

SIONICS
TUCSON, ARIZONA

**SAR-15 RIFLE
OWNERS MANUAL**

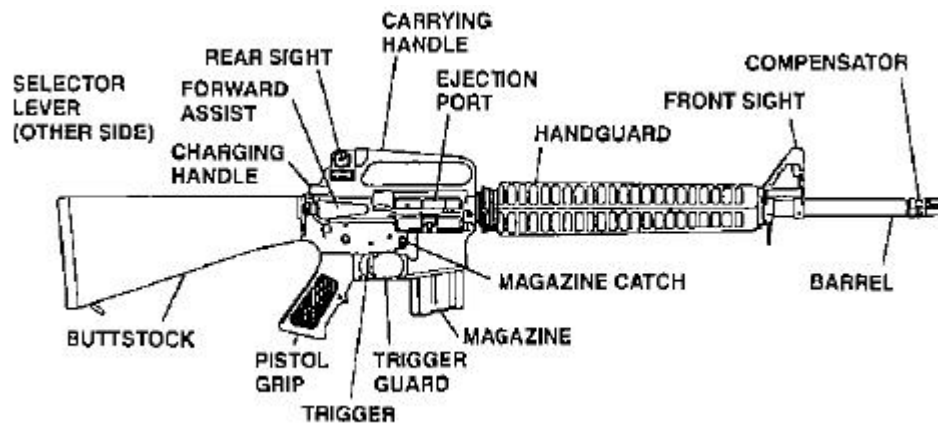
SIONICS WEAPON SYSTEMS

Our mission is to manufacture quality firearms made with pride in the USA. We are able to do accomplish this by using only the best American made parts. The employees of Sionics value our customers and do our best everyday to assure the utmost quality in each and every product that we produce.

THANK YOU FOR BUYING SIONICS!

Before disassembling, loading or using this firearm, please Read, Understand and Follow all the instructions in this manual regarding proper handling and safe use!

For any information or details not covered in this manual please contact Sionics Weapon Systems customer service.



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

Warning: This Firearm could chamber a round if it is dropped or jarred with a loaded magazine in place - with the bolt carrier assembly locked to the rear, or in its forward position.

Caution: Use only clean, dry, high quality commercial manufactured ammunition. Use only ammunition that is appropriate for the 5.56mm/.223 Rem. caliber of your firearm.

FUNDAMENTAL RULES AND PROCEDURES FOR SAFE FIREARMS HANDLING

- Always treat every gun as if it were loaded!
- Always keep the firearm pointed in a safe direction!
- Always be sure the barrel is clear of any obstruction
- Always be sure of what lies beyond your target and the safety of bystanders before you shoot
- Always wear ear & eye protection when shooting
- Always carry your gun so that you can control the direction of the muzzle if you fall or stumble.
- Never load the firearm until ready to shoot!
- Never leave a firearm unattended. Guns and ammunition should always be secured and stored separately, and beyond the reach of children and adults unfamiliar with firearms
- Never allow your firearm to be used by anyone who has not read this instruction and safety manual
- Never point any gun, loaded or unloaded, at anything you do not intend to shoot
- Never touch the barrel after firing - it could be very hot!
- Keep your finger on the trigger and leave the safety on until ready to shoot!
- If your rifle stops firing with a live round still in the chamber (a misfire), quickly remove the round, keeping your face away from the ejection port. If you cannot remove it within 10 seconds, remove the magazine, and wait 15 minutes with the rifle pointed in a safe direction. At this point, the rifle could still fire the round

GETTING READY TO SHOOT:

- With the safety on, insert the loaded magazine into the magazine well, always making sure the muzzle is pointed in a safe direction!
- Pull the charging handle fully to the rear
- Release the charging handle. Do not ride or push the charging handle. Let it move forward on its own
- Release bolt catch
- Move safety lever from safe to fire
- Note: If the rifle is not going to be fired immediately, make sure the selector lever is still on safe

