOLT	1
8	SR 22007	S333R HAMMER STRUT	1
9	SR 22008	S333R ROTATION HAND	1
10	SR 22009	S333R FIRING TRANSFER BLADE	1
11	SR 22010	S333R MAIN SPRING	2
12	SR 22011	S333R BARREL BODY	1
13	SR 22012	S333R FIRING PIN	2
14	SR 22013	S333R CYLINDER ARM	1
15	SR 22016	S333R FRONT PORT INSERT	1
16	SR 22018	S333R ABS GRIP CUP	1
17	SR 22019	S333R CYLINDER EJECTOR	1
18	SR 22020	S333R MAIN SPRING GUIDE ROD	2
19	SR 22021	S333R FIRING PIN CUP	2
20	SR 22022	S333R CYL ARM PIVOT POST	1
21	SR 22023	S333R EJECTOR SPRING POST	1
22	SR 22013	S333R CYLINDER ARM	1
23	SR 22025	S333R FIRING PIN SPRING	2
24	SR 22026	S333R EJECTOR SPRING	1
25	SR 22027	S333R HAMMER STRUT SPRING	1
26	SR 22028	S333R FIRING PIN BUSHING	2
27	SR 22030	S333R TRIGGER RETURN HAND SPRING	1
28	SR 22031	S333R BOLT SPRING	1
29	SR 22032	S333R TRIGGER PIVOT PIN	2

ITEM NO.	PartNo	DESCRIPTION	QTY.
30	SR 22033	S333R FRAME PIN FRONT	1
31	SR 22035	S333R HAMMER PIVOT PIN	1
32	SR 22036	S333R STRUT PLUNGER	1
33	SR 22038	S333R CYLINDER PIVOT SPRING	1
34	SR 22042	S333R FRAME MID PIN	1
35	SR 22043	#8-32 BTN HD CAP SCREW	1
36	SR 22044	S333R SAFETY TRIGGER TAB	1
37	SR 22045	S333R MAIN SPRING PLATE	1
38	SR 22046	S333R MAIN SPRING CUP	2
39	SR 22047	S333R TRIGGER SAFE PIN	1
40	SR 22048	S333R ELASTOMER GRIP	1
41	SR 22049	S333R CRANE LOCK BOLT	1
42	SR 22052	S333R CRANE LOCK PLUNGER	1
43	SR 22053	S333R CRANE LOCK PIN	1
44	SR 22054	S333R EJECTOR SPRING SCREW TUBE	1
45	SR 22055	S333R CRANE BOLT SPRING	1
46	SR 22056	S333R TRIGGER BUSHING	2
47	SR 22057	S333R MAIN SPRING HAMMER PIN	1
48	SR 22058	S333R CYLINDER RELEASE PIN	1
49	SR 22059	S333R FRAME TANG SCREW	1
50	SR 22060	S333R TRIGGER SAFETY SPRING	1
51	SR 22061	S333R TRIGGER SPRING BUSHING	1
52	SR 22062	S333R CYLINDER POSITION RING	1
53	SR 22065	S333 R SNAP CAP RING	1
54	SR 22069	S333R CYLINDER RETAINER	1
55	SR 22070	S333R CYLINDER LOCKER	1
56	SR 22072	S333R CYLINDER FACE BUSHING	1
57	SR 22118	S333 R COMBOLDED GRIP(22018, 22048)	1
58	SR 22134	S333R GRIP EXTENSION	1
59	SR 22017	S333R CYLINDER RELEASE	1



**WARNING:** A gun containing broken, malfunctioning or badly worn parts should not be fired.

Standard Mfg. Co. S333®  
PARTS LIST & EXPLODED VIEW



## THE BASIC RULES OF SAFE FIREARMS HANDLING

We believe that Americans have a right to purchase and use firearms for lawful purposes. The private ownership of firearms in America is traditional, but that ownership imposes the responsibility on the gun owner to use his firearms in a way which will ensure his own safety and that of others. When firearms are used in a safe and responsible manner, they are a great source of pleasure and satisfaction, and represent a fundamental part of our personal liberty.

Firearms do not cause accidents! Firearms accidents are almost always found to have been the result of carelessness or ignorance on the part of the shooter of the basic rules of safe gun handling.

The following rules must be observed by gun users at all times. Safe gun handling is not just desirable, it is absolutely essential to your safety, the safety of others, and the continuation of gun ownership and sport shooting as we know it today.

### 1. LEARN THE MECHANICAL AND HANDLING CHARACTERISTICS OF THE FIREARM YOU ARE USING.



Not all firearms are the same. The method of carrying and handling firearms varies in accordance with the mechanical provisions for avoiding accidental discharge and the various proper procedures for loading and unloading. No person should handle any firearm without first having thoroughly familiarized himself with the particular type of firearm he is using, and with safe gun handling in general.

