



AR-15 SEMI-AUTOMATIC INSTRUCTION/SAFETY MANUAL

GUN SAFETY



Warning: Cancer and Reproductive Harm
www.P65Warnings.ca.gov

1. Treat every weapon as if it were loaded
2. Never point your weapon at anything you don't intend to shoot
3. Keep your finger straight and off the trigger until ready to fire
4. Keep your weapon on **SAFE** until ready to fire
5. Know your target and what is beyond

WARNING: Improper use of this firearm can result in injury, death, or damage to property. For questions concerning the safe handling of this firearm, please contact San Tan Tactical's Customer Service Department at **(817)-752-5423**.

LEGAL NOTICE: San Tan Tactical shall not be responsible for injury, death, or damage to property resulting from either intentional or negligent discharge of this firearm, or from its function when used for purposes or subjected to treatment for which it was not designed. San Tan Tactical 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, or the use of ammunition other than original high quality commercially manufactured ammunition in good condition, or any combination thereof. San Tan Tactical will not honor claims involving this firearm for any reason or cause when such claims are made by the second or subsequent owner.

IMPORTANT: Before this firearm left the factory it was tested, carefully inspected, and packaged. San Tan Tactical 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. The dealer will be pleased to assist you in making this examination and endeavor to answer any further questions.

ATTENTION: End user is responsible for knowledge of local, state, and federal laws, and for adhering to all regulations. San Tan Tactical is not responsible for misuse of any products.

ABOUT THE MANUAL

This manual covers all STT-15 Rifles and Pistols based on an AR-15 platform configuration built with a billet receiver set.

- STT-15-6ARC 18" Rifle+ Gas 6mm ARC
- STT-15L-6ARC-LITE 18" Rifle+ Gas 6mm ARC
- STT-15 5.56 7.5" Pistol Gas
- STT-15 5.56 10.5" Pistol Gas
- STT-15 5.56 16" Rifle Gas
- STT-15 300 BO 7.5" Pistol Gas
- STT-15 300 BO 10.5" Pistol Gas
- STT-15 300 BO 16" Pistol Gas

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MAIN FEATURES

The STT-15 Rifles and Pistols are a lightweight, semi-automatic firearm. Features include a wedgelock MLOK rail system and an ambi-billet receiver set.



The STT-15 Pistol is functionally identical in the operation and maintenance of the STT-15 Rifle.



- 1 — Upper Receiver
- 2 — Lower Receiver
- 3 — Stock / Brace
- 4 — Barrel
- 5 — Magazine
- 6 — Stock Release Button
- 7 — Bolt Release
- 8 — Trigger
- 9 — Safety Selector Lever
- 10 — Charging Handle
- 11 — Handguard
- 12 — Pistol Grip

SAFETY INSTRUCTIONS

PLEASE FOLLOW ALL SAFETY INSTRUCTIONS FOR THE SAFETY OF YOURSELF AND OTHERS.

GENERAL SAFE HANDLING

- **TREAT EVERY WEAPON AS IF IT WERE LOADED** to avoid negligent discharge which could cause injury, death, or damage to property.
- **NEVER POINT YOUR WEAPON AT ANYTHING YOU DON'T INTEND TO SHOOT** to avoid negligent discharge which could cause injury, death, or damage to property.
- **KEEP YOUR FINGER STRAIGHT AND OFF THE TRIGGER UNTIL READY TO FIRE** to avoid a negligent discharge.
- **KEEP YOUR WEAPON ON SAFE UNTIL READY TO FIRE** to avoid negligent discharge which could cause injury, death, or damage to property.
- **KNOW YOUR TARGET AND WHAT IS BEYOND** before firing to avoid injury, death, or damage to property.
- **VERIFY THAT THE FIREARM IS UNLOADED AND ON SAFE** with your finger off the trigger and the firearm pointed in a safe direction to avoid discharging the firearm unintentionally.
- **ALWAYS TRANSPORT YOUR FIREARM UNLOADED** so that your firearm cannot be discharged unintentionally. The end user assumes all responsibility to comply with local, state, and federal laws regarding transportation of firearms.
- **NEVER LEAVE A FIREARM UNATTENDED.** Included with this firearm is a child safety lock for your use.

