

# **OPERATION AND SAFETY MANUAL**



# **PRECISION**

**Calibers Featured Include:**

**5.56 NATO, .223 Rem., .308 Win,  
224 Valkryie**

**[www.sv-precision.com](http://www.sv-precision.com)  
253-301-7955**

# ***SERIAL NUMBER INFORMATION***

**Record the serial number of your SV Precision firearm!**

# \_\_\_\_\_

(When holding the firearm the serial number will be found on the left side of the firearm, stamped on the magazine well):

**And a description of it:**

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Make a copy of this operations manual and proof of purchase/sales record. Maintain these items in a secure safe or fireproof container. These materials will be necessary if the firearm is damaged, stolen or returned to SV Precision for warranty or repair.

Attach proof of purchase here!

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# ***WARNING***

If this firearm is carelessly or improperly handled, unintentional discharge could result and could cause personal injury, death or damage to property.

FOR YOUR SAFETY AND THE SAFETY OF OTHERS, this Operations Manual contains important instructions, warnings and safety procedures that must be understood BEFORE using your SV Precision firearm. It is imperative that you read the ENTIRE MANUAL and if you do not understand any part of it or the operation of your SV Precision firearm, you should seek professional firearms instruction.



## **WARNING**

Children are attracted to and can operate firearms that can cause severe injuries or death. 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**

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 una 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 enviarle a la cárcel.

# ***NOTICE***

SV PRECISION shall not be responsible for personal injury, death or damage to property resulting from either intentional or accidental discharge of this firearm, or from its function when used for purposes or subjected to treatment for which it was not designed. SV PRECISION will not honor claims involving this firearm which result from careless or improper handling, unauthorized adjustment or parts replacement, corrosion, neglect, or the use of wrong caliber ammunition, other than original high quality commercially manufactured ammunition in good condition, or any combination thereof. SV PRECISION will not honor claims involving this firearm for any reason or cause when the second or subsequent owner makes such claims.

Before the rifle left the factory, this firearm was tested, carefully inspected and packaged. SV PRECISION cannot control product handling after it leaves the factory; therefore please examine this firearm carefully at the time of purchase to ensure that it is unloaded and undamaged.

## ***GENERAL HANDLING CAUTIONS***

1. Do NOT alter or modify your SV Precision firearm, and have it serviced regularly!
2. Always handle your firearm as if loaded.
3. Never point your firearm at anything you don't intend to shoot.
4. Always make sure your firearm is not loaded and the bolt is latched open and to the rear before laying it down or handing it to someone else.
5. Never leave a loaded firearm unattended.
6. Always be sure bore, muzzle, chamber and action are clear of obstruction.
7. Always check that ammunition is clean and undamaged.
8. Never drink alcoholic beverages or take drugs before or during shooting.
9. Always wear eye and ear protection when shooting.
10. Always keep safety on "SAFE" when firearm is loaded and a round is chambered until ready to shoot.
11. Never attempt to fire if water is in the bore.
12. Never indulge in "horseplay" when holding your firearm.

## ***DANGEROUS PROCEDURES***

1. Be sure the cam pin is installed in the bolt group. If it isn't, your rifle can still fire but it could possibly explode, causing you, personal injury or harm. **(Applies to all SV Precision AR style rifles and complete uppers)**
2. DO NOT exchange or switch bolt assemblies from one rifle to another, it could cause personal injury to you and others and damages to your rifle.
3. If your firearm fails to fire, hold it, keep it pointed towards the target and wait 30 seconds. If a hangfire has occurred, the round will fire within 30 seconds. If the round does not fire, remove magazine, eject round and examine the primer. If firing pin indent is light, misaligned or non-existent, have your firearm examined by a competent gunsmith. If firing pin indent on primer appears normal (in comparison to previously fired rounds) assume faulty ammunition; appropriately dispose of misfired round from other live ammunition; reload and resume firing.

## ***USE OF SAFETY SELECTOR***

A selector lever, located on the left of lower receiver, has two positions, "FIRE" and "SAFE". When set to "FIRE" the firearm will fire a single shot each time the trigger is squeezed. When set to "SAFE" a cam bears upon the rear of the trigger, blocking movements and preventing the hammer from being released.



### ***“SAFE”***

Rifle will not fire. Selector lever cannot be on safe unless rifle is cocked. Always place on SAFE when loading and unloading.



### ***“FIRE”***

Rifle will fire one round each time the trigger is pulled.

## ***FUNCTION CHECK***

**SAFE Note:** Remove magazine and make sure your rifle is unloaded and there is **no ammunition in the chamber**. Point in safe direction. Pull charging handle to rear and release. Place on safe. Pull trigger. Hammer should not fall.

**FIRE Note:** Remove magazine and make sure your rifle is unloaded and there is **no ammunition in the chamber**. Point in safe direction. Place selector on fire. Pull trigger and hold to rear. Hammer should fall. Pull charging handle to rear and release. Release trigger and pull again. Hammer should fall.

## ***SAFETY FEATURES***

### ***Disconnecter***

The disconnecter, a part of the firing mechanism, prevents the firearm from firing full automatic. As the hammer is cocked after each shot the disconnecter holds the hammer until the trigger is released. When the trigger is released, retention of hammer passes from disconnecter to trigger ready for the next shot.

### ***Firing Pin Collar***

The bolt carrier assembly, located within the upper receiver, is designed to prevent the firing pin from striking a cartridge until the bolt is locked to the barrel.

