USERS HANDBOOK

THIS HANDBOOK REFERS TO S510 XS TDR MODELS

PLEASE READ THIS MANUAL BEFORE USING YOUR NEW RIFLE, IT CONTAINS IMPORTANT SAFETY INFORMATION AND INSTRUCTION ON ADJUSTMENT AND MAINTENANCE.

Safety First

- Always treat your air rifle or pistol as if loaded. Never assume it is clear. CHECK.
- When first picking an air rifle or pistol up, check to make sure it is not cocked or loaded.
- Never leave your rifle or pistol cocked or loaded.
- Never leave a cocked or loaded rifle or pistol unattended.
- Always point your rifle or pistol in a safe direction. Never point the gun at anyone.
- Always know the back drop to your shooting. Make sure you know where your pellets are going.
- Be aware of ricochets.
- Always conduct yourself in a sports-man like manner.

Be aware that your actions will be under the scrutiny of other members of the public who may not share your enthusiasm for air gun shooting. Bad practises promote bad publicity. Do not jeopardise your future enjoyment by misusing this rifle.

Contents Of The Box

- 1 x S510 TDR with 2 magazines and moderator
- 1 x Thread protector (packed with tool kit)
- 1 x Manual
- 1 x Tool kit. This kit consists of 1 x 1.5mm Allen key, 1 x 2.5mm Allen key
  1 x 4mm Allen Key
  1 x Filling adaptor

Important Information

WARNING ! - UNAUTHORISED DISASSEMBLY OF THIS RIFLE WILL INVALIDATE THE MANUFACTURERS WARRANTY. THIS INCLUDES ANY ANTI-TAMPER DEVICES FITTED.

Before leaving the factory this rifle was Q.A. inspected and test fired using Air Arms pellets to check operation and final adjustment.

It was dispatched in a sealed purpose designed box. Air Arms may not be responsible for any damage to the contents or missing items if the box is not original, if it is damaged or the seals are not intact.

Air Arms cannot be held responsible for damage or missing items due to transit damage, mishandling or being tampered with after leaving the factory.

If this rifle is not received in the original box with the seals intact, please examine carefully for any damage, missing tools or documentation.

In the first instance any problems or complaints regarding this product should be referred to the supplier.

The air cylinder is a highly pressurised unit that must not be modified in any way. Serious personal injury may result if this, and the advice below is not followed.

Important Information (Continued)

Do not pressurise the cylinder if there are any surface abrasions or dents. Contact Air Arms for advice.

Do not store the rifle in places with, or near sources of high temperature such as fires or boilers.

Air Arms recommend using a dry pack filter kit on any hand pumps used to fill our air rifles.

If accessories not manufactured by Air Arms are used on this rifle, Air Arms can not be held responsible for any loss of performance or damage to your rifle. Contact your supplier or Air Arms for any advice on this matter.

Do not store this rifle in a damp place such as garden shed or garage.

Do not store this rifle in a plastic or PVC gun bag without first applying a surface corrosion inhibitor.

Always ensure the loading bolt is fully closed before firing.

Do not attempt to dismantle when pressurised.

Do not pressurise beyond the stated filling pressure (see filling instruction section). Damage caused by such action is not covered by the manufacturers warranty.

Only use clean, filtered and dry compressed air. Never use any other gas, particularly industrial or welding gases such as oxygen, carbon dioxide, acetylene, hydrogen, argon, etc.

If compressed air is being used other than from a diving shop, the inside of the cylinder should be inspected for corrosion at least annually. If in doubt contact Air Arms for advice.

In any event the cylinder should be inspected every two years. Air Arms can provide this service at a reasonable cost.

To maintain this rifle in good working order it should be serviced annually by a competent gunsmith, your supplier may be able to provide this service or contact Air Arms.

A reasonable amount of advice will be provided to enable the end user to service their own rifle, however this is at the discretion of Air Arms and may not be given in all cases.

The velocity of this rifle has been set using Air Arms Field pellets. If any other make or type of pellet is to be used the rifle must be re-tested, to ensure the muzzle energy is within the limits determined by current legislation.

Due to the nature of hand pumps and their relative inefficiency in removing moisture from the compressed air, the chances of corrosion damage to the cylinder and other internal components are increased. Therefore the rifle should be regularly serviced and/or checked for any signs of damage by a competent gunsmith.

CHECKING VELOCITY

1. Use a reliable chronograph to check velocity, (the formula below requires the reading to be in feet per second - FPS)
2. Use fine measurement scales to weigh the pellet, if scales are unavailable the pellet weight may be stated on the pellet container lid or contact the supplier. (The formula requires the weight to be in grains). To convert from grams to grains multiply by 15.432, i.e. 0.69 grams x 15.432 = 10.65 grains.
3. To find the muzzle energy in ft/lbs use the formula (FPSxFPSxGrains)/450240, i.e. (700x700x10.65) = 5218500 divide by 450240 = 11.59.

CURRENT LEGISLATION LIMITS NON-FAC HOLDERS, IN THE UK, TO AIR RIFLES WITH A MAXIMUM OF 12ft/lbs MUZZLE ENERGY.

WARNING! IT IS A VERY SERIOUS OFFENCE TO BE IN POSSESSION OF AN AIR RIFLE THAT YOU ARE NOT CERTIFIED FOR. CONVICTION CAN RESULT IN CONFISCATION OF YOUR RIFLE, A HEAVY FINE OR IMPRISONMENT, EVEN A COMBINATION OF ALL THREE.

***** LIMITED LIABILITY WARRANTY *****
UK Customers only.

This product is warranted to the retail customer for 3 years from date of purchase against defects in materials and workmanship and is NOT transferable to any subsequent owner. Proof of purchase is required to receive warranty repairs, retain your purchase invoice and return the warranty registration card as soon as possible after purchase. The warranty card must show the dealer/supplier name and address and date of purchase.

What is covered

- Replacement parts & labour on a ‘back to base’ basis, return transportation to the consumer (mainland UK only).

What is not covered

- Transportation from the consumer to Air Arms.
- Damage caused by misuse, abuse, lack of routine maintenance, transit damage between the dealer/supplier and the consumer or unauthorized disassembly.
- Parts subject to normal wear and tear.
- Any other consequential cost incurred by the consumer.
- Return transportation to consumers outside mainland UK.

<u>No warranty is implied as to the fitness for any particular purpose.</u>

Unpacking

The rifle is packed from the factory with the moderator fitted and the butt stock packed separately in the case. The thread protector will be packed with the tool kit and filling adaptor.

There is a packing piece of foam used to fill the void where you scope will fit once attached to your rifle. It is suggested you keep this piece for use should you ever transport the rifle with no scope attached.

There is also a section for tins of pellets in the case. This area is supplied with two foam in-fills for use depending on pellet tin size.

Assembly And Disassembly Of The Rifle

The S510 TDR has the ability to be broken down into three component parts.