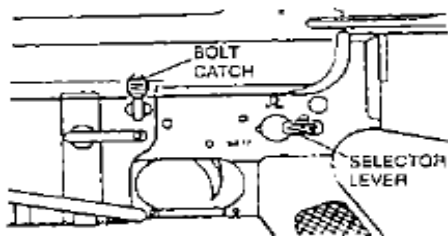


FIGURE 10
BOLT CATCH AND
SELECTOR LEVER

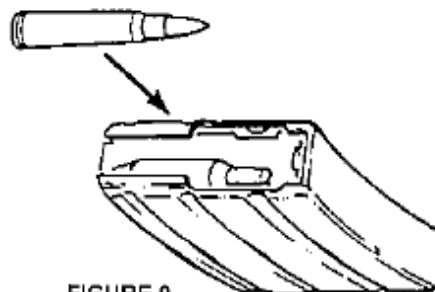


FIGURE 9
LOADING THE MAGAZINE

DISASSEMBLY

- Make sure firearm is not loaded and is pointed in a safe direction
- Remove magazine and clear the chamber
- Open the bolt by pulling the charging handle completely to the rear while holding the charging handle in this position, use your other hand to lock the bolt in the rearward position by pushing the lower end of the bolt catch lever
- The bolt carrier should lock in the rearward position. Let go of the charging handle. Do not ride it back!
- If there was a round in the chamber it should have been ejected...make sure there is not a round in the chamber by LOOKING INTO THE CHAMBER from THE EJECTION PORT AND VISUALLY CONFIRMING THAT THERE IS NOT A ROUND IN THE CHAMBER!
- Now that you are sure the gun is unloaded, you may proceed in the disassembly
- Send the Bolt "Home" by releasing the Bolt Catch
- By using a small diameter drive tool, push both takedown pins from left to right until they stop (Figure 11)

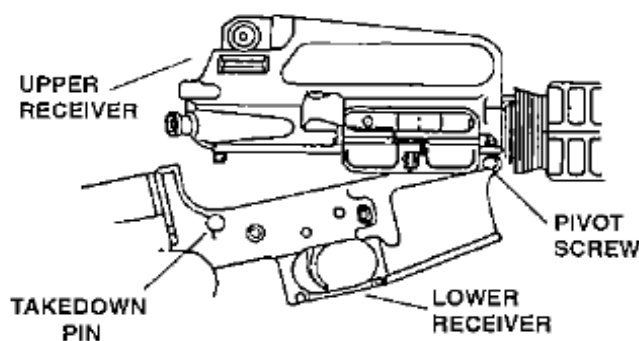


FIGURE 11 - RECEIVERS SEPARATED

- Separate the receivers by holding the grip with one hand and pulling the upper receiver up and forward
Note: The charging handle must be in the closed position; there will be some resistance due to the close tolerance fit between the upper and lower receivers
- You may now pull back on the charging handle to remove the bolt carrier assembly (figure 12)

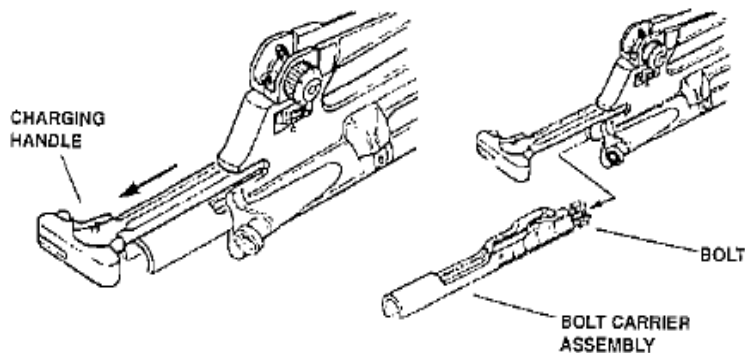


FIGURE 12 — REMOVE BOLT CARRIER ASSEMBLY

DISASSEMBLY CONTINUED

Remove the buffer spring and buffer assembly by depressing the detent in the lower part of the buffer tube. Use caution as buffer spring will be under pressure! (Figure 16, 17)

