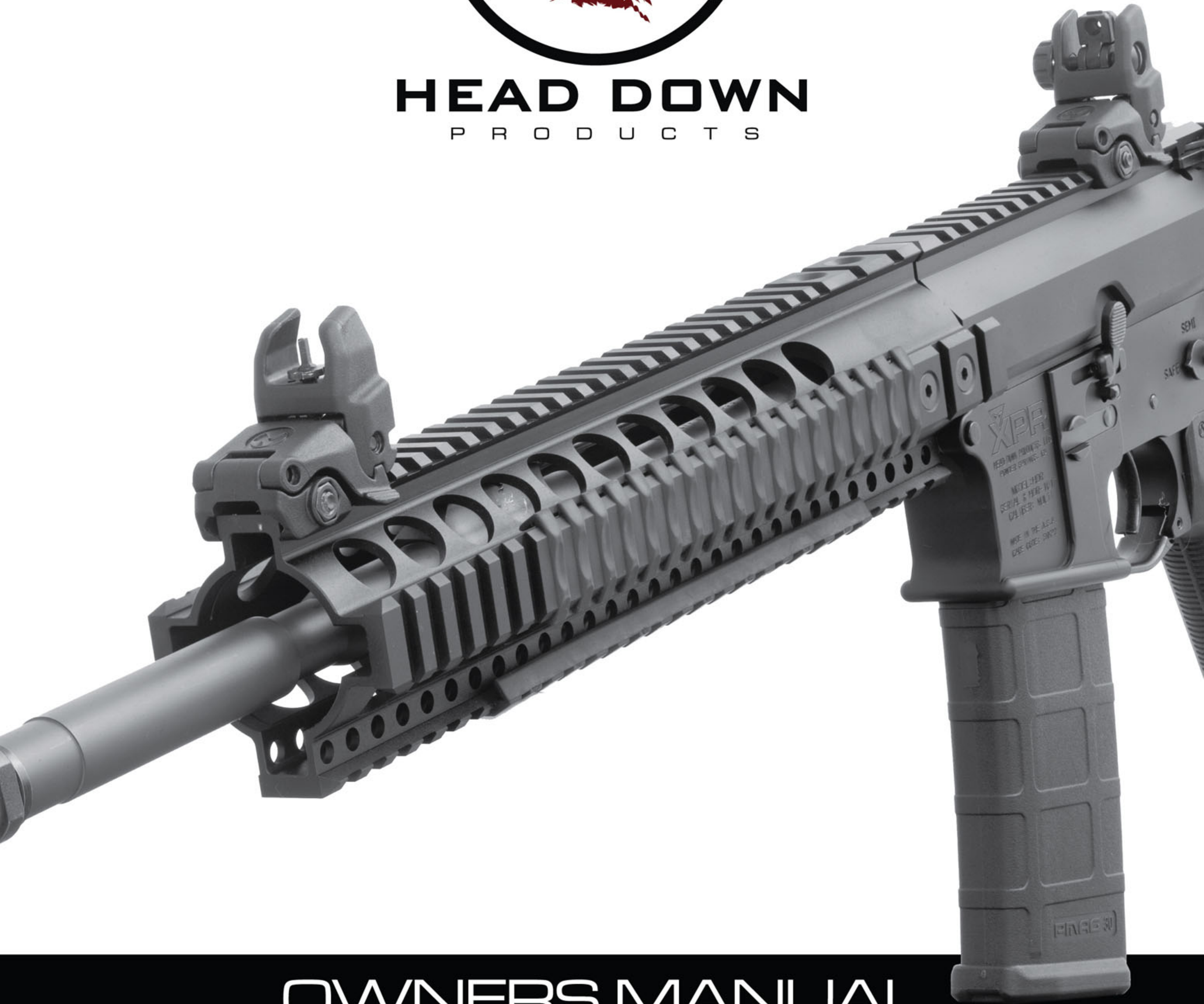




HEAD DOWN
P R O D U C T S



OWNERS MANUAL

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PLEASE PRACTICE SAFE FIREARMS HANDLING!

⚠ WARNING:

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

⚠ CAUTION:

CAREFULLY READ THIS DOCUMENT PRIOR TO LOADING AND FIRING THIS FIREARM. FOLLOW ALL INSTRUCTIONS ON THE PROPER HANDLING AND SAFE USE OF THIS FIREARM - LIVES MAY DEPEND ON IT! If unfamiliar with firearms, seek further advice through safe handling courses run by your local gun clubs, NRA approved instructor, or similar qualified organizations.

⚠ CAUTION:

USE ONLY CLEAN, DRY, HIGH QUALITY COMMERCIALY MANUFACTURED AMMUNITION IN GOOD CONDITION which is appropriate to the 5.56mm caliber of your firearm. We do not recommend the use of remanufactured or hand loaded ammunition because it may damage your rifle. Use of improper ammunition will invalidate your warranty.

⚠ WARNING:

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

FUNDAMENTAL RULES FOR SAFE GUN HANDLING

ALWAYS KEEP YOUR GUN POINTED IN A SAFE DIRECTION.

NEVER LOAD THE GUN UNTIL READY TO USE.

KEEP YOUR FINGER OFF THE TRIGGER UNTIL READY TO SHOOT.





WARNING! BEWARE OF DANGEROUS PROCEDURES

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

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



ABOUT YOUR HEAD DOWN RIFLE...

- ★ This Operating Manual covers all Head Down XPR15 models chambered for 5.56mm NATO/.223 Remington ammunition. They are lightweight, gas operated, air-cooled, magazine-fed rifles, carbines that are Semi-Automatic in operating mode (i.e., a single round will fire each time the trigger is pulled). Note: For Law Enforcement and Military markets, Head Down makes similar models in either Full-Automatic (continuous fire as long as the trigger is pulled) or Three Round Burst (a group of 3 shots will fire as long as the trigger is pulled) configurations. Sales of these models require special permits and are regulated by ATF.
- ★ On all models, the Upper And Lower Receivers are easily opened for cleaning and inspection. XPR15 Models have billet aluminum Upper and Lower Receivers.
- ★ Barrels on XPR15 Models are either chrome lined Chrome Moly Vanadium Steel or 416 Stainless Steel. They are usually button rifled 1 turn in 7" with a right hand twist.
- ★ All models can be configured with either 6 position Telescoping Buttstocks or solid A2 "Trapdoor" Buttstocks. Forends are of removable split design and are vented to allow heat dissipation. All models feature detachable magazines. Magazine capacity is 30 rounds standard (depending on State Regulations), but all AR-15/M-16 Type magazines of capacities from 5 to 40 rounds will fit the XPR15 and function in it.



CLEARING YOUR RIFLE...

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

- 1.) Point Rifle in a **SAFE DIRECTION!** Place Safety Selector Lever on **SAFE**.

NOTE: If the rifle is not cocked, the Safety Selector Lever cannot be pointed toward **SAFE**.



- 2.) Press Magazine Catch Button and pull Magazine down to remove.



- 3.) To Lock Bolt Open, Pull Charging Handle rearward. Press bottom of Bolt Catch and allow Bolt to move forward until it engages Bolt Catch. Return Charging Handle to forward. If you haven't before, now place Safety Selector Lever on **SAFE**.



CHECK BEFORE YOU FIRE!...

- 1.) Check to see that there is **NO EXCESSIVE OIL** in the Bore. If there is, swab it out with a patch and the cleaning rod. **ALWAYS CLEAN A NEW RIFLE BEFORE FIRING.**

WARNING! If the rifle is fired with oil - or water - in the barrel, excessive pressure will be created causing the rifle to explode.

- 2.) Retract the Bolt to ensure free movement between Bolt Carrier and Gas Tube.

- 3.) Perform Safety Function Check (below) to ensure that Safety Selector Lever works properly.



SAFETY FUNCTION CHECK...

UNLOAD RIFLE - REMOVE MAGAZINE - CHECK CHAMBER

- 1.) Remove Magazine if installed. Pull Charging Handle assembly to rear. Check that Chamber is clear. Let the Bolt and Bolt Carrier close. Do not pull Trigger. Leave Hammer in cocked position.

WARNING! If Rifle fails any of the following tests, continued use of the Rifle could result in injury to, or death of, people around you.

- 2.) Place Selector Lever in **SAFE** position, point rifle in a safe direction, and pull Trigger. **THE HAMMER SHOULD NOT FALL.**

Continued on next page...



SAFETY FUNCTION CHECK... (CONTINUED)

3.) Place Selector Lever in **FIRE** position. Pull the Trigger. **THE HAMMER SHOULD FALL.**

NOTE: For purposes of the following check, "SLOW" is defined as one fourth to one half the normal rate of trigger release.

4.) Hold Trigger to the rear, pull Charging Handle to the rear and release Charging Handle. Then release pressure on the Trigger with a slow, smooth motion, without hesitations or stops, until the Trigger is fully forward.

AN AUDIBLE CLICK SHOULD BE HEARD - THE HAMMER SHOULD NOT FALL.

5.) Repeat the FIRE position test **FIVE TIMES**. The Rifle must not malfunction during any of these five tests. If the Rifle malfunctions during any of these five tests, have the Rifle checked by a qualified gunsmith.



PREPARING TO FIRE - LOADING A MAGAZINE...

DO NOT LOAD DAMAGED AMMUNITION!



- 1.) Use only quality 5.56mm or .223 Remington Ammunition suitable for your firearm. Examine each Cartridge - particularly around the primer. Look for dents, scratches, and other signs of damage.
- 2.) With the Magazine facing forward as shown in the illustration, place a Round between the Feed Lips of the Magazine with the Bullet Tip forward. Push the Round down until it is held by the Magazine Feed Lips.
- 3.) If necessary, give the Round a slight push backward to seat it against the inside back edge of the Magazine Feed Lips. Place next Round on top of the previous Round and repeat steps until desired number of Rounds are loaded into Magazine.

CAUTION: Safe Firearms Handling dictates that you **ONLY LOAD LIVE AMMUNITION INTO YOUR RIFLE WHEN YOU ARE ABOUT TO SHOOT.**



OPERATION OF YOUR RIFLE... LOADING

CAUTION: ALWAYS POINT THE MUZZLE IN A SAFE DIRECTION!

1.) With the Hammer cocked, place Selector Lever on **SAFE**.



2.) Open Bolt and check Firing Chamber. **Make sure it is CLEAR!**



INSERTING A MAGAZINE...

1.) Return Charging Handle to forward, locked position. Push Magazine up into Magazine Well until Magazine Catch engages and holds the Magazine.



2.) Slap upwards on Magazine bottom to make sure it is seated correctly.



OPERATION OF YOUR RIFLE... (CONTINUED)

CHAMBERING A ROUND FROM AN OPEN BOLT...

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

- 1.) Depress upper portion of Bolt Catch. Bolt should spring forward. This will chamber a round from the Magazine.

BOLT CATCH



- 2.) TAP the Forward Assist with the heel of your hand to ensure that the Bolt is fully forward and locked.



FORWARD ASSIST

RIFLE IS NOW READY TO BE AIMED AND FIRED!