### 2. ALWAYS KEEP THE MUZZLE POINTED IN A SAFE DIRECTION.

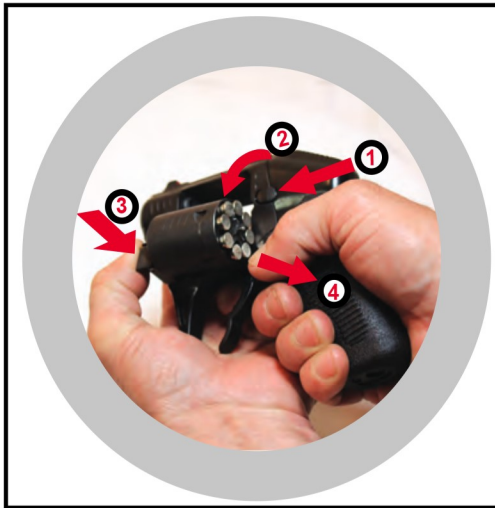


Be sure of the bullet stop behind your target, even when dry-firing. Never let the muzzle of a firearm point at any part of your body or at another person. This is particularly important when loading or unloading a firearm. In the event of an accidental discharge, no injury can occur as long as the muzzle is pointing in a safe direction. A safe direction means a direction that will not permit a discharged bullet to strike a person,

or to strike an object from which the bullet may ricochet.

A safe direction must take into account the fact that a bullet may penetrate a wall, ceiling, floor, window, etc., and strike a person or damage property. Make it a habit to know exactly where the muzzle of your gun is pointing whenever you handle it, and be sure that you are always in control of the direction in which the muzzle is pointing, even if you fall or stumble. Keep your finger off the trigger until you are ready to shoot

### **3. FIREARMS SHOULD BE UNLOADED WHEN NOT IN USE.**



Firearms should be loaded only when you are in the field or on the target range or shooting area, ready to shoot. Firearms and ammunition should be securely locked in safes, racks or cabinets, or by using the locking device supplied with the firearm when not in use. Ammunition should safely be stored separate from firearms. Store your firearms out of sight of visitors and children. It is the gun owner's responsibility to be certain that children and persons unfamiliar with firearms cannot gain access to

firearms, ammunition, or components.

### **4. BE SURE THE BARREL IS CLEAR OF OBSTRUCTIONS BEFORE SHOOTING.**

Even a bit of mud, snow or excess lubricating oil or grease in the bore may cause the barrel to bulge, or even burst on firing, and can cause serious injury to the shooter and bystanders. Be sure that you are using ammunition of the proper caliber and loading for the gun you are using. If the report or recoil on firing seems weak, or doesn't seem quite right, **CEASE FIRING IMMEDIATELY**, unload your firearm, and check to be sure that no obstruction has become lodged in the barrel.





### **5. BE SURE OF YOUR TARGET BEFORE YOU SHOOT.**

Don't shoot unless you know exactly where your bullet is going to strike. Be sure of the bullet stop behind your target, even when dry-firing with an unloaded gun. If you are in the field hunting, do not fire at a movement or noise. Take the time to be absolutely certain of your target before you pull the trigger.

### **6. WEAR SHOOTING GLASSES AND HEARING PROTECTION WHEN YOU SHOOT.**

All shooters should wear protective shooting glasses and adequate hearing protection when shooting. Exposure to shooting noise can damage hearing, and wearing adequate eye protection when shooting is essential.



### **7. NEVER CLIMB A TREE OR FENCE WITH A LOADED FIREARM.**

Put the firearm down carefully before climbing a fence, and unload it before climbing or descending a tree or jumping over a ditch or other obstruction. Never pull or push a loaded firearm toward yourself or another person. When in doubt, or whenever you are about to do anything awkward, unload your gun!

**8. DON'T SHOOT AT A HARD SURFACE OR AT WATER.**

Bullets can glance off many surfaces like rocks or the surface of water and travel in unpredictable directions with considerable velocity.



**9. NEVER TRANSPORT A LOADED FIREARM.**

Firearms should always be unloaded before being placed in a vehicle. A suitable carrying case or scabbard should be used to carry an unloaded firearm to and from the shooting area.

**10. AVOID ALCOHOLIC BEVERAGES WHEN SHOOTING.**

Don't drink until the day's shooting is over. Handling firearms while under the influence of alcohol in any form, or medications that could affect your judgment or coordination, constitutes a criminal disregard for the safety of others.





**Standard Mfg. Co.**  
**100 Burritt Street**  
**New Britain, CT 06053 USA**  
**[www.stdgun.com](http://www.stdgun.com)**