1. The main rifle body
2. The moderator or thread protector (if the moderator is not fitted.)
3. The butt stock

To Remove Or Fit The Moderator

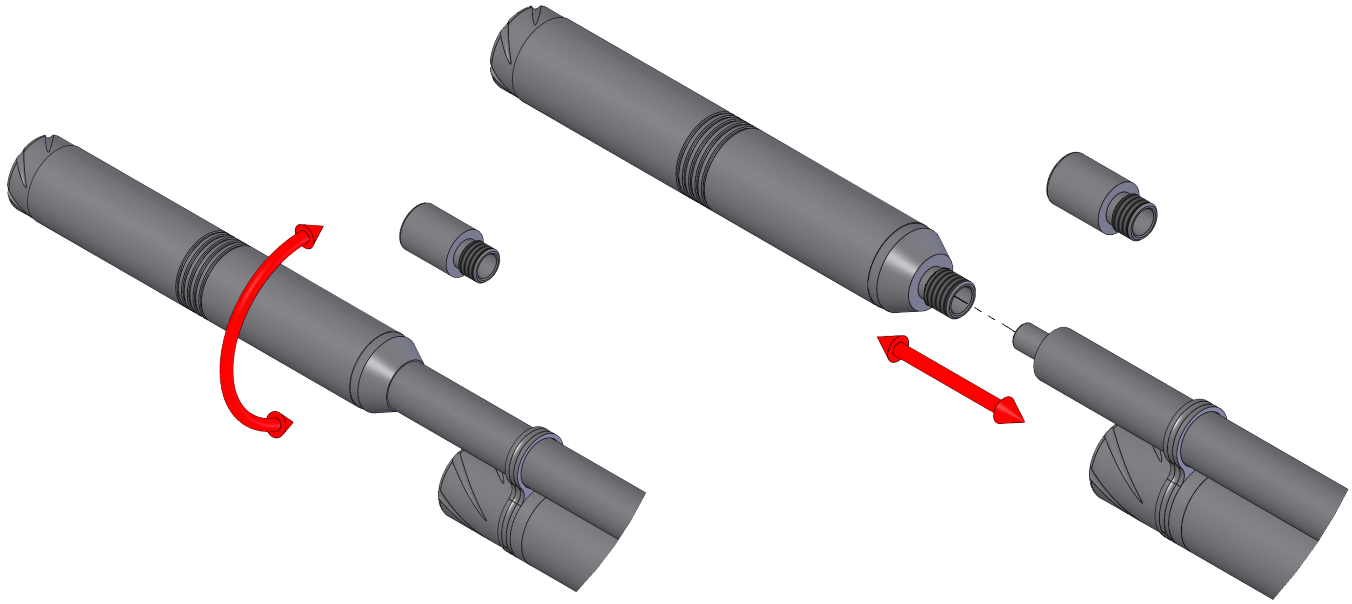
Always ensure the rifle is NOT cocked or loaded during the assembly or disassembly procedure

The moderator is fitted to the rifle via a threaded boss.

To remove the moderator, simply unscrew it in a clockwise direction as you look down the barrel. Once the thread is completely unscrewed the moderator will slide off of the end of the barrel.

To refit the moderator is the reverse process. Do not over-tighten the moderator as it only needs to be 'nipped' up to the shroud.

It is recommend that the thread protector be used if the moderator is not fitted to the rifle.



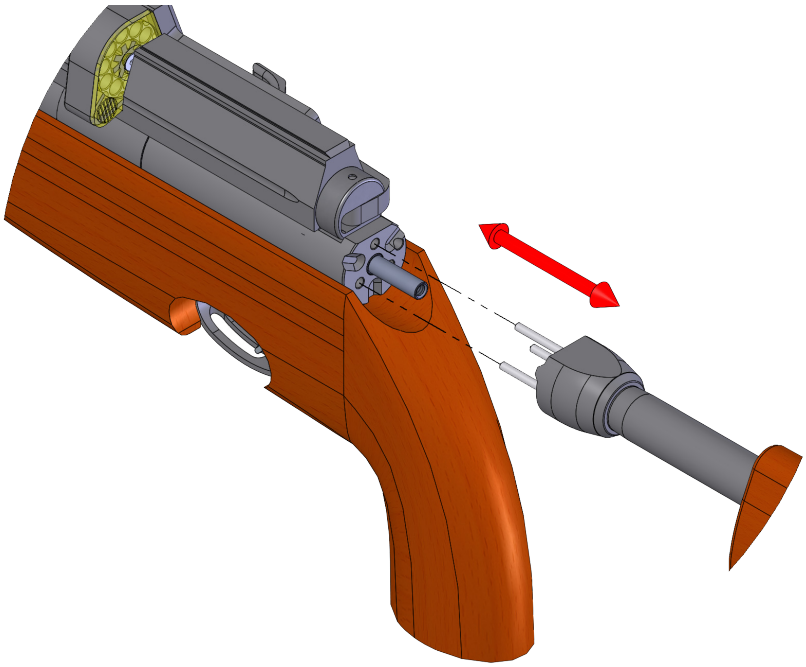
Assembly And Disassembly Of The Butt Stock

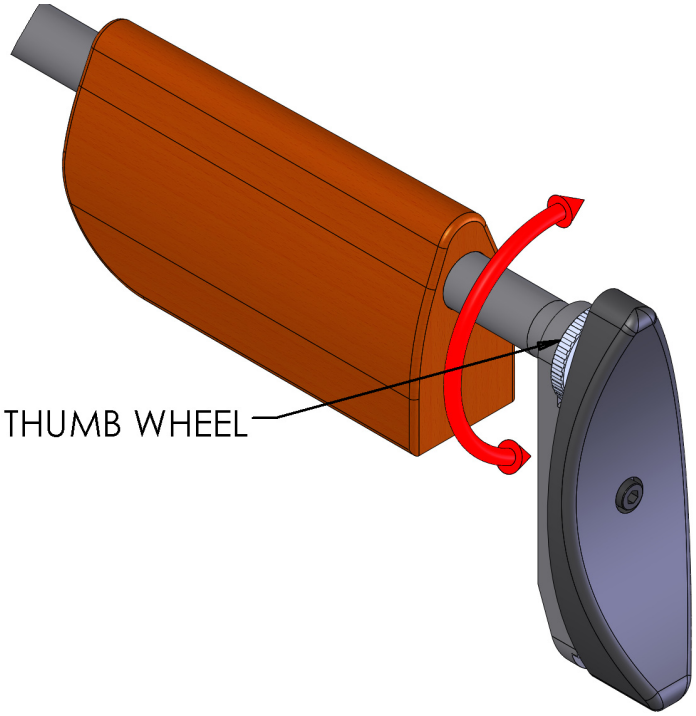
The butt stock can be removed from the main rifle to allow it to be packed into a smaller carrying case.

To fit the rear stock, slide the assembly onto the centre rod and align the three pins with the holes in the main body. Once aligned push the assembly into the body and turn the thumb wheel clockwise to tighten the action.

To remove the stock turn the thumb wheel anti-clockwise.

Please note that the rifle will be very low powered when the butt stock is not fitted and is not designed to be fired in this state. The pellet may not leave the barrel. As such it is recommended NOT to fire the rifle without the butt stock fitted.





Safety Function

The S510 TDR is fitted with a manual through-trigger safety button. This allows a mechanical lock on the trigger mechanism making the rifle safe.

To make the rifle safe press the button on the trigger in on the left hand side, this applies the lock.

To release press the button in on the right hand side of the trigger, this will allow the rifle to discharge.

Please note that it is possible to stop the safety button working properly with incorrect or poorly adjusted trigger adjustments.

