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ACME Model Number

Description

Publication control number and date

State-By-State Warnings

Some states require warning notices in larger-than-normal type be conspicuously included by the manufacturer, distributor or retailer with firearms sold in that state. ACME Machine sells its products in compliance with all applicable laws and regulations.

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.”

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 1 of 2

“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.”

Massachusetts 2 of 2

“IT IS UNLAWFUL TO STORE OR KEEP A FIREARM, RIFLE, SHOTGUN OR MACHINE GUN IN ANY PLACE UNLESS THAT WEAPON IS EQUIPPED WITH A TAMPERRESISTANT 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.”

NOTE: Check with local FFL retailer or state police for possible additional warnings which may be required by local law or regulation.

ACME Promotes Safe and Responsible Gun Ownership Practices READ THIS MANUAL

Please read this Instruction Manual on how to properly use and care for ACME rifles. Please contact ACME at (800) 471-6298 if you have any questions. Be certain you fully understand the manual prior to handling the firearm. Inexperienced individuals should seek personalized instruction from a certified firearms safety instructor, gun retailer, gun clubs or police departments. If none of these sources can help, visit www.nra.org or write to the following address: National Rifle Association 11250 Waples Mill Road Fairfax, VA 22030-7400.

General ACME Rifle Information

ACME firearms are gas impingement driven box magazine fed, autoloading rifle available in multiple calibers. The mechanism utilizes the gas from the firing of the round to drive the bolt carrier rearward and rotate a bolt that locks into the barrel. The rifle can be field stripped without the use of tools and breaks down into basic subassemblies. The safety, located above the trigger on the left side of the lower receiver, blocks the trigger and permits the bolt carrier to be cycled with the safety in the on or "SAFE" position. A bolt catch mechanism is provided for convenience in holding the bolt open for loading and inspection. The firing pin is retracted mechanically as the bolt starts to unlock and the rifle will fire only when the bolt is locked.

WARNING Do Not Modify ACME Rifles

This product was designed to function properly in its original condition. Alterations can make the firearm unsafe. Do not alter any part or add or substitute parts or accessories not approved or manufactured by the ACME Machine company.