**The following sections contain caliber specific information. Please open to the section relevant to your particular rifle's caliber. If you are unsure of the caliber of the rifle, the caliber marking can be found on the barrel of the rifle, immediately in front of the gas block on the bottom of the barrel.**

***Everyone should read page 36 for additional information pertaining to the Lifetime Warranty and returns!***

# **5.56 NATO, .223 Rem, .308 Win and .224 Valkryie**

*Includes the Following AR Style Rifles:*

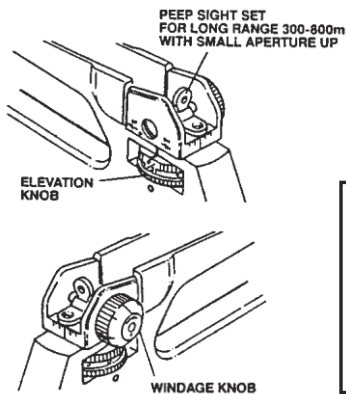
**TPR-2**

**TPR-3**

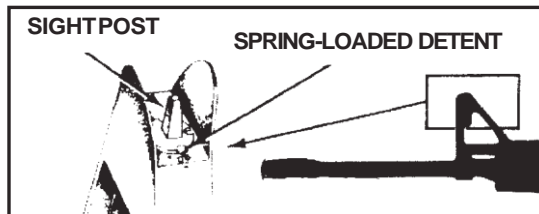


# SIGHTS

1. Rear sight can be adjusted for both windage and elevation and has a dual aperture peep sight, one for short range and one for long range.
2. When flipped forward, the aperture is marked O-2 for zero to 200 meters. When using this setting the elevation knob should be set at 8/3 low or 6/3 for detachable carry handle or flat top rear sights and at its lowest position.
3. When the aperture is flipped back, it is set for using the long range sight. When using this setting you can adjust the elevation knob for range required: 8/3 low for 300 m, 4 for 400m, 5 for 500m, 6 for 600m, 7 for 700m, and 8/3 high for 800m. There are click settings in between for fine tuning.
4. The windage knob is located on the right side of the rear sight. To adjust for horizontal movement on target, turn knob clockwise for right and counter-clockwise for left.
5. The front sight is adjustable for elevation zeroing only, it is not used at any other time in firing.



**FRONT SIGHT** - To adjust elevation, depress detent, rotate post. To raise strike of bullet, rotate post in the direction of arrow marked up. Reverse the direction of rotation to lower strike of bullet. Each graduation (notch) moves the point of impact of bullet as indicated in chart.



## ZEROING SIGHTS

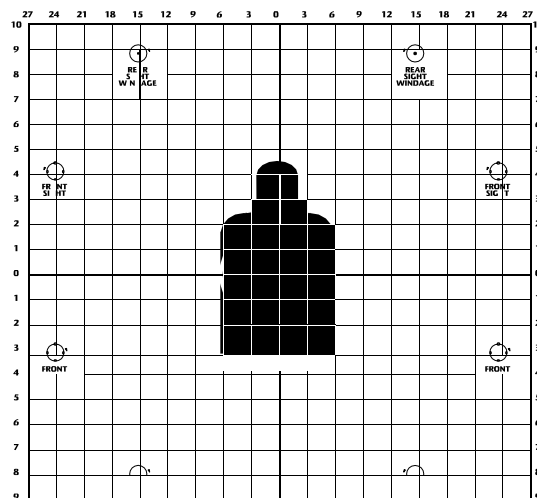
This procedure is for .223 ammunition. The procedure described is for zeroing at 25 meters but may be adjusted accordingly for longer ranges. The following table shows change of impact per click at specific range.

Windage:

25 m	3/8 in.
100m	1 3/8 in.
200m	2 3/8 in.

Elevation:

25 m	1/8 in.
100m	1/2 in.
200m	1 in.
300m	1 1/2 in.
400m	2 in.
500m	2 1/2 in.
600m	3 in.
700m	3 1/2 in.
800m	4 in.



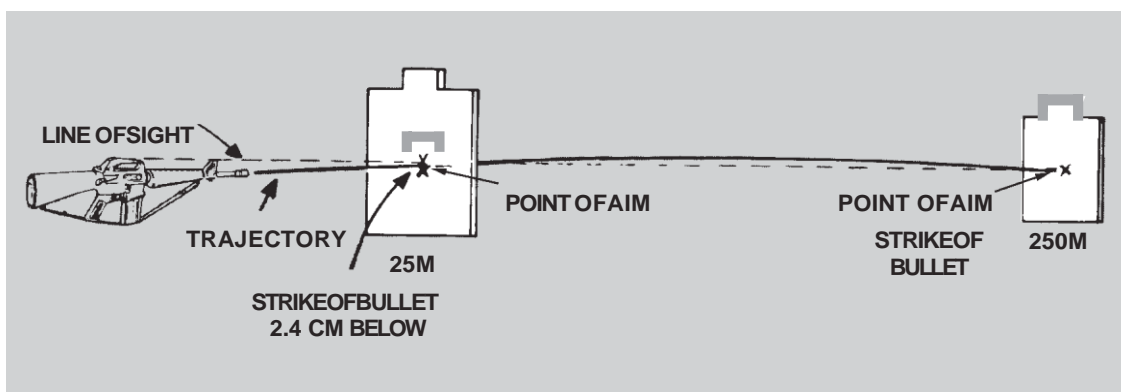


## ***ZEROING SIGHTS***

1. Set elevation to 8/3 low or 6/3 for detachable carry handle and flat top rear sights, then raise it one click. No further adjustment should be made during zeroing.
2. Flip aperture to small long range sight.
3. Set aperture to mechanical zero by adjusting windage until sight is aligned with center line on scale under sight.
4. Carefully aim and fire at bull's-eye on target at 25 meters: Fire ten rounds to establish a group.
5. Compare group with bull's-eye, if they match, no further adjustment is necessary.
6. If group does not match bull's-eye, measure vertical and horizontal distance from bull's eye.
7. Calculate clicks of windage required to move impact appropriate distance. Turn windage knob accordingly. (see chart on page 8 for 25m windage clicks)
8. Calculate clicks of front sight required to raise or lower impact appropriate distance. (1 click = 3/8 in. at 25 m)
9. Depress plunger and front sight required number of clicks. Clockwise will lower sight and raise impact, and counter-clockwise will raise sight and lower impact.
10. Repeat steps 4 through 9 until impact matches bull's-eye. Your sight is now zeroed.
11. Set elevation knob back to 8/3 or 6/3 low and flip aperture back to 0-2 for ranges of 0-200m.

