



ARMALITE®, INC
OWNER'S MANUAL
FOR

ARMALITE® AR-50A1™



⚠ READ THIS MANUAL THOROUGHLY, PARTICULARLY THE WARNINGS, BEFORE USING THIS FIREARM! IT'S IMPORTANT!

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P/N: MANUAL AR50A1

ArmaLite®, Inc.
P.O. Box 299
Geneseo, Illinois, USA 61254
1-800-336-0184
www.ArmaLite.com



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1. READ THIS FIRST!

Throughout this manual you will find **WARNINGS** and/or **CAUTIONS** printed in bold print. All **WARNINGS** and **CAUTIONS** should be read carefully and followed completely.

WARNINGS discuss issues that could result in damage to your firearm, or injury or death to you or a bystander. **CAUTIONS** discuss issues that could result in damage or malfunction of your firearm.



WARNING: IT IS YOUR RESPONSIBILITY TO ASSURE THAT YOUR FIREARM IS HANDLED, FIRED, AND STORED SAFELY AND RESPONSIBLY AT ALL TIMES.

This manual provides instructions on the operation and maintenance of your ArmaLite® firearm. Read and understand it carefully before you try to use your firearm. Your safety, and that of those around you, depends on your knowledge of your firearm and on your knowledge of safety rules common to all firearms. Please study the common-sense safety rules noted in this manual. Your first responsibility as a gun owner is always safety!

Your second responsibility as a gun owner is security. Make sure that your firearm remains in responsible hands...YOURS! Don't become an unwitting partner in a crime or tragedy: make sure your firearm is properly secured. Lock it in a secure storage container or, if none is available, remove the bolt assembly and store it separately. If you have more than one AR-50™, make sure that you have identified the bolts because the bolts are NOT interchangeable. The last three digits of the rifle's serial number are inscribed on the bolt.

It is also your responsibility to assure that you comply with all federal, state, and local laws with regard to the purchase, ownership, use, and storage of your firearm.

NOTICE: THIS MANUAL MAY COVER NUMEROUS MODELS AND/OR CALIBERS OF OUR FIREARMS. THE TEXT, PICTURES, AND EXPLODED VIEWS DO NOT NECESSARILY DEPICT ALL MODEL VARIATIONS. YOU MAY NEED TO CONTACT US FOR INFORMATION ON PARTS THAT ARE UNIQUE TO YOUR MODEL.

NOTICE

ArmaLite® has no control over the use of your firearm, and shall not be responsible for injury, death, or damage to property resulting from either intentional or accidental discharge of this firearm. In addition, ArmaLite® shall not be responsible for proper function of the firearm when it is used for purposes or subjected to treatment for which it was not intended. ArmaLite® will not honor claims which may result from careless or improper handling, unauthorized adjustments or parts replacement, corrosion, neglect, use of the wrong type or caliber of ammunition, or the use of ammunition other than original, high quality commercially manufactured ammunition in good condition or any combination thereof.

2. SAFETY FIRST! IT'S YOUR RESPONSIBILITY!

- * Treat every firearm as if it is loaded ...AT ALL TIMES!**
- * Always keep the muzzle pointed in a safe direction.**
- * Never point your firearm at anything that you do not intend to shoot.**
- * Keep your finger off the trigger and out of the triggerguard until you are aiming at your target and ready to shoot.**
- * Always keep the safety in the "SAFE" position, especially when the firearm is loaded and cocked, until you are ready to fire.**
- * Always keep and carry your firearm with an empty chamber until you intend to shoot, so that your firearm cannot be fired unintentionally. Firearms should be unloaded when not actually in use.**
- * Be sure of your target and backstop before you shoot. Ask yourself what your bullet will hit if it misses or goes through the target.**
- * Never shoot at hard, flat surfaces or water...bullets can ricochet.**
- * Always wear hearing and eye protection when shooting.**
- * Discharging firearms in poorly ventilated areas, cleaning firearms, or handling ammunition may result in exposure to lead, a substance known to be associated with birth defects, reproductive harm, and other serious injury. Have adequate ventilation at all times and wash hands after handling.**
- * Be sure that your barrel is clear of obstructions, including excessive oil, grease, cleaning patches, etc before shooting.**
- * Use only clean, high quality factory loaded ammunition in good condition. ArmaLite® cannot condone the use of handloaded ammunition. Any such use voids the ArmaLite® warranty.**
- * Do not alter or modify your firearm.**
- * Do not try to change your firearm's trigger pull, because alterations of trigger pull can affect sear engagement and might cause accidental firing.**
- * Store firearms and ammunition separately, and beyond children's reach.**
- * Make sure that no cleaning patch or other obstruction is in the barrel or muzzle brake. Firing the rifle with such an obstruction may damage the rifle or flying debris may cause injury.**

IN CASE OF MALFUNCTION, STOP! REVIEW THIS MANUAL TO IDENTIFY AND RESOLVE THE PROBLEM. IF YOU CANNOT RESOLVE IT, CONTACT ARMALITE®.

KEEP THIS MANUAL WITH YOUR RIFLE. IF YOU SELL THE RIFLE, GIVE THIS MANUAL TO THE NEW OWNER.

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4. SAFE STORAGE

 **WARNING: ALWAYS ASSURE THAT YOUR FIREARM IS COMPLETELY UNLOADED BEFORE STORING IT. ALWAYS TREAT YOUR FIREARM AS IF IT WERE LOADED. ALWAYS STORE YOUR FIREARM IN A SAFE LOCATION, SEPARATE FROM THE AMMUNITION.**

Make certain that the chamber of your rifle is unloaded before you store it. Store your rifle in a securely locked gun safe. If you do not have a safe, remove the bolt assembly (R-6) from your rifle and store it separately from the rifle in a secure location. Store your ammunition separately from the rifle and from the bolt assembly.

 **WARNING: IF YOU HAVE MORE THAN ONE AR-50A1, MAKE SURE THAT YOU SPECIFICALLY IDENTIFY THE REMOVED BOLT ASSEMBLY WITH ITS ORIGINAL FIREARM BECAUSE THE BOLTS ARE NOT INTERCHANGEABLE.**

As is typical of many high precision firearms, ArmaLite® AR-50A1™ rifles are individually headspaced at the factory. The individual mating of each bolt, barrel, and receiver delivers the highest possible accuracy as well as assuring unmatched reliability and safety. On current production rifles, the mating of the bolt to the barreled receiver is evidenced by etching the last three digits of the rifle's serial number onto its mated bolt.

5. GENERAL INFORMATION



Figure 1
The AR-50A1™ Rifle with Accessories

Description:

The AR-50A1™ is a strong, front locked, bolt action single-shot rifle chambered for the .50 caliber Browning Machine Gun cartridge. It is an accurate rifle intended for long range target shooting.

The AR-50A1™ is a finely made rifle, a sophisticated machine built for many years of reliable use. It consists of two major elements, the receiver group assembly and the stock group assembly. They are joined at a unique machine-rest style V-block interface. Accurate, repeatable bedding is formed by the engagement of the octagonal receiver and the deep “V” channel in the aluminum forestock.



Figure 2
The ArmaLite® .50 Caliber Muzzle Brake

The AR-50A1™ is equipped with an extremely effective muzzle brake. It reduces the punishing recoil of the .50BMG to a mild shove. It is effective enough that even a small-statured shooter can fire the rifle, and most shooters will be able to spend long days at the range without discomfort.

 **WARNING: THE MUZZLE BRAKE IS HELD IN PLACE BY BOTH A LOCK RING AND LOC-TITE. DON'T REMOVE IT UNLESS REPLACEMENT OR REPAIR IS NECESSARY. TRYING TO FORCE THE BRAKE OFF WITHOUT SOFTENING THE LOC-TITE MAY UNSCREW THE BARREL!**

 **WARNING: YOUR ARMALITE® FIREARM WAS DESIGNED TO FUNCTION PROPERLY WITH ITS ORIGINAL COMPONENTS. ALTERATIONS TO ITS ORIGINAL COMPONENTS OR REPLACEMENT OF THEM WITH AFTERMARKET (NON-ARMALITE®) COMPONENTS CAN CAUSE MALFUNCTIONS OR EVEN MAKE THE FIREARM UNSAFE. DO NOT ALTER ANY PART OR ADD / SUBSTITUTE PARTS NOT MANUFACTURED BY ARMALITE® INC.**

As is typical of many high precision firearms, the AR-50A1™ is individually headspaced at the factory. The individual mating of each bolt, barrel, and receiver delivers the highest possible accuracy as well as assuring unmatched reliability and safety. The mating of the bolt to the barreled receiver is currently evidenced by etching the last three digits of the rifle's serial number onto its mated bolt.