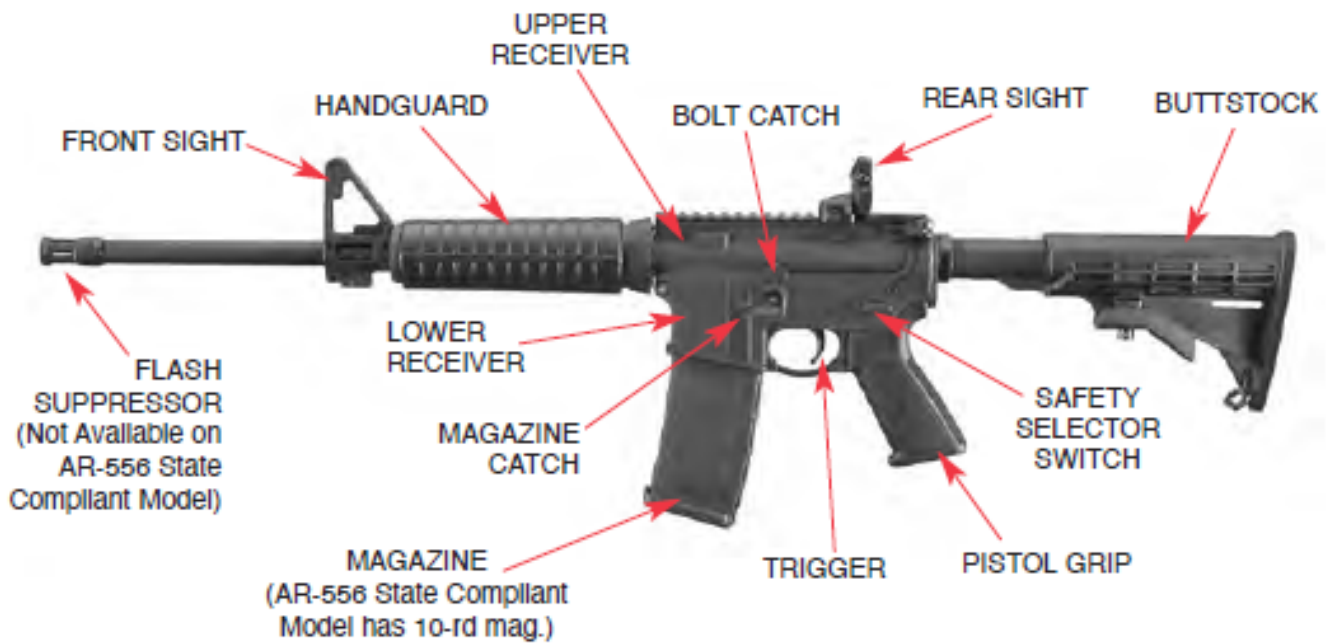
To order genuine replacement parts call

ACME Machine at (800) 471-6298

TABLE OF CONTENTS

State-By-State Warning	2
General Information	4
Rifle Nomenclature	6
Safety Lever Operation	7
Ammunition	8
Magazines	9
Shooting the Rifle	10
Unloading the Rifle	12
Removing a Bore Obstruction	13
Clearing a Jam	15
Disassembling the Rifle	16
Reassembling the Rifle	22
Care and Cleaning	27
Storing the Rifle	28
Service and Parts	29
Ordering Parts	30
Parts List	31
Illustrated Parts Breakdown	33
Warranty	38

RIFLE NOMENCLATURE



SAFETY LEVER OPERATION

The manual safety mechanism is located above the trigger on the left side of the lower receiver for convenient operation and is on when in its fully horizontal position pointing to the word "SAFE." (See Fig. X.)



Fig. X

The safety can be moved to "SAFE" anytime the hammer is cocked. When the safety is on "SAFE," it blocks the trigger. The safety should always be placed on "SAFE" before loading or unloading the rifle and should be kept on "SAFE" at all times except when actually firing.



Fig. X

WARNING: Keep the safety on unless actually firing. Always move the safety fully to its intended position and check it. The safety is not "ON" unless it is completely "ON." Never depend on a safety mechanism or any other mechanical device to justify careless handling or permitting the rifle to point in an unsafe direction. The only "safe" rifle is one in which the bolt is open, the chamber is empty, and there is no magazine in the gun.

AMMUNITION

ACME rifles are chambered for many of the most popular cartridges. The particular caliber for each rifle is marked on the barrel. Use cartridges only of the designated caliber that is marked on the barrel.

ATTENTION: If you are unable to determine the correct caliber of your rifle, please contact ACME at (800) 471-6298.

WARNING: Death, serious injury and damage can result from the wrong ammunition, bore obstructions, powder overloads or incorrect cartridge components. Even the strongest gun can be “blown up” as a result of excess pressure.

ALWAYS WEAR SHOOTING GLASSES AND HEARING PROTECTION

AMMUNITION (CARTRIDGES) NOTICE

ACME MACHINE SPECIFICALLY DISCLAIM RESPONSIBILITY FOR ANY DAMAGE OR INJURY WHATSOEVER OCCURRING IN CONNECTION WITH, OR AS THE RESULT OF, THE USE IN ACME FIREARMS OF FAULTY, OR NONSTANDARD, OR “REMANUFACTURED” OR HAND LOADED (RELOADED) AMMUNITION, OR OF CARTRIDGES OTHER THAN THOSE FOR WHICH THE FIREARM WAS ORIGINALLY CHAMBERED.

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.

SHOOTING OR CLEANING GUNS MAY EXPOSE YOU TO LEAD

MAGZINES

ACME Machine magazines supplied with the rifle are caliber specific. Available in 5, 10 and 30 round capacities according to caliber and laws governing magazine capacity restrictions.

Loading a Magazine

Align with the bullet forward and push downward until the cartridge snaps into place. Place the next round and repeat until the desired number of cartridges are loaded. Do not attempt to load more than the designated number.

Inserting the Magazine Into the Rifle

The magazine may be inserted with the bolt carrier either in the closed or open position although significantly more force will be necessary to insert the magazine with the bolt in the closed position.

1. Hold the magazine as shown and insert it all the way up into the magazine well.
2. Check to be sure that the magazine is securely latched into place.



Removal of the Magazine From the Rifle

To remove the magazine, simply push the magazine catch button toward the side of the lower receiver until the magazine drops out of the magazine well. To minimize the possibility of damage and malfunctions, do not let the magazine drop to the ground



Press magazine release button

Pull magazine down and out

SHOOTING THE RIFLE

This procedure begins with an empty rifle with the magazine out.

1. ALWAYS be certain the muzzle is pointing in a safe direction.
2. Before inserting a loaded magazine, pull back the charging handle full travel and engage the bolt catch on the left side of the lower so the bolt carrier is held open. Check the chamber to be certain it is empty. MOVE THE SAFETY TO THE ON "SAFE" POSITION. See Fig X

Bolt Catch Operation

- A. Pull the charging handle all the way to the rear.
- B. Depress the bottom part of the bolt catch plunger and allow the bolt carrier to move forward until it stops.
- C. Put the safety on "SAFE"

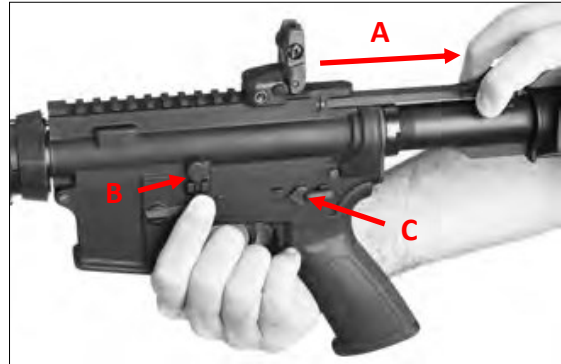


Fig. X

CAUTION: Bolt carrier is under heavy spring tension.