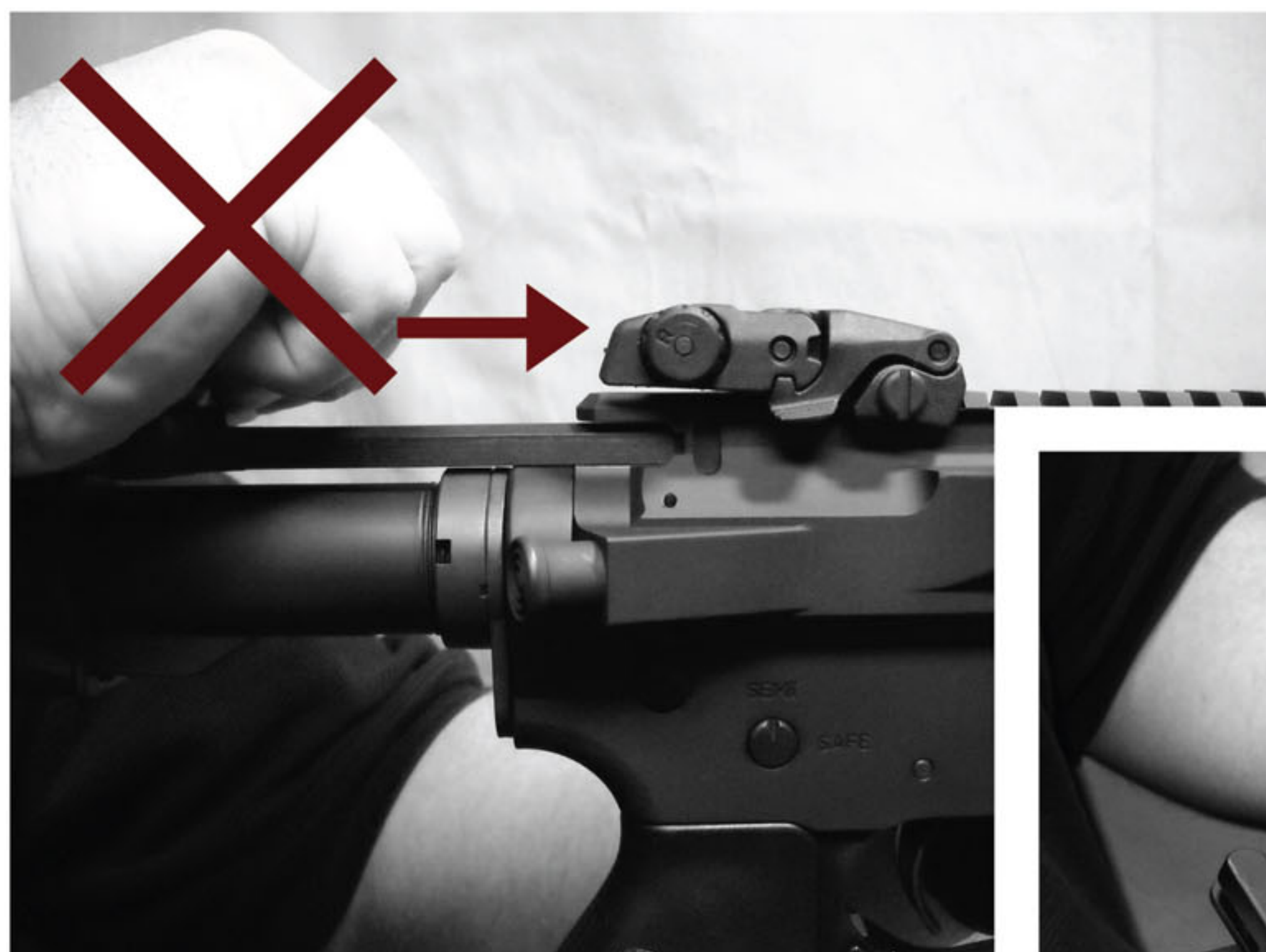
OPERATION OF YOUR RIFLE... (CONTINUED)

CHAMBERING A ROUND FROM A CLOSED BOLT...

1.) With a Magazine in the Rifle, pull the Charging Handle fully to Rear.

Then release the Charging Handle allowing the Bolt to spring forward - chambering the first round.

NEVER "Ride" or push the Charging Handle forward (as depicted below). Let it move forward on its own.



2.) TAP the Forward Assist to ensure that the Bolt is fully forward and locked.

RIFLE IS NOW READY TO BE AIMED AND FIRED!



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



OPERATION OF YOUR RIFLE... (CONTINUED)

CONDITION: Rifle is now Loaded, a Round is Chambered, and Safety Selector should be on **SAFE**.

CAUTION: ALWAYS POINT THE MUZZLE IN A SAFE DIRECTION!

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

Aim at Target – Pull Trigger – Release.

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

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



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



IMMEDIATE ACTIONS — IN CASE OF TROUBLE! (CONT'D)

CAUTION: ALWAYS POINT THE MUZZLE IN A SAFE DIRECTION!

3.) If Cartridge or Case is ejected, or Chamber is clear, **RELEASE** Charging Handle to feed a new Round. Don't "ride" the Charging Handle forward.



4.) Tap Forward Assist to ensure Bolt is locked.

5.) Now **FIRE**.
If the Rifle will not fire, look for trouble and apply the Remedial Actions described on the next Page.



REMEDIAL ACTIONS ...



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



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

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



BULLET STUCK IN THE BORE...



WARNING: IF AN AUDIBLE "POP" OR REDUCED RECOIL IS EXPERIENCED DURING FIRING, IMMEDIATELY CEASE FIRE: Then, (1.) Remove the Magazine, (2.) Lock the Bolt to the rear, (3.) Place the Selector Lever on the SAFE and (4.) visually inspect and/or insert a Cleaning Rod into the Bore to ensure there is not a Bullet stuck in the Bore.



1.) Remove the Magazine



2.) Lock the Bolt to the rear.



3.) Place the Selector Lever on **SAFE**

DO NOT APPLY THE "IMMEDIATE ACTIONS" DESCRIBED ON PREVIOUS PAGES.

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



DISASSEMBLING YOUR RIFLE...

1.) **CLEAR YOUR RIFLE!** (as described on Page 7).

2.) Push in Takedown Pin (a Bullet tip can help) as far as it will go. Pivot Upper Receiver from Lower Receiver.



3.) Push in Pivot Pin (a Bullet tip can help).



4.) Separate Upper and Lower Receivers.

5.) Pull back Charging Handle and Bolt Carrier.



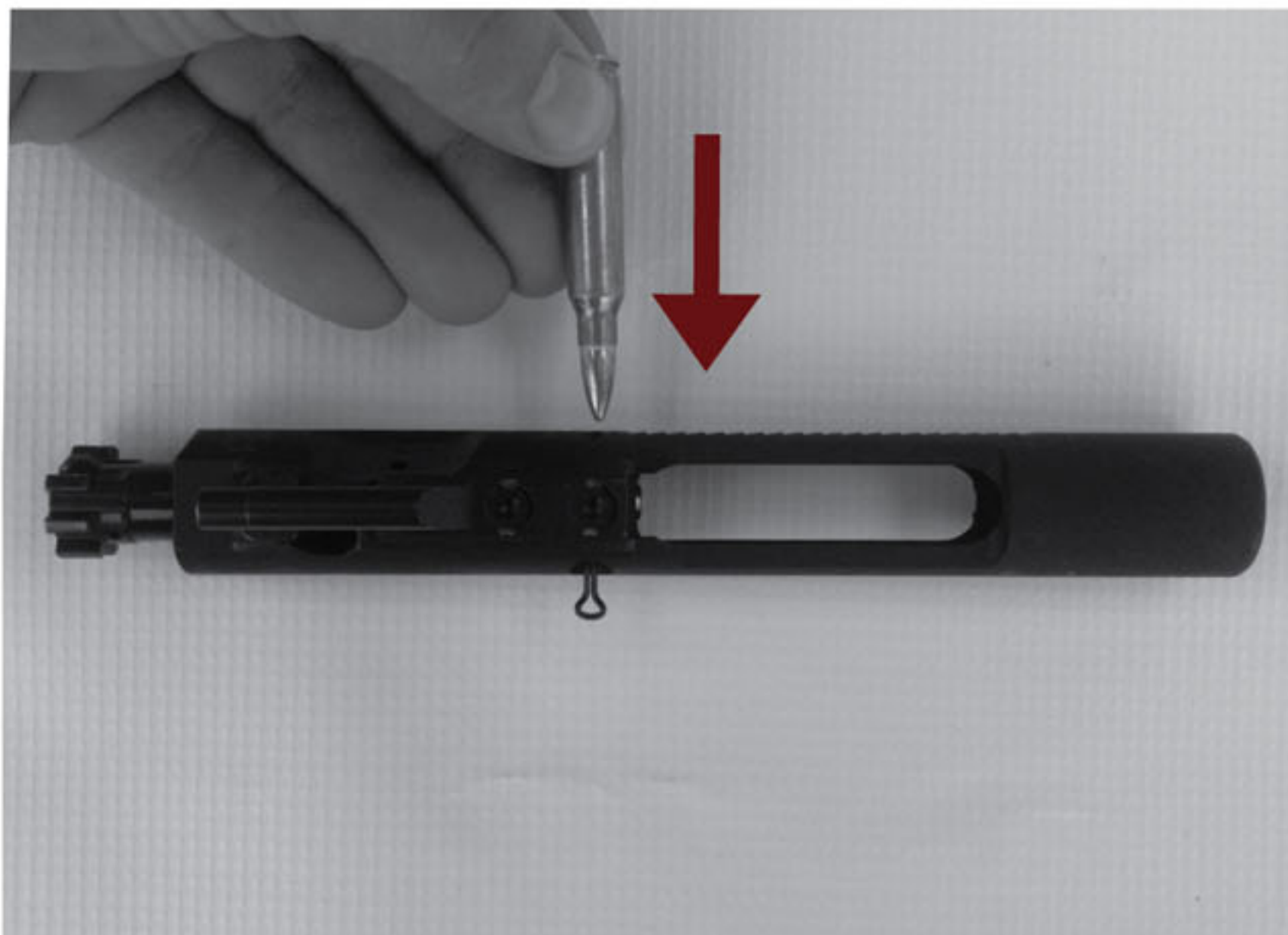
DISASSEMBLING YOUR RIFLE... (Continued)

6.) Remove Bolt Carrier and Bolt.

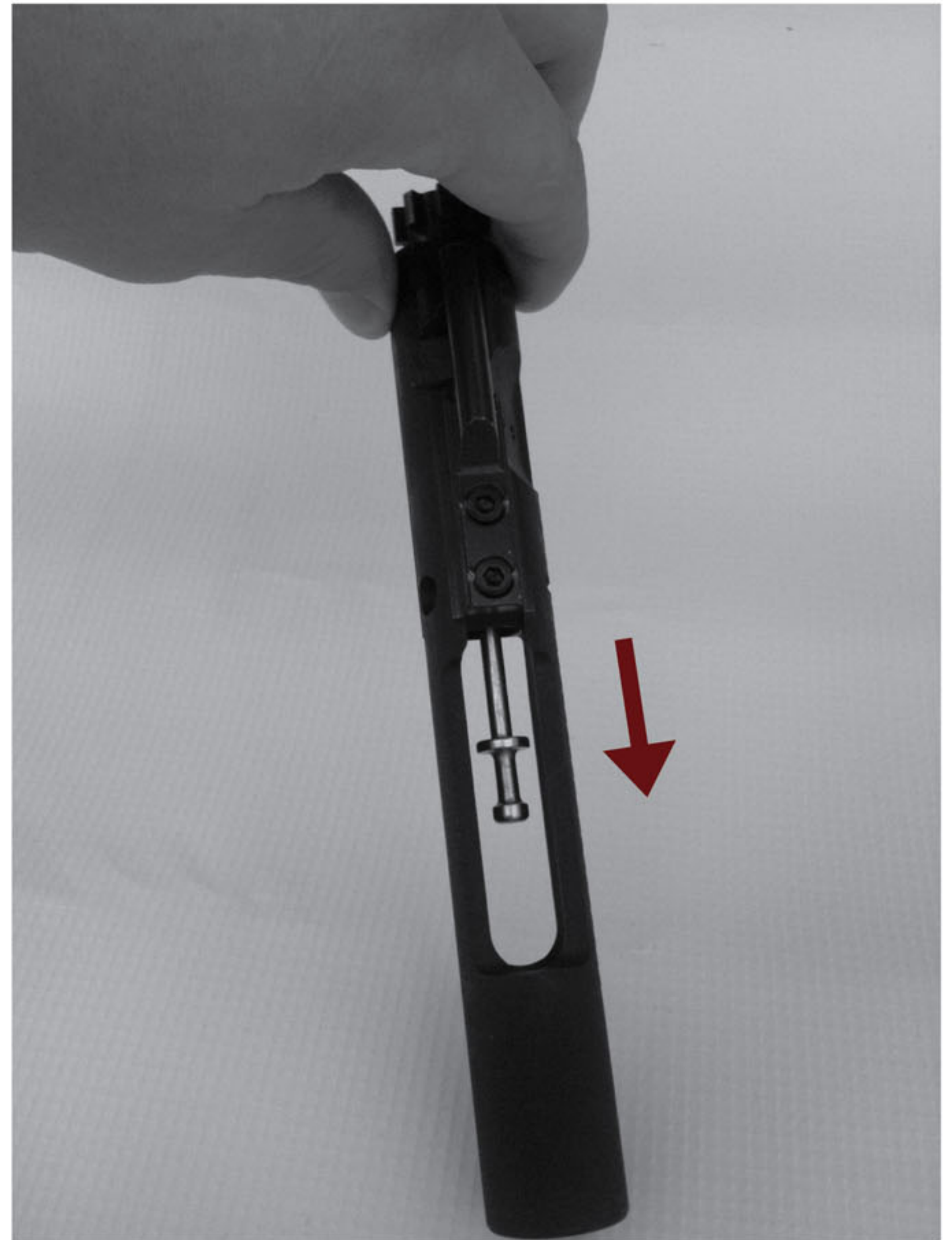


7.) Remove Charging Handle by pulling back and up until "Ears" clear cutouts in Receiver.

8.) Remove Firing Pin Retaining Pin. A Bullet tip can help push it out of the Bolt Carrier.



9.) Drop Firing Pin out of rear of Bolt Carrier.



Do Not open or close split end of Firing Pin Retaining Pin, and Do Not substitute a common cotter pin on reassembly.