RANGE SAFETY

- **ALWAYS BE SURE YOUR BACKSTOP IS ADEQUATE** to stop and contain bullets before beginning practice so that you do not hit anything outside the range shooting area.
- **ALWAYS PUT A KNOWLEDGEABLE AND RESPONSIBLE PERSON IN CHARGE TO MAINTAIN SAFETY CONTROL WHEN A GROUP IS FIRING ON A RANGE.** Obey their commands so that discipline is maintained to reduce the likelihood of accidents.
- **ALWAYS CARRY YOUR FIREARM EMPTY WITH THE BOLT LOCKED OPEN WHILE ON A RANGE** until preparing to fire. Keep it pointed towards the backstop when loading, firing, and unloading to eliminate the risk of injury, death, or property damage from negligent discharge.

LOADING SAFETY

- **ALWAYS BE SURE BARREL BORE, CHAMBER, AND ACTION ARE CLEAN AND CLEAR OF OBSTRUCTIONS.** Clean a wet or fouled firearm immediately so that it will function correctly and safely.
- **ALWAYS USE CLEAN, DRY, ORIGINAL, HIGH-QUALITY COMMERCIALLY MANUFACTURED AMMUNITION IN GOOD CONDITION WHICH IS APPROPRIATE TO THE CALIBER OF YOUR FIREARM.**
- **ALWAYS CHECK THAT AMMUNITION IS CLEAN AND UNDAMAGED BEFORE USING THE FORWARD ASSIST.** Forcing damaged ammunition into the chamber could damage your firearm and result in injury, death, or property damage.

LOADING CAUTIONS

- **NEVER CONSUME ALCOHOLIC BEVERAGES OR TAKE DRUGS BEFORE OR DURING SHOOTING** as your vision, coordination, and judgment could be seriously impaired, making firearm handling unsafe.
- **ALWAYS SEEK A DOCTOR'S ADVICE IF YOU ARE TAKING MEDICATION** to be sure you are fit to handle a firearm safely.
- **ALWAYS WEAR AND ENCOURAGE OTHERS TO WEAR EAR PROTECTION WHEN SHOOTING**, especially on a range. Without ear protection, the noise from your firearm and other firearms close to you could leave a "ringing" in the ears for some time after firing, while the cumulative, long-term effect could result in permanent damage.
- **ALWAYS WEAR AND ENCOURAGE OTHERS TO WEAR PROTECTIVE SHOOTING GLASSES.** Flying particles could damage eyes and cause blindness.
- **ALWAYS KEEP THE SAFETY SELECTOR LEVER SET TO SAFE** when your firearm is loaded until you are aimed at your target and intend to fire to minimize the risk of a negligent discharge.
- **ALWAYS KEEP YOURSELF AND OTHERS CLEAR OF THE EJECTION PORT.** Spent cartridges are ejected with enough force to cause injury. The ejection port must be unobstructed to ensure safe ejection of spent rounds. Never place fingers in the ejection port; they could be burned by hot metal or injured by the bolt moving forward.
- **NEVER SQUEEZE THE TRIGGER OR PUT YOUR FINGER IN THE TRIGGER GUARD UNTIL YOU INTEND TO SHOOT** and are aimed at your target to prevent negligent discharge of the firearm while it is pointing in an unsafe direction.
- **ALWAYS BE 100% SURE OF YOUR TARGET AND THE AREA BEHIND AND BEYOND IT** before you squeeze the trigger. If you are at all in doubt about what is behind or beyond

your target, do not shoot.