## ***BATTLESIGHT ZERO***

TO ZERO THE RIFLE, YOU MUST HAVE THE FRONT SIGHT (ELEVATION) AND THE REAR SIGHT (WINDAGE) ADJUSTED SO THAT IT CAN HIT YOUR POINT OF AIM AT A GIVEN RANGE.



### **NOTE:**

To battle-sight zero your rifle, you adjust your sights so you can hit an aiming point at 250 meters. Zeroing can also be accomplished on a 25 meter range by adjusting the sights so that the bullet will strike 2.4 centimeters below the point of aim.

# ***MOUNTING OPTICS***

SV Precision AR style rifles feature a Lo-Pro style upper receiver. These rifles have a Mil-Std-1913 Picatinny Rail on the top of the receiver.

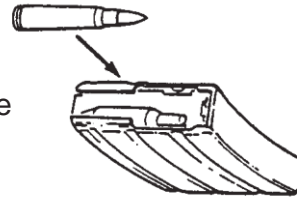
This will accept Weaver based rings and mounts. Standard size rings and mounts will be sufficient for scopes with objective diameters less than 58mm. Certain diameter scopes, depending on the size of the objective lens, may need either a riser, high rings, or mount.

# LOADING

**CAUTION:** Always check that ammunition is clean and undamaged before using the forward assist. Forcing damaged ammunition into the chamber could result in personal injury or death to you and others and damage your rifle and property. The use of reloaded, hand-loaded or high pressure ammunition can be dangerous and will void the warranty.

## *To load a magazine...*

1. Use only ammunition for which your firearm is chambered.
2. With front of magazine forward, place a round between the lips of the magazine with the bullet forward. Press the round down until it is retained by the magazine lips. Place the next round on top of the last and repeat until desired number is loaded.



Make sure the rifle is pointed in a safe direction and the safety is engaged at all times while loading the rifle.  
**NEVER** allow your fingers or other objects to contact the trigger while loading or unloading the rifle.  
Do **NOT** disengage the safety until you are ready to fire and have the rifle pointed safely downrange.

## *To load the rifle...*

1. Press in on bottom of bolt catch while pulling back on charging handle, to cock the hammer and leave the bolt and carrier to the rear.
2. Return the charging handle to fully forward until it locks and remove finger from bolt catch.
3. Set selector to "SAFE" position.
4. With the bullets pointing forward, insert loaded magazine into magazine well and push it in until it stops and is retained by magazine catch.
5. With the rifle pointed in a safe direction press in on top of bolt catch. This will release the bolt and carrier and move a round into chamber. The rifle is now loaded with a round in the chamber and the hammer cocked.
6. You may now close the ejection port cover if you wish; it is located on the right side of the upper receiver and will open automatically when the first round is fired.

## *To Unload the Rifle...*

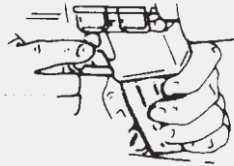
1. Set selector to "SAFE" position.
2. Press magazine catch button and remove magazine.
3. Pull charging handle to rear and push in lower portion of bolt catch. If a round had been in the chamber it should have been ejected. If last round in magazine had been fired and if the magazine was in place, bolt and carrier should already be held to the rear.

## CLEAR YOUR RIFLE

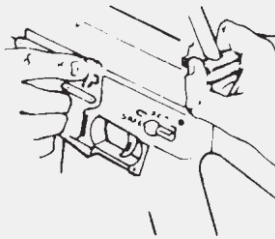
1. Place selector on SAFE. If weapon is not cocked, lever cannot be pointed toward SAFE.



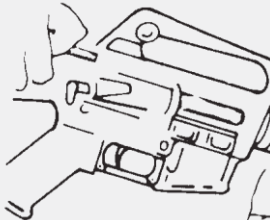
2. Remove magazine



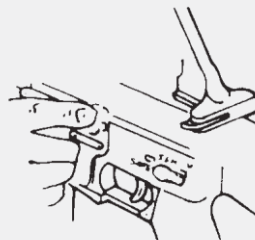
3. To lock bolt open, pull charging handle rearward, press bottom of bolt catch & allow bolt to move forward until it engages bolt catch. Return charging handle to forward. If you haven't before, place on SAFE.



4. Eyeball receiver and chamber to ensure these areas contain no ammo.



5. With selector lever pointing toward SAFE, allow bolt to go forward by pressing upper portion of bolt catch



Before firing your rifle, practice your stance, aim, rhythm and breathing for steady aim with your firearm unloaded. Practice firing on a range before going hunting or using your firearm for any other type of shooting.

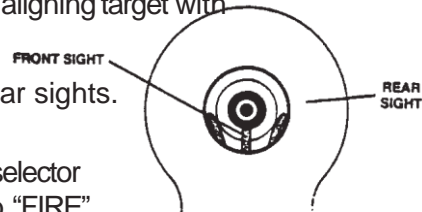
## FIRING

**NEVER** load a cartridge into the chamber until you are ready to fire the rifle.

Do **NOT** disengage the safety until the rifle is pointed in a safe direction and you are ready to fire.

### To Fire...

1. Always wear ear and eye protection when firing your weapon.
2. Load firearm as previously described.
3. Set rear sight to range required.
4. Grasp firearm with one hand on hand guard and other hand on pistol grip with trigger finger resting alongside of trigger guard. Raise firearm and pull buttstock firmly into shoulder.
5. Aim by aligning target with front and rear sights.
6. Move selector lever to "FIRE".
7. Keeping steady aim, place trigger finger on trigger and squeeze gently until trigger releases hammer. Do not jerk the trigger as you will disturb your aim and ruin your accuracy. To fire the next round and subsequent rounds, all that is necessary is release the trigger and squeeze-it again after every shot until you are finished or the magazine is emptied.
8. This is a semi-automatic firearm and is immediately loaded and ready to fire after each shot until magazine is empty.
9. Release trigger, remove finger from trigger, and set selector lever to "SAFE". If you have fired the last round from magazine, the bolt and carrier will be held to the rear so that you can quickly reload by replacing the magazine or the chamber can be checked to ensure it is empty.