 **WARNING: IN ORDER TO MAINTAIN PROPER HEADSPACE FOR SAFETY, RELIABILITY AND ACCURACY, BOLT ASSEMBLIES MUST NOT BE INTERCHANGED AMONG RIFLES. BOLT HEADS ARE FACTORY REPLACEABLE ONLY.**

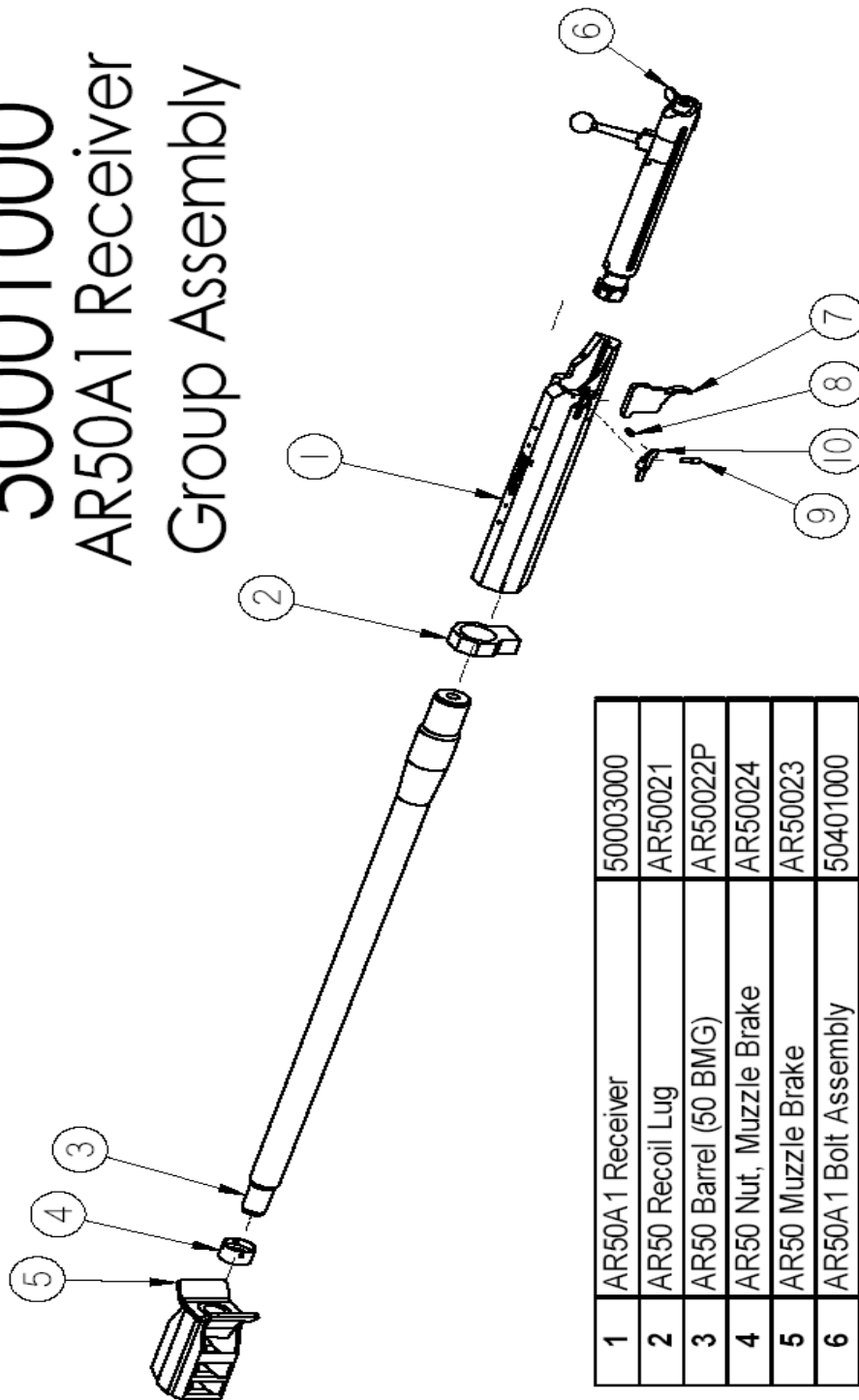
6. EXPLODED DRAWINGS AND PARTS LISTS

The drawings and associated parts lists in this section will give you visual references to parts discussed in the text. In the text, you will note part numbers in parentheses behind some part names. Those part numbers are the same as part numbers shown in the exploded drawings and parts lists. For example, a part numbered “R-7” in the text would refer to the part numbered “7” in the Receiver group assembly exploded view.

50001000

AR50A1 Receiver

Group Assembly



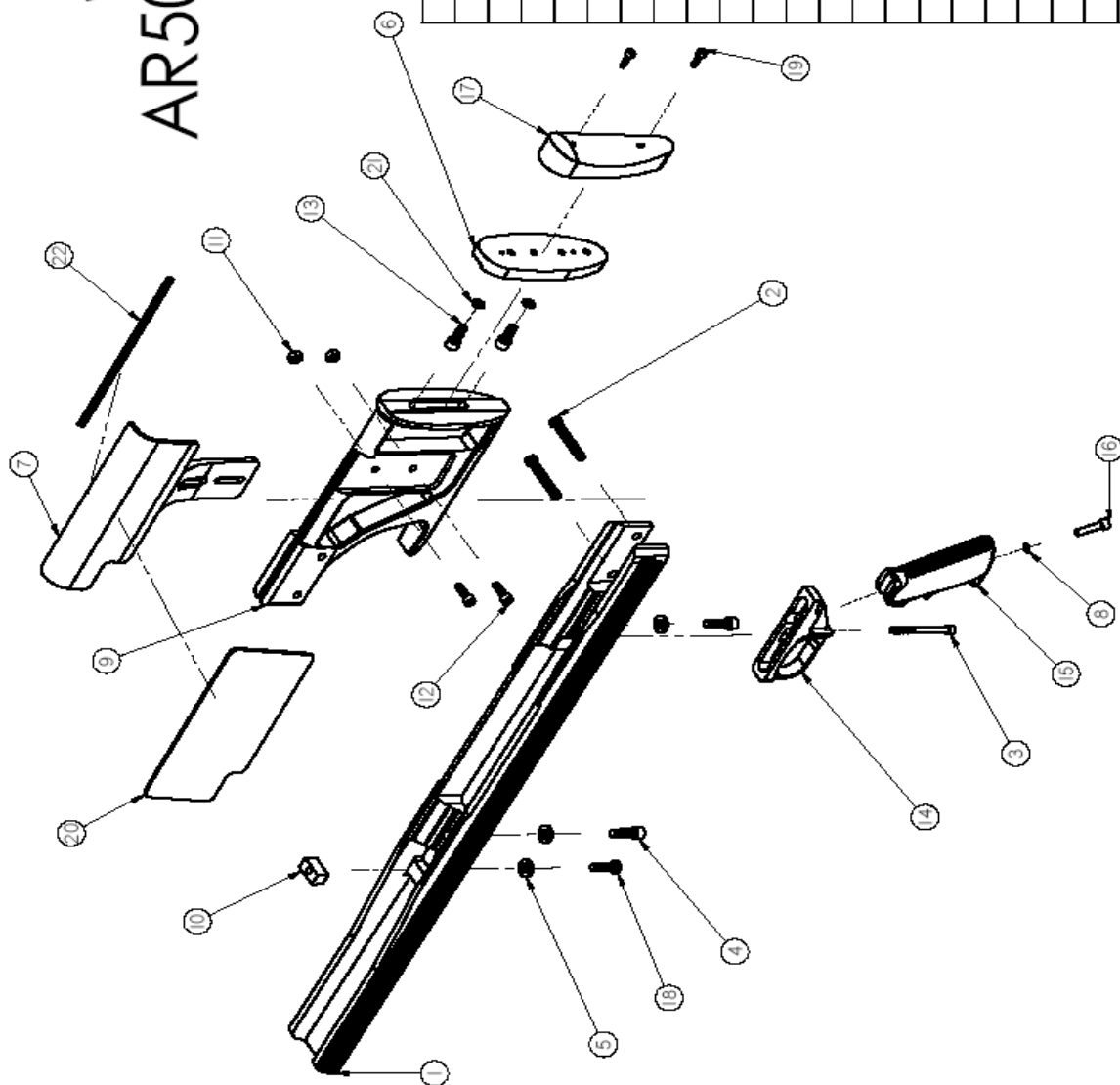
1	AR50A1 Receiver	50003000
2	AR50 Recoil Lug	AR50021
3	AR50 Barrel (50 BMG)	AR50022P
4	AR50 Nut, Muzzle Brake	AR50024
5	AR50 Muzzle Brake	AR50023
6	AR50A1 Bolt Assembly	50401000
7	AR50/ AR30 Shilen Trigger	AR50019
8	AR50A1 Bolt Stop Spring	50004200
9	AR50A1 Bolt Stop Pin	50004100
10	AR50A1 Bolt Stop	50004000