- **NEVER ATTEMPT TO DISCHARGE A FIREARM WITH AN OBSTRUCTED BORE.**
- **NEVER SHOOT AT A HARD SURFACE, SUCH AS ROCK, OR A LIQUID SURFACE, SUCH AS WATER.** A bullet may ricochet and travel in any direction striking you, others, or surrounding objects that you may be unable to see, resulting in injury, death, or damage to property.
- **NEVER DISCHARGE A FIREARM NEAR FLAMMABLE MATERIAL.** Flame and sparks erupt from the firearm when discharged, potentially starting a fire or causing flammable liquids and gases to explode.

MALFUNCTIONS

- **IF YOU EXPERIENCE A FAILURE TO FIRE, HOLD THE FIREARM POINTING TOWARDS THE TARGET OR SAFE OPEN AREA AND WAIT.** If a hangfire (slow ignition) has occurred, the round will fire within a short period of time. If the round does not fire, cycle the bolt, eject the round, and examine the primer.
- **NOTE 1:** It is normal for a light firing pin indent to appear on the primer of cartridges that have been fed into the chamber but not fired.
- **NOTE 2:** Dispose of any misfired rounds in accordance with the ammunition manufacturer's instructions.

CLEANING & STORAGE

- **ALWAYS MAKE SURE YOUR FIREARM IS NOT LOADED AND ON SAFE BEFORE CLEANING AND STORING.**

- **REMOVE ALL AMMUNITION FROM THE AREA BEFORE DISASSEMBLY AND CLEANING YOUR FIREARM.**
- **ALWAYS KEEP AND STORE YOUR FIREARM AND AMMUNITION IN A SEPARATE LOCKED RECEPTACLE** out of reach and sight of children and untrained people, to minimize the risk of firearm and ammunition being readily available for loading and firing.

FIREARM ABUSE

- **NEVER ABUSE YOUR FIREARM** by using it for any purpose other than shooting.
- **NEVER DRY FIRE WHEN THE RECEIVERS ARE OPEN** as the lower receiver may be damaged.
- **NEVER ALTER PARTS** and only utilize OEM parts for necessary maintenance.

SAFETY FEATURES

TRIGGER GUARD

The Trigger Guard is a metal strip below the trigger to protect it from damage and prevent negligent discharge. The Trigger Guard on the STT-15 Rifles and Pistols feature radiused and beveled edges to accommodate shooters wearing gloves.

SAFETY SELECTOR LEVER

The Safety Selector Lever is located on the lower receiver’s left and right side and has two

positions, **FIRE** and **SAFE**. The bullet shape indicates **FIRE**, and the bullet shape with an X indicates **SAFE**. We will refer to **FIRE** when referencing the bullet shape or **SAFE** when referencing the bullet shape with an X.

When set to **FIRE**, the firearm will discharge a single shot each time the trigger is pulled. When set to **SAFE**, a cam bears upon the rear portion of the trigger, blocking the trigger’s sear surface and preventing the hammer from being released.

NOTE: The safety features on the STT-15 Rifles and Pistols are a mechanical safeguard. As with all mechanical systems, failures within this system are possible and may not be visible to the operator. Activating the safety selector lever to the **SAFE** position does not mean the firearm is incapable of firing if mishandled.

BOLT LOCKING

The firearm can discharge only when the Bolt is fully locked to the barrel, and the firing pin is free to move forward. The firing pin is prevented from reaching the cartridge by the Bolt Carrier. Only when the Bolt Carrier moves forward over the Bolt, rotating it to the fully locked position, can the firing pin move forward enough to fire the rifle. This design feature ensures that the firearm will not discharge before the cartridge is fully chambered and the Bolt is fully rotated (locked) to the barrel.

SEPARATION OF UPPER AND LOWER RECEIVERS

In the event of a functional problem, the lower receiver can be separated from the upper

receiver by pivoting it downwards after pushing out the rear takedown pin. The separation provides access to the mechanism and separates the firing mechanism from other components so that the cocked hammer cannot strike the firing pin.