With the button pressed in the rifle is safe

With the button out the rifle is now ready to fire

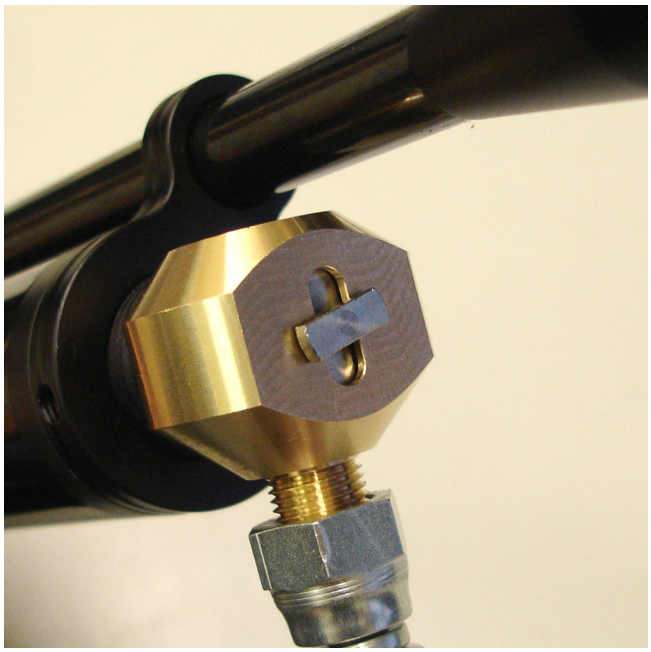
Filling Instructions

NOTE! ONLY USE CLEAN, DRY AND FILTERED COMPRESSED AIR, PREFERABLY FROM A DIVING SHOP. OVER PRESSURISATION MAY DAMAGE THE CYLINDER BEYOND REPAIR.

First the female part of the filling kit (this was supplied with the rifle) must be fitted to your filling equipment. The female part (S475) has a 1/8th BSP male thread that screws directly into the hose of your pump or bottle.

Next remove the dust cover from the end of your rifle. This is achieved by unscrewing the cover in an anti-clockwise direction.

Once the connector is exposed the adaptor on the filling kit can be placed over the male connector. Pass the Tee-piece of the male connector through the slot in the female and twist the female to hold in place.



With the female in place the gun can now be filled.

If the rifle is empty the mechanism will need to be cocked to allow the firing valve to close. If the rifle is not cocked when the bottle is opened or the pump used, the air will pass the valve and exhaust through the barrel.

Check that the bleed valve on the filling equipment is closed (turn clockwise to close) then slowly open the main valve on the bottle or start using the pump. The pressure in the hose will equalise and then the rifle will start to fill.

If you are filling your rifle from empty there may be some air exhausted through the barrel until the air pressure is sufficient to overcome the firing valve spring, this will happen at approximately 50 bar (750psi). This is normal.

The filling pressure of the S510 XS TDR high power is **250 bar (3626psi)**. Filling to a higher pressure will not increase either power or number of shots. Over filling will lower the power and may cause irreparable damage to the cylinder.

Once the filling pressure has been reached, close the valve on the bottle or stop pumping, open the bleed valve on the filling kit (to vent the hose, if you do not vent the hose you will not be able to remove the female from the rifle). Now the female connector can be removed from the rifle and end cap can be replaced over the male connector ensuring not to overtighten.

The S510 XS TDR range of rifles are fitted with a pressure gauge (manometer) mounted on the underside of the rifle just in front of the stock screw. This gauge provides the user with a visual check on the amount of air remaining in the cylinder. The on board gauge should not be used during the filling process as the needle reaction speed has been slowed to prevent damage whilst filling. After filling, the needle can take several seconds to synchronize with the air in the cylinder. The gauge below shows a gun with just over 150 bar of pressure. Although every gun is slightly different the recommended refill pressure for the S510 XS TDR is 150 bar. **Always use the gauge on the filling kit.**

Using Hand Pumps

The procedure for using hand pumps is the same as for bottle. It is more important to turn the female on the gun to lock it in place. When using the pump it must be remembered that the first few strokes on the pump are filling the hose and NOT the gun. When the pressure in the hose equalizes that of the gun, the cylinder will start to fill. It can take some effort to fill the cylinder to capacity using a pump and we recommend using the pump to top up instead of filling from empty.

WARNING NOTE CONCERNING 300 BAR BOTTLES

WITH THE ADVENT OF THE 300 BAR BOTTLE IT SHOULD BE NOTED THAT CARE HAS TO BE TAKEN WHEN FILLING YOUR RIFLE.

THE FILLING PROCEDURE DESCRIBED IN THIS MANUAL MUST BE FOLLOWED TO AVOIDED DAMAGE TO THE RIFLE, PARTICULARLY THE SLOW OPENING OF THE VALVE ON THE BOTTLE. OPENING THE VALVE QUICKLY WILL ALLOW UP TO 300 BAR OF PRESSURE INTO THE CYLINDER AT ONCE, THIS COULD CAUSE SERIOUS PERSONAL INJURY OR IRREPARABLE DAMAGE TO THE CYLINDER.

Cylinder Information

On the front of the cylinder is an engraved warning...

'READ MANUAL. COMPRESSED AIR MWP ###bar. MFP ###bar. DOM ##/##/####. INSPECT BI-ANNUALLY'

- MWP - Maximum working pressure. The pressure stated may differ from model to model. This is the pressure the rifle should be filled to for best performance.
- MFP - Maximum filling pressure. The pressure stated may differ from model to model. This is the maximum pressure the cylinder should be filled to avoid potentially damaging the rifle.
- DOM - Date of cylinder manufacture. The date is stated.

There is also a 5 digit tracking number used during production (internal use only).

Note: Filling the cylinder above the recommended working pressure level will NOT improve performance or shot count. For best results please refer to the fill pressure stated above.

Only compressed air should be used in Air Arms products.

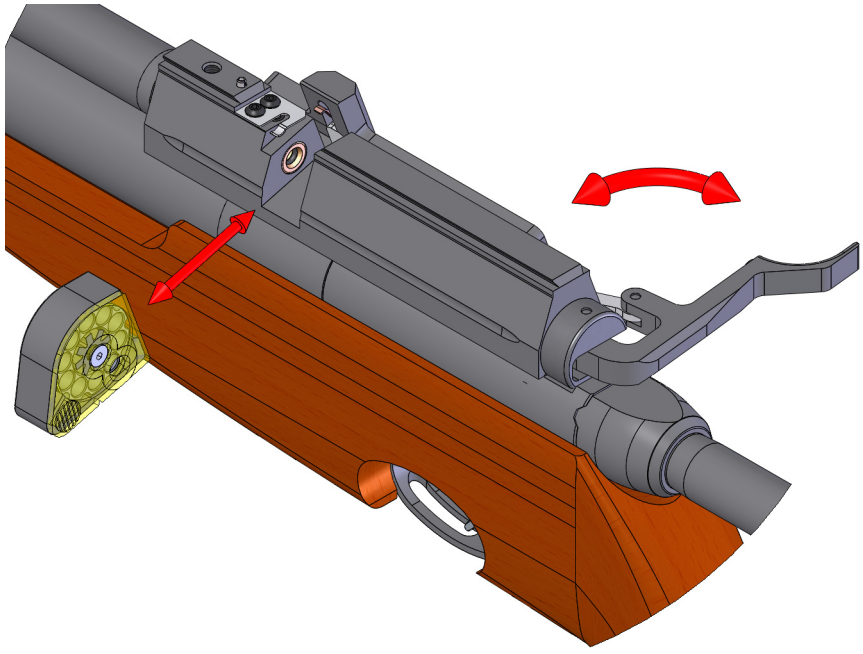
Loading The Magazine

The S510 XS TDR is fitted with a self indexing magazine system that has to be loaded with pellets in order to use the rifle.