Parts 1 through 7 on this page are factory replaceable only.

50701000

AR50A1 Stock Group

Assembly

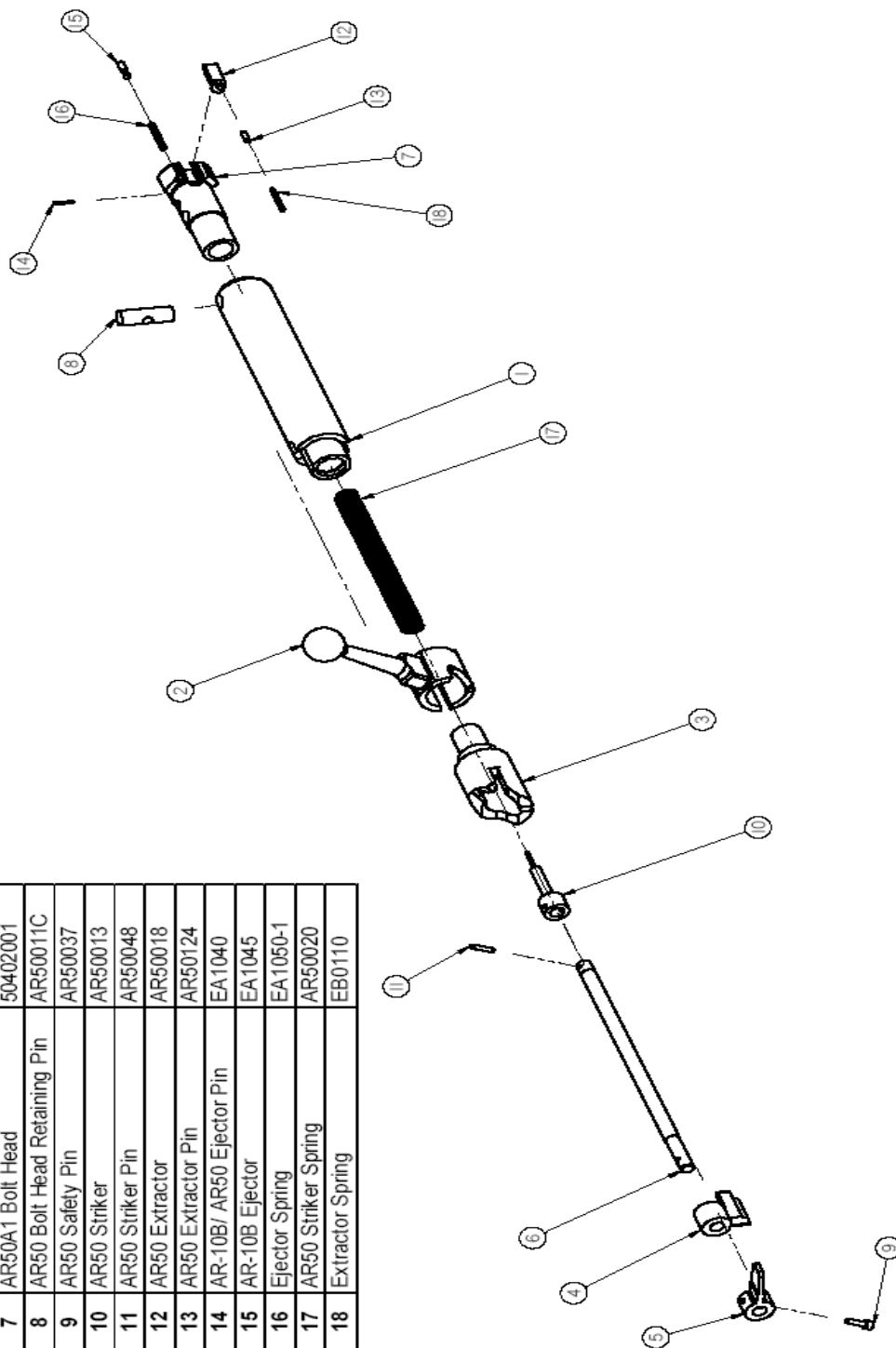


1	AR50 Forestock	AR50035
2	AR50 Forestock/ Buttstock Screw	AR50101
3	AR50 Grip Frame Screw	AR50102
4	AR50 Action Screw	AR50100
5	AR50/ AR30 Action Screw Washer	AR50104
6	AR50 Adjustable Butt Plate	AR50042
7	AR50 Cheek Piece	AR50029
8	Pistol Grip Washer	EL0020
9	AR50 Buttstock	50708030
10	AR50/ AR30 Bedding Wedge	AR50034
11	AR50 Cheek Piece Nut	AR50043
12	AR50 Cheek Piece Screw	AR50118
13	AR50 Butt Plate Screw	AR50106
14	AR30/ AR50 Grip Frame	30708025
15	Pistol Grip (Black)	EL0030
16	Pistol Grip Screw	EL0010
17	AR50 Recoil Pad	AR50105
18	AR50 Bedding Wedge Screw	AR50123
19	AR50 Recoil Pad Screw	AR50117
20	AR50 Cheek Piece Pad	AR50044
21	Nylon Washer	E 20175
22	AR50 Cheek Piece Trim	AR50030

50401000

AR50A1 Bolt Assembly

1	AR50 Bolt Tube	AR50011B
2	AR50 Bolt Handle	AR50012
3	AR50 Bolt Sleeve	AR50033
4	AR50 Cocking Piece	AR50016
5	AR50 Safety	AR50017
6	AR50 Striker Rod	AR50015
7	AR50A1 Bolt Head	50402001
8	AR50 Bolt Head Retaining Pin	AR50011C
9	AR50 Safety Pin	AR50037
10	AR50 Striker	AR50013
11	AR50 Striker Pin	AR50048
12	AR50 Extractor	AR50018
13	AR50 Extractor Pin	AR50124
14	AR-10B/ AR50 Ejector Pin	EA-1040
15	AR-10B Ejector	EA-1045
16	Ejector Spring	EA-1050-1
17	AR50 Striker Spring	AR50020
18	Extractor Spring	EB0110



Part 7 on this page is factory replaceable only.

7. AMMUNITION

Nomenclature of cartridges can be confusing. It is vital that you understand cartridge nomenclature and only fire cartridges for which this firearm was designed. To assist you, the name of the appropriate cartridge will be etched on the receiver and/or barrel of each ArmaLite®. (More information regarding cartridge nomenclature can be found in the Tech Notes on our website.)