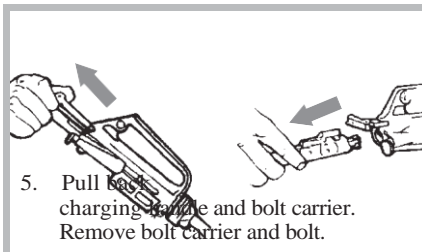
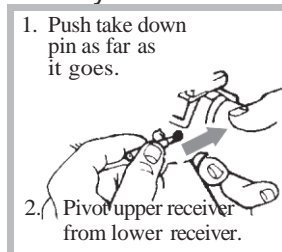
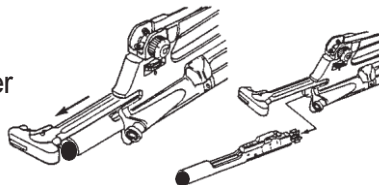


# MAINTENANCE

Your SV PRECISION rifle is based on military rifle design and is very rugged but proper maintenance is necessary to keep it in good working condition.

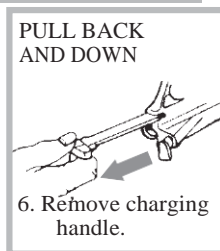
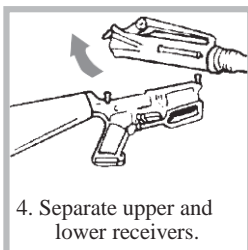
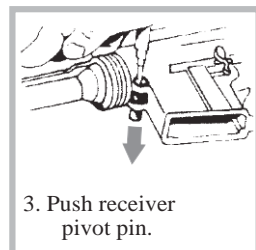
## Field Stripping/ Disassembly

1. Press take down pin in from left of lower receiver (it may be necessary to use a punch as the fit between upper and lower may be very tight). Pull it out the right side until it comes to a positive stop.
2. Pivot lower receiver down and away from upper portion of receiver.
3. Press front pivot pin in from left side of lower receiver and pull out right side until it comes to a positive stop.
4. You can now separate the upper and lower receivers.
5. Pull charging handle to rear and remove bolt and carrier assembly.
6. Remove charging handle by pulling it backwards to key way and down out of receiver.



Push in firing pin retaining pin right-to-left of bolt carrier and remove it by pulling it out to the left.

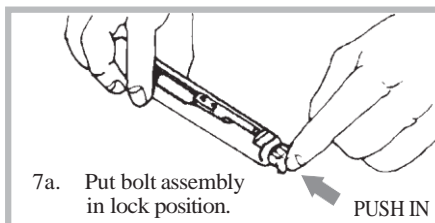
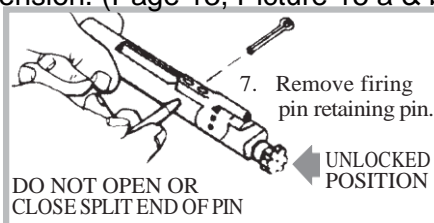
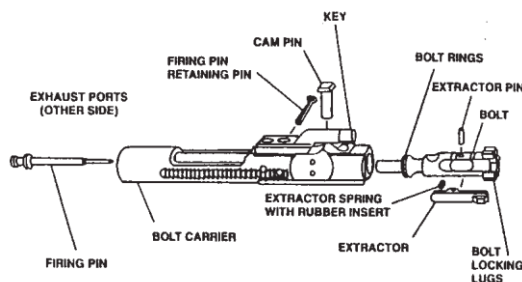
7. Tilt bolt face up and remove firing pin. (Page 13, Picture 8)



8. Push bolt in towards the carrier until it rotates and comes to a stop, then turn cam pin 90°. (Page 9)

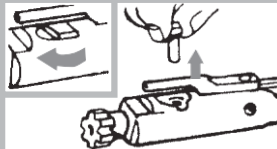
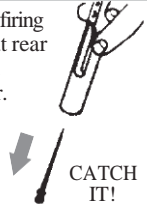
9. Remove cam pin by lifting it out away from bolt and carrier.

11. Pull bolt forward out of carrier. (Page 13, Picture 11)
12. Depress buffer, maintaining pressure as buffer is under spring tensions, to prevent it from being ejected when buffer retainer is depressed. Depress buffer retainer to permit buffer and spring to move forward. Then depress hammer to allow the buffer and spring to continue to move forward and be removed from receiver extension. (Page 13, Picture 15 a & b).



# MAINTENANCE

8. Drop firing pin out rear of bolt carrier.

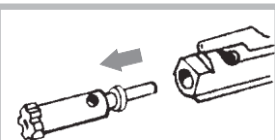


9. Remove bolt cam pin.

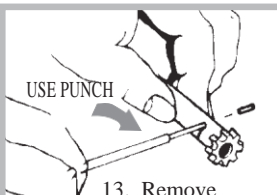
13. With a punch, remove the extractor pin from the bolt assembly.