3. Load a magazine with the desired number of cartridges.
4. Insert the loaded magazine into the magazine well, and push the upper pad on the bolt catch towards the side of the lower receiver. A cartridge will be stripped from the magazine and chambered by the motion of the bolt carrier.
5. The rifle is now cocked with a cartridge is chambered. Visually check to be certain the safety is in the on or the "SAFE" position, and keep the rifle pointed in a safe direction.

ATTENTION: Inexperienced shooters unfamiliar with the skills necessary to shoot a rifle safely and with accuracy should seek individual training with a certified firearms instructor as referenced on page 4 of this owners manually under the section entitled "ACME Promotes Safe and Responsible Gun Ownership Practices".

WARNING: If cartridges do not feed smoothly from the magazine into the chamber then do not use the rifle until the problem is corrected.

WARNING: The bolt carrier automatically opens and shuts quickly while firing. Keep face and hands away from it. Hot brass and powder gas is ejected quickly and can burn you. The rifle should be fired from the right shoulder (this rifle can be configured for firing from the left shoulder for left handed shooters). Always wear shooting glasses and hearing protection.

6. When you are ready to fire the rifle, move the safety to the “FIRE” position.

WARNING: DO NOT TOUCH THE TRIGGER UNTIL YOU ARE ACTUALLY READY TO FIRE. KEEP THE SAFETY “ON” UNLESS ACTUALLY FIRING.

7. The rifle will fire one shot each time the trigger is pulled until the magazine is empty. The gas produced by the combustion of the powder in the cartridge is used to drive the bolt carrier rearward. This process ejects the fired cartridge case, recocks the gun, and loads a new cartridge from the magazine into the firing chamber.

8. **Immediately following the firing of a shot, and if a subsequent shot is not to be fired at once, put the safety in the on “SAFE” position while the rifle is still pointing in a safe direction.** The safety should be moved to the “SAFE” position as soon as firing is completed, and it should be on “SAFE” at all times except when the rifle is on target and being fired.

9. When the last cartridge in the magazine has been fired, the bolt catch will automatically engage.

WARNING: HANDLING If dropped or struck with the safety “off”, the rifle may fire. Keep chamber empty unless actually firing! Keep the safety in the “SAFE” position unless actually firing!

WARNING: Sustained firing can create excessive heat in the barrel and can cause “cook-off” of ammunition (heat-firing of the cartridge in the chamber). This “cook-off” can occur a substantial period of time after firing has ceased. Always unload the firearm and unload the chamber immediately after you have finished shooting.

UNLOADING THE RIFLE

WARNING: The rifle can be used as a single loader, it will fire whether or not a magazine is in the gun if a cartridge is chambered. Removing the magazine does not unload the rifle! To unload, first remove the magazine, then pull the charging handle to the rear, eject the chambered cartridge, and visually inspect the chamber. The safety should always be in the "SAFE" position when loading or unloading the rifle.

1. Keep the muzzle pointed in a safe direction at all times and keep fingers outside the trigger guard. Rotate the safety to the "SAFE" position.
2. Remove the magazine. REMEMBER that even though the magazine has been removed, a cartridge remaining in the chamber can still be fired!
3. Pull the charging handle all the way to the rear, extracting and ejecting the cartridge in the chamber.
4. When the bolt carrier is fully retracted, push down on the bottom pad of the bolt catch and then allow the bolt carrier to move forward until it comes to rest against the bolt catch.
5. Always visually double check the chamber to be certain it is empty.
6. REMEMBER The only "safe" rifle is one in which the bolt carrier is open and the chamber and magazine are empty, and the muzzle is pointed in a safe direction.



WARNING This sequence must be followed exactly! Failure to do so can result in the rifle's chamber becoming unintentionally loaded with a cartridge!

REMOVING A BORE OBSTRUCTION

Excess oil, grease or water may form an obstruction which could cause damage and injury. If you suspect that your rifle may have excess oil, grease or other contaminants in the barrel, or if it may have been exposed to humid conditions which could cause condensation, or to rain or snow which might have entered the bore, open the bolt carrier and clean out the barrel. Inspect the bore visually to be sure that it is perfectly clear.