 **WARNING: USE OF INCORRECT AMMUNITION CAN CAUSE FIREARM DAMAGE, PERSONAL INJURY, OR DEATH. MAKE ABSOLUTELY CERTAIN THAT YOU ARE USING CARTRIDGES DESIGNED FOR YOUR FIREARM. DO NOT FIRE OLD, CORRODED, DEFORMED, OR HANDLOADED AMMUNITION. IF YOU HAVE ANY QUESTIONS, CONTACT ARMALITE® BEFORE FIRING.**

The AR-50A1™ is chambered for the .50 Caliber Browning Machine Gun cartridge. It is designed to fire all standardized U.S. military ball .50 BMG cartridges (except cartridges using sabot projectiles). Do not attempt to fire any other cartridges in this firearm.

 **WARNING: DO NOT FIRE SABOTED AMMUNITION FROM YOUR RIFLE. THE SABOT COULD LODGE IN YOUR MUZZLE BRAKE CAUSING FIREARM DAMAGE AND POTENTIAL INJURY OR DEATH.**

 **CAUTION: FIRING OF TRACER AND ARMOR PIERCING AMMUNITION REDUCES BARREL LIFE.**

Firing of any of the ammunition described in the above warnings will void your warranty.

8. INITIAL ASSEMBLY, INSPECTION, AND CLEANING

 **WARNING: READ THIS MANUAL COMPLETELY AS YOU INSPECT YOUR NEW ARMALITE® FIREARM. MAKE CERTAIN THAT YOU UNDERSTAND HOW TO ASSEMBLE, OPERATE, DISASSEMBLE, MAINTAIN, AND STORE YOUR FIREARM SAFELY BEFORE YOU USE IT.**

Your AR-50A1™ will require some assembly before you fire it. The buttstock, and the scope rail are shipped with your rifle, but not assembled to it. Assembly instructions are given in this section of your manual.

8.1 INITIAL ASSEMBLY

8.1.1 Installing the Buttstock



Figure 4



Figure 3

Push the buttstock (S-9) up and forward to install it on the forestock (S-1) (See Figure 3). Install the two buttstock screws (S-2) at the right rear of the forestock using a 5/32 inch Allen wrench (See Figure 4).

8.1.2 Installing the Telescopic Sight Rail

Three scope rails are available from ArmaLite®. Each incorporates special recoil lugs designed to defeat both lateral and longitudinal recoil forces and to engage the scope mounting holes on the receiver. One provides 15 minutes of elevation to an attached scope mount for use at ranges out to 1000 yards. The second provides 30 minutes of elevation to allow shooting at ranges from 500 to 1500 yards. The third is a 50 minute scope rail for targeting from 1000 yards 2000 yards. Each is designed to accept ArmaLite®'s scope mounts, as well as most other Weaver type rings. The 15 minute rail is shipped with your rifle. NOTE: The optimum rail for your application is dependent on the amount of elevation adjustment in your scope. If you are in doubt regarding the optimum rail for your application, contact us.

Scope rails are supplied with four Allen screws for attachment to the receiver.

1. Remove the bolt assembly as instructed in the Disassembly section of this manual.
2. Set the scope rail on the receiver, with the recoil lugs of the base engaging the slots of the receiver. NOTE: The high end of the rail must be to the rear.
3. Insert the rear screw and tighten it snugly with the provided 5/32 Allen wrench., but DO NOT BREAK IT OFF.
4. Repeat the process with the other screws.
5. You may apply Blue Loctite or thread cement to the screw threads if you wish. It is not necessary.



Figure 5
ArmaLite® Scope Mount

8.1.3 Attaching the ArmaLite® Scope Mount or Rings

The scope rail will accept ArmaLite® mounts or rings. They are equipped with a positioning cross-rail. Select a location on the scope rail, and attach the scope mount with the cross-rail engaging a slot in the rail. Tighten the mount or rings securely: they are held in place by the grip of the side rail.

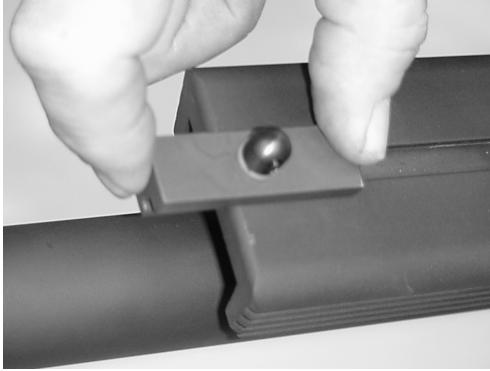


WARNING: MAKE CERTAIN THAT THE SCOPE IS MOUNTED FAR ENOUGH FORWARD SO THAT IT WILL NOT IMPACT YOUR FACE DURING RECOIL. CHECK THE DISTANCE BETWEEN THE SCOPE AND YOUR FACE WHEN YOU ARE IN THE FIRING POSITION. WHEN IN DOUBT INCREASE THE EYE RELIEF. RECHECK YOUR EYE RELIEF WHEN YOU CHANGE FIRING POSITIONS (E.G. FROM SITTING TO PRONE) BECAUSE YOUR EYE RELIEF WILL CHANGE.

D. Attaching the Bipod Adapter and Bipod

The AR-50A1™ is designed to be fired from a rest or bipod. To install the bipod adapter:

1. Screw the sling swivel lug into the adapter.



Figures 6 and 7

2. Insert the small rail of the adapter into the front of the accessory slot running along the bottom of the forestock. Slide the adapter to the desired position. Tighten the lug until the adapter is snug and align the holes in the lug at right angles to the barrel.
3. Follow the instructions included with the bipod to attach the bipod to the adapter.

8.2 INITIAL INSPECTION

8.2.1 Controls and Indicators

1. Bolt Handle. Lift the bolt handle (B-2) to unlock the bolt assembly (R-6) and pull the bolt assembly to the rear. Pulling back slowly leaves the cartridge in the receiver (R-1), pulling quickly ejects it. The AR-50A1™ is a large rifle; therefore more force will be required to unlock the bolt than is typical for most bolt action rifles.



CAUTION: DO NOT SLAM THE BOLT ASSEMBLY BACK TO ITS MOST REARWARD POSITION. THIS CAN DAMAGE YOUR BOLT OR THE BOLT STOP.

2. Safety. The safety (B-5) is mounted at the rear of the bolt assembly (R-6). To engage the safety, turn the safety counterclockwise to the 1:30 o'clock "SAFE" position.

NOTE: THE SAFETY CAN ONLY BE PUT IN THE "SAFE" POSITION WHEN THE STRIKER IS COCKED. Raising the bolt handle cocks the striker.

NOTE: THE SAFETY CAN ONLY BE PLACED INTO THE "SAFE" AND "FIRE" POSITIONS WHEN THE BOLT IS IN THE FORWARD POSITION. Attempting to manipulate the safety with the bolt to the rear will result in the bolt sleeve turning.

To place the safety to "FIRE," turn the safety to the horizontal, 3:00 o'clock "FIRE" position.



CAUTION: DO NOT PULL THE TRIGGER (R-7) WHEN THE SAFETY IS SET TO "SAFE". IF THE TRIGGER IS PULLED WHEN THE SAFETY IS IN THE "SAFE"

POSITION, THE STRIKER WILL SHIFT FORWARD ABOUT 1/8 INCH BEFORE IT IS STOPPED BY THE SAFETY. IN ORDER TO RETURN THE SAFETY TO THE “FIRE” POSITION, YOU MUST FIRST RAISE AND THEN RE-CLOSE THE BOLT HANDLE. ARMALITE® RECOMMENDS AGAINST USING THE SAFETY TO CARRY A LOADED AR-50A1™. INSTEAD, ARMALITE® RECOMMENDS LOADING THE RIFLE ONLY IMMEDIATELY BEFORE FIRING, THEN EJECTING THE FIRED ROUND AND LEAVING THE BOLT ASSEMBLY TO THE REAR.