NOTE: The Bolt Carrier Group must be in the full forward position to allow the upper receiver to separate from the lower receiver.

FUNCTION

The STT-15 Rifles and Pistols have a semi-automatic action.

- With the hammer cocked, chamber loaded, and safety selector lever set to **FIRE** the firearm may be discharged by squeezing the trigger. The trigger rotates, disengaging the trigger sear surface from the hammer. The hammer spring drives the hammer forward to strike the firing pin, which strikes the primer in the base of the cartridge, igniting the primer composition that ignites the main powder charge.
- High-pressure gases push the bullet down the barrel, where rifling grooves impart a stabilizing spin to the bullet. As the bullet passes the gas port (a small hole in the barrel below the front sight), gas is redirected, flows through the gas tube into the gas key, driving the bolt carrier group rearward. As the bolt carrier moves to the rear, the firing pin is withdrawn into the bolt while the cam track in the bolt carrier acts upon the bolt cam pin, causing the bolt to rotate until its locking lugs are no longer in engagement with the lugs of the barrel extensions.
- The bolt is now unlocked and is carried rearward by the bolt carrier.
- The extractor removes the spent case and holds it against the face of the bolt until the

ejectors push the spent case through the ejection port.

- The bolt carrier group continues rearward, compressing the action spring and returning the hammer to its cocked position until the buffer assembly strikes the bottom of the receiver extension and stops. The action spring then forces the bolt carrier group forward so that the bolt's face strips the next round of ammunition from the magazine and feeds it into the chamber. Simultaneously, the extractor engages the rim of the cartridge case, and the bolt locks into the barrel.
- The hammer is now held rearward by the disconnect. When the trigger is reset, the disconnect is rotated back releasing the hammer onto the sear. However, before the disconnect hook releases the hammer, the trigger sear surface is rotated in front of the hammer notch so that the hammer is held on the trigger sear surface, making the firearm ready for the next shot.
- This is a semi-automatic firearm and is automatically loaded and ready to fire again after each shot until the magazine is empty. To unload the rifle, the magazine must be removed, and the bolt carrier group must be pulled to the rear with the charging handle, extracting any round in the chamber.

AMMUNITION SELECTION

San Tan Tactical's systems are designed to function with various brands and types of factory manufactured ammunition in the appropriate caliber. NOT ALL AMMUNITION WILL PRODUCE THE SAME RESULTS. San Tan Tactical recommends that after you read and understand this manual, you go to the range and fire different ammunition, which is appropriate to your firearm's caliber. Once you find the ammunition which functions best – keep using it.

Ensure the ammunition selected is the correct caliber. San Tan Tactical does not recommend the use of any hand-loaded or re-manufactured ammunition.

FORWARD ASSIST

The forward assist is an emergency feature that enables you to help the bolt lock into the barrel, but should only be used on rare occasions if the bolt fails to lock fully. When you must use the forward assist, it usually indicates it's time for you to clean your firearm, paying particular attention to the bolt and the chamber's cleanliness.

CAUTION: ALWAYS CHECK THAT AMMUNITION IS CLEAN AND UNDAMAGED BEFORE USING THE FORWARD ASSIST. Forcing damaged ammunition into the chamber can damage your firearm and result in injury, death, or property damage.

LOADING MAGAZINE

Use only ammunition recommended inside the front cover of this instruction manual suitable for your firearm. Examine the ammunition, particularly on and around the primer. Look for dents, scratches, and other signs of damage. Do not load damaged ammunition. With the curved end of the magazine facing forward, place a round between the magazine's lips with the bullet forward. Press the round down until the magazine lips hold it. Place the next round on top of the previous round and repeat until the desired number is loaded.

CAUTION: TO MINIMIZE RISK OF UNINTENTIONAL DAMAGE, LOAD LIVE AMMUNITION INTO YOUR FIREARM ONLY WHEN YOU ARE ABOUT TO SHOOT.