14. Remove the extractor and spring. DO NOT remove the spring from extractor.

15. Press top of extractor spring rubber tip to test spring function.



11. Remove bolt assembly from carrier

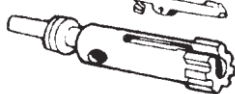


13. Remove extractor pin

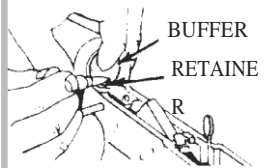


FURTHER DISASSEMBLY SHOULD ONLY BE PERFORMED BY THE FACTORY (SV PRECISION)

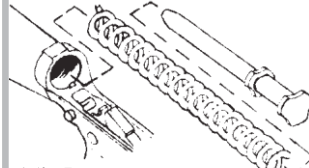
DON'T SEPARATE SPRING FROM EXTRACTOR



14. Remove extractor and spring.



15a. Press in buffer, depress retainer and release buffer



15b. Remove buffer and spring

## Notes on the .308 and 6.5 Creedmoor Rifles

The .308 and 6.5 Creedmoor does use a different buffer and spring than the 5.56/.223 SV Precision rifles even though it takes the same SVP Rifles A2 stock.

**NOTE:** Do not strip your firearm further than previously described. If additional maintenance is necessary consult a competent gunsmith.

*Your rifle is now field stripped for cleaning.  
To reassemble repeat procedure in reverse order.*

# THOROUGH CLEANING

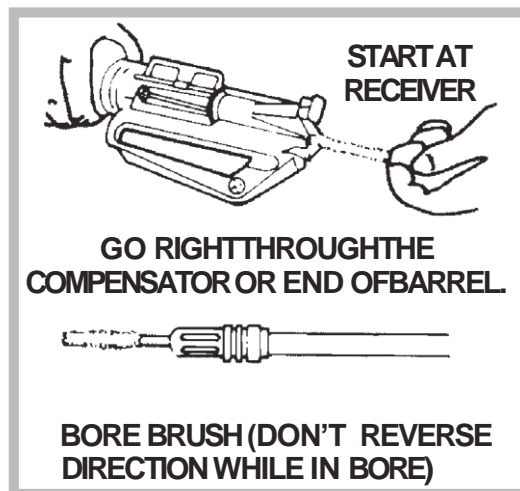
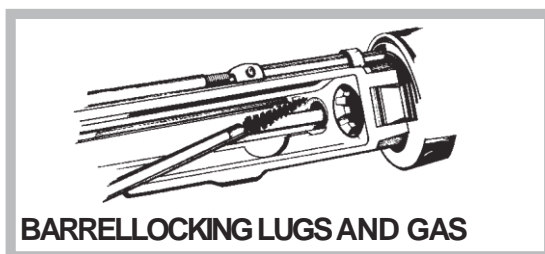
## Upper receiver

Be sure to clean & inspect:

### CLEAN WITH RBC (Rifle Bore Cleaner)

- All areas for powder fouling, corrosion, dirt and rust
- Bore & chamber
- Locking lugs
- Gas tube

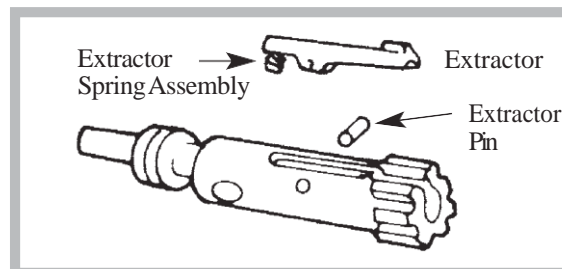
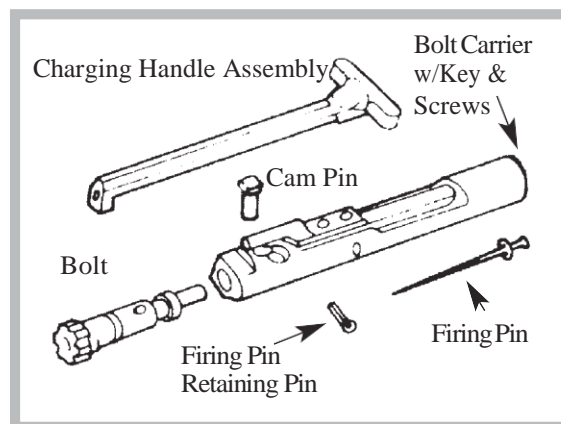
Use a worn bore brush to get outside surface of protruding gas tube (get sides and bottom from bottom of receiver)



## Bolt carrier group

Be sure to include:

- Outer & inner surfaces of bolt carrier
- Carrier key
- Firing pin recess and firing pin
- Firing pin hole (Use pipe cleaner there)



- Carbon deposits & dirt from locking lugs
- Areas behind bolt ring and under lip of extractor



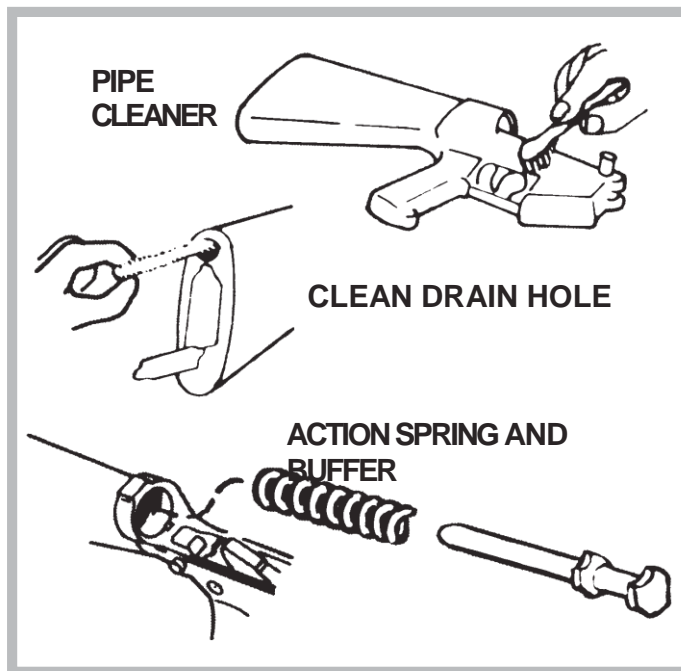
# ***THOROUGH CLEANING***

## ***Lower receiver group***

- Clean areas of powder fouling, corrosion and dirt
- Wipe dirt from trigger mechanism
- Clean buffer and inside lower receiver extension

### **CAUTION**

Do not use wire brush or any type of abrasive material to clean aluminum surfaces.