3. Trigger. The trigger (R-7) is located within the trigger guard. It is of conventional, single stage design. Grasp the pistol grip (S-15) with the right hand and pull the trigger straight to the rear. The weight of the striker assembly requires the trigger to be set at a heavier weight than is normal on a lighter rifle. It will not disturb accurate shooting.

4. Buttplate Adjustment. Loosen the buttplate screws (S-13) with a ¼ inch Allen wrench to raise or lower the buttplate to suit the shooter’s firing position. Tighten the screws snugly when a comfortable position is found.

5. Cheekpiece Adjustment. Loosen the cheekpiece screws (S-12) with a 5/32 inch Allen wrench to raise or lower the cheekpiece (S-7). Tighten the screws snugly when a comfortable position is found.

8.2.2 Maintenance and Safety Checks

1. Place the safety (B-5) in the “SAFE” position.
2. Make sure that the rifle is unloaded, and that the bolt assembly is to the rear or removed.
3. Inspect the bore to make sure that there are no obstructions.

⚠ CAUTION: THE BOLT SLEEVE (B-3) MAY SLIP OUT OF “TIMING” IF ROTATED WHILE REMOVING THE BOLT ASSEMBLY (R-6) FROM THE RECEIVER (1). IF THIS OCCURS, THE BOLT ASSEMBLY WILL NO LONGER FIT PROPERLY INTO THE RECEIVER. IF THIS HAPPENS, ROTATE THE BOLT SLEEVE CLOCKWISE FROM THE REAR UNTIL THE COCKING PIECE (B-4) SNAPS INTO THE BOLT HANDLE NOTCH (SEE FIGURE 8). THE SLOT ALONG THE SIDE OF THE BOLT SHOULD BE ALIGNED THROUGH THE TUBE, HANDLE, AND SLEEVE (SEE FIGURES 8 AND 9). THIS IS EASILY ACCOMPLISHED IF THE SAFETY WAS SET TO “SAFE” PRIOR TO BOLT REMOVAL.

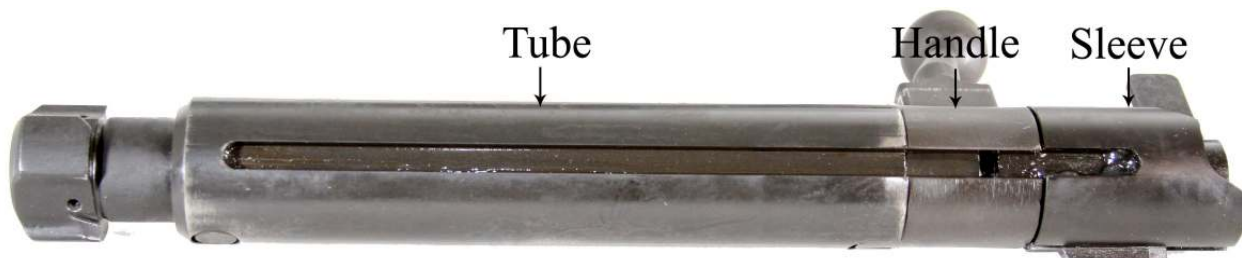


Figure 8

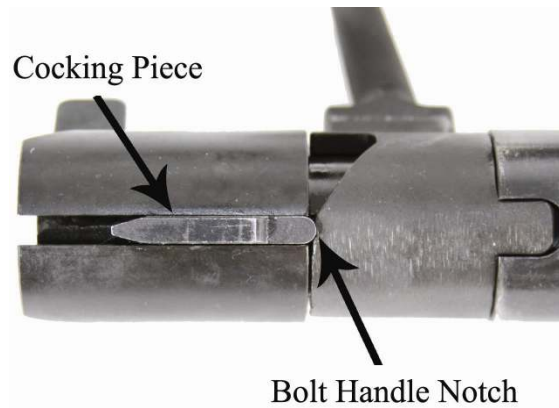


Figure 9

4. Inspect the muzzle brake (R-5) to assure that it is tight.
5. Reinstall and close the bolt assembly, assuring that the safety (which is attached directly to the striker) remains at the rear, safe/cocked position.
6. Rotate the safety to the 3:00 “FIRE” position, and pull the trigger. The safety should jump forward to the fired position.
7. Raise the bolt handle, making sure that the safety shifts to its rear position.
8. Close the bolt handle and place the safety in its “SAFE”, 1:30, position.

8.3 INITIAL CLEANING

Clean the bore of your rifle and lubricate the rifle as described in the Maintenance section below. Lubricate well before firing. No unusual break-in procedures or abrasives are recommended. Merely clean frequently with solvent dampened patches, followed by dry patches. We recommend brass brushes for all cleaning, and recommend specifically AGAINST either stainless steel or nylon brushes.

⚠ WARNING: TO ASSURE ITS PROTECTION FROM CORROSION, YOUR ARMALITE® FIREARM HAS BEEN SHIPPED WITH PRESERVATIVE OIL IN THE BORE. FIRING THE FIREARM WITH PRESERVATIVE IN THE BORE CAN INCREASE PRESSURES, WITH POSSIBLE FIREARM DAMAGE OR PERSONAL INJURY OR DEATH. CLEAN AND DRY THE BORE BEFORE FIRING YOUR ARMALITE® FIREARM.

8.4 BREAKING IN MATCH BARRELS

ArmaLite® has spoken with several barrel manufacturers. NONE of them recommend breaking in barrels using abrasives. For optimum accuracy and barrel life, ArmaLite® recommends the following break-in procedure:

1. Fire 9 single shots. After each shot, push a cotton patch wet with solvent through the bore. Then wet a bronze brush with solvent and stroke the barrel five to ten round trips. Follow with another wet patch and then a dry patch or two. (We do NOT recommend nylon or stainless steel brushes.) After you finish, wash the solvent off your brush so that the brush won't deteriorate.
2. From 10 to 30 shots, clean as above after each five shots. Initial break-in should now be complete.

8.5 DRY FIRING YOUR RIFLE

ArmaLite® does not recommend dry firing your rifle. If you do dry fire it, make sure that you have a snap cap or empty cartridge case (with a fired primer installed) in the chamber to cushion/stop the firing pin.



CAUTION: DRY FIRING YOUR RIFLE WITH THE CHAMBER EMPTY CAN CAUSE THE STRIKER ROD TO PEEN OVER, RESULTING IN MISFIRES.



WARNING: FOLLOW ALL OF THE RULES OF SAFE GUN HANDLING ANYTIME YOU DRY FIRE YOUR FIREARM.

9. LOADING AND FIRING

 **WARNING: ALWAYS KEEP THE SAFETY IN THE “SAFE” POSITION UNTIL YOU ARE READY TO FIRE THE FIREARM. REMEMBER THAT THE SAFETY IS SIMPLY A MECHANICAL DEVICE, AND AS SUCH, COULD POSSIBLY FAIL. NEVER DEPEND ON ANY MECHANICAL SAFETY TO JUSTIFY UNSAFE GUN HANDLING. ALWAYS KEEP THE CHAMBER EMPTY AND THE FIREARM POINTED IN A SAFE DIRECTION EVEN WHEN THE SAFETY IS ON.**

 **WARNING: ALWAYS WEAR EYE AND EAR PROTECTION. MAKE SURE THAT NEARBY BYSTANDERS ALSO WEAR EYE AND EAR PROTECTION.**

1. **Verify safety of the range.** Make sure that the rifle is pointed in a safe direction, towards a known, adequate backstop. Make sure that everybody within 100 yards knows that the rifle is about to be fired and protects their hearing.