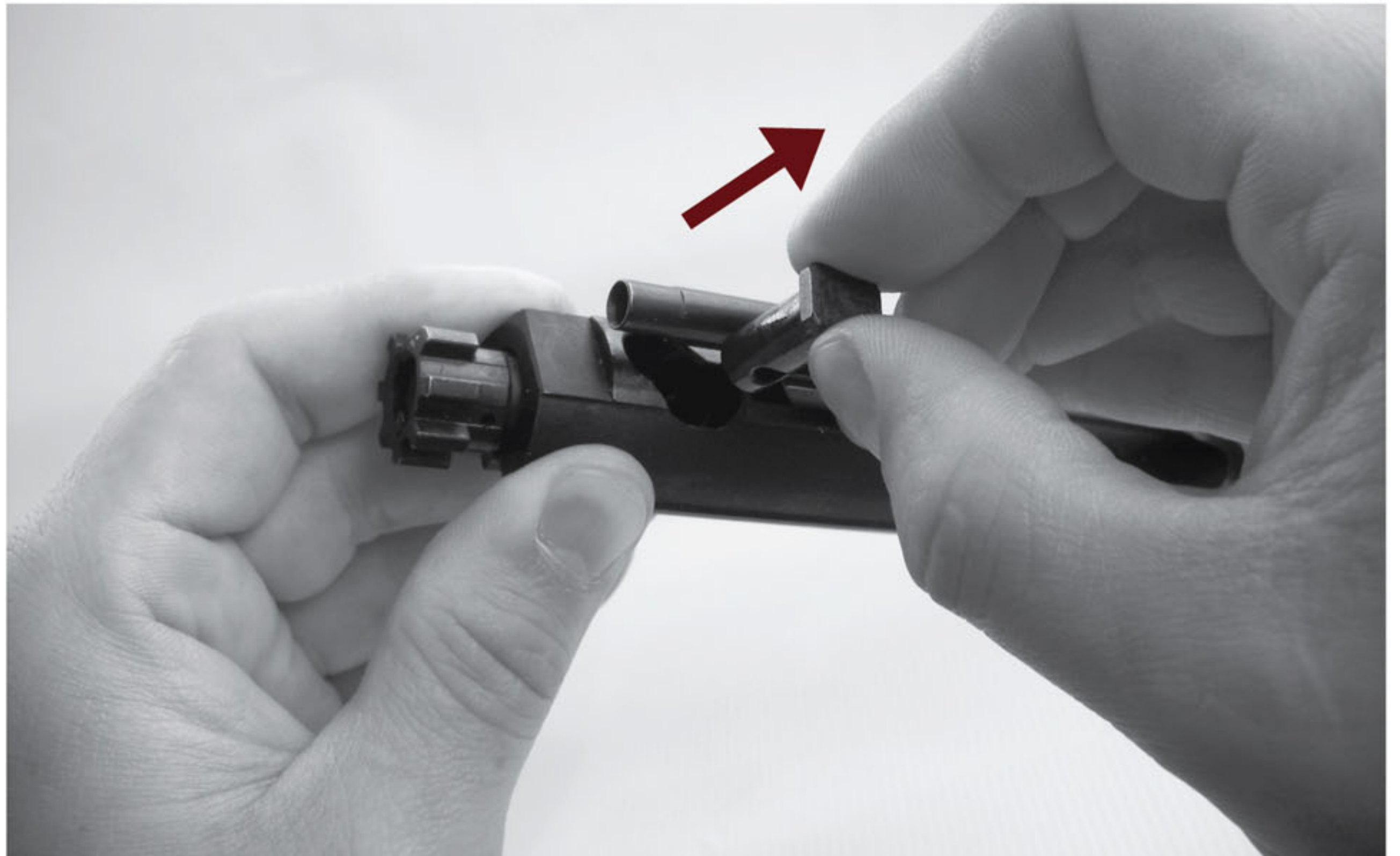


DISASSEMBLING YOUR RIFLE... (Continued)

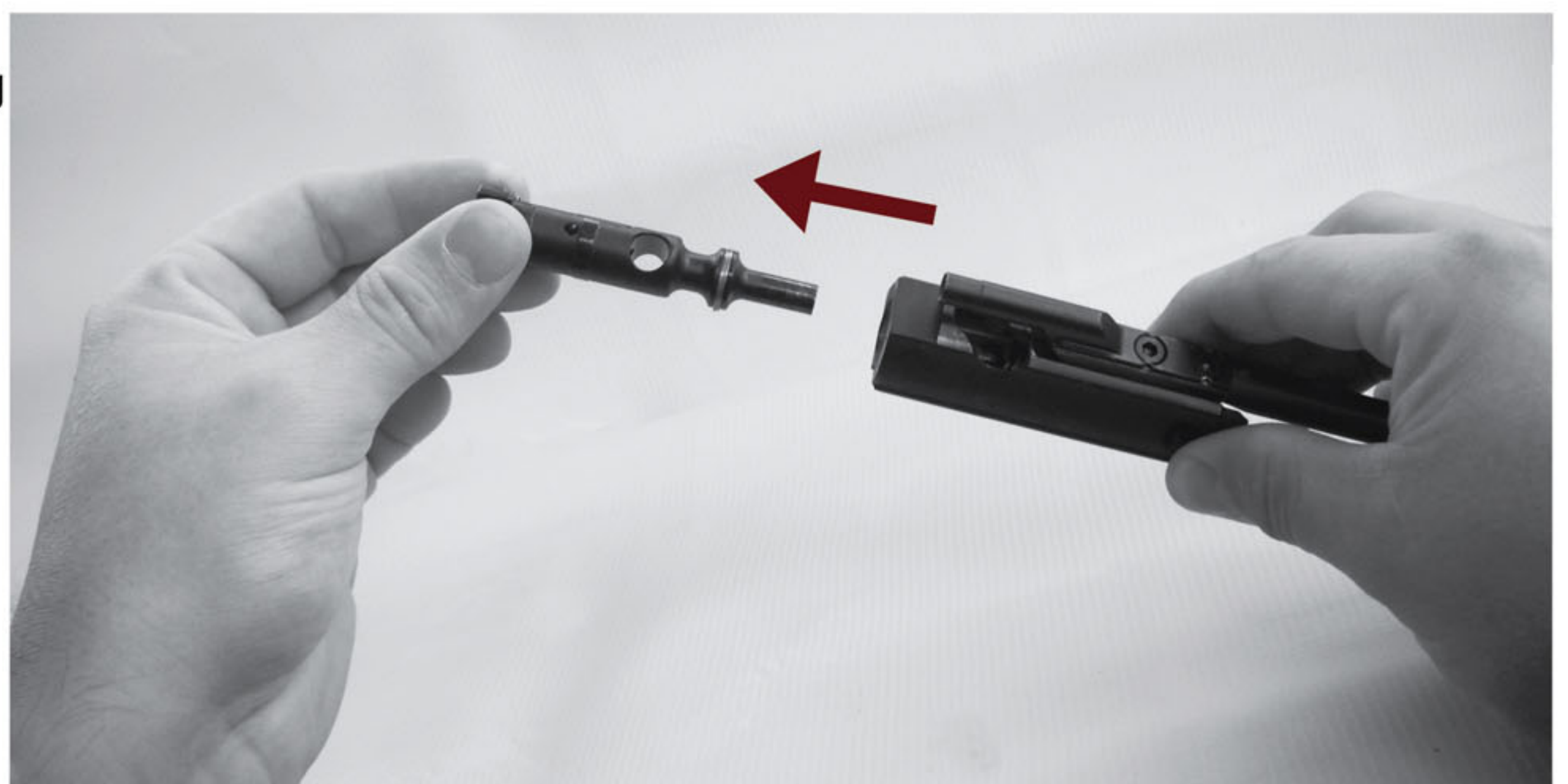
10.) Push Bolt in to locked position.



11.) Remove Cam Pin by rotating 1/4 turn and lifting out.



12.) Remove Bolt Assembly from Bolt Carrier by pulling straight out.



DISASSEMBLING YOUR RIFLE... (Continued)

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

13.) Remove Extractor Pin by pushing out with a punch or the tip of a Bullet.



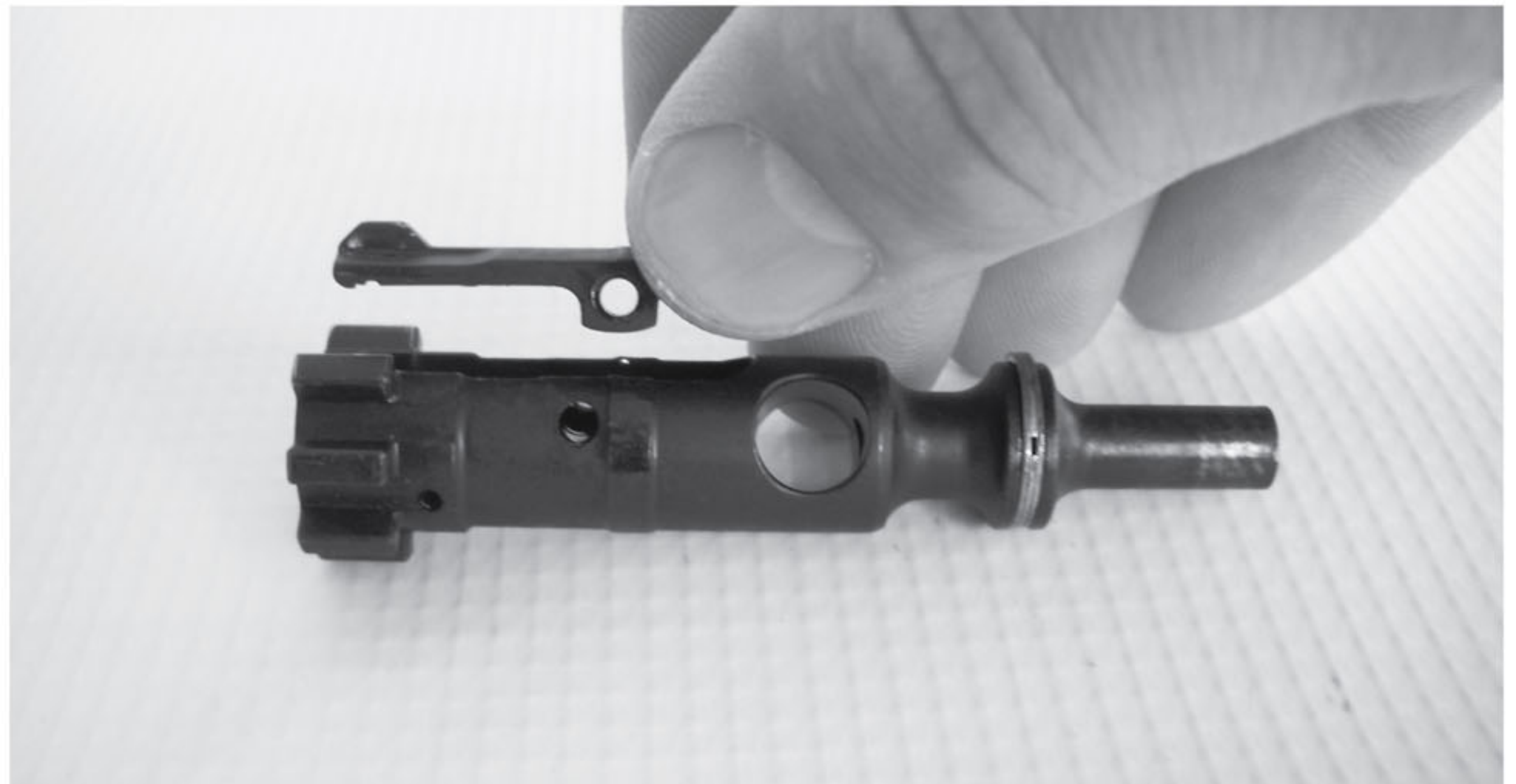
14.) Remove Extractor with Spring.

CAUTION:

Extractor Spring may pop out and get lost!

NOTE:

Press rear of Extractor to check Spring function.



DISASSEMBLING YOUR RIFLE... (Continued)

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

15.) With Hammer cocked, depress Buffer Retainer with punch or Bullet tip to release Buffer and Spring.



CAUTION!

Buffer is under tension from Action Spring.

NOTE: Hammer needs to be cocked to allow Buffer and Spring to clear Receiver.

16.) Pull out Buffer and Action Spring for cleaning.



The Handguards may be disassembled at any point in your cleaning procedures as necessary. Clean as per instructions for aluminum Upper and Lower Receivers.

STOP!

HEAD DOWN DOES NOT RECOMMEND ANY FURTHER DISASSEMBLY.



HEAD DOWN
PRODUCTS

INSPECTION — CLEANING — LUBRICATION...