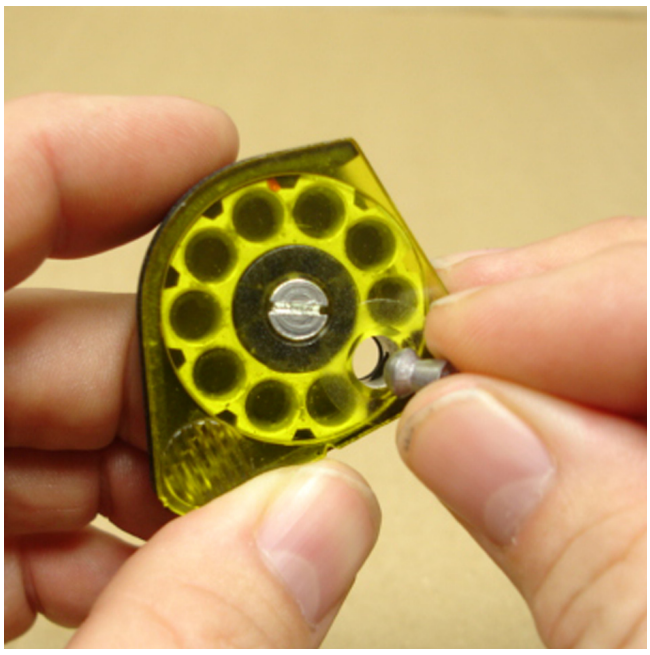
The magazine has a ten shot capacity and will auto-rotate each time the rifle is cocked.

First Remove The Magazine From The Rifle

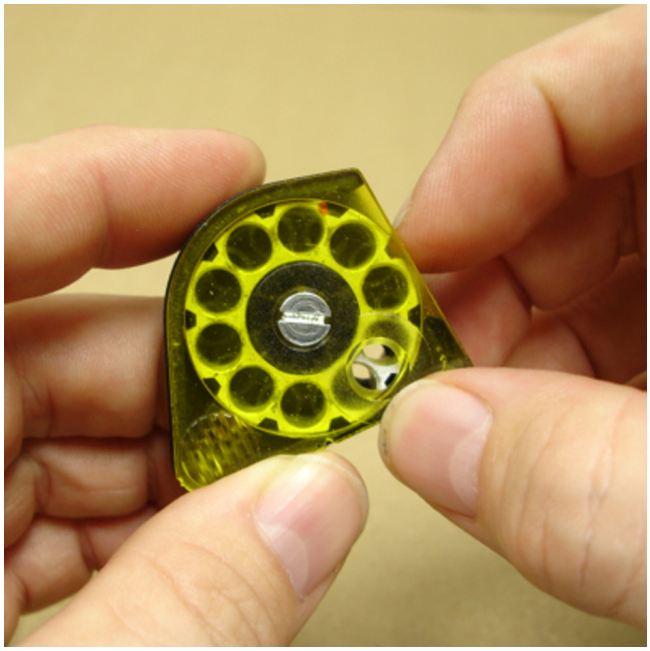
Apply the safety button. Holding the rifle, open the cocking lever and pull it to the rear position. Holding the lever in the rear position, the magazine can be removed from the breech. Pinch the magazine from the bolt housing. It should slide out without much resistance. If it does not move make sure you have the cocking lever pulled back completely. This will ensure the loading bolt is not engaged with the magazine.



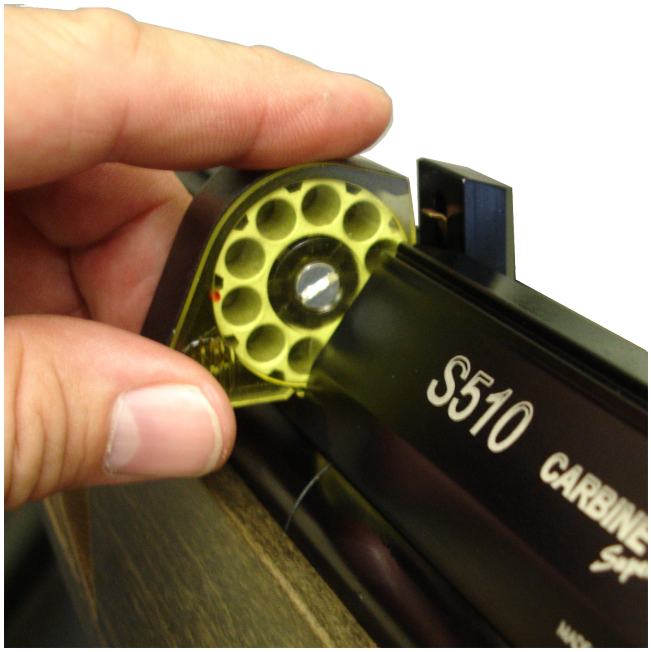
Pinch the magazine out of the housing



Load the pellets into the empty chambers



Manually turn the pellet carrier to the next empty chamber and load another pellet



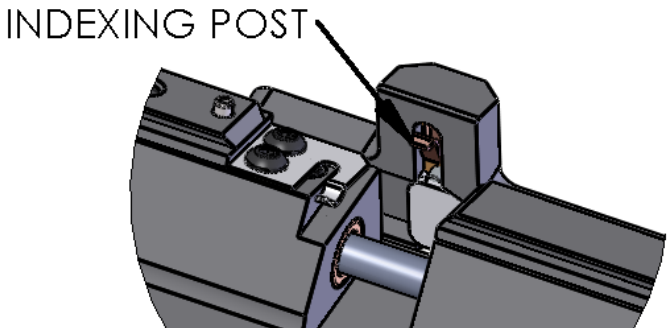
Reload the magazine back into the housing keeping the magazine pressed to the base of the slot.

With the magazine back in the breech the cocking lever can now be closed. This action will push a pellet into the barrel.

Caution the rifle is now 'LIVE' and ready to fire.

From this point on each time the cocking lever is operated the magazine will present a new pellet into the breech. Care should be taken not to double load pellets into the barrel.

Note About Indexing Post And Magazine



Be very careful not to damage the indexing spring when demounting or mounting the magazine. Follow the instructions carefully.

A small drop of oil should be applied occasionally to the magazine 'O' ring to keep it moist, and increase its life span.

Operating Instructions

Cocking The Rifle

Hold the rifle securely in one hand and with the other hand open the cocking lever and pull to the rear. At the end of the stroke the magazine will index and present a new chamber to the barrel, the trigger mechanism will also engage. This can be determined by the trigger blade 'kicking' forward at the end of the cocking stroke. A soft 'click' may also be heard. The effort required to cock the gun is quite low so minimal force should be used. Push the cocking lever forward into the closed position, the rifle is now cocked and loaded.

The rifle is now ready to fire. After firing simply repeat the cocking action to engage the action and load another pellet.

Note ! It is very important that the cocking lever is pulled back to the correct position, in one positive motion. The magazine indexes to the next pellet position as the bolt is retracted and it is possible for a partial index to occur if the lever is not pulled back fully.