 **WARNING: THIS FIREARM IS EXTREMELY LOUD DUE TO THE LARGE CARTRIDGE AND THE EFFICIENCY OF THE MUZZLE BRAKE. WEAR DOUBLE HEARING PROTECTION: FOAM PLUGS AND GOOD QUALITY HEARING PROTECTION MUFFS. ASSURE THAT SPECTATORS AND OTHER SHOOTERS WITHIN 100 YARDS OF THE FIRING POINT ARE ALSO WEARING HEARING PROTECTION. YOU ARE RESPONSIBLE FOR WARNING THEM THAT YOU ARE ABOUT TO FIRE, AND THAT THE SHOT WILL BE LOUD!**

 **WARNING: AVOID MUZZLE BLAST. THE RIFLE’S MUZZLE BRAKE WORKS BY DIVERTING MUZZLE GASSES TOWARDS THE REAR. IT IS LOUD AND CAN STIR UP DEBRIS FROM THE GROUND! BOTH FIRERS AND SPECTATORS SHOULD WEAR EYE AND EAR PROTECTION. EVEN WHEN WEARING PROTECTION, SPECTATORS SHOULD NOT STAND WITHIN 25 YARDS OF THE RIFLE AND SHOULD BE ESPECIALLY CAREFUL NOT TO STAND IN THE AREA 30 TO 90 DEGREES TO EITHER SIDE OF THE RIFLE. THE BEST PLACE TO BE IS DIRECTLY TO THE REAR OF THE RIFLE, SHOOTING IT!**

 **WARNING: NEVER FIRE THE RIFLE WITHOUT THE MUZZLE BRAKE IN PLACE. THE MUZZLE BRAKE IS AN IMPORTANT SAFETY DEVICE. IT MAKES THE RIFLE COMFORTABLE TO SHOOT AND AIDS ACCURACY. FIRING THE RIFLE WITHOUT THE MUZZLE BRAKE IN PLACE WILL EXPOSE THE SHOOTER TO VERY HARD, UNPLEASANT RECOIL. ASSURE THAT THE MUZZLE BRAKE IS FIRMLY SECURED AND UNDAMAGED.**

 **WARNING: THIS RIFLE FIRES AN EXTREMELY POWERFUL CARTRIDGE. MAKE SURE THAT YOUR BACKSTOP IS FULLY CAPABLE OF STOPPING THE PROJECTILE.**

2. Place the safety (B-5) in the “SAFE” position.
3. If it’s not already open, raise the bolt handle (B-2) and pull the bolt assembly (R-6) to the rear.

 **CAUTION: DO NOT USE EXCESSIVE FORCE TO PULL THE BOLT ASSEMBLY TO THE REAR. THE BOLT ASSEMBLY DOES NOT NEED TO BE SLAMMED REARWARD. THE CARTRIDGE CASE WILL EXTRACT AND EJECT RELIABLY WITHOUT SUCH FORCE. PULLING THE BOLT ASSEMBLY REARWARD WITH EXCESSIVE FORCE CAN DEFORM OR BREAK THE BOLT STOP. REPEATED EXCESSIVE FORCE CAN ALSO PEEN THE BOLT TUBE, INCREASING THE FORCE NEEDED TO CYCLE THE BOLT ASSEMBLY.**

4. Place a cartridge into the receiver through the ejection port.
5. Close the bolt to chamber the cartridge and lock the bolt: push the bolt forward forcefully so that the extractor (B-12) snaps over the case rim. You will feel fairly strong resistance as the ejector (B-15) is pressed back into the face of the bolt head (B-7). Turn the bolt handle down completely.
6. Assume a good, stable position behind the rifle. Make sure that the buttplate is locked at a level that allows it to rest in complete contact with your shoulder. Make sure that your cheek is well forward on the cheek piece.
7. Aim at the target. Place the safety in the “FIRE” position.
8. Pull the trigger straight to the rear. You will know when the rifle fires!!!!

 **WARNING: INJURY, DEATH, OR FIREARM DAMAGE CAN RESULT FROM FIRING A FIREARM WITH AN OBSTRUCTION IN THE BORE. BEFORE YOU FIRE, MAKE SURE THAT THE BORE IS NOT OBSTRUCTED. NEVER ATTEMPT TO SHOOT OUT A BORE OBSTRUCTION.**

Note: the AR-50A1™ is equipped with a very secure manual safety. However, ArmaLite® recommends only loading the rifle immediately before firing a shot instead of leaving the rifle loaded and on safe. As a practical target shooting measure, the rifle should be considered safe only when it is unloaded and the action is open.

 **WARNING: HANDLING OF CARTRIDGES AND FIRING FIREARMS MAY EXPOSE YOU TO LEAD. ALWAYS ASSURE THAT THERE IS ADEQUATE VENTILATION. ALWAYS WASH YOUR HANDS AFTER HANDLING AMMUNITION OR FIRING YOUR FIREARM.**



WARNING: RAPID FIRING OF THE FIREARM MAY CAUSE SOME COMPONENTS TO BECOME HOT ENOUGH TO CAUSE INJURY. EXTENDED SESSIONS OF VERY RAPID FIRING MAY CAUSE A CARTRIDGE LEFT IN THE CHAMBER TO “COOKOFF”, FIRING ITSELF WITHOUT YOU PULLING THE TRIGGER. ALWAYS UNLOAD THE FIREARM IMMEDIATELY AFTER YOU FINISH FIRING.



WARNING: IF THE RIFLE FAILS TO FIRE WHEN THE TRIGGER IS PULLED, KEEP THE RIFLE POINTED IN A SAFE DIRECTION:

- 1. WAIT 15 SECONDS TO ALLOW A POSSIBLE “HANGFIRE” TO GO OFF THEN...**
- 2. CHECK TO SEE IF THE SAFETY IS ENGAGED BY MISTAKE. IF SO, RAISE AND THEN LOWER THE BOLT HANDLE TO ASSURE THE STRIKER IS RECOCKED, ROTATE THE SAFETY TO THE 3:00 “FIRE” POSITION, AND FIRE.**
- 3. IF THE RIFLE STILL DOESN'T FIRE, BE CAUTIOUS AND ASSUME THE CARTRIDGE MIGHT DISCHARGE WHEN THE BOLT IS OPENED. WAIT ANOTHER 15 SECONDS TO ALLOW A POSSIBLE HANGFIRE TO DISCHARGE. STAND ON THE SIDE OPPOSITE THE EJECTION PORT, OPEN THE BOLT QUICKLY, AND UNLOAD THE RIFLE.**
- 4. EXAMINE THE RIFLE CAREFULLY TO IDENTIFY THE CAUSE OF THE MALFUNCTION, AND CORRECT IT.**



WARNING: THE FIRED CARTRIDGE CASE IS HOT WHEN IT IS EJECTED FROM THE FIREARM. DO NOT ALLOW IT TO BURN YOU, OR TO DISTRACT YOU FROM SAFE HANDLING OF THE FIREARM.

10. CLEARING / UNLOADING THE FIREARM

The AR-50A1™ is a single shot, bolt action rifle. As such, it is very simple to unload and inspect for safety. While keeping your finger off the trigger and out of the trigger guard, merely move the safety to its “SAFE” position, open and retract the bolt assembly, and visually inspect the chamber to assure that it is empty.



WARNING: ALWAYS ASSUME ALL FIREARMS ARE LOADED. ANYTIME YOU HANDLE A FIREARM, YOU SHOULD INSPECT IT TO ASSURE THAT IT IS COMPLETELY UNLOADED.



WARNING: NEVER ASSUME THAT THE CHAMBER IS EMPTY UNTIL YOU HAVE VISUALLY EXAMINED IT AND SEE THAT IT IS EMPTY.

11. ZEROING THE SIGHTS

Your ArmaLite® AR-50A1™ is designed to employ a telescopic sight. To install and zero the scope on your AR-50A1™ follow the instructions in your scope owner's manual.

12. DISASSEMBLY

 **WARNING: ALWAYS UNLOAD YOUR FIREARM BEFORE CLEANING, LUBRICATION, DISASSEMBLY, OR REASSEMBLY.**

1. Assure that the rifle is unloaded, and engage the safety (B-5).



Figure 8
Bolt Stop

2. Depress the bolt stop (R-10) (See Figure 8) to remove the bolt assembly. Pull the bolt assembly to the rear and out of the receiver.

NOTE: If you have the cheekpiece in a low position, you may need to raise or remove it.

 **CAUTION: FURTHER DISASSEMBLY OF THE BOLT ASSEMBLY SHOULD ONLY BE CONDUCTED BY A TRAINED GUNSMITH.**

 **CAUTION: NO FURTHER DISASSEMBLY OF THE RIFLE IS NEEDED FOR ROUTINE CLEANING AND MAINTENANCE.**

3. If for some reason, it is necessary to remove the receiver group assembly from the stock group assembly, it should be done in the following manner.