AFTER FIRING YOUR RIFLE, clean it as soon as possible to make the job easier and to avoid allowing the development of any corrosion.

When your firearm has not been fired, you should clean it at least once or twice a year if you live in a temperate climate, or as often as once a week in a tropical climate.

If you get your firearm wet, clean it as soon as possible to avoid the onset of corrosion or rust.

Use a high quality rifle cleaning kit that includes a cleaning rod; swab holder; cotton flannel bore patches; pipe cleaners; a small toothbrush; brass wire bristle bore and chamber brushes and a Cleaner/Lubricant/Preservative (CLP in Army terminology).

After you have disassembled the rifle, thoroughly clean, inspect and lubricate all parts according to the techniques described on following pages.



Cotton Flannel Bore Patches

A Quality Gun Oil / Cleaner / Preservative

Cleaning Kit with Patch Holder, Bore & Chamber Brushes

PLUS, an old toothbrush for cleaning parts and dislodging dirt build-up, and pipe cleaners or Q-tips for cleaning Gas Key and Gas Tube and other hard to reach areas.



DETAILED CLEANING TECHNIQUES...

NOTE: The procedures below describe cleaning with a standard military issue multi-piece rod cleaning kit. Other commercial cleaning kits may include alternate cleaning instructions which may be just as effective.

CLEANING THE BORE: The bore of your Bushmaster rifle has Lands and Grooves called rifling. Rifling makes the bullet spin very fast as it moves down the Bore and down range. It is difficult to **push** a new, stiff Bore Brush through the Bore. You will find it much easier, and more effective, to **pull your Bore Brush through the Bore**. Also, because the brush will clean better if the bristles follow the grooves (this is called tracking), you want the Bore Brush to be allowed to turn as you pull it through.

ALWAYS CLEAN FROM THE CHAMBER TOWARD THE MUZZLE. Follow these steps:

- 1.) Attach three Rod Sections together but leave each one about two turns short of being tight. Attach the Patch Holder but leave it two turns short of tight also.
- 2.) Point Muzzle down. Hold the Upper Receiver in one hand while inserting the end of the Rod with Patch Holder attached into the Chamber. Guide the Rod carefully through the Bore.
CAUTION: Do not let the Rod or its threaded end scratch the Chrome Lining of the Bore or Firing Chamber. About 2 - 3 inches of the Rod should protrude out of the Muzzle.
- 3.) Attach the Handle Section of the Cleaning Rod to the end of the Rod sticking out of the Muzzle, and swab out the Bore with a patch moistened with "CLP".
- 4.) Remove Patch Holder and attach Bore Brush (leaving it two turns short of tight).
- 5.) Pull the Brush through the Bore and out the Muzzle. You should be able to see the Rod twisting as you pull it - this is the Brush "tracking" in the rifling.
- 6.) After one pull, take off the handle section and repeat the process. After three or four pulls, the three rod sections and the Bore Brush may become screwed tightly together. Loosen them up and repeat the process.
- 7.) Send a patch through the Bore occasionally to help clean out the crud that the brush is getting loose. Just replace the Bore Brush with the Rod Tip (Patch Holder) and a wet patch. Pull it through. If you leave the rods loose again, the patch will "track" in the rifling as before. But remember, always have the Bore **wet with cleaner** before trying to pull a brush through.

NEVER reverse the direction of the Bore Brush while it is in the Bore.



CLEANING THE UPPER RECEIVER...

NOTE: Check to ensure that there is no looseness between the Barrel and the Upper Receiver - if you detect any movement by twisting with your hands, the Barrel Nut must be retorqued. Bring the Rifle to your Armorer.

- 1.) Using a "CLP" type product, clean all areas (inside and out) of Powder Fouling, Corrosion and Dirt. Never use a wire brush or any type of abrasive to clean the Aluminum Upper Receiver - you'll scratch and damage the finish. A Toothbrush is good for loosening any dirt buildup, and won't scratch the Receiver.
- 2.) Clean the Firing Chamber - dip the larger Chamber Brush in CLP and use at least 5 plunge strokes and 3 - 360° clockwise rotations. Then swab out the Bore as described previously to remove contaminated solution or loosened crud.
- 3.) Use the Bore Brush - wet with CLP - to clean carbon and powder residue from around the Gas Tube. Run a Pipe Cleaner into the Gas Tube, clean the Bolt Locking Lugs, Bolt Rings, Firing Pin, Bolt Cam Pin, lip of the Extractor, and inside the Bolt Carrier from both front and rear.
- 4.) Wipe all components clean and dry, and inspect for excessive wear, corrosion or mechanical damage. Have your Armorer replace any worn or defective parts before firing again (or contact HEAD DOWN PRODUCTS at 404-590-AR15 for parts needs.)

Cleaning the Bolt, Bolt Carrier & Components...

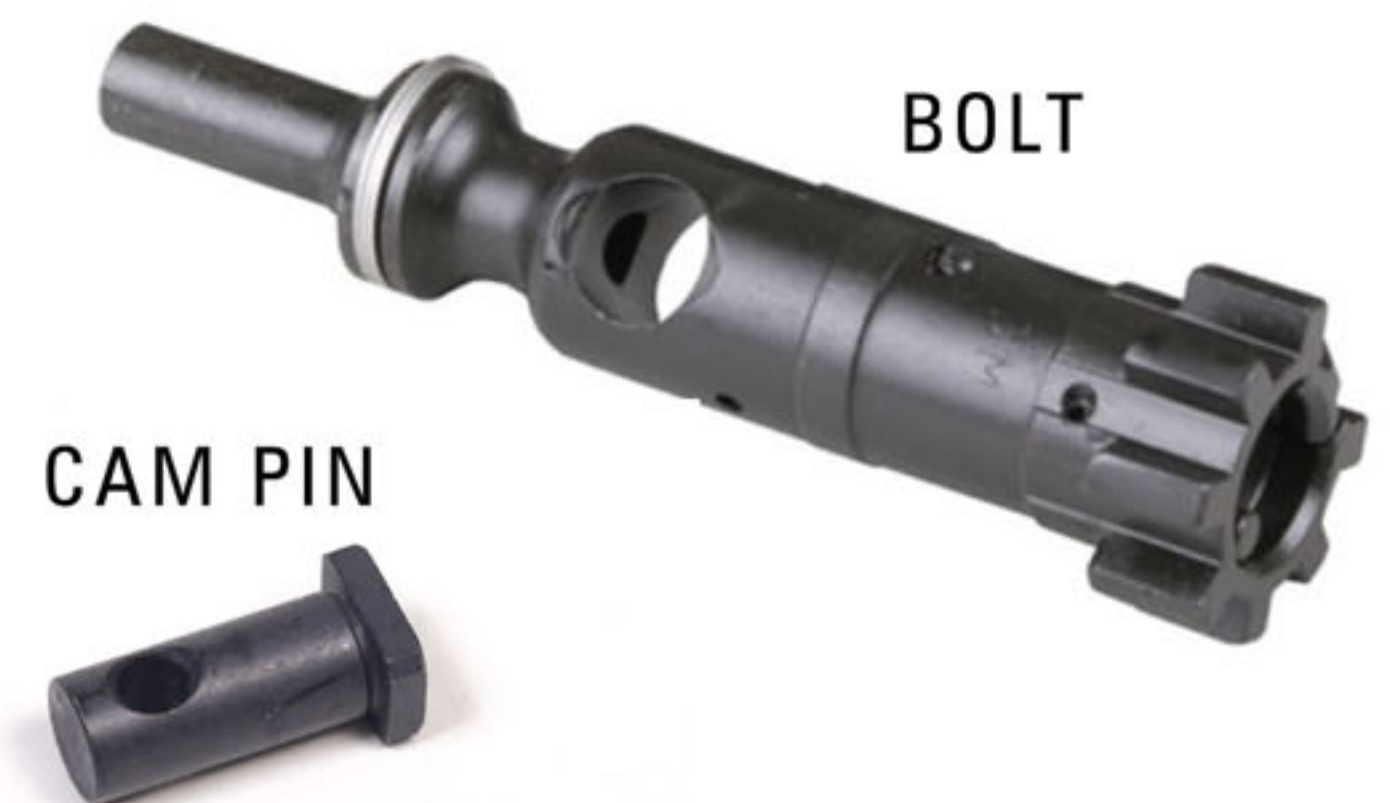
- 1.) Clean out the Gas Key on top of the Bolt Carrier with a Q-Tip or a Pipe Cleaner. Also clean out an carbon/powder residue from vent holes in the Bolt Carrier.
- 2.) Clean and inspect Bolt, Cam Pin, Firing Pin and Firing Pin Retaining Pin thoroughly.

CHECK THE BOLT: Look for cracks or fractures, especially in the Cam Pin hole area. Inspect Bolt Face - Bolts with any pitting extending into the firing pin hole should be replaced.

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

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

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



CAM PIN

BOLT



FIRING PIN



FIRING PIN
RETAINING PIN

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



CLEANING THE UPPER RECEIVER... (Continued)

Cleaning the Bolt, Bolt Carrier & Components...

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



Cleaning / Lubricating the Ejector...

NOTE: The design of the Ejector makes its disassembly for cleaning somewhat impractical (i.e. we don't recommend it). Make sure your rifle ejects empty cases efficiently by following these steps on a monthly basis (more frequently if firing blanks).

- 1.) With the Bolt removed from the Bolt Carrier and the Extractor installed, hold it as shown, and dribble a few drops of CLP around the Ejector to form a puddle.
- 2.) Take a fired or dummy case and place it under the lip of the Extractor. With a rocking motion, press the case down against the Ejector. Since the Ejector is spring loaded, some resistance will be felt. Press on the case until it stops against the bolt face. Ease off with your thumb slightly and press down again. Repeat several times. Replace the CLP frequently. Once the spring action of the Ejector is smooth and strong, dry off any excess lubricant.



CLEANING THE LOWER RECEIVER...

- 1.) Clean all areas of Powder Fouling, Corrosion, Dirt and Rust. Again, never use a wire brush or any type of abrasive to clean the Aluminum Lower Receiver.
- 2.) Wipe any dirt from the Trigger Mechanism. Carefully clean the Magazine Release Button and the cavity for the Magazine Catch on the left side of the Receiver. Also inspect and clean the Bolt Catch Mechanism and Receiver's Takedown and Pivot Pins. Clean the Buffer, Action Spring, and inside the Lower Receiver Extension (the Buffer Tube). A piece of rag attached to the Cleaning Rod and Patch Holder can be used to wipe inside the Buffer Tube.



- 3.) If rifle has been used in very dirty/muddy conditions, the Vent Screw in the A2 Solid Buttstock (shown) or the Vent Hole in the Telestock Receiver Extension may need to be cleaned out. Use a Pipe Cleaner or piece of wire to ensure that Vent Hole is clear.
- 4.) Buttstocks may require cleaning as necessary. Telescoping Stock Latch can be pulled down to remove Stock. Clean the 6 Position Lock Holes, and lightly lube the Receiver Extension and Latch Mechanism to ensure proper telescoping action. A2 Solid Buttstocks may require cleaning / lubrication of Storage Compartment Door Latch and Hinge, and interior of Storage Compartment.