If you find the mechanism has not cocked completely but the magazine has indexed, pull the lever all the way back and remove the magazine, manually index the magazine back to an empty chamber, replace the magazine and fire as normal. If this procedure is not followed it is likely that you will load a second pellet into the barrel.

De-cocking The Rifle

If you find you need to de-cock your rifle at any time, the simplest solution is to fire it into some soft ground.

If for any reason this is not possible take the following steps.

1. Apply the safety button
2. Operate the lever as if to cock the rifle.
3. Remove the magazine, clear it of pellets and refit.
4. Hold the cocking lever in the backwards position release the safety button and fire the rifle off in a safe direction.
5. The tension on the lever will increase slightly as the spring load is transferred from the striker to the cocking lever.
6. Now allow the lever to move forwards under your control until the spring tension is dispersed.
7. Close the lever as normal.

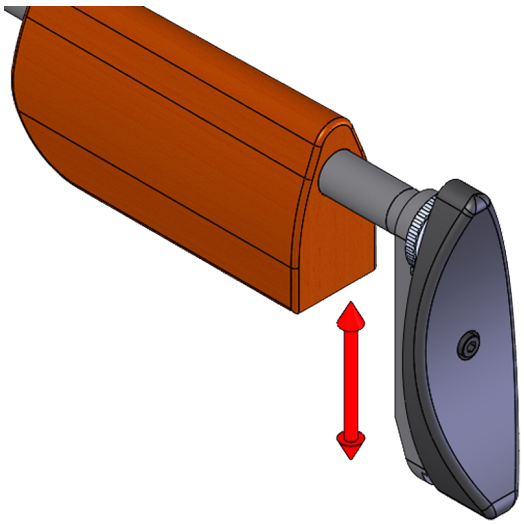
Be aware. If you are de-cocking the rifle after it was loaded the de-cocking process will still leave the pellet in the barrel.

Butt Pad Adjustment

The butt pad on the S510 TDR is adjustable in the vertical plane up and down.

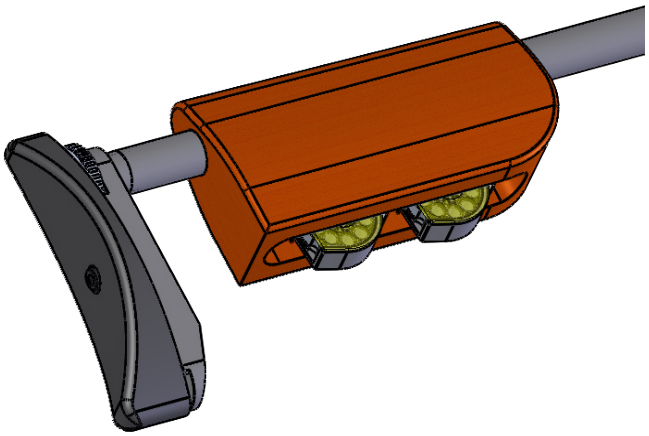
Using the 4mm allen key provided, loosen the screw in the centre of the pad, slide the rubber section of the pad into the desired position and re-tighten the screw.

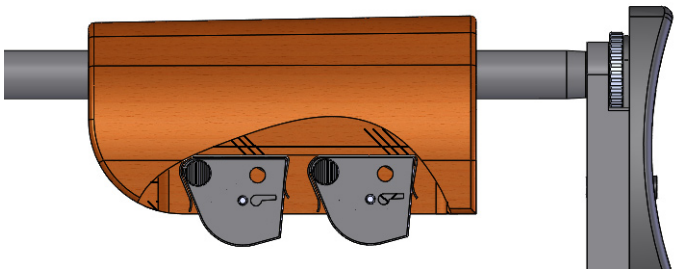
Do not over tighten the screw.



Spare Magazine Storage

The S510 XS TDR has location for 2 spare magazines in the butt stock. The magazines are held in place in two spring clips. Align the magazines in the orientation as the clips (as per the cut out image below) and simply push into place.



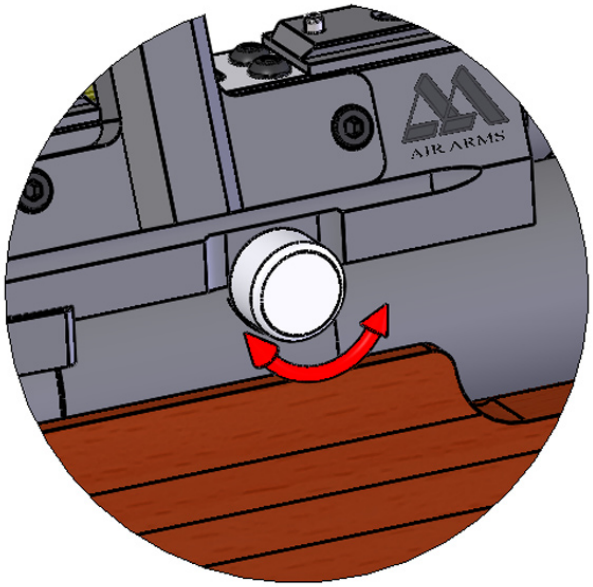


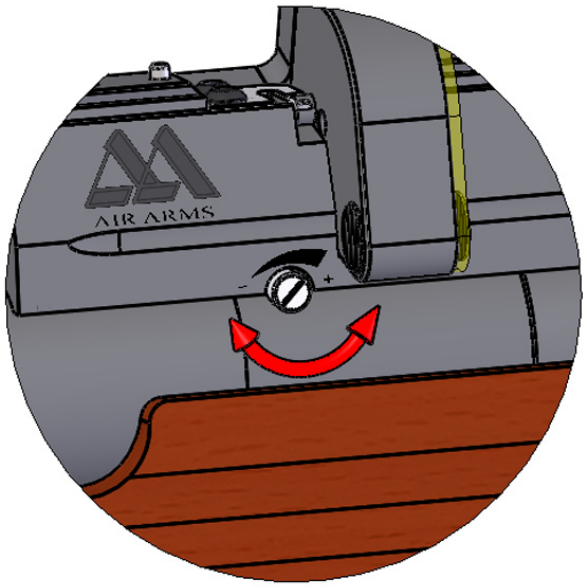
Power Adjuster

The S510 XS TDR high power is fitted with a power knob on the right hand side of the rifle. The adjuster allows the rifle to be set at various power levels depending on the shooter's requirements. On the left hand side of the action are indicator markings to show where in the power output the rifle is set.

There are 5 'click' points to choose and it is suggested that some time is taken to familiarise your self with the characteristics of each setting.

With the knob rotated completely anti-clockwise the power is on its highest setting.





Trigger Adjustments

The S510 XS TDR models all have a two stage trigger unit which allows adjustments to both stages plus a weight of pull screw for further adjustment. It is easy to upset the balance between the two stages and make the trigger inoperable if incorrectly adjusted.

If you have no experience of adjusting two stage trigger units, seek guidance or leave the trigger as set by the factory.