LOADING FIREARM

Administrative Loading of Firearm:

- Ensure firearm is on **SAFE**, pointing in a safe direction, and you're not touching the trigger.
- Insert a loaded magazine into the magazine well and push/pull until the magazine is fully seated.
- Grasp charging handle and pull fully to the rear.
- Release charging handle allowing bolt to move forward freely and chamber first round. Don't manually assist the charging handle forward.
- Return charging handle fully forward until it locks forward. Now the firearm is considered loaded.

Bolt Lock Loading of Firearm:

- Ensure firearm is on **SAFE**, pointing in a safe direction, and you're not touching the trigger.
- Depress magazine release, removing expended magazine, if present.
- Insert a loaded magazine into the magazine well and push/pull until the magazine is fully seated.
- Depress bolt release button located on side of firearm. This will release the bolt allowing it to travel forward chambering the first round. Now the firearm is considered loaded.

CAUTION: NEVER LEAVE YOUR FIREARM COCKED AND LOCKED, READY TO FIRE, WITHOUT SELECTOR LEVER BEING SET TO SAFE, as this is extremely dangerous. Firearms can accidentally be discharged, causing injury, death or damage to property.

UNLOADING

CAUTION: ALWAYS UNLOAD YOUR FIREARM IMMEDIATELY AFTER USE AND BEFORE CLEANING AND STORAGE TO MINIMIZE THE RISK OF NEGLIGENT DISCHARGE.

READ THE SAFETY INSTRUCTIONS SECTION. KEEP YOUR FIREARM POINTING IN A SAFE DIRECTION AND FINGER OFF THE TRIGGER.

- Set the safety selector lever to **SAFE**. **NOTE:** The hammer must be cocked to place this firearm on **SAFE**.
- Press the magazine release button and remove the magazine.
- Pull the charging handle to the rear and push in the lower portion of the bolt catch. If a round has been in the chamber, it should have been ejected. If the last round had been fired, the bolt carrier group should already be held to the rear provided a magazine was in place. Push the charging handle until it locks.
- Inspect the chamber through the ejection port to make sure the chamber is empty.
- When the magazine is removed and the chamber is empty, push the top of the bolt catch to allow the bolt carrier group to return forward.
- Remove remaining live rounds by sliding them forward out of the magazine.
- Collect live ammunition for safe storage and spent cartridge cases for disposal.

FIRING SEQUENCE

KEEP YOUR FIREARM POINTING IN A SAFE DIRECTION AND FINGER OFF THE TRIGGER.

- Load the firearm as previously described.
- Grasp firearm with one hand on handguard and the other hand on pistol grip with the index finger resting along outside of trigger guard. Raise firearm and pull buttstock into shoulder – extend buttstock as necessary.
- Aim by aligning target with front and rear sights.
- Move safety selector lever to **FIRE**.
- Keeping steady aim, place index finger on the trigger and squeeze gently until the trigger hammer releases. Don't jerk the trigger as you will disturb your aim and ruin your accuracy. To fire the second and subsequent rounds, release the trigger and squeeze it again after every shot until you have completed firing or emptied the magazine.

CAUTION: Firearm can be fired without a magazine in place.

- Release trigger, remove finger from the trigger, and set the selector lever to **SAFE**. If you have fired the last round from the magazine, the bolt will be held to the rear so that the firearm can quickly be reloaded by replacing the magazine, or the chamber can be inspected to make sure it is empty.

CAUTION: While firing, if you notice a difference in sound or recoil, stop firing. A bullet could be stuck in the barrel. If you fire again before clearing the blockage, the barrel may bulge or burst and cause injury.

If this occurs, retract the bolt slowly to remove and identify the fired cartridge case. Clear the firearm and make sure the bore is clear. Any unburned propellant or obstruction in the bore must be removed before firing again to prevent the risk of damage and injury.