Figure 9
The Bedding Wedge

The rifle's receiver is held tightly in the stock by two action screws (S-4) that pull it down into the stock, and a bedding wedge (S-10) (See Figure 9) that pulls the receiver rearward into contact with the stock. Loosen the bedding wedge at the front of the receiver by loosening the bedding wedge screw (S-18) under the receiver using a 3/16 inch Allen wrench.



Figure 10
Removing the Grip Frame

4. Place the rifle upside down. Remove the grip frame (S-14) by removing the grip frame screw (S-3) (See Figure 10), using a 3/16 inch Allen wrench. Pull the grip frame from the forestock (S-1). NOTE: The grip frame must be removed in order to obtain access to the rear action screw.
5. Remove the two action screws (S-4) from the bottom of the forestock using a 1/4 inch Allen wrench. Lift the stock assembly straight off the receiver.



Figure 11



Figure 12

6. To remove the buttstock (S-9) from the forestock (S-1), remove the two buttstock screws (S-2) at the right rear of the forestock using a 5/32 inch Allen wrench (See Figure 11). Pull the buttstock down and to the rear to remove it (See Figure 12).

⚠ WARNING: DO NOT REMOVE THE TRIGGER OR MUZZLE BRAKE. THE TRIGGER IS NOT USER-SERVICEABLE AND A REASSEMBLY ERROR COULD INTERFERE WITH CORRECT RIFLE FUNCTION. THE MUZZLE BRAKE IS HELD IN PLACE BY ITS LOCK RING AND LOCTITE.

13. MAINTENANCE



WARNING: ALWAYS UNLOAD YOUR FIREARM BEFORE CLEANING, LUBRICATION, DISASSEMBLY, OR REASSEMBLY.



WARNING: DO NOT APPLY LUBRICANT OR PRESERVATIVE TO YOUR AMMUNITION. DOING SO MAY CAUSE THE CARTRIDGE TO PARTIALLY MALFUNCTION, LEAVING THE BULLET LODGED IN THE BORE, CREATING A BORE OBSTRUCTION.

13.1 CLEANING SOLVENTS AND LUBRICANTS

The Military Services generally use a multipurpose chemical called CLP (cleaner, lubricant, and preservative) sold commercially as “Break Free.” Although it is useful if nothing else is available, armament engineers prefer individual, specialized products. A combination of military RBC (Rifle Bore Cleaner) and LSA (Lubricant, Semifluid, Automatic firearms) is superior. High quality cleaning solvent like Hoppes No. 9 removes metal fouling from the bore excellently; and Teflon bearing lubricants are outstanding lubricants. For maximum reliability and service life, lubricate your rifle (especially the highly stressed bolt and bolt carrier assembly) generously with high quality firearms lubricants.

Under NO conditions should any lubricant containing graphite be used with your rifle. Graphite can encourage rapid corrosion to the aircraft-grade aluminum used in your rifle.

In addition to cleaning solvents and lubricants, the basic cleaning equipment you will need includes a cleaning rod, brass bore brush, chamber brush, toothbrush, patches, pipe cleaners, and the most important item: a lint-free cloth. A pull-through cleaning cable allows for efficient, breech-to-muzzle cleaning in the field.

Improper cleaning ruins more firearms than extensive shooting does. The AR-50A1™ will provide years of use with minimal cleaning and preservation.

Note: The phosphated finish of a new bolt assembly and receiver will make the movement of a new action seem rough. Movement of the bolt assembly will become very slick as these parts break in and are properly lubricated.

Use a pull-through device or a high quality cleaning rod to clean the bore. Use a proper caliber bore brush soaked with a good bore solvent. Pass it from the breech to the muzzle several times.

Note: Heat treat processes may produce dark areas of phosphate at the breech ring and bolt cam of the receiver. This is normal.

In addition to cleaning solvents and lubricants, the basic cleaning equipment you will need includes a cleaning rod, brass bore brush, chamber brush, toothbrush, patches, pipe cleaners, and the most important item: a lint-free cloth. A pull-through cleaning cable allows for efficient, breech-to-muzzle cleaning in the field.

13.2 RECEIVER AND BARREL ASSEMBLY

 **WARNING: LEAD MAY BE PRESENT IN THE FOULING OF A DIRTY RIFLE. AVOID CONTACT WITH IT, AND CLEAN HANDS AFTERWARD TO AVOID INGESTING LEAD.**

 **CAUTION: DON'T REVERSE THE DIRECTION OF THE BORE BRUSH WHILE IT'S IN THE BORE.**

 **WARNING: ARMALITE'S AR-30 TRIGGER ASSEMBLY ISN'T USER ADJUSTABLE. ATTEMPTING TO ADJUST THE TRIGGER MAY RESULT IN UNSAFE CONDITIONS AND VOIDS THE WARRANTY.**

 **CAUTION: AVOID ALLOWING SOLVENTS, LUBRICANTS, OR PRESERVATIVES TO DRAIN INTO THE TRIGGER MECHANISM. THEY MAY CAUSE IT TO MALFUNCTION. SUCH CONTAMINATES CAN BE REMOVED BY SQUIRTING LIGHTER FLUID INTO THE TRIGGER MECHANISM. DO NOT DISASSEMBLE THE TRIGGER MECHANISM OR REMOVE IT FROM THE RECEIVER.**

1. Use cleaning solvent to clean the bore and chamber, the receiver, locking lugs and all areas of powder fouling, corrosion, dirt or dust. First apply the solvent with a patch on your rod. Follow by brushing the bore in accordance with the instructions on the solvent bottle.
2. Install the chamber brush on the cleaning rod, dip it in cleaning solvent, and insert it into the chamber and locking lugs. Clean by pushing and twisting the cleaning rod.
3. Lightly lubricate the bore, chamber, and outer surface of the barrel. With a lubricated swab, run the rod from the receiver to the flash suppressor (if applicable). Do not over lubricate.
4. Oil or lightly grease the narrow track in the receiver behind the bolt. The sear surface of the cocking piece (B-6) runs through this track and serves as a rear bolt guide. A "Q-Tip" or other such device will suffice.

13.3 BOLT ASSEMBLY



WARNING: DO NOT INTERCHANGE BOLTS BETWEEN RIFLES.

1. Clean all parts and outer surfaces of the bolt assembly with a swab saturated with cleaning solvent.
2. Remove carbon deposits and dirt from the locking lugs with a bore brush dipped in solvent.
3. Clean the bolt face and under the lip of the extractor.
4. Press the ejector in repeatedly to remove accumulated brass shavings from the ejector hole and assure the ejector moves freely. Lubricate it generously.
5. Lightly lubricate the firing pin and firing pin recess in the bolt assembly.
6. Lightly lubricate the outside of the bolt.
7. Lightly lubricate the bolt lugs with a high pressure lube/grease.

13.4 FORESTOCK ASSEMBLY



CAUTION: DO NOT USE A WIRE BRUSH OR ANY TYPE OF ABRASIVE MATERIAL TO CLEAN ALUMINUM SURFACES

1. Wipe dirt from the exterior surfaces with a clean cloth.

13.5 LONG TERM STORAGE

Clean your firearm well and apply a good quality preservative.

It is at least theoretically possible for some springs to take a set during prolonged storage. To preclude this possibility, ArmaLite offers the following recommendations regarding long term storage of your firearm.



WARNING: FOLLOW ALL OF THE RULES OF SAFE GUN HANDLING ANYTIME YOU DRY FIRE YOUR FIREARM.

Clear all cartridges from your firearm. Remove the magazine. Then pull back the bolt handle and visually confirm that the chamber is empty and that there is no cartridge in the chamber. Then check it again. Then dry fire the firearm to allow the firing pin to fall to the fired position. Reasonable amounts of dry firing should not damage your firearm.