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***1. CLEAN...***

***2. INSPECT...***

***3. LUBE...***

If any parts are missing or defective, contact SV PRECISION.



## ***LUBRICATING GUIDE***

**Lightly Lube** - A film of oil barely visible to the eye.

**Generously Lube** - Heavy enough so that it can be spread with the finger.

**Remember to remove excessive oil from the bore before firing.**

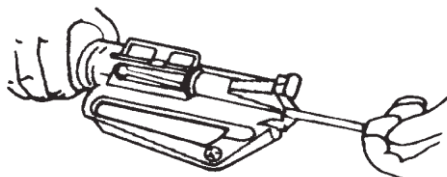
## ***LUBRICATING***

### ***Upper Receiver***

#### **LIGHTLY LUBE:**

BORE & CHAMBER, OUTER SURFACES OF BARREL AND FRONT SIGHT, SURFACES UNDER HANDGUARD, DEPRESS FRONT SIGHT DETENT SEVERAL TIMES TO WORK LUBE INTO THE SPRING.

**START AT RECEIVER**



**GO RIGHT THROUGH THE COMPENSATOR**

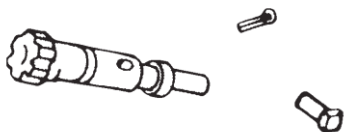


**(DON'T REVERSE DIRECTIONS IN BORE)**

### ***Bolt Carrier Group***

**GENEROUSLY LUBE OUTSIDE OF THESE PARTS**

MAKE CERTAIN TO GET CAM PIN AREA, PISTON RINGS, AND OUT-SIDE OF THE BOLT BODY.



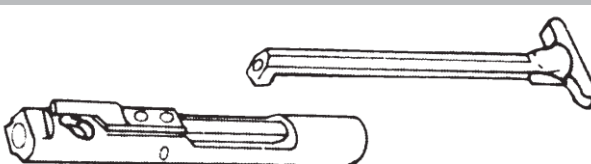
#### **CAUTION**

Lightly lube firing pin and firing pin recess in bolt.

**DRY WITH PIPECLEANER, THEN PLACE ONE DROP OIL**



**CARRIER KEY**



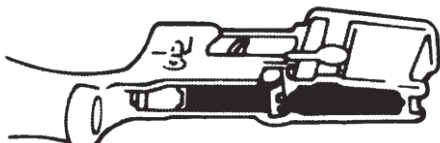
**LIGHTLY LUBE** CHARGING HANDLE, INNER AND OUTER SURFACES OF BOLT CARRIER. **GENEROUSLY LUBE** SLIDE AND CAM PIN AREA OF BOLT.

# LUBRICATING

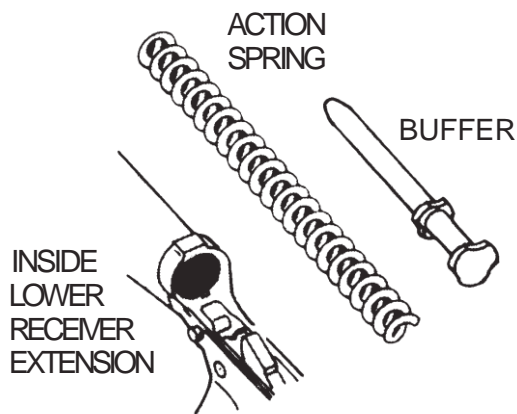
## Lower Receiver Group

### GENEROUSLY LUBE

TAKE DOWN AND PIVOT PINS



INSIDE PARTS LOWER RECEIVER

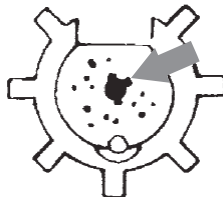


## INSPECT - before assembly

**WARNING** DO NOT interchange bolts between rifles



**BOLT** - Cracks or fractures, especially in the cam pin hole area. Bolts that contain pits extending into the firing pin hole need replacing.



**FIRING PIN RETAINING PIN** - Replace if bent, broken, or badly worn.



**CAM PIN** - Replace if cracked, chipped or missing.



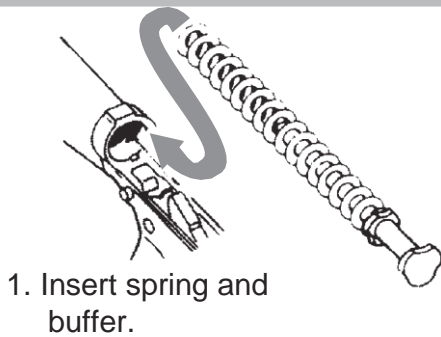
**FIRING PIN** - Replace if it has a bent, cracked or blunted end.



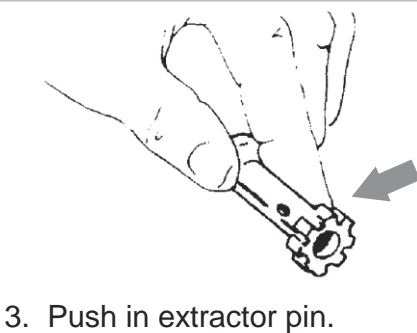
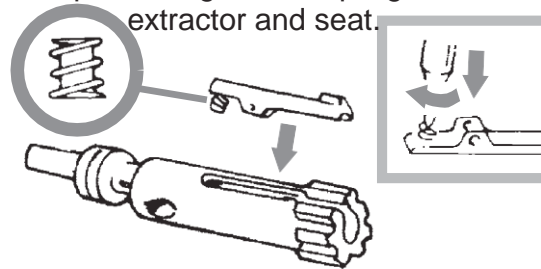
**IF PARTS ARE MISSING OR DEFECTIVE, CONTACT SV PRECISION.**

**EXTRACTOR AND EXTRACTOR SPRING**  
Check extractor for chipped or broken edges in the area of the lip that engages the cartridge rim.