CAUTION: If your firearm fails to fire, hold it, keeping it pointed towards the target and wait. If a hangfire (slow ignition) has occurred, the round will fire within a short period of time. If the round does not fire, remove the magazine, eject the round, and examine the primer. If the firing pin indent on the primer is light, misaligned, or nonexistent, have your firearm examined by a competent gunsmith.

If the firing pin ended on the primer appears normal (compared with previously fired rounds) assume faulty ammunition; segregate the misfired round from the other live ammunition and empty cases; reload and carry on firing.

NOTES: On the STT-15 Rifles and Pistols, it is normal for light firing pin indent to appear on cartridges that have been fed into the chamber but not fired. Dispose of misfired rounds in accordance with the ammunition manufacturer's instructions.

CAUTION: Keep your firearm pointing in a safe direction. Unload as previously described.

IMPORTANT: If you load your firearm but do not fire it, keep the safety selector lever set to **SAFE** until you're ready to fire.

MAINTENANCE

Your STT-15 Rifles and Pistols will perform better, last longer, and remain safer when they are properly maintained. Follow the instructions in this section to keep your firearm in good condition.

CAUTION: UNLOAD THE FIREARM AS PREVIOUS DESCRIBED AND REMOVE ALL AMMUNITION FROM THE AREA BEFORE PERFORMING MAINTENANCE.

WEAR SAFETY GLASSES IN CASE YOU LOSE CONTROL OF ANY SPRING LOADED COMPONENTS WHICH COULD CAUSE INJURY.

STRIPPING FOR CLEANING

IMPORTANT: To prevent loss of small components during stripping and cleaning, lay them out on a flat surface in an orderly fashion.

Make sure the bolt carrier is in the forward position. Press the rear takedown pin in from the lower receiver's left side and pull the pin out of the receiver's right side until it comes to a positive stop (*Fig. 1*).

Pivot the lower receiver down and away from the upper receiver. If required for more convenience, completely separate the upper receiver from the lower receiver by pressing the front takedown pin from the left of the lower receiver and pull out the pin on the right of the receiver until it comes to a positive stop.

Pull the charging handle to the rear and remove the bolt carrier group. Remove the charging handle by pulling it backward and then down and out of the upper receiver (*Fig. 2*).



BOLT CARRIER DISASSEMBLY

Push the firing pin retaining pin from right to left of the bolt carrier group and remove the pin by pulling it out to the left (*Fig. 3*).

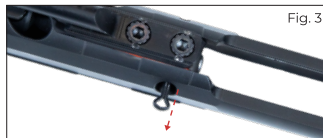


Fig. 3

Tilt the bolt face up and remove the firing pin (*Fig. 4*).

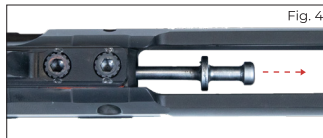


Fig. 4

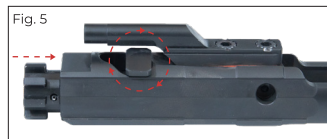


Fig. 5

Push the bolt towards the carrier until it rotates and comes to a stop, then turn the bolt cam pin 90° (*Fig. 5*).

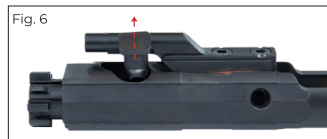


Fig. 6

Remove the cam pin by lifting it out and away from the bolt and bolt carrier (*Fig. 6*).



Fig. 7

Pull the bolt assembly and remove it from the bolt carrier (*Fig. 7*).

BUFFER AND BUFFER SPRING REMOVAL

Depress the buffer, maintaining pressure as the buffer is under spring tension, to prevent it from being ejected when the buffer retainer pin is depressed.

Depress the buffer retainer pin to permit the buffer and the action spring to move forward. Depress the hammer to allow the action spring and the buffer assembly to be removed entirely from the receiver extension.