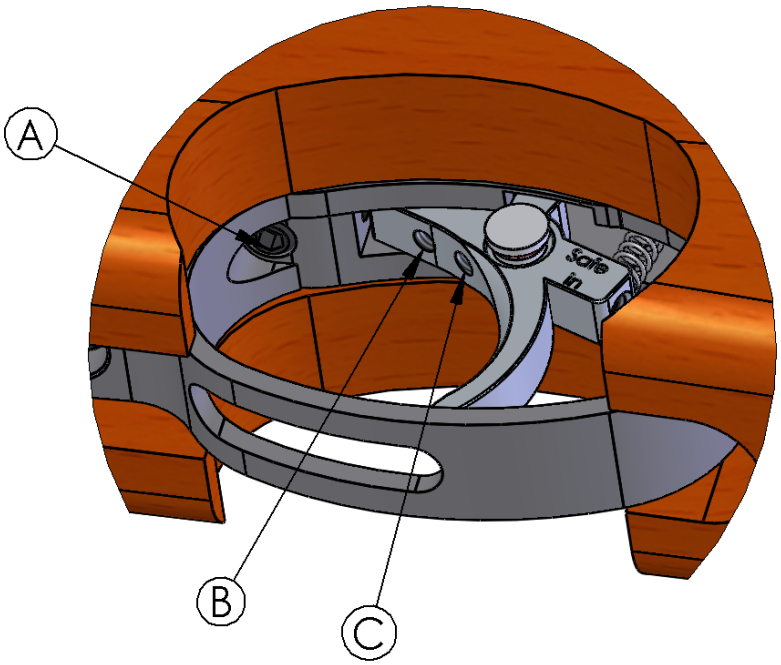
Note! *Incorrectly adjusted trigger mechanisms are not covered by the manufacturers warranty. It is not possible to test this rifle with an incorrectly adjusted trigger, therefore all triggers leave the factory with correct adjustment.*

WARNING! ***Please note that it is possible to stop the safety button working with an poorly adjusted trigger. AN INCORRECTLY ADJUSTED TRIGGER CAN MAKE THE RIFLE UNSAFE TO HANDLE.***

Description Of Operation

The S510 XS TDR rifles have a true two stage trigger mechanism. This means that as the trigger is pulled the bottom sear gradually disengages with the top sear until the two disengage completely and the rifle goes off. If the pressure on the trigger is released at any point before full disengagement, the bottom sear will automatically return back to full engagement. This type of trigger allows very fine but safe operation because it is the release of the 2nd stage that actually makes the rifle fire. This arrangement is vastly superior to pseudo two stage triggers where the first stage is just a pivoting trigger blade that does not move sears. The down side is that they are more difficult to adjust correctly.

Adjustment



There are three adjuster screws, A-B-C.

The weight of pull adjuster (A) is located in the front of the trigger guard. Clockwise rotation increases pull weight. If adjusted too far the spring will become coil-bound and prevent trigger operation.

The second stage adjuster (C) is the rear screw located in the trigger blade. This screw determines the exact point that the 2nd stage starts. If the 1st stage screw is incorrectly adjusted this screw may not have any effect.

The first stage adjuster (B) is the front screw located in the trigger blade. This screw determines the length of travel before the 2nd stage starts. Clockwise adjustment reduces the first stage travel.

Maintenance

NOTE: Before carrying out any maintenance on your rifle, confirm it is not cocked or loaded and remove the magazine.

Fixings

Regularly check the fixing screw on the main stock body to ensure firm fixing. There is only one screw used to hold the action in the stock. This is a 6mm bolt up into the action on the under side of the rifle just forward of the gauge.

Use a 5mm Allen key to check the screw tightness. Always take care not to over tighten any bolts or screws on the rifle.

Barrel Cleaning

To ensure ultimate accuracy it is good practise to clean the barrel regularly. It is difficult to advise how often this should be as shooting practises differ, but in general every 1000 shots will keep the barrel clean and lubricated.

At Air Arms we use Napier products.

Cleaner:	*Napier Gun Cleaner*
Oil:	*Napier Gun Oil*
Pull through pad:	*Napier Rifle Clean*
Pull through line:	*Napier Pull Through Kit, strong fishing line will work*

1. Cut a piece of line 3 times the length of your barrel, fold the line in half and tie the ends together. Remove moderator if fitted and open the breech.
2. Feed the untied end of the line down the barrel from the muzzle end until it protrudes from the breech approximately 50mm.
3. Cut approximately 60mm of 'Rifle Clean', fold it in half and pass it through the looped end of the line.
4. Apply a little of the 'Gun Cleaner' to the pad, being careful not to soak the mechanism, and slowly pull the pad through the barrel.
5. Repeat this action until the pad comes through clean.
6. Now repeat once more using 'Gun Oil' instead of cleaner to re-lubricate the barrel.

Once the cleaning process is complete, shoot the rifle several times at non-critical targets to remove any excess oil.

NOTE: Cleaners designed for shotguns and full/small bore rifles will not be suitable for air rifle barrels unless specifically stated by the manufacturer.

Lubrication

Lubrication of the internal components is outside the scope of this manual. Internal maintenance should be carried out by Air Arms or any other competent gunsmith.

It is good practise to remove the action from the stock and clean the underside if the rifle has been used in wet conditions.

Removing The Stock

There is only one screw used to hold the action in the stock. This is a 6mm bolt up into the action on the under side of the rifle just forward of the gauge.

This screw uses a 5mm Allen key.

Always take care not to over tighten any bolts or screws on the rifle. Remove the screw and the action will lift free of the stock.

The re-fitting of the stock is the reverse process to above.

External Surfaces

Wipe all external metal over with an oily rag to clean and protect the surface from corrosion caused by moisture or other contaminants that may damage the surface finish.

The stock is an oil finish.

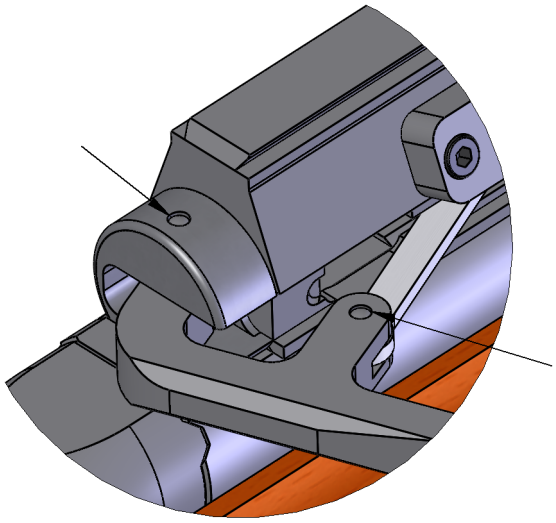
Wipe clean all surfaces and remove moisture after shooting to reduce risk of damage. The oiled stock will also benefit from an application of an oil such as linseed or danish oil from time to time. Apply the oil to the clean surface using a lint free rag or '000' wire wool, use sparingly in line with manufacturers guidance. Always allow the oil to dry before storing your rifle.