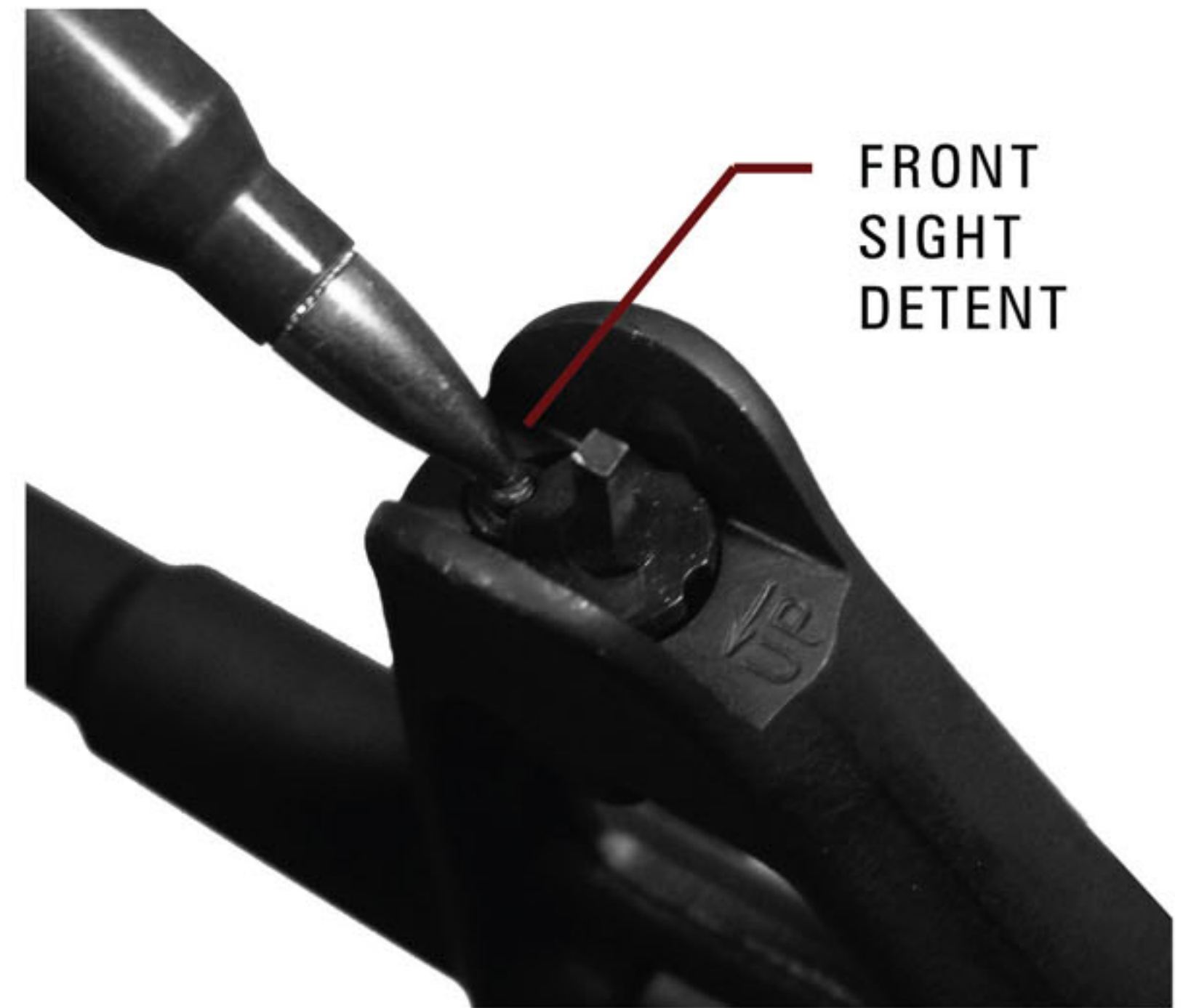


LUBRICATION – UPPER & LOWER RECEIVERS...

Upper Receiver...

Lightly Lubricate the inside of Upper Receiver, the Bore and Chamber (using the cleaning rod and a patch), the outer surfaces of the Barrel and Front Sight, and surfaces under the Handguards. Be sure you lubricate in and around all the Locking Lugs (as in photo above). The Forward Assist should also be lightly lubed inside the Receiver and checked for function.

Front Sight Detent: Depress and apply two or three drops of CLP to it. Depress the detent several times to work the lubricant down into the Spring.



Lower Receiver...

Lower Receiver Extension: Lightly lubricate inside the Lower Receiver Extension (Buffer Tube), the Buffer and the Action Spring. Also lightly lubricate the Telestock Latch and exterior of the Receiver Extension.

Lower Receiver: Generously lubricate **ALL MOVING PARTS INSIDE THE LOWER RECEIVER** including the Trigger, Hammer, Safety, Bolt Catch, Magazine Release, etc), and their various Pins and Detents. Don't forget the Takedown and Pivot Pins and their Detents. Use an oiled rag to wipe off any fingerprints on the exterior surfaces (they can start the corrosion process). A black cloth is best as it won't leave visible lint.



LUBRICATION – BOLT CARRIER GROUP...

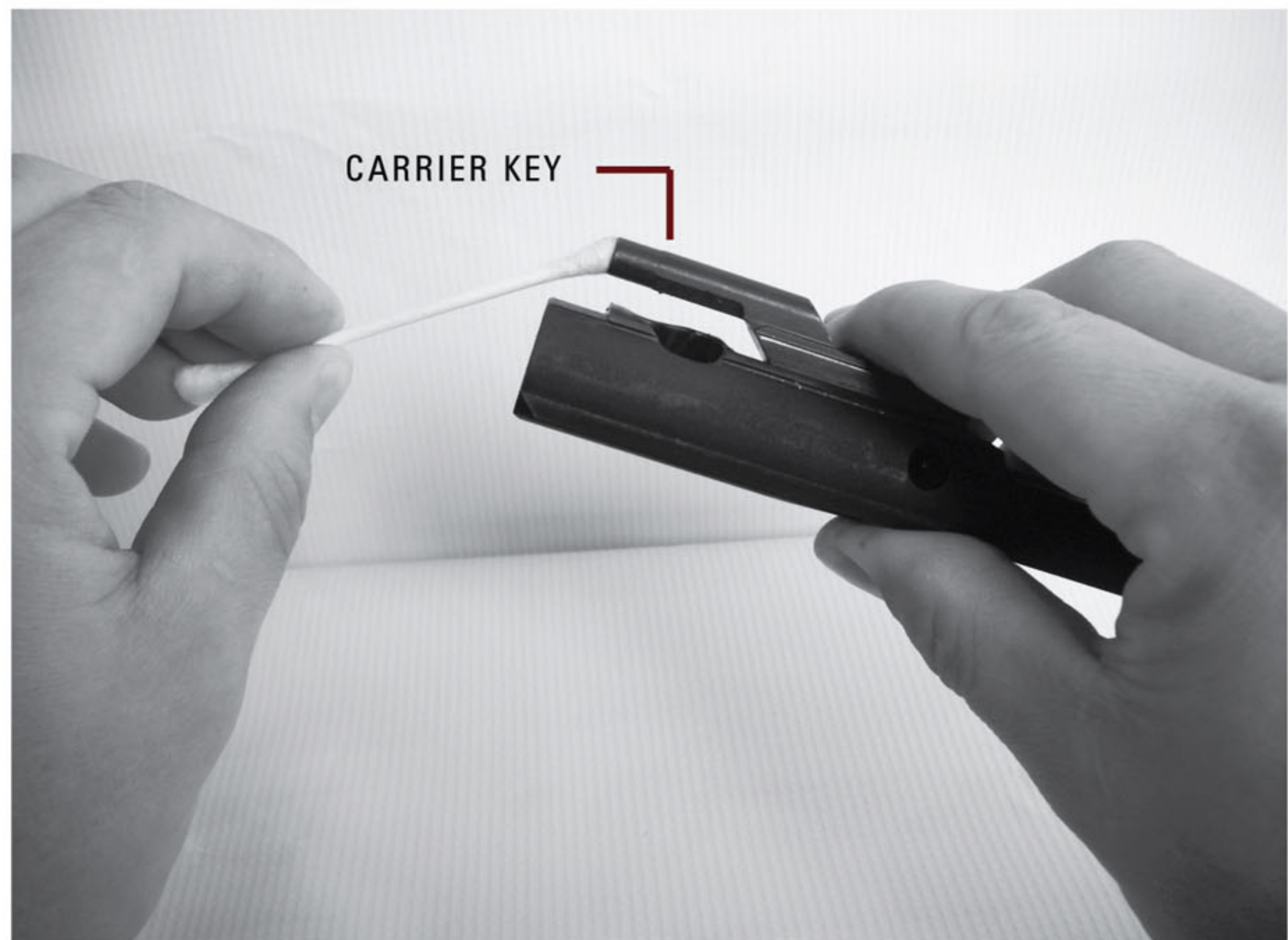
Firing Pin: Lightly lubricate the Firing Pin with CLP - also the Firing Pin recess in the Bolt.

Bolt Carrier: Lightly lubricate the inner and outer surfaces of the Bolt Carrier. Generously lubricate the Cam Pin area and the "Slide" Rail areas of the Bolt Carrier where they contact the inside of the Receiver.

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

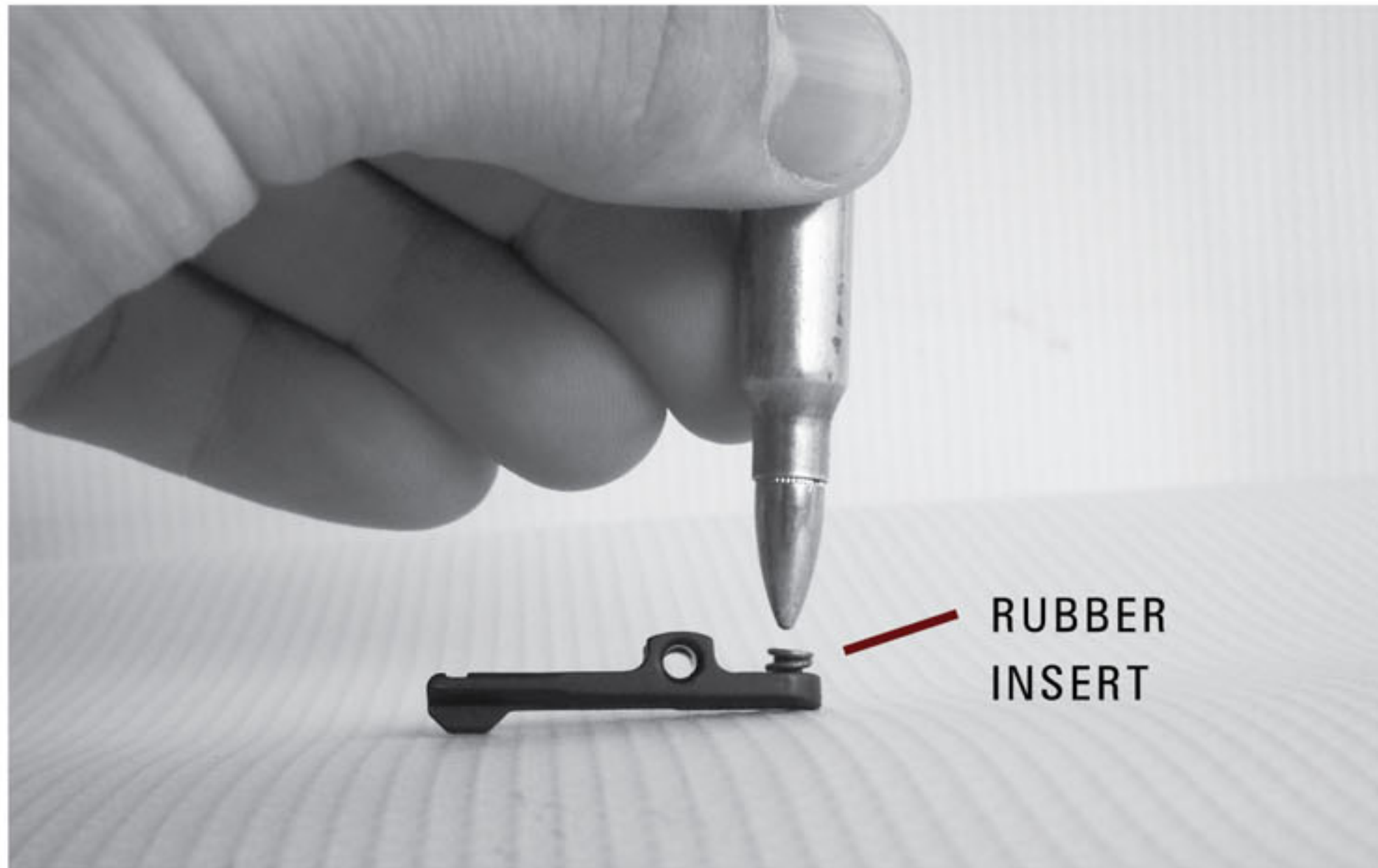
Charging Handle: Lightly lubricate the Charging Handle and it's Latch and Spring.

Carrier Key: The inside of the Carrier Key on the Bolt Carrier should be dried with a Q-Tip or Pipe Cleaner - then place one drop of CLP inside.