IMPORTANT: DO NOT STRIP YOUR FIREARM FURTHER THAN PREVIOUSLY DESCRIBED. IF ADDITIONAL MAINTENANCE IS REQUIRED, SEE “SERVICE AND REPAIR” LATER IN THIS INSTRUCTION MANUAL. REASSEMBLE YOUR FIREARM BY REVERSING THE STRIPPING PROCEDURE ALREADY DESCRIBED AND ENSURING THAT THE CAM PIN IS INSTALLED CORRECTLY.

CAUTION: DO NOT ATTEMPT TO FIRE WITHOUT THE BOLT CAM PIN, MAY RESULT IN DAMAGE OR INJURY

WHEN TO CLEAN

- **BEFORE FIRING.** Make sure that the barrel and chamber are clean and dry.
- **AFTER FIRING.** Clean your firearm as soon as possible to reduce chances of corrosion.
- **PERIODICALLY.** When your firearm has not been fired, we suggest you clean it when necessary and at least once or twice a year in a temperate climate or as often as once a week in a tropical climate. If you carry a loaded firearm, UNLOAD it and clean it when necessary and at least once a month. If you get your firearm wet, clean it as soon as possible.

STORAGE

CAUTION: ALWAYS UNLOAD YOUR FIREARM FOR STORAGE AND STORE AMMUNITION SEPARATELY.

Store your firearm and ammunition securely locked in separate locations out of reach and sight of children.

SERVICING AND REPAIR

Contact San Tan Tactical for servicing, repair, and OEM parts.

An illustration and list of part names are included in the next section of this instruction manual to identify the parts you need. Parts should be installed by San Tan Tactical or by a

competent gunsmith. When ordering parts, provide the part name as it is given on the Parts List and the serial number of the firearm.

IMPORTANT: If you make unauthorized adjustments or use unauthorized parts, San Tan Tactical will not assume responsibility for this firearm's functioning, and your warranty may become void.

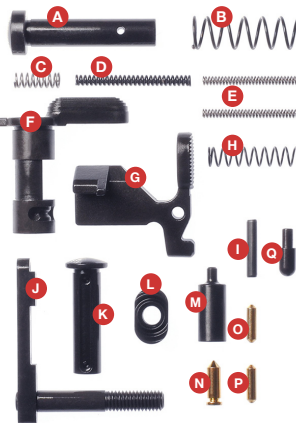
NOTE: This firearm is manufactured to perform correctly with the original parts as designed. You must make sure any parts you buy are installed correctly and that neither replacements nor originals are altered or changed. Your firearm is a complex tool with many parts that must relate correctly to other parts. Putting a firearm together incorrectly or with modified parts can damage the firearm and cause danger, injury, or death to you and others through malfunction. **ALWAYS LET A QUALIFIED GUNSMITH WORK ON YOUR FIREARM AND CHECK ANY WORK YOU THINK WAS NOT PERFORMED BY A GUNSMITH.**

PARTS LIST & ILLUSTRATIONS

NOT PICTURED: Dust Cover (Cover, Spring, Pin, E-Clip), Forend, Barrel, Gas System (Block, Tube, Pin) Crush Washer, Flash Hider

- A Pivot Pin
- B Magazine Catch Spring
- C Bolt Spring Catch
- D Safety Detent Spring
- E Take Down Detent Springs (x2)
- F Safety Selector
- G Bolt Catch
- H Buffer Retainer Detent Spring
- I Bolt Catch Roll Pin
- J Magazine Catch
- K Rear Takedown Pin
- L Magazine Release Button
- M Buffer Retainer
- N Safety Selector Detent
- O Takedown Pin Detent
- P Pivot Pin Detent
- Q Bolt Catch Detent
- R OCKS Gas Key Fasteners (x2)
- S Carrier Gas Key
- T Bolt Carrier
- U Dual Ejector Bolt Head
- V Ejectors (x2)
- W Sprinco Ejector Springs (x2)
- X Ejector Assembly Roll Pin
- Y Extractor
- Z Springco 5 Coil Extractor Spring
- AA Viton Extractor O Ring
- BB Extractor Pin
- CC Firing Pin Retaining Pin
- DD Firing Pin
- EE Springco Gas Rings (x3)
- FF Cam Pin