Magazine

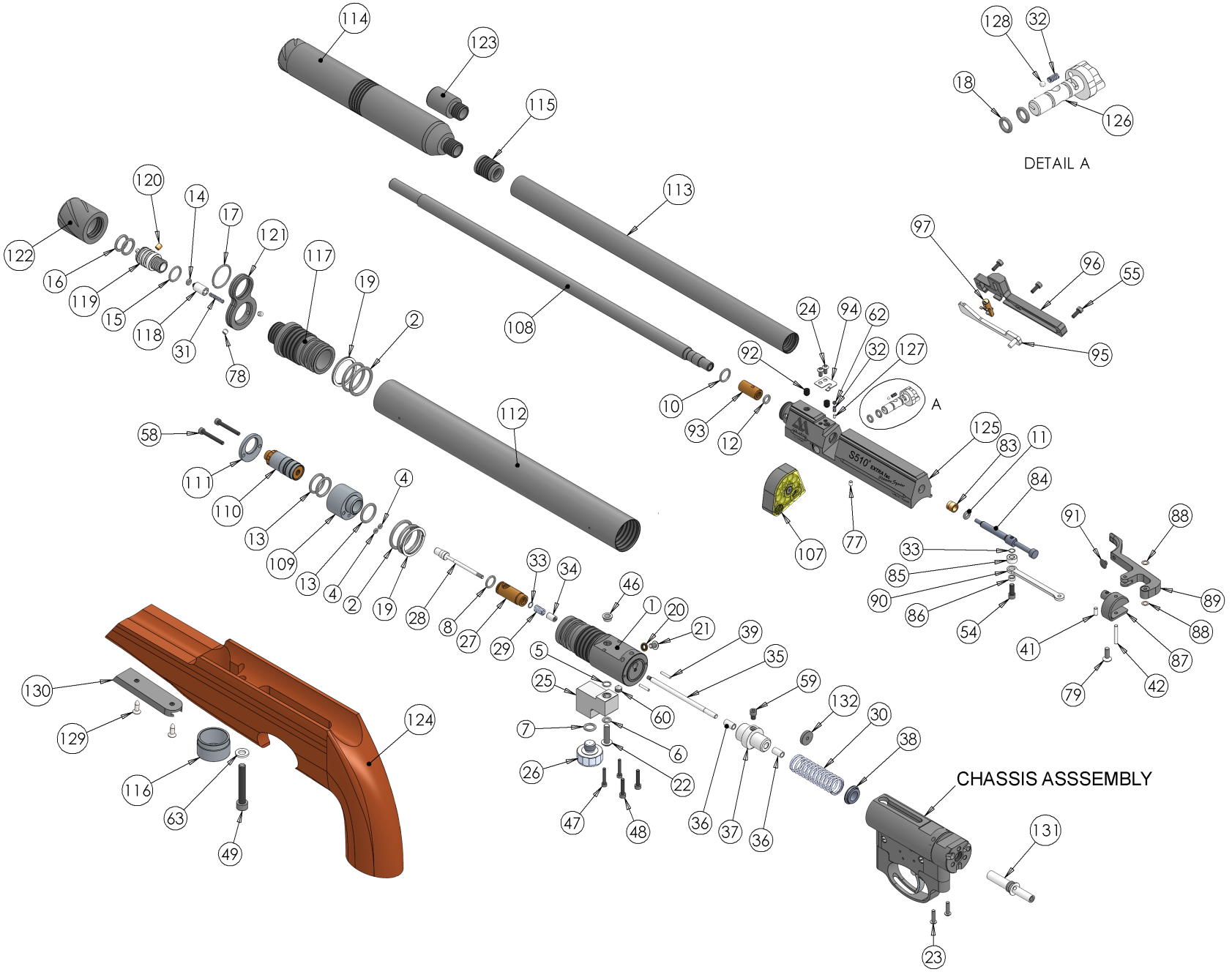
The O ring on the magazine should be kept moist and this is achieved by applying a single drop of oil from time to time. This will keep the O ring lubricated and increase the life of this component.

Cocking Lever

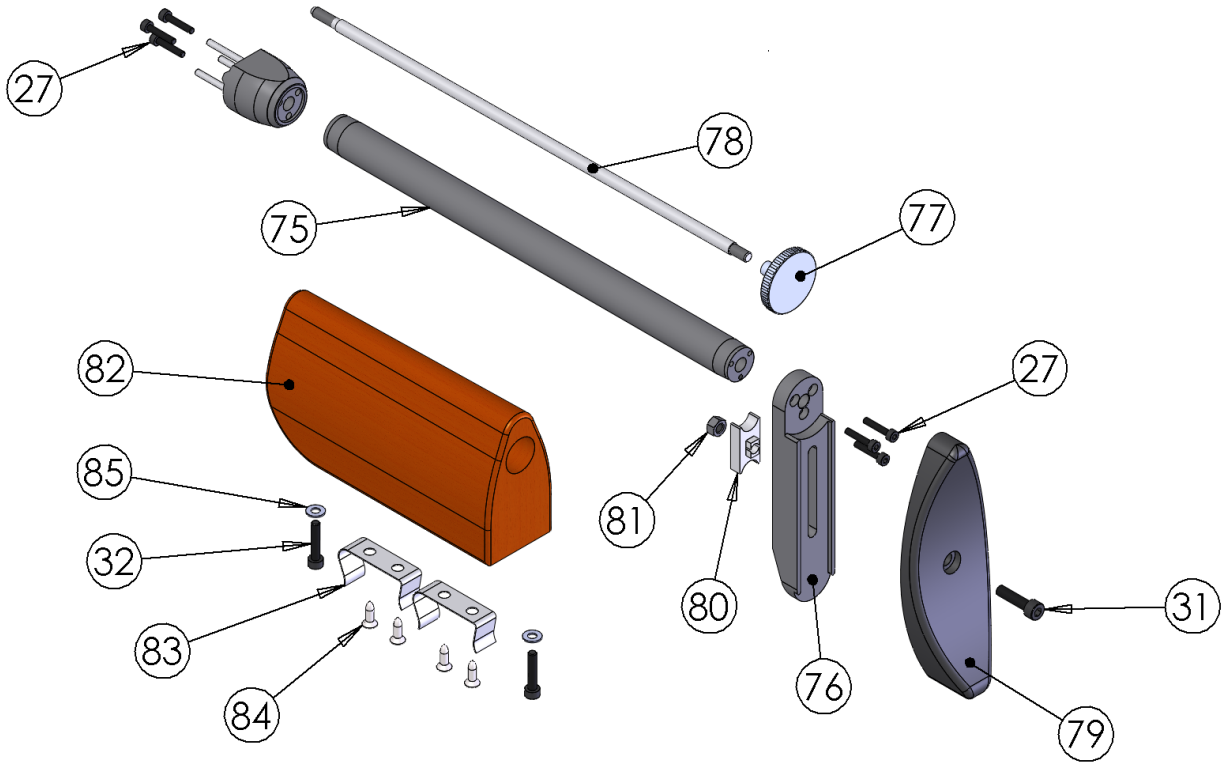
Apply a small amount of oil (a drop or two) to the pivot point of the cocking lever.