A gun user should recognize that a lodged bullet is a fairly common form of bore obstruction. Therefore, the following information on how a bullet may become lodged in the bore, and how it should be removed, deserves most careful reading and understanding!

WARNING: Before loading or shooting the ACME rifle, be certain the bore is unobstructed. Firing the rifle with any obstruction in the bore may result in severe damage to the rifle and serious injury to the shooter and other persons nearby.

WARNING: A misfire or unusual report (sound) upon firing is always a signal to cease firing immediately and after waiting for one minute, examine the chamber and bore of the firearm. It is not sufficient to retract the charging handle and examine the chamber. You must remove the magazine, clear the chamber, lock the bolt carrier open and inspect the chamber visually. Then close the bolt. Disengage the take down pin, remove the bolt and carrier (SEE PAGES XXXXX) and inspect the bore visually, and with a rod if necessary - to be certain it is completely clear of any obstruction. Failure to detect and correctly remove a bore obstruction can result in serious injury to the shooter and bystanders, and damage to the firearm. DO NOT "SHOOT OUT" A BORE OBSTRUCTION.

1. When firing, a bullet may become lodged in the bore if the cartridge contains no powder, or the powder fails to ignite and only the primer charge ignites, producing insufficient force to propel the bullet out of the bore.
2. A bullet may also become lodged in the bore when extracting a cartridge from the chamber (unloading). If the bullet is not crimped tightly enough in the cartridge case, the bullet may stick in the bore, with only the case being extracted.

Experience indicates that the two conditions described above occur most frequently with reloaded ammunition.

When either of the above described (1 or 2) situations occur, proceed as follows with the rifle pointing in a safe direction:

- a) If the rifle is cocked, move the safety to the "SAFE" position.
- b) Remove the magazine from the rifle.
- c) Retract the charging handle and lock it in the open position by pressing on the bottom pad of the bolt catch in the lower receiver. Retracting the charging handle should remove the cartridge case. Be certain the safety is in the "SAFE" position.

- d) Check the chamber to be certain there is no cartridge case in it – if there is, extract it before proceeding with steps (e) and (f).
- e) After making sure the chamber is clear and the magazine is removed, close the bolt, disengage the takedown pin, remove the bolt and carrier (SEE PAGES xxxx) and inspect the bore visually and with a rod as necessary.

CLEARING A JAM

If you experience a malfunction, study the situation to determine the nature of the malfunction and how best to clear it. Any autoloading firearm may occasionally malfunction.

If it does:

1. **Be certain the muzzle is pointed in a safe direction and the safety is in the on (“SAFE”) position.**
2. When attempting to free a jammed cartridge, do not use any type of tool that is likely to act as a “firing pin” and discharge the cartridge should the tool impact the primer. Never use a cartridge as a “tool.”
3. After clearing a jam, inspect the gun mechanism to determine if dirt or debris might be the cause of the problem. Excess lubricant or grease can cause cartridges to feed sluggishly. An accumulation of grease, dirt or powder grains in the magazine can contribute to cartridge feeding problems.
4. After clearing a jam, inspect all cartridges that have been removed from the gun. Safely dispose of any cartridges which are dented, nicked or have bullets that are loose or improperly positioned in the cartridge case.
5. If it appears that the gun and magazine are not at fault, and that the jam was caused by the type of cartridge being used, then try another type or brand of cartridge.
6. If the above procedures do not result in a smooth and reliable feeding firearm, don’t use the gun until it feeds cartridges smoothly and reliably. If a solution cannot be obtained take to rifle to a gunsmith for service or return to ACME Machine. (SEE PAGES XXX)

NOTE: Form the habit of examining fired cartridge cases from time to time. If fired cases have bulged heads or show splits on any part of the case, stop using that ammunition. If the problem persists with different types of ammunition, return the rifle to the factory for inspection.

7. If a cartridge is caught between the bolt carrier and receiver, put the safety on “SAFE,” remove the magazine, retract the bolt carrier using the charging handle, and lock it in the open position using the bolt catch. Then remove the jammed case.
8. If a **fired** cartridge case is in the chamber, use a cleaning rod to knock it out.
9. If an unfired cartridge is stuck in the chamber, keep the muzzle pointed in a safe direction with the safety in the “SAFE” position. Close the bolt, disengage the takedown pin, remove the bolt and carrier (SEE PAGES XX) and remove the unfired cartridge from the breech-end rather than trying to dislodge it with a cleaning rod inserted from the muzzle. Use a piece of 3/16” brass rod which has one end shaped like a screwdriver tip. Insert the tip in the extractor groove of the cartridge, use the face of the ejection port as

9. continued ... a fulcrum and carefully pry out the cartridge. Be careful not to strike the primer area of the live cartridge! Brush-clean the chamber with solvent after clearing any jam involving the chamber.