# ASSEMBLY

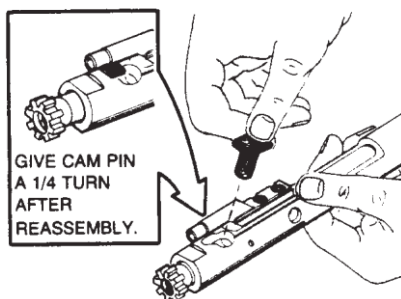
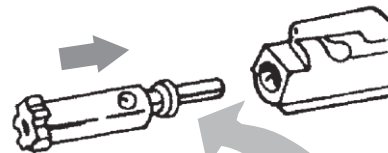


New extractor has a silicone insert w/spring. Be sure not to lose it. If the spring comes loose, put the large end of spring in the extractor and seat.



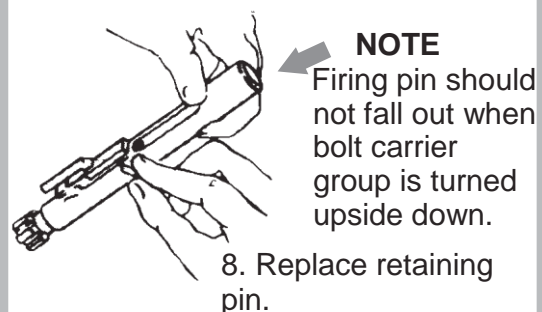
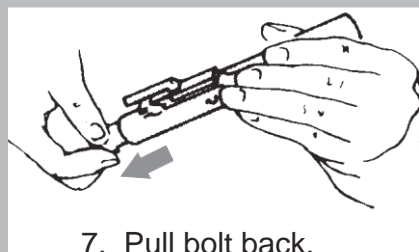
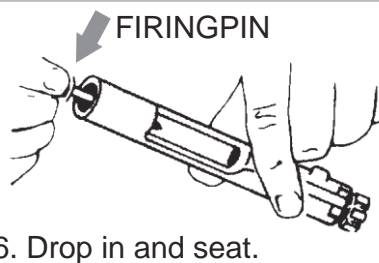
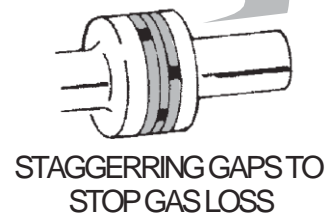
## WARNING

Don't switch bolts between rifles.

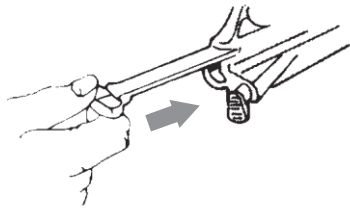


## WARNING

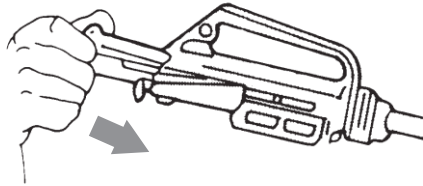
Be sure that the cam pin is installed in the bolt group. If it isn't, your rifle can still fire and will explode.



# ASSEMBLY

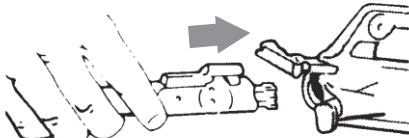


9. Engage, then push charging handle part way.

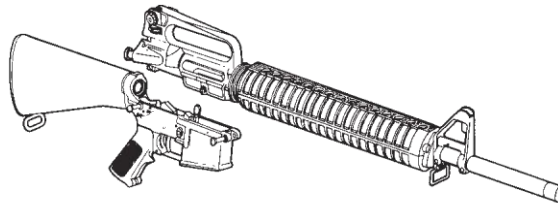


11. Push in charging handle and bolt carrier group together.

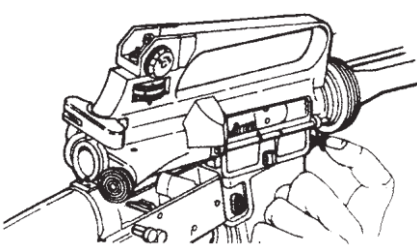
BE SURE BOLT IS  
STILL UNLOCKED



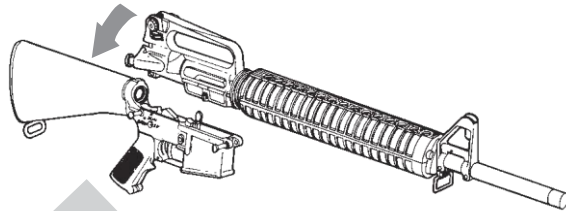
10. Slide in bolt carrier group.



12. Join upper and lower receivers.



13. Engage receiver pivot pin.



14. Close upper and lower receiver groups. Push in takedown pin.

CHECK THE *selector lever*  
BY PERFORMING THE  
**FUNCTIONAL CHECK**  
SEE PAGE 6.

## CAUTION

Selector lever must be on  
safe before closing  
upper receiver.

FIRE



**IS EVERYTHING  
INSTALLED?**

# ***PROJECTILE LODGED IN BORE***

## **WARNING**

If an audible “POP” or reduced RECOIL is experienced during firing, immediately CEASE FIRE, remove the magazine (1), lock the bolt to the rear (2), and place the selector lever on the “SAFE” position (3). Visually inspect and/or insert a cleaning rod into the bore to ensure there is not a projectile lodged in the bore (4).

1E

***DO NOT APPLY IMMEDIATE ACTION.***



If a projectile is lodged in the barrel of the weapon, DO NOT attempt to remove it. Contact SV PRECISION.