ITEM NO.	PART NUMBER	DESCRIPTION	QTY	ITEM NO.	PART NUMBER	DESCRIPTION	QTY	ITEM NO.	PART NUMBER	DESCRIPTION	QTY
1	KS507-R	FIRING VALVE BODY TDR	1	37	S520H-R	STRIKER HP	1	96	S550-R	SIDE PLATE ADJ HP - REGULATED	1
2	S836	23 X 2.5 NBR90	4	38	KS530AT	REAR GUIDE	1	97	S515A	INDEXING POST ASSY	1
4	S960	2 X 1.5 NBR90	2	39	S326	2 X 11.8 ROLLER	2	107	S555A	MAGAZINE YELLOW - .177	2
5	S427	6 X 1 NBR70	1	41	E127	3 X 7.8 ROLLER	1		S555A-US	MAGAZINE GREY - .177	
6	S536	BS008 NBR70	1	42	RN355	3 X 19.8 ROLLER	1		S555B	MAGAZINE - .22	
7	RN219-9	BS011 NBR70	1	43	CHASSIS	CHASSIS ASSEMBLY	1		S555B-US	MAGAZINE GREY - .22	
8	S966	8 X 1.5 NBR70	1	46	S610-HP-R	TRANSFER PORT BUSH HP	1	108	S401F-BO	BARREL - .22	1
10	S337	10 X 1.5 NBR 70	1	47	S946	M2.5 X 16 SKT CAP	2		S401G-BO	BARREL - .177	
11	S140	.22 BUFFER	1	48	RN102A	M3 X 16 SKT CAP	2	109	S936-25	REGULATOR HOUSING	1
	S142	.177 BUFFER		49	S625	M6 X 40 SKT CAP	1	110	S962A-150	SERIES 6 REGULATOR - 150 BAR	1
12	S538	BARREL SEAL - .22	1	54	S355H	M4 X 10 MODIFIED	1	111	S938	REGULATOR RETAINER	1
	FP121	BARREL SEAL - .177		55	S565	M3 X 8 SKT CAP	3	112	S950S-R	CYLINDER SHORT- REGULATED	1
13	S342	15 X 2 NBR90	3	58	S346	M3 X 50 SKT CAP	2	113	KS600HC-SL	BARREL TUBE - TDR	1
14	S327	BS005 NBR90	1	59	S356H	M4 X 5 MODIFIED	1	114	S710-KS2-177	MODERATOR 177	1
15	S484	12 X 1.5 NBR70	1	60	S934	M6 X 6 SKT SET CONE PT	1		S710-KS2-22	MODERATOR 22	
16	S474	12 X 2 NBR70	2	62	TX237	M3 X 3 SKT SET CONE PT	1	115	KS133	SHROUD INSERT	1
17	S484H	20 X 1.5 NBR70	1	63	S655	M6 WASHER	1	116	S640R-BK	STOCK RING	1
18	E880-6	BS0031-16 NBR70	2	77	S303	M3 X 3 SKT SET FT PT	1	117	S491-R	FILLING VALVE BODY	1
19	S837	23 X 2.5 BACKUP RING	2	78	TX228	M4 X 4 SKT SET FT PT	2	118	S473	FILLING VALVE	1
20	S912	BONDED SEAL	1	79	S322	M4 X 12 CSK SKT	2	119	S472	MALE CONNECTOR	1
21	S928	M4 X 6 SKT BTN	1	83	S501-SL	BOLT HSE BUSH .22 - SL	1	120	S471	SINTERED FILTER	1
22	S968	M5 X 16 SKT BTN	1		S502-SL	BOLT HSE BUSH .177 - SL		121	S382H-SL	FRONT CLAMP	1
23	KS318	M3 X 12 SKT BTN	2	84	S540A-SL	LOADING BOLT STEM - 177	1	122	E483BK	END CAP - BLACK	1
24	RN193	M3 X 6 SKT BTN	2		S540B-SL	LOADING BOLT STEM - .22		123	KS134	THREAD PROTECTOR	1
25	S640AT	GAUGE MOUNT	1	85	S541	LOADING BOLT BEARING	1	124	KS630	STOCK - WALNUT	1
26	S645	INDICATOR GAUGE	1	86	S542	SIDE LEVER BUSH	1		KS630-K	STOCK - BLACK	
27	S932-HP	VALVE SEAT - HP	1	87	KS130	COCKING ARM PIVOT BLOCK	1	125	S500H-R	BOLT HOUSING HP ADJ	1
28	S370H-R	FIRING VALVE HP	1	88	E160	M3 CRINKLE WASHER	2	126	S508-R	POWER ADJUSTER	1
29	S942	COMPRESSION SPRING	1	89	S125	COCKING ARM	1		S508L-R	POWER ADJ - LOCKABLE	
30	S331	COMPRESSION SPRING	1	90	S264	COCKING LINK	1		S508UL-R	POWER ADJ - TAIWAN	
31	S319	COMPRESSION SPRING	1	91	TX227	BUFFER	1	127	S517	DOWEL	1
32	S522	COMPRESSION SPRING	1	92	RN113	M5 X 6 SKT SET CUP PT	2	128	S528	7/64" BALL BEARING	1
33	S541-1	BEARING SHIM	2	93	S402AH-R	BARREL SEAL HOLDER HP .22	1	129	KS445	No.6 x 0.50	2
34	S940	VALVE STEM NUT	1		S402BH-R	BARREL SEAL HOLDER HP .177		130	KS441	TDR RAIL	1
35	KS340-R	GUIDE ROD TDR - REGULATED	1	94	S505	MAG RETAINING CLIP	1	131	KS342-R	BUTT MOUNT FIXING	1
36	E222	BUSH	2	95	S560	CAM PLATE	1	132	S952	SPRING BAFFLE	1


DETAIL A
A
CHASSIS ASSSEMBLY

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
27	RN102A	M3 X 16 SKT CAP	6
31	E420	M5 X 20 SKT CAP ST/ST	1
32	KS626	M4 X 20 SKT CAP	2
75	KS440	CHEEK PIECE TUBE	1
76	KS457	BUTT PAD BASE PLATE	1
77	KS460	WHEEL	1
78	KS465-2	REAR STOCK FIXING SCREW MK2	1
79	RN455	BUTT PAD	1
80	RN462	BUTT PAD LOCKING PLATE	1
81	KDT005	M5 NUT	1
82	KS630A	CHEEK PIECE	1
83	KS631	MAGAZINE SPRING	2
84	KS445	No.6 x 0.50	4
85	KS627	M4	2



ITEM NO.	PART NUMBER	DESCRIPTION	QTY
9	S526	3 X 1 SiR70	1
31	S319	COMPRESSION SPRING	1
32	S522	COMPRESSION SPRING	1
39	S326	2 X 11.8 ROLLER	3
40	TX398	3 X 11.8 ROLLER	1
43	KS317-3-R	STRIKER BODY REGULATED - TDR	1
50	TX236	M4 X 16 SKT CAP	1
51	S496	M3 X 6 SKT CAP	1
52	S316	M4 X 25 SKT CAP	1
53	TX460	M4 X 12 SKT CAP	1
61	S524	M3 X 4 SKT SET CONE PT	2
66	S313	TRIGGER CHASSIS	1
67	S325-2	MIDDLE SEAR	1
68	S321-2	BOTTOM SEAR	1
69	S320-2	TOP SEAR	1
70	S495	TOP SEAR SPRING	1
71	S420S-2	TRIGGER BLADE	1
72	S521-2A	SAFETY BUTTON - PART ONE	1
73	S521-2B	SAFETY BUTTON - PART TWO	1
74	S523	3/32" BALL BEARING	1
75	TX432	ADJUSTER SCREW LOCKING PAD	1
76	S421	M3 X 10 SKT SET FT PT	2
79	S322	M4 X 12 CSK SKT	2
80	S314	TRIGGER GUARD	1
81	S318	COVER PLATE	1
82	RN106	M3 X 6 CSK SLOT	2
135	S311	COMPRESSION SPRING	1