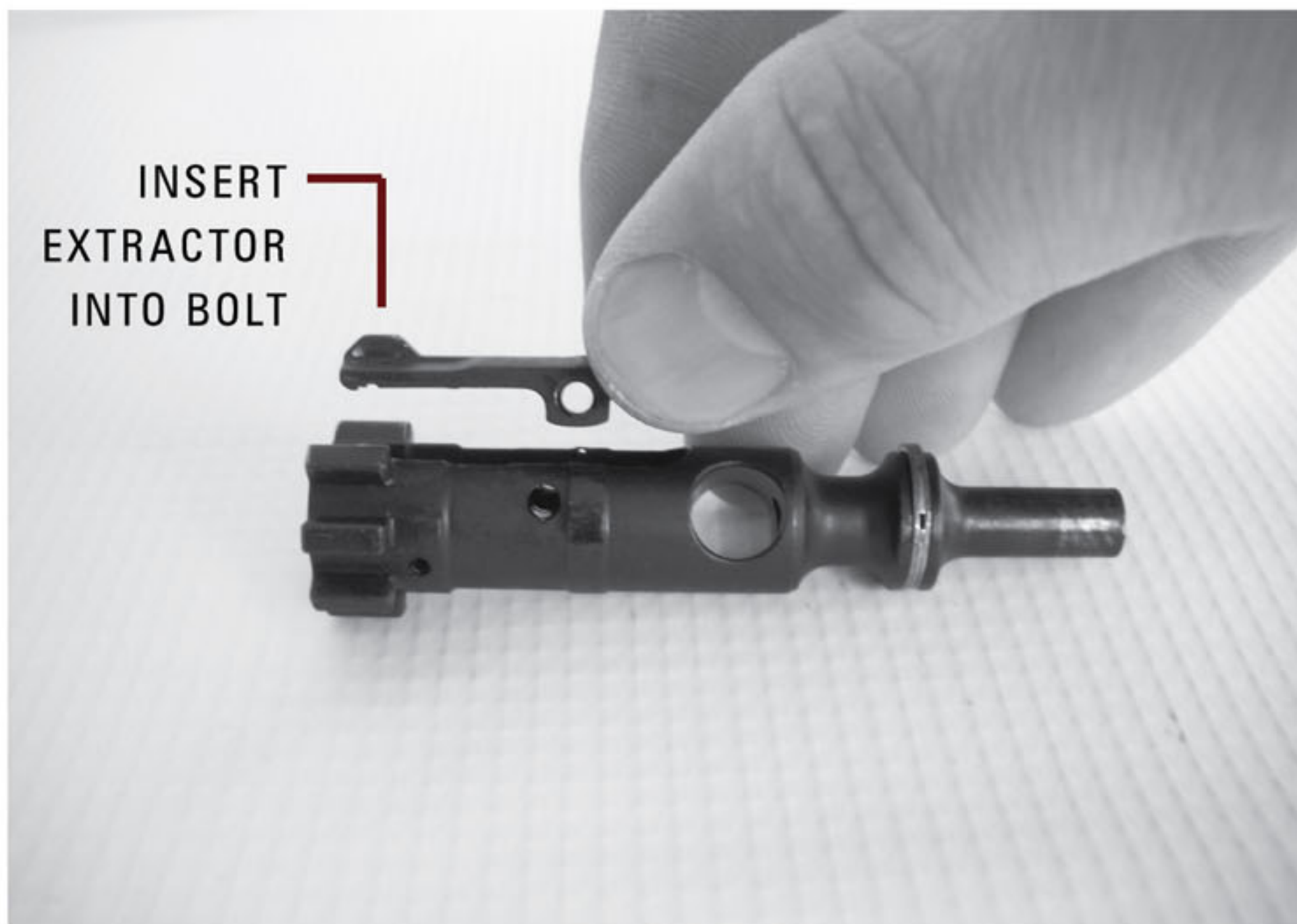
REASSEMBLING YOUR RIFLE...

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



- 2.) Insert Extractor and Spring.

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

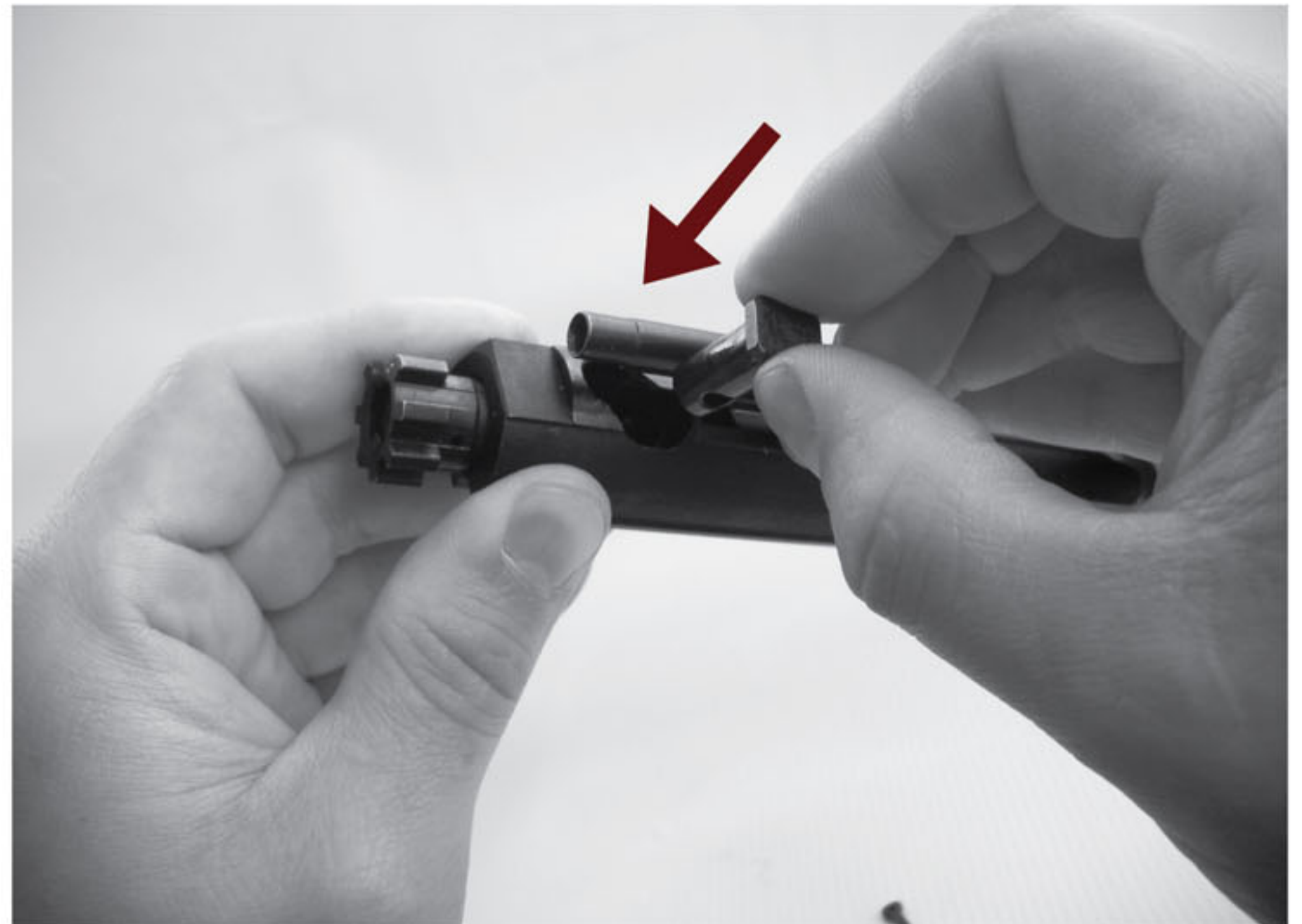
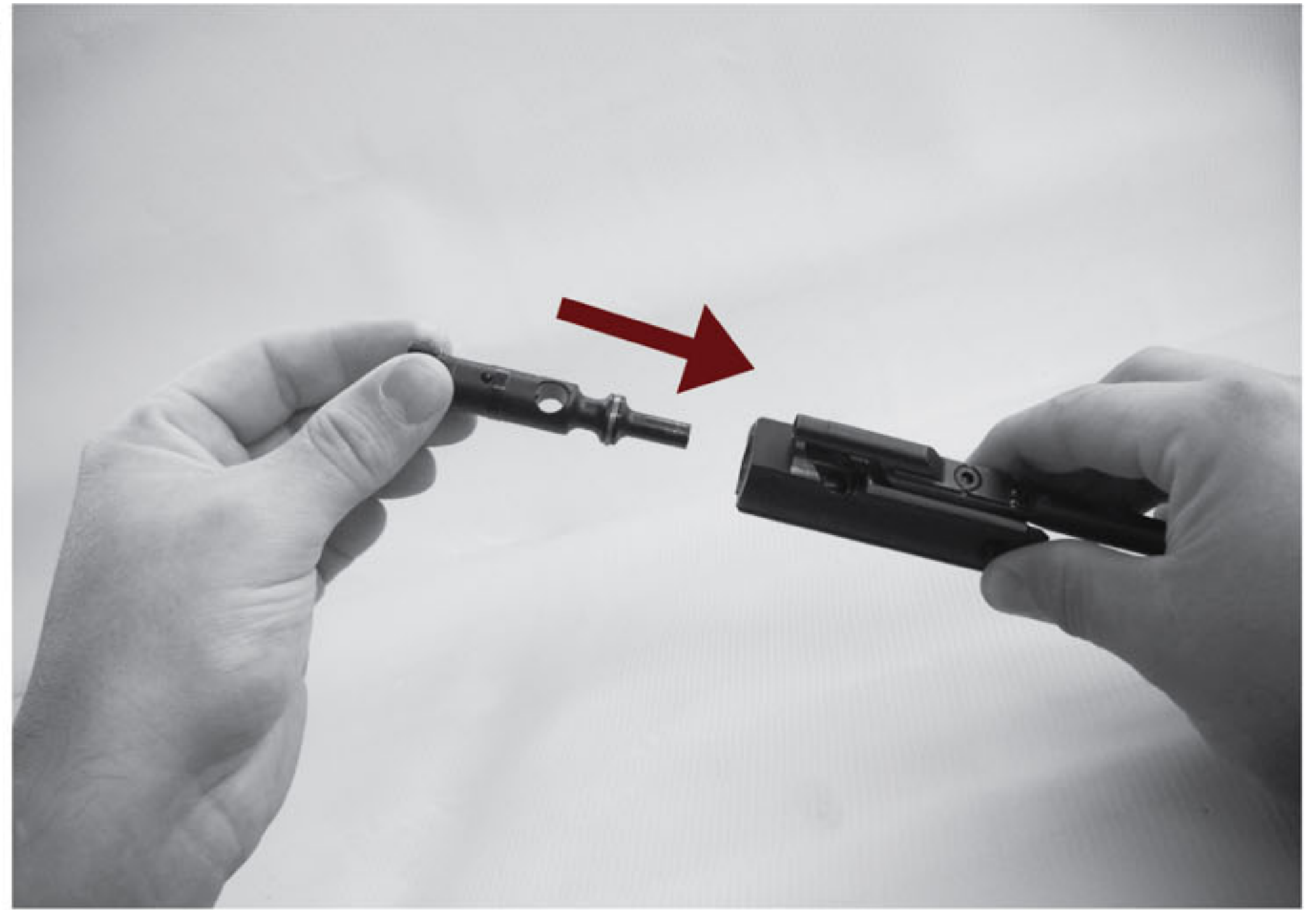


- 3.) Then push down on Extractor to depress Spring, and reinsert Extractor Pin.



REASSEMBLING YOUR RIFLE... (Continued)

- 4.) At the back end of the Bolt, stagger the Gas Ring Gaps to reduce gas pressure loss. Position the three ring gaps 120° apart around the bolt (3rd gap not seen at back side of bolt). The rings will slide around in their groove by pushing them into position with a small sharp object.
- 5.) Insert Bolt into Bolt Carrier. Twist into position so Cam Pin can be inserted (remember Cam Pin can only be installed in Bolt from one side, so if it doesn't fit right away, twist the Bolt 180° and try again).
- 6.) Once Cam Pin is inserted, twist it 90° (this will allow insertion of the Firing Pin).