# ***UNUSUAL CONDITIONS***

## **Extreme Cold-**

- a. Clean and lubricate rifle using a gun lubricant. (FrogLube Extreme, Liberal Tears, etc.) Keep it moisture free.
- b. Operate controls through their entire range, at intervals, to keep them from freezing up.
- c. When your rifle is not being used and kept outside, protect it with a cover.

## **Hot Climates-**

- a. Inspect rifle more frequently, especially the hidden surfaces of the bolt assembly, and lower receiver components. Make certain they are lubricated with a gun lubricant.
- b. When handling, make certain to wipe dry, as moisture could cause corrosion. After drying, lubricate with gun lubricant.

## **Hot, Dry Climates-**

- a. Clean and oil rifle more frequently with a gun lubricant.

## **Dusty and Sandy Areas-**

- a. Clean and lubricate your rifle more frequently.
- b. Keep sand out of parts when inspecting, lubricating, or assembling rifle. Apply only a very light amount of lubrication on outside of rifle. Using too much lubricant can attract dust and sand.

# ***TROUBLESHOOTING***

<b>Problem</b>	<b>Check for</b>	<b>What to Do</b>
<b>Won't Fire</b>	Selector lever on SAFE	Put on FIRE
	Improper assembly of firing pin	Assemble correctly
	Too much oil in firing pin recess	Wipe off
	Defective ammo	Remove & discard
	Too much carbon on firing pin	Clean
<b>Bolt Won't Unlock</b>	Dirty	Clean
<b>Won't Extract</b>	Broken extractor spring	Contact SVPRECISION
	Dirty or corroded ammo	Remove. Push stuck round with cleaning rod. Be careful not to damage rifling. If possible, use a plastic rod.
	Carbon in chamber -	Clean chamber
	Fouling or carbon in extractor recess or lip.	

# TROUBLESHOOTING

Problem	Check For	What To Do
<b>Won't Feed</b>	Dirty or corroded ammo	Clean
	Dirty magazine	Clean
	Defective magazine	Replace
	Too many rounds in magazine	Take out excess
	Restricted buffer assembly action	Take out buffer and spring, clean
	Magazine not fully seated	Adjust magazine catch.
<i>(Press button on right side. Turn catch clockwise to tighten and counterclockwise to loosen.)</i>		
<b>Won't Chamber</b>	Dirty or corroded ammo	Replace ammo
	Damaged ammo	Replace
	Carbon in chamber	Clean
<b>Won't Lock</b>	Dirt, corrosion or carbon buildup in barrel locking lugs	Clean lugs
	Frozen extractor	Remove and clean
	Restricted buffer assembly	Remove and clean
	Restricted movement of bolt	Remove, clean, lube carrier group.
	<i>(When putting bolt back in, make sure gas tube fits into carrier key and moves freely).</i>	
<b>Double Feed</b>	Defective magazine	Replace
<b>Short Recoil</b>	Gaps in bolt rings (not staggered)	Stagger ring gaps
	Carbon or dirt in carrier key or on outside of gas tube	Clean
<b>Bolt Fails to Lock After Last Round</b>	Dirty or corroded bolt catch	Clean
	Faulty magazine	Replace
<b>Selector Lever Binds</b>	Needs oil	Lubricate with a gun lubricant
<b>Bolt Carrier "Hung Up"</b>	Round jammed between bolt and charging handle	
1. Remove magazine charging handle		
2. Hold charging handle back and bang rifle butt on ground.		
KEEP CLEAR OF MUZZLE! Caution: After round is removed, bolt is under tension.		
3. While bolt is held to rear, push charging handle forward. Round should fall through magazine well.		

## ***LIFETIME WARRANTY***

At SV Precision, we take pride in our craftsmanship and in our products. Because of these ideals, we offer a LIFETIME WARRANTY against manufacturing and product defects on all SV Precision custom rifles we offer. We will repair or replace your firearm if it becomes damaged or defective at no charge to you. If we cannot repair your product, we will replace it with a comparable current product. Our lifetime warranty is fully transferable, so even if you purchased the custom rifles second hand, we will still stand behind our product.

We do not warranty normal product wear from continuous use.

We do not cover cosmetic damage such as scratches, dents and/or color fading.

If the firearm has been modified by the user in a manner that causes failure, we may at our discretion, void warranty on that part of the rifle.

If at any time you have questions or concerns about your SV Precision custom rifle, please do not hesitate to contact us.

SV Precision

Melrose, FL

253-301-7955

## ***WARNING - Alterations & Modifications***

Altering or modifying parts is dangerous and may void the warranty. This SV Precision rifle was manufactured to perform properly with the original parts as designed. It is your duty to make sure any parts you buy are made for this rifle and are installed correctly and that neither the replacements nor originals are altered or changed. Your SV Precision rifle is a complex precision tool with many parts that must relate correctly to other parts in order for proper and safe operation. Putting a rifle together wrong or with incorrect or modified parts can result in a damaged rifle, serious personal injury or death to you and others through malfunction. Always have a qualified gunsmith work on your rifle or at least check any work not performed by a gunsmith.

**NOTE:** It is illegal to ship a firearm with ammunition in the firearm or in the same packaging. Firearms and ammunition must be shipped separately. For more information about shipping, call SV Precision at 253-301-7955.

## ***AMMUNITION***

SV PRECISION recommends the use of high quality, domestically produced ammunition for best results and highest accuracy. For plinking and practice, we recommend only domestic, commercially manufactured ammunition or high quality surplus NATO specification ammunition. **Please note that the use of improperly re-loaded ammunition may void the factory warranty.**

Your rifle is an investment and it only makes sense to choose quality ammunition for a quality rifle!



**SV PRECISION offers a variety of  
AR Rifles, Parts, and Accessories**

**Call for information or visit us online at  
[www.sv-precision.com](http://www.sv-precision.com)**

**THANK YOU FOR  
CHOOSING  
SV PRECISION!**