Store in a container that contains no foam. (Foam absorbs moist air. Heating the container may drive moisture from the foam. It can then condense on a cool rifle.) Use a desiccant or Vapor Phase Inhibitor in the container to help prevent rust.

When you're taking your firearm out of long term storage, completely remove the preservative (especially from the bore and chamber) and lubricate as stated elsewhere in this manual.

14. REASSEMBLY



WARNING: ALWAYS UNLOAD YOUR FIREARM BEFORE CLEANING, LUBRICATION, DISASSEMBLY, OR REASSEMBLY.

Reverse the steps explained in DISASSEMBLY above. Tighten the two action screws (S-4) very **LIGHTLY**. Then tighten the bedding wedge screw (S-18) at the front of the receiver. Finally, tighten the two action screws firmly. This assures that the recoil lug is seated properly.

For those of you who desire to duplicate factory screw torques, the following values are suggested:

Bedding Wedge Screw-----	12.5 – 15 ft-lbs
Buttstock to Forestock Screws-----	7.5 – 10 ft-lbs
Front Action Screw-----	17.5 – 20 ft-lbs
Rear Action Screw-----	7.5 – 10 ft-lbs*
Grip Frame Screw-----	7.5 – 10 ft-lbs.*

*NOTE: Excessive torque on the rear action screw and/or the grip frame screw can cause the bolt assembly to bind when entering the receiver. If you encounter this problem, adjust those two screws appropriately.

14.1 FUNCTIONAL CHECK

1. Retract the bolt assembly (R-6) and visually inspect the chamber to assure that it is empty.
2. Pull the bolt assembly (R-6) to the rear. It should be stopped by the bolt stop (R-10). Then return the bolt assembly forward and lock it.
3. Place the safety (B-5) on “SAFE”. Squeeze the trigger (R-7). The firing pin should not fall.
4. Place the safety (B-5) on “FIRE”. Squeeze the trigger (R-7). The firing pin should fall.

15. TROUBLESHOOTING

PROBLEM	CHECK FOR	WHAT TO DO
WON'T FIRE	Selector lever on SAFE"	Put it on "FIRE"
	Defective ammunition	Remove and discard
BOLT WON'T LOCK	Dirty bolt	Clean
	Burred or broken bolt	Contact ArmaLite®
	Dirt, corrosion, or carbon buildup in receiver locking lugs	Clean lugs
WON'T EXTRACT	Broken extractor spring	Contact ArmaLite®
	Dirty, corroded, or reloaded ammunition	Remove and discard
	Carbon in chamber	Clean chamber
	Frozen or worn extractor	Contact ArmaLite®
WON'T CHAMBER	Dirty, corroded or defective ammunition	Remove and discard

16. WARRANTY, SERVICE, AND SUGGESTIONS

Specific warranty provisions for your ArmaLite® firearm are shown on the warranty card shipped with your new firearm. Be sure to complete your warranty card and return it to ArmaLite® immediately.

THE WARRANTY WILL ONLY BE HONORED UPON COMPLETION OF THE WARRANTY FORM AND ITS RETURN TO ARMALITE® WITHIN 30 DAYS OF THE ORIGINAL CUSTOMER'S PURCHASE DATE ALONG WITH A COPY OF THE DATED SALES RECEIPT.

If no warranty card and sales receipt are on file, all work will be billed at shop rates. Custom work will be billed at ArmaLite®'s shop rates, as will work on firearms submitted with no warranty problem existing. Shipping to and from ArmaLite® is the owner's responsibility, except that ARMALITE® will return the firearm to the customer shipping prepaid if the return was covered under warranty.

Returns for any reason will NOT be accepted without a Return Merchandise Authorization (RMA) number issued by ArmaLite®. Please call 1-800-336-0184, Ext. 125 to receive your RMA number. After you receive your RMA number, print it on the outside of the box and include a short note in the box. The note should include the RMA number, your name, address, email, phone number, the model and serial number of the firearm you're returning, and a detailed explanation of the problems that you're having with the firearm. If you wish to put your note on our RMA form, you can print out our RMA form by clicking on the link in the Policies or Contact Us sections of our website.

Remove any accessories (scope, scope mount, sling, bipod, cleaning equipment, etc) that don't pertain to your problems before you send the firearm in.

Firearms that you wish to return for warranty or out-of-warranty repair may be returned directly to ArmaLite®.

Before seeking warranty service: use the troubleshooting guide in this Operator's Manual to attempt to solve the problem, perform all instructed maintenance, and assure that ammunition and magazines are correct and in good condition. **Shop rates plus the cost of return shipping will be applied if no covered defect is found.**

Include a note explaining, in as much detail as possible, the nature of the problem or service needed. The note should include the RMA number, your name, address, email, phone number, and the reason for return. If you wish to put your note on our RMA form, you can print out our RMA form found in the "Contact Us" and "Policies" sections of our website (www.ArmaLite.com). Keep your shipping receipt and the serial number of the firearm for your records in case of loss in shipment.



WARNING: MAKE ABSOLUTELY SURE THAT THE FIREARM IS UNLOADED!!! BELIEVE IT OR NOT, WE SOMETIMES GET FIREARMS BACK THAT ARE LOADED!!!



WARNING: NEVER SHIP LIVE AMMUNITION WITH ANY FIREARM THAT YOU ARE RETURNING TO ARMALITE® FOR SERVICE.



WARNING: IT IS THE OWNER'S RESPONSIBILITY TO ASSURE THAT ANY PARTS THAT ARE PURCHASED FROM ARMALITE® ARE CORRECTLY FITTED AND INSTALLED. IMPROPER FITTING OR INSTALLATION MAY RESULT IN INJURY, DEATH, OR DAMAGE/MALFUNCTION OF THE FIREARM.

A copy of the owner's manual for any ArmaLite® firearm is available free in the Library on ArmaLite®'s website or may be obtained free in hard copy by contacting ArmaLite®.

Additional technical information can be found in Technical Notes in the Library section of ArmaLite®'s website.

To answer any questions you may have about the firearm, or to offer suggestions for improvements, please contact us at:

ArmaLite, Inc
P.O. Box 299
Geneseo, Illinois, 61254

Phone: 1-800-336-0184 or 309-944-6939

Fax: 309-944-6949

Email: info@ArmaLite.com

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PATENTS & TRADEMARKS

“ArmaLite®, “AR-10®”, and “SPR®”, are registered trademarks of ArmaLite®, Inc.

“M-15™”, “AR-30™”, “AR-50™”, and other model variants are trademarks of ArmaLite®, Inc.

The AR-10® Series Rifles and Carbines (including the SuperSASS™) are protected by U.S. Patents 5,638, 626 and 5,911,173 and 6,044,748.

The M-15™ Series Rifles and Carbines are protected by U.S. Patents 5,911, 173 and 6,044,748.

The AR-30™ and AR-50™ Series Rifles are protected by U.S. Patents 6,487,805 and 6,637,142.

The AR-23 Subcaliber Device for the Mk-19 Grenade Machine Gun is protected by U.S. Patents 5,983,772 and 6,202,533.

The Blank Firing Adapter for the Mk-19 Grenade Machine Gun is protected by U.S. Patent 5,438,907.

Other patents granted or assigned to ArmaLite® include:

Weapons Operating System, U.S. Patent 6,591,535

Cartridge for a Firearm, U.S. Patents 6,367,389 and 6,959,647 and 6,976,431 and 7,458,332

Light Weight Weapon Operating System and Cartridge Feed, U.S. Patent 6,591,535

AVAILABLE ACCESSORIES

Part Name:	Price:	Ask for Part #:
30 Minute Rail	\$80.00	50809330KIT
50 Minute Rail	\$80.00	AR500365
Stock Length of Pull Kit	\$32.00	50702115
Pro-Shot Cleaning Kit	\$42.00	CP0500
Kleen Bore Cleaning Kit	\$44.00	CP1805
Soft Rifle Case	\$169.00	HWC 62 BLK
1" Scope Mount	\$89.00	EX0027
30mm Scope Mount	\$89.00	EX0022
Prince Bi-Pod	\$200.00	EX3200

Price and availability of accessories subject to change without notice.