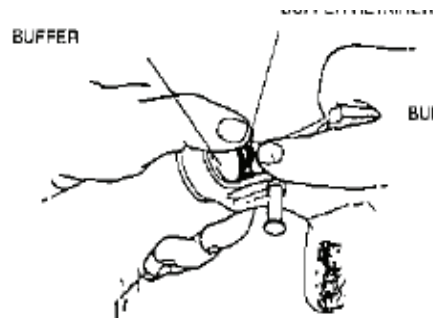


FIGURE 16 — BUFFER RETAINER DEPRESSED TO START BUFFER

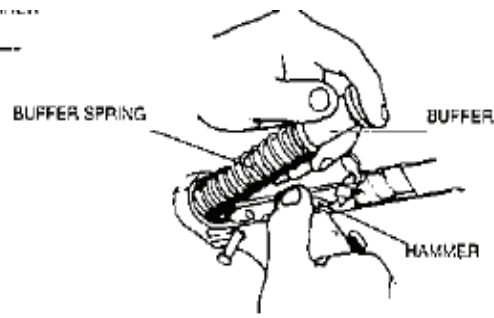
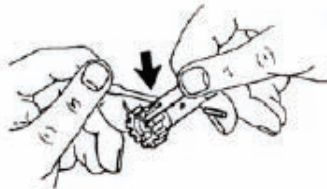
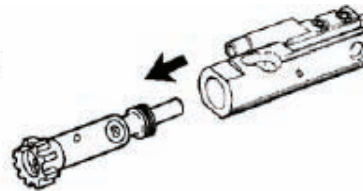


FIGURE 17 — BUFFER AND ACTIONS SPRING REMOVED

5. Remove bolt assembly from carrier.



6. Push extractor pin out

Note: Press rear of extractor to check spring function. Remove extractor pin by pushing out with a punch, or the tip of a bullet.

7. Remove extractor and spring.
Caution: Extractor spring may pop out and get lost.



**Bolt assembly should be disassembled only when dirty or damaged.
Always replace damaged parts or see a qualified gunsmith.
(Steps 6 & 7)**

INSPECTION BEFORE LUBRICATING...

- Check the bolt - Look for cracks or fractures. Bolts with any pitting extending into the firing pin hole should be replaced
- Check the firing pin - If it is bent, cracked, or too sharp, it should be replaced
- Check the extractor and extractor spring. If the extractor is chipped or has broken edges in the area of the lip that engages the cartridge rim, it should be replaced
- Check the cartridge guide for wear or damage. To reassemble, make sure the cartridge guide is pressed back into place and the end should pop into the hole

LUBRICATION

ALWAYS USE A HIGH QUALITY FIREARM LUBRICANT!

UPPER AND LOWER RECEIVERS:

Lightly Lubricate

- The inside of the upper receiver, bore and chamber (using cleaning rod and patch)
- The firing pin
- The charging handle and the inner and outer surfaces of the bolt carrier

Generously Lubricate

- All moving parts inside the lower receiver (trigger, hammer, safety, bolt catch, etc) and all its various pins and detents. Don't forget the takedown, pivot pins and their detents
- The bolt, cam pin area and bolt gas rings. The carrier key should be dried with a pipe cleaner and add one drop of oil. Wipe off fingerprints (they can start the corrosion process) from exterior surfaces with a soft oiled rag

ANY FURTHER DISASSEMBLY SHOULD ONLY BE DONE BY A QUALIFIED GUNSMITH OR BY THE SIONICS REPAIR FACILITY.