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



REASSEMBLING YOUR RIFLE... (Continued)

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

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

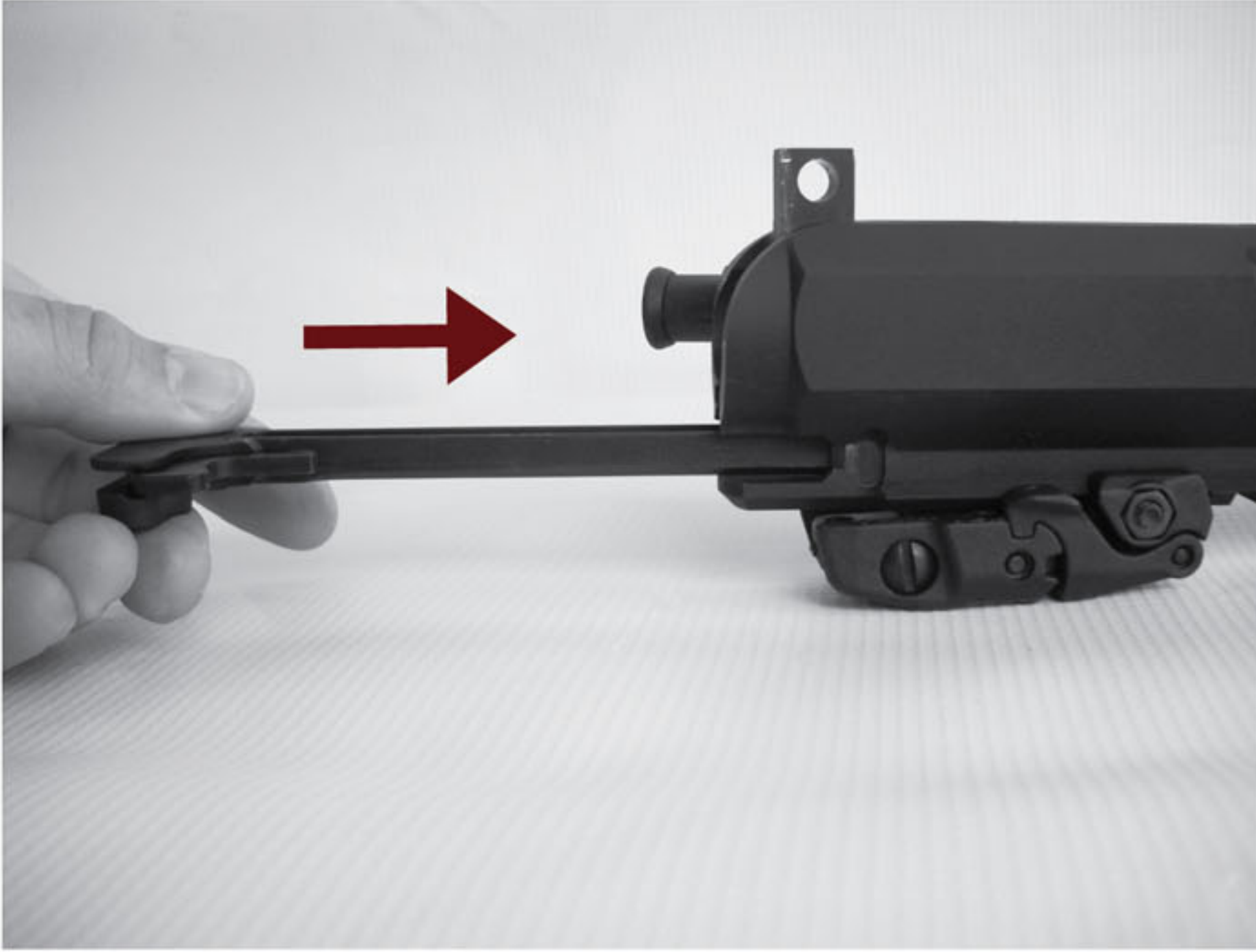


CAUTION: HEAD DOWN DOES NOT RECOMMEND THE PRACTICE OF SWAPPING BOLTS BETWEEN DIFFERENT RIFLES. DOING SO COULD RESULT IN DAMAGE, PERSONAL INJURY OR DEATH.

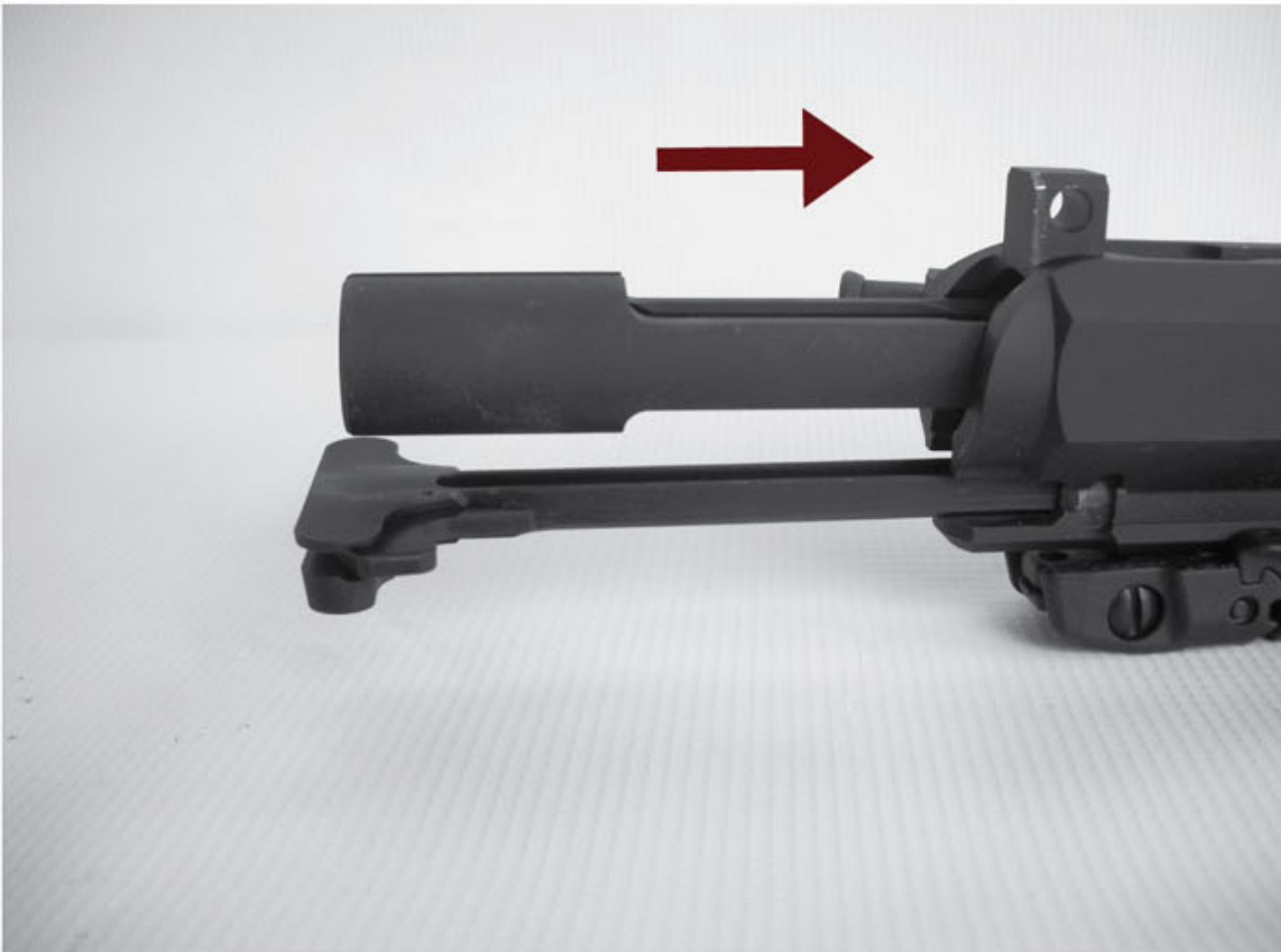


REASSEMBLING YOUR RIFLE... (Continued)

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



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



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

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

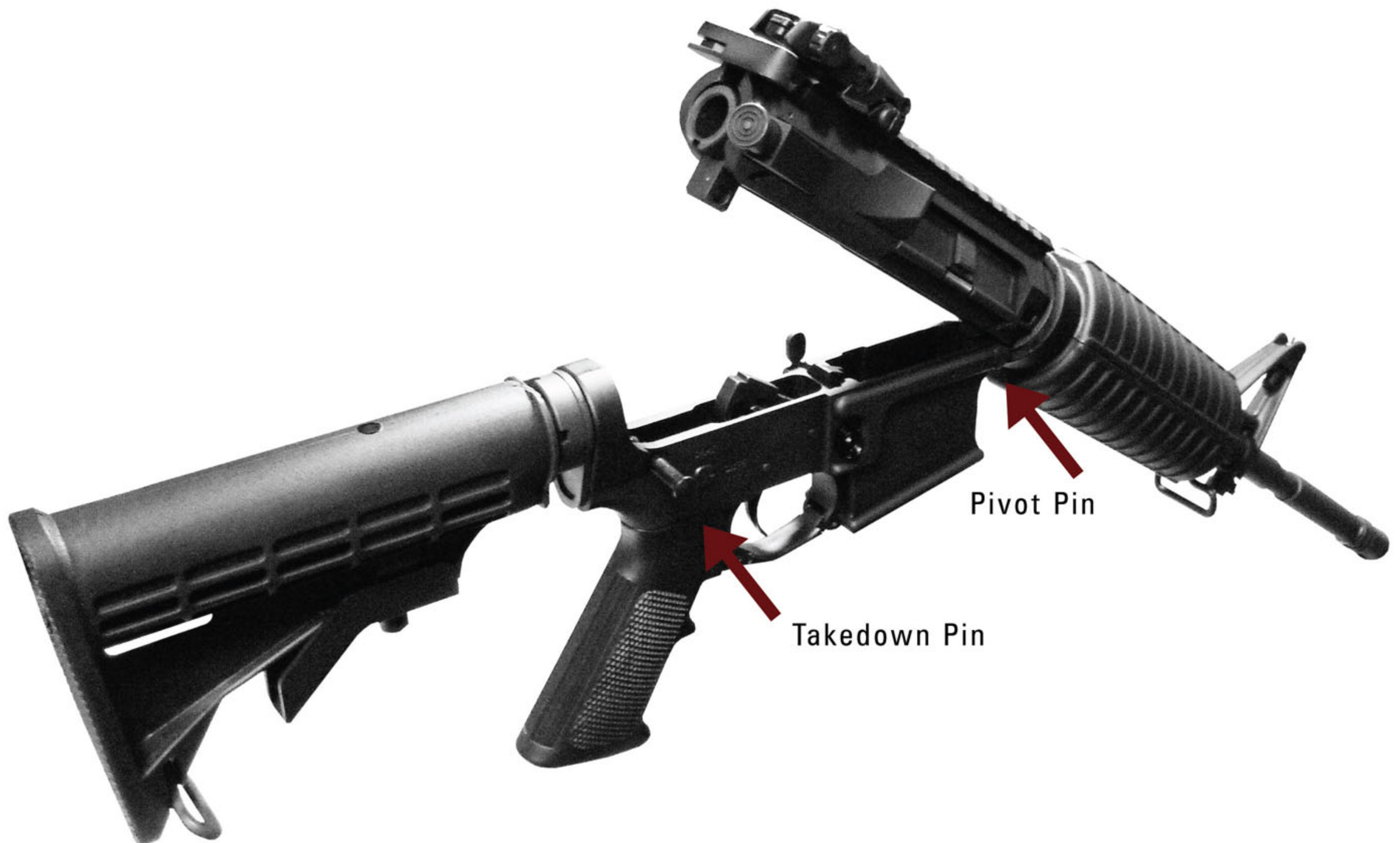


REASSEMBLING YOUR RIFLE... (Continued)

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

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



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



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




PROBLEMS / SOLUTIONS ...

| PROBLEM | CHECK FOR: | WHAT TO DO: |
|--------------------------|---|--|
| <p>RIFLE WON'T FIRE</p> | <p>SELECTOR LEVER ON SAFE</p> <p>IMPROPER ASSEMBLY OF FIRING PIN</p> <p>TOO MUCH OIL IN FIRING PIN RECESS</p> <p>DEFECTIVE AMMUNITION</p> <p>TOO MUCH CARBON ON FIRING PIN OR IN FIRING PIN RECESS</p> | <p>PUT IT ON FIRE</p> <p>ASSEMBLE CORRECTLY RETAINING PIN GOES IN BACK OF LARGE SHOULDER ON FIRING PIN</p> <p>WIPE OUT WITH PIPE CLEANER</p>  <p>REMOVE AND DISCARD</p> <p>CLEAN</p>  |
| <p>BOLT WON'T UNLOCK</p> | <p>DIRTY OR BURRED BOLT</p> | <p>CLEAN, OR SEE YOUR GUNSMITH</p> |
| <p>WON'T EXTRACT</p> | <p>BROKEN EXTRACTOR SPRING</p> <p>DIRTY OR CORRODED AMMO</p> <p>CARBON IN CHAMBER</p> <p>FOULING OR CARBON IN EXTRACTOR RECESS OR LIP</p> | <p>SEE YOUR GUNSMITH</p> <p>REMOVE STUCK ROUND PUSH OUT WITH CLEANING ROD</p> <p>CLEAN CHAMBER</p> <p>CLEAN EXTRACTOR</p> |





PROBLEMS / SOLUTIONS ...

| PROBLEM | CHECK FOR: | WHAT TO DO: |
|---------------|---|---|
| WON'T FEED | DIRTY OR CORRODED AMMO | CLEAN |
| | DIRTY MAGAZINE | CLEAN |
| | DEFECTIVE MAGAZINE | REPLACE |
| | TOO MANY ROUNDS IN MAGAZINE | TAKE OUT EXCESS |
| | ACTION OF BUFFER ASSEMBLY IS RESTRICTED | TAKE OUT BUFFER AND SPRING - CLEAN THEM |
| | MAGAZINE NOT FULLY SEATED | ADJUST MAGAZINE CATCH PRESS MAGAZINE CATCH BUTTON ON RIGHT SIDE. |
| | |  |
| | | TURN CATCH CLOCKWISE TO TIGHTEN AND COUNTERCLOCKWISE TO LOOSEN |
| DOUBLE FEED | DEFECTIVE MAGAZINE | REPLACE |
| WON'T CHAMBER | DIRTY OR CORRODED AMMO | CLEAN |
| | DAMAGED AMMO | REPLACE |
| | CARBON IN CHAMBER OR ON GAS TUBE | CLEAN |
| WON'T LOCK | DIRT, CORROSION, OR CARBON BUILDUP IN BARREL LOCKING LUGS | CLEAN LUGS |