Autoloading firearms of all makes and types occasionally jams when a cartridge fails to feed from the magazine to the chamber, or when a cartridge (or fired case) fails to properly extract and eject.

To minimize the possibility of such occurrences, the gun user should:

1. Use ammunition of the correct caliber and type which is loaded to Industry Specifications. Avoid reloads, remanufactured cartridges, and cartridges that are dirty, corroded or deformed.
2. Clean and lubricate the gun in accordance with the instructions in this manual.
3. If the rifle shows signs of not functioning correctly, or if a part is damaged or broken -- don't use the gun. Have it inspected and repaired by a gunsmith or return to ACME Machine.
4. Use only high-quality AR-style magazines and carefully load the magazine. Do not exceed the stated magazine capacity.
5. Do not 'ride' the charging handle when chambering a cartridge from the magazine. The bolt carrier should be permitted to snap forward under the full force of the buffer spring. If a cartridge does not fully chamber, use the forward assist no more than twice to force the bolt carrier closed. If the cartridge is still not chambered completely, the round should be cleared as a jam.
6. To minimize the probability of an unfired cartridge being jammed should it 'fall back' onto the magazine, remove the magazine before retracting the bolt carrier. When extracting an unfired cartridge, tip the right side of the rifle towards the ground so that gravity will assist the cartridge to fall clear of the ejection port. Always retract the charging handle briskly whenever extracting a live cartridge. Take care to see that a cartridge is not forcibly ejected against a surface where the primer might be set off.

WARNING: A cartridge can be "discharged" before it is chambered if its primer receives a sharp blow. If a cartridge hangs up, jams, or binds when being chambered or when being fed from the magazine into the chamber, do not attempt to force it into the chamber by pushing or striking the bolt carrier. The forward assist may be depressed up to two times, after which time if the cartridge is still not chambered completely, the round should be cleared as a jam. Any jam or feeding problem is a signal to immediately stop using the gun until it can be determined what is wrong. Most failures of a cartridge to feed or to chamber are caused by a damaged magazine, improper gun handling or defective ammunition. Whatever the cause, cartridge jams can result in the potentially very dangerous situation of a cartridge discharging before it is chambered. If this occurs, the cartridge case will rupture and its fragments will fly out of the gun with sufficient force to cause injury. Always wear shooting glasses and hearing protection! Keep face away from chamber!

DISASSEMBLING THE RIFLE

WARNING: Always unload a firearm before cleaning, lubrication, disassembly or assembly.

WARNING: Read all instructions and follow each step in the order it is listed. Do not proceed to the next step until the previous step has been completed. Failure to do so may result in serious injury or death.

1. Remove the magazine from the rifle.

- a. Point the rifle in a safe direction, safety in the "SAFE" position.
- b. Hold magazine in left hand.
- c. With right index finger press inward on the magazine catch button.
- d. Remove magazine and set aside.
- e. Pull the charging handle full travel to the rear.
- f. Depress the bottom part of the bolt catch plunger and allow the bolt carrier to move forward until it stops.
- g. Look in the ejection port window at the chamber to make sure there are no live or spent cases in the chamber.



2. Release bolt into battery position.

- a. After clearing the chamber and holding the pistol grip in right hand, switch the selector switch to the "SAFE" position.
- b. Press the upper thumb pad of the bolt catch to release the bolt carrier assembly into battery position.



3. Release bolt into battery position.

- a. On the left-hand side of the lower receiver, push the rear takedown pin to the right. (If the pin is hard to remove use a punch and gently tap with a hammer. The pin will become easier to remove over time.)



- b. From the right side of the rifle, pull the pin outward until the detent stops any additional travel. (It is best if you hold the upper and lower receivers together until you are ready to open the rifle.)
CAUTION: The upper receiver will move forward once the pin is disengaged and could pinch your fingers if you are holding the magazine well.



WARNING Do not alter any part or add or substitute parts or accessories not approved or manufactured by the ACME Machine company.

4. Removing bolt carrier assembly and charging handle.

- a. Tip the upper receiver forward on the front pivot pin to access the carrier assembly and charging handle.
- b. Unlock the charging handle by holding the handle with the index and middle fingers and pull the handle away from the rifle while compressing the charging handle latch.



- c. Pull the charging handle about halfway out and stop. The carrier assembly will follow the charging handle.



- d. Grasp the backside of the carrier assembly and remove it from upper receiver and set aside.



- e. Grasp the charging handle and pull it out until the handle stops, slide the handle down and out of the keyhole to remove.