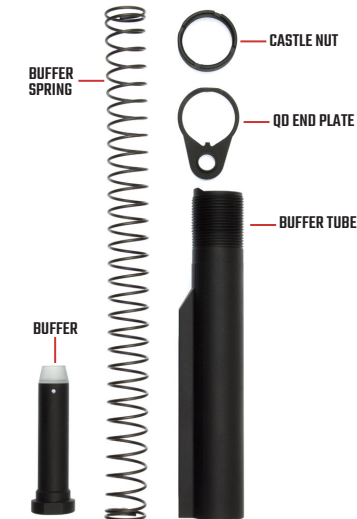
LOWER PARTS



BOLT CARRIER GROUP



BUFFER TUBE PARTS



UPPER RECEIVER



LOWER RECEIVER



DROP-IN TRIGGER



WARRANTY

San Tan Tactical manufactured or branded products come with a limited lifetime warranty granted to the original owner. This warranty is non-transferable. San Tan Tactical products are warranted to be free of manufacture and quality defects.

Under this warranty, San Tan Tactical, upon inspection and at its discretion, will repair or replace a product due to any defects found in material or quality.

San Tan Tactical's warranty will not cover any of the following:

- Unauthorized alterations to a firearm or upper
- Modifying the firearm any way from the factory condition
- Careless or negligent handling resulting in accidental damage of the firearm
- Barrel obstructions due to improper ammunition or maintenance
- Ordinary wear and tear of the product, including cosmetic damage
- Unauthorized repairs not made by San Tan Tactical
- Damage caused by not conducting routine maintenance resulting in rust or corrosion
- The use of the following types of ammunition will void the warranty: incorrect caliber, hand-loaded, factory remanufactured, or factory loaded ammunition not loaded to CIP or SAAMI specifications.

Any repairs that are conducted on a voided warranty will be at the expense of the customer. An RMA number must be on the product before being repaired either on the shipping label or written on the package for warranty work to be conducted. If there is no RMA number on the shipping label or written on the package, the product will be returned to sender.

Repair requests will be made through the San Tan Tactical website (<https://santantactical.com/rma-form/>), and at that time, an RMA number will be issued. If the item is purchased directly from San Tan Tactical, please have your order number and email ready before contacting a Customer Service Representative. If the product was not ordered from San Tan Tactical, please ensure that you retain a copy of the invoice and/or sales receipt from dealer verifying proof of purchase.

When sending products for repair, the package's contents must be adequately secured to protect from damage that may occur during the shipping process. San Tan Tactical is not responsible for damage to a product caused by shipping. Please remove all accessories from the firearm before shipping to San Tan Tactical.

WARRANTY & SERVICE

NOTE: Various local, state, and federal laws govern the transfer and transportation of firearms. Take the dealer's advice in your state on how to send your firearm to San Tan Tactical. Before shipping your firearm, take note of some essential points:

CAUTION: MAKE SURE THE MAGAZINE IS EMPTY AND THE FIREARM IS NOT LOADED.

- Use our Return Request Authorization form to submit a request. You will receive a response within 5 business days. <https://santantactical.com/rma-form/>

SHIPPING WARNINGS

- Do not ship any ammunition with your firearm.
- Do not send any presentation boxes or accessories with your firearm.
- Do not indicate the contents or include “San Tan Tactical” on the packaging to avoid theft.
- To mitigate risk of loss or theft, we strongly recommend insuring your package prior to shipping.

HEALTH AND ENVIRONMENTAL WARNINGS

Discharging firearms in