PROBLEMS / SOLUTIONS ...

| PROBLEM | CHECK FOR: | WHAT TO DO: |
|----------------------|---|---|
| <p>WON'T EXTRACT</p> | <p>FROZEN EXTRACTOR</p> <p>RESTRICTED BUFFER ASSEMBLY</p> <p>RESTRICTED MOVEMENT OF BOLT CARRIER GROUP</p> | <p>REMOVE AND CLEAN</p> <p>REMOVE AND CLEAN</p> <p>REMOVE, CLEAN, AND LUBE (BEFORE PUTTING BOLT BACK IN, MAKE SURE GAS TUBE FITS INTO CARRIER KEY AND THAT THE CARRIER MOVES FREELY)</p> |
| <p>SHORT RECOIL</p> | <p>CORRECT ALIGNMENT OF GAPS IN BOLT GAS RINGS</p> <p>CARBON OR DIRT IN CARRIER KEY OR ON OUTSIDE OF GAS TUBE</p> <p>Q-TIP, PIPE CLEANER PIECES, OR OTHER DEBRIS STUCK INSIDE CARRIER KEY</p> | <p>"GAPS" IN THE 3 GAS RINGS SHOULD BE STAGGERED 120° AROUND THE BOLT BODY FOR MAXIMUM EFFECTIVENESS</p>  <p>TIP: Gas Rings should be replaced every 3,000 Rounds</p> <p>CLEAN CARRIER KEY OR AROUND THE GAS TUBE</p> <p>CLEAN OUT IF POSSIBLE OR HAVE RIFLE CHECKED BY YOUR GUNSMITH</p>  |



PROBLEMS / SOLUTIONS ...

| PROBLEM | CHECK FOR: | WHAT TO DO: |
|-------------------------------------|---|---|
| BOLT FAILS TO LOCK AFTER LAST ROUND | DIRTY OR CORRODED BOLT LATCH FAULTY MAGAZINE | CLEAN - OR REPLACE - BOLT CATCH CHECK FOR BUFFER ENDCAP BACKOUT OR OBSTRUCTION CHECK FOR FULL TRAVEL OF BOLT CARRIER REPLACE |
| SELECTOR LEVER BINDS | NEEDS OIL DIRT OR SAND UNDER TRIGGER | LUBRICATE WITH CLP CLEAN |
| BOLT CARRIER "HUNG UP" | ROUND JAMMED BETWEEN BOLT AND CHARGING HANDLE AND/OR DOUBLE FEED WARNING: KEEP CLEAR OF MUZZLE CAUTION: AFTER ROUND IS REMOVED, BOLT IS UNDER TENSION | 1.) REMOVE MAGAZINE. 2.) PUSH IN ON THE BOTTOM OF THE BOLT LATCH. 3.) WHILE PULLING DOWN ON CHARGING HANDLE, TAP THE RIFLE BUTT ON THE GROUND. BOLT SHOULD LOCK TO THE REAR. 4.) WHILE BOLT IS HELD TO THE REAR, ROUND SHOULD FALL THROUGH THE MAGAZINE WELL. NOTE: IF THIS PROCEDURE FAILS, USE A SECTION OF CLEANING ROD TO PUSH THE BOLT FULLY TO REAR THROUGH THE EJECTION PORT. |



COLD WEATHER SHOOTING...

If cold weather requires it, your rifle can be shot with gloved or mittened hands. The Trigger Guard is designed to allow the use of a glove. If needed open and swing down allowing better access to Trigger when the shooter is wearing gloves or mittens. Some Head Down lower receivers have integrated trigger guards that can not be removed.

1.) Push in Forward Trigger Guard Pin with Bullet tip to release Trigger Guard.

2.) Swing Trigger Guard down for shooting with gloves or mittens.



CAUTION!... Be careful of accidental discharges when inserting gloved fingers into Trigger Guard area.

MAINTENANCE IN EXTREME WEATHER...

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

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

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

RAINS: DO NOT FIRE THE RIFLE IF WATER IS PRESENT IN THE BARREL. Excess pressure can cause the Rifle to explode.

ALWAYS drain any water from Barrel prior to firing. Dry the Bore with a Swab and Cleaning Rod if wet.



TORQUE SCREW

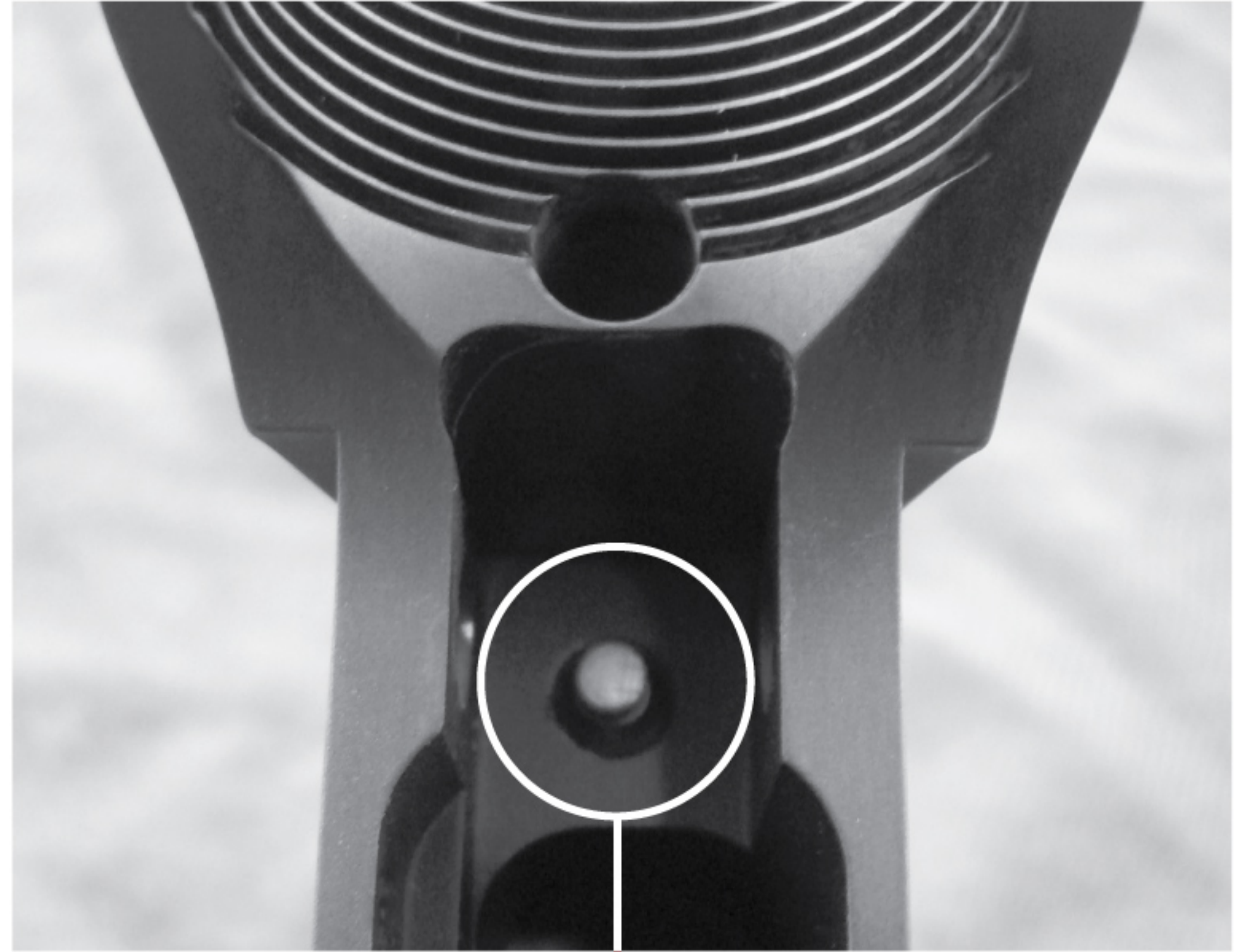
The Torque Screw was adopted to prevent undesired "slop" in the upper and lower receiver. By utilizing the Torque Screw it has been proven to provide a weapon system that has superior accuracy.

NOTE: The use of the Torque Screw is optional and not required to operate your Head Down rifle. All Head Down rifles come standard with this feature and is adjusted at the factory prior to shipment.

LOWER RECEIVER (BOTTOM VIEW)



LOWER RECEIVER (TOP VIEW)



NYLON TIP TORQUE SCREW

To adjust the amount of pressure the Torque Screw puts on your upper receiver use a standard allen wrench.

Torque Screw adjustment location on lower receiver.



LIMITED MANUFACTURERS WARRANTY

Head Down Products are warranted to be free from defects in materials and workmanship. Any such defect of which Head Down Products, LLC. is given written notice, as provided below, within one year and ten days from the date of first purchase by a customer will be remedied by Head Down Products, LLC. This warranty is granted by Head Down Products, LLC., 4031 Fambrough Ct. STE 300, Powder Springs, GA 30127

To initiate a Warranty claim, call Head Down Customer Service from 9:00 AM to 5:00 PM E.S.T.- Monday thru Friday to get a "Return Merchandise Authorization" (RMA) number. Warranty claims should state (in writing) the model and serial number of the firearm concerned, a description of the difficulty experienced, and the date of purchase. The firearm concerned should be shipped (transportation charges prepaid), to the Warranty Service Department, Head Down Products, LLC., 4031 Fambrough Ct. STE 300, Powder Springs, GA 30127. Firearm shipment should be insured by the owner, as Head Down Products, LLC. will accept no responsibility for loss or damage in transit. Shipping and insurance charges for the return of a firearm to its owner will be paid by Head Down Products, LLC. if the related claim is a proper claim for warranty work.

Under no circumstances shall Head Down Products, LLC. be responsible for incidental or consequential damages with respect to economic loss or injury to property, whether as a result of express or implied warranty, negligence or otherwise. Some states do not allow the exclusion of limitation of incidental or consequential damages, so the above limitation may not apply to you. Head Down Products, LLC. will not be responsible for the results of careless handling, unauthorized adjustments, defective, low quality, reloaded, or improper ammunition, corrosion, neglect, ordinary wear and tear, or unreasonable use. Furthermore, the liability of Head Down Products, LLC. under this warranty shall be limited solely to the obligation to repair or replace the firearm, and to pay transportation and insurance charges for return of the firearm to owner.

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

WARRANTY REGISTRATION CARD

To register your purchase with us please complete this warranty card and submit by mail to our office address listed below. Please note, failure to submit your warranty card could result in Head Down Products denying your warranty claim.

Full Name: _____

Address: _____

City: _____ State: _____ Zipcode: _____

Purchased from: _____

Date purchased: _____

Warranty Service Department

Head Down Products, LLC.
4031 Fambrough Ct. STE 300
Powder Springs, GA 30127

PLEASE PRACTICE SAFE FIREARMS HANDLING!

WARNING:

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

CAUTION:

CAREFULLY READ THIS DOCUMENT PRIOR TO LOADING AND FIRING THIS FIREARM. FOLLOW ALL INSTRUCTIONS ON THE PROPER HANDLING AND SAFE USE OF THIS FIREARM - LIVES MAY DEPEND ON IT! If unfamiliar with firearms, seek further advice through safe handling courses run by your local gun clubs, NRA approved instructor, or similar qualified organizations.

CAUTION:

USE ONLY CLEAN, DRY, HIGH QUALITY COMMERCIALY MANUFACTURED AMMUNITION IN GOOD CONDITION which is appropriate to the 5.56mm caliber of your firearm. We do not recommend the use of remanufactured or hand loaded ammunition because it may damage your rifle. Use of improper ammunition will invalidate your warranty.

WARNING:

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

A SAFETY NOTE REGARDING LEAD... Discharging firearms in poorly ventilated areas, cleaning firearms, or handling ammunition may result in exposure to lead, a substance known to cause birth defects, reproductive harm, and other serious physical injury. Have adequate ventilation at all times. Wash hands thoroughly after exposure.

This Operating and Safety Instruction Manual should always be kept with your Head Down Firearm, and in case of sale or transfer, should be passed on to subsequent owners.

MODEL: _____
SERIAL NUMBER: _____
SOLD TO: _____
DATE SOLD: _____



HEAD DOWN
PRODUCTS