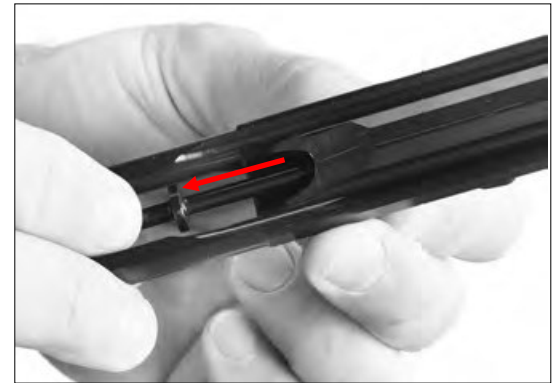
5. Bolt carrier disassembly.

- a. Once the bolt carrier is removed from the upper receiver, remove the firing pin retaining pin.



- b. Move the bolt into the locked position.

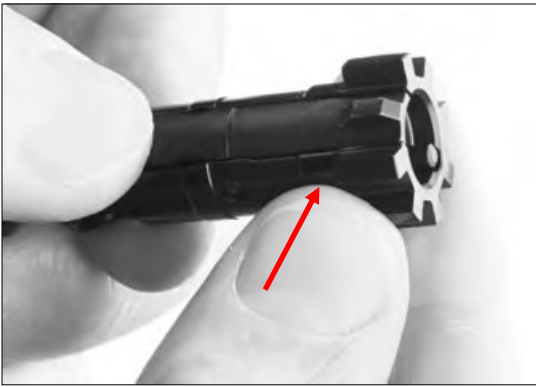
- c. Remove the firing pin from the bolt carrier.



- d. Turn the bolt cam pin clockwise a quarter turn and lift it out of the bolt carrier.

- e. Remove the bolt from the bolt carrier.



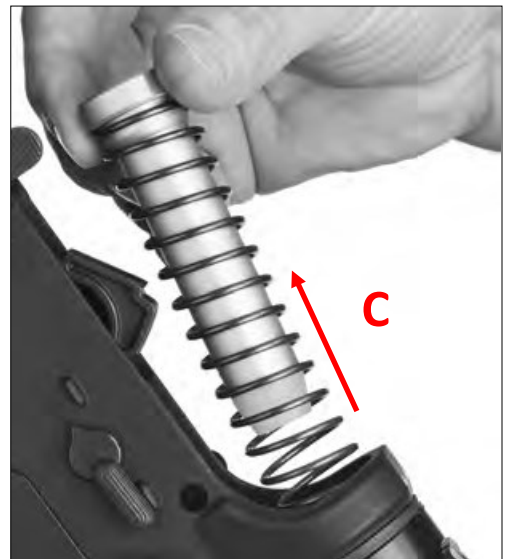


- f. Press the rear of the extractor and check for resistance. If no resistance is present, the extractor must be removed, and the parts must be cleaned.
- g. Use a small punch and remove the extractor pin.
- h. Remove the extractor



6. Buffer and Spring Field Stripping.

- a. Push the buffer towards the rear of the buffer tube.
- b. Press the buffer retainer to let the buffer out.
- c. Remove the buffer and spring.



WARNING: Do not attempt to stretch or otherwise modify the buffer spring. Functional issues can result from modifications to the buffer spring.

WARNING: Do not replace either the buffer or the buffer spring with anything but genuine ACME Machine parts. Use of other buffers or buffer springs can result in functional issues and reduced endurance life.

7. Handguard removal

Left blank, need instructions, handguard installation.

8. Removing the upper receiver from the lower receiver.

- a. With the takedown pin already disengaged, remove the upper receiver from the lower receiver by pushing the pivot pin on the left side of the lower receiver to the right. (If the pin is hard to remove, use a punch and gently tap with a hammer. The pin will become easier to remove over time.)



- d. Reach to the right-hand side of the lower receiver and pull the pivot pin to the right until the detent stops any additional travel. (It is best to hold the upper and lower receivers together until you are ready to remove the upper receiver.)



REASSEMBLING THE RIFLE

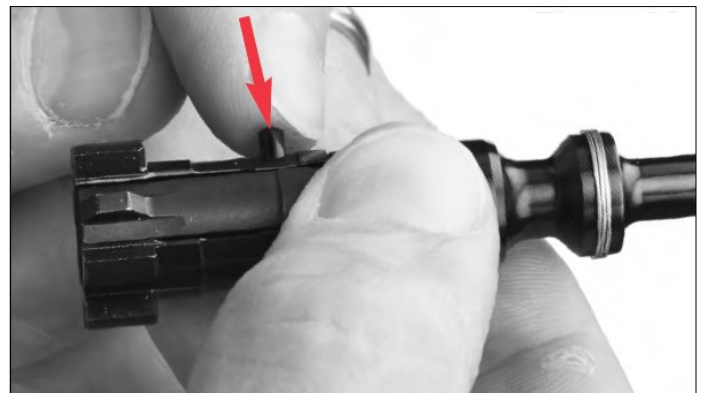
1. Bolt carrier assembly:

- a. Make sure the grooves in the gas rings are not aligned

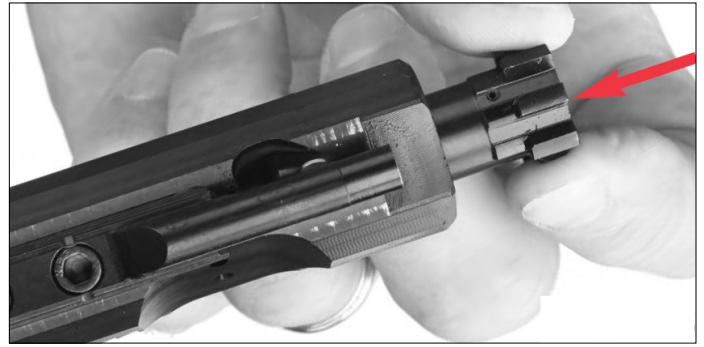
WARNING: The splits in the gas rings need to be offset in order for the ACME rifle to function properly. If the splits in the gas rings align, they will allow hot gases to flow by the gas rings, and keep the firearm from functioning properly.



- d. Make sure the extractor spring and extractor buffer spring are in place in the extractor.
- e. Place the extractor in the slot and insert the extractor pin.



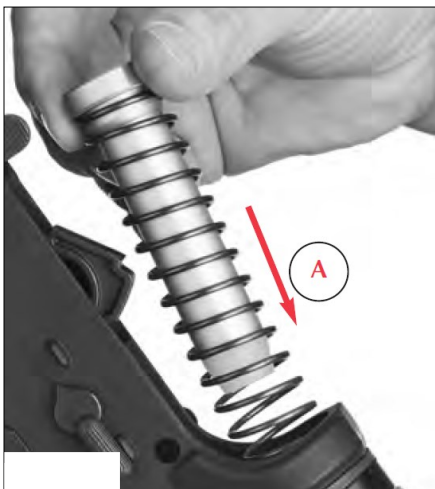
- d. Insert the bolt into the bolt carrier.
- e. Insert the cam pin and rotate a quarter turn counterclockwise
- f. Insert the firing pin



- g. Insert the firing pin retaining pin.



2. Buffer and spring assembly:



- a. Insert the spring and buffer into the buffer tube
- b. Press the buffer retainer and push the buffer toward the rear of the buffer tube.
- c. Release the buffer retainer.

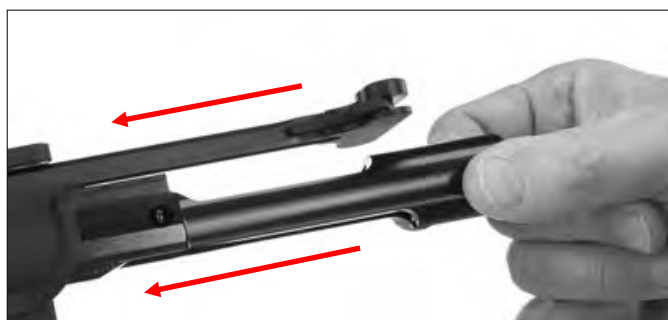


3. Reassemble the charging handle and bolt carrier into the upper receiver:

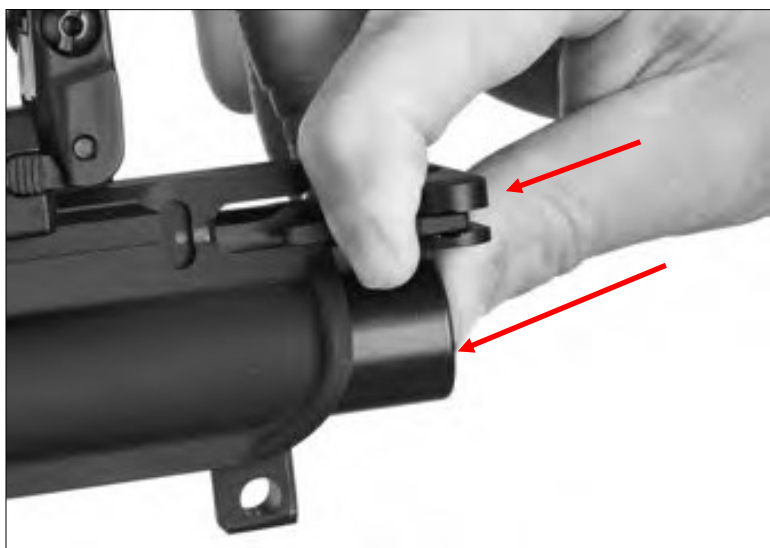
- a. Turn the upper receiver upside down so that the top of the rifle is pointing toward the ground. Install the charging handle with the pick-up lug pointing toward you.