TROUBLESHOOTING

PROBLEM

WON'T FIRE

CHECK FOR:

Selector lever on SAFE

Too much oil in firing pin recess

Defective ammunition

Too much carbon on firing pin or in firing pin recess

WHAT TO DO:

Put it on FIRE

Wipe out with pipe cleaner

Remove and discard

Clean

WON'T EXTRACT

Dirty or corroded ammo

Carbon in chamber

Fouling or carbon in extractor recess

Remove stuck round
push out with cleaning rod

Clean chamber

Clean extractor

WON'T FEED

Dirty or corroded ammo

Dirty magazine

Defective magazine

Too many rounds in magazine

Action of buffer assembly is restricted

Magazine not fully seated

Clean/replace

Clean

Clean

Remove excess

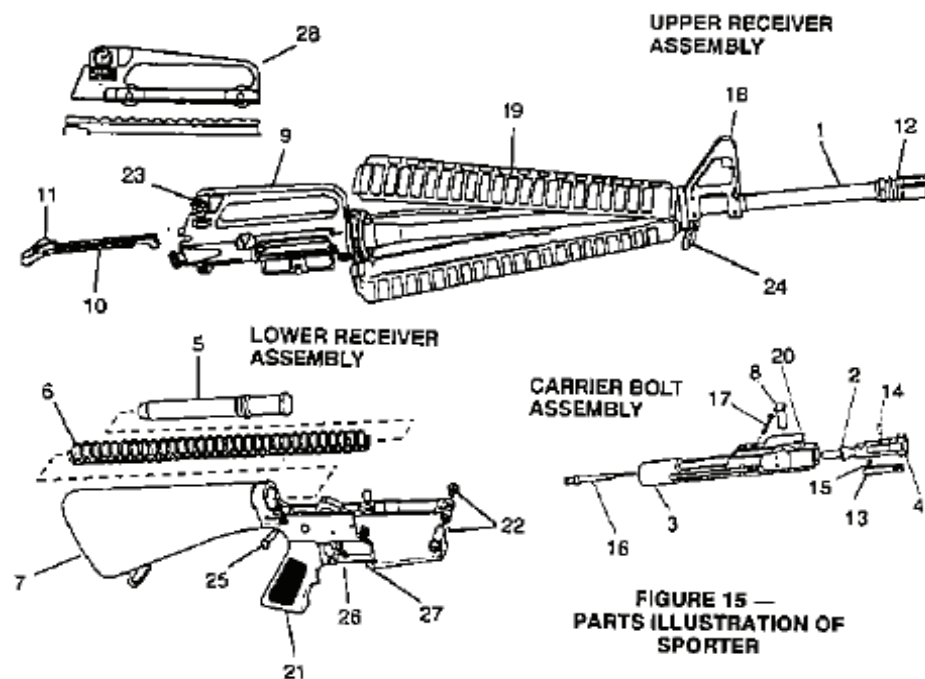
Clean Buffer

Firmly seat magazine

Limitation of Damages:

Except where prohibited by law, Sionics will not be liable for any loss or damage arising from the use of this firearm, whether direct, indirect, consequential, or punitive. This warranty gives only the original purchaser specific legal rights; other rights may also be available, which may vary from state to state.

- | | |
|---------------------------|---|
| 1. Barrel | 15. Extractor Spring Assembly |
| 2. Bolt | 16. Firing Pin |
| 3. Bolt Carrier | 17. Firing Pin Retaining Pin |
| 4. Bolt Locking Lugs | 18. Front Sight |
| 5. Buffer | 19. Handguard Assembly (2) |
| 6. Buffer Spring | 20. Key |
| 7. Buttstock | 21. Pistol Grip |
| 8. Cam Pin | 22. Pivot Screw |
| 9. Carrying Handle | 23. Rear Sight Assembly |
| 10. Charging Handle | 24. Sling Swivel |
| 11. Charging Handle Latch | 25. Takedown Pin |
| 12. Compensator | 26. Trigger |
| 13. Extractor | 27. Trigger Guard |
| 14. Extractor Pin | 28. Carrying Handle (for flat top receiver) |



NOTES

Model _____

Serial Number _____

Caliber _____

Date Purchased _____

Purchased At _____

Other:

Ammunition: SIONICS Rifles are designed and tested using premium, commercial ammunition - we do not recommend using reloaded, surplus or ammunition from an unknown source.