- b. Slip the charging handle guides into the cut out in the upper receiver and leave the charging handle sticking out of the rear of the upper receiver.



- c. Turn the bolt carrier upside down and, making sure the bolt is fully forward, lay the bolt carrier on the charging handle and push both the bolt carrier and the charging handle forward until the charging handle lock engages the upper receiver. Care should be taken not to turn the upper receiver so that the bolt carrier can slide out the back of the upper receiver while the charging handle is unlocked.



- d. The bolt carrier will not fall out of the upper receiver as long as the charging handle is locked onto the upper receiver.

4. Assemble the upper receiver to the lower receiver:

- a. Make sure the hammer is cocked, place the selector on "SAFE," and make sure both the takedown pin and pivot pin are pushed completely to the right side of the lower receiver. Make sure the bolt carrier is all the way forward in the upper receiver. Put the upper receiver onto the lower receiver and slide the upper receiver all the way rearward against the threaded section of the buttstock.



- b. Push the pivot pin into the receiver until the detent locks in the hole in the pivot pin. Push the takedown pin into the receiver until the detent locks in the hole in the takedown pin.



7. Handguard assembly:

Left blank, need instructions, handguard installation.

CARE AND CLEANING

WARNING: BEFORE CLEANING, BE CERTAIN THE RIFLE AND ITS MAGAZINE CONTAIN NO CARTRIDGES.

After each shooting session, at regular intervals, or whenever the rifle has been exposed to sand, dust, extreme humidity, condensation, immersion in water or other adverse conditions; disassemble, clean and oil it. Proper periodic maintenance is essential to the reliable functioning of any firearm.

To clean the rifle, proceed as follows:

1. Disassemble (field-strip) the rifle to the extent described on pages 27 - 33. The handguard and gas block should not be removed for cleaning or maintenance. Do not disassemble the rifle any further than as described on pages 16 - 20.
2. Clean the bore with dry patches and examine. Bore fouling can contribute to reduced accuracy, and grease accumulation in the chamber can interfere with proper feeding of the cartridges from the magazine. Using a cleaning rod, run a properly sized, solvent-wetted patch through the bore several times. Then attach a solvent-wetted brush to a cleaning rod and run it back and forth the full length of the bore as many times as necessary to remove grease and dirt from the gas block bore.
3. Using powder solvent on a clean patch or bore brush, remove powder residue from all components of the mechanism. After cleaning, run a dry patch through the bore, then follow with a patch that is very lightly oiled. Wipe all surfaces clean with a cloth, then wipe all surfaces with a patch or cloth that has been very lightly oiled.
4. NOTE: Only a light application of oil is needed to provide adequate lubrication of moving parts and to prevent rust. Excess accumulation of oil tends to attract particles of dust and dirt and may congeal in cold weather which can interfere with the safe and reliable function of the rifle.

WARNING: Firing a rifle with oil, grease or any other material even partially obstructing the bore may result in damage to the rifle and serious injury or death to the shooter and those nearby. Do not spray or apply lubricants directly on ammunition. If the powder of a cartridge is affected by the lubricant, it may not be ignited, but the primer firing may push the bullet into the bore where it may be lodged. Firing a subsequent bullet into the obstructed bore may damage the rifle and cause serious injury or death to the shooter and those nearby. Use lubricants properly. You are responsible for the proper care and maintenance of your firearms.

IMPROPER LUBRICATION DESTROYS GUNS

STORING THE RIFLE

WARNING: Never store a loaded firearm. Prior to storage unload the rifle by first removing the magazine, then pull the charging handle to the rear, eject any chambered cartridge, and visually inspect the chamber. The safety should always be in the “SAFE” position when loading or unloading the rifle.

WARNING: 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.

WARNING: Use a locking device to secure the rifle for storage. Securing your rifle to prevent theft or access to the rifle from unauthorized individuals including children or mentally impaired adults is one of the largest responsibilities of firearm ownership .

WARNING: For increased safety, firearms should be stored unloaded in a location that is separate from the ammunition and inaccessible to children, mentally impaired adults and any other unauthorized person.

SERVICE AND PARTS POLICY

SHIPPING THE RFFLE FOR REPAIR

ORDERING PARTS

PARTS LIST

PARTS LIST

ILLISTRATED PARTS BREAKDOWN

ILLUSTRATED PARTS BREAKDOWN

ILLUSTRATED PARTS BREAKDOWN

ILLUSTRATED PARTS BREAKDOWN

ILLUSTRATED PARTS BREAKDOWN

THE ACME RIFLE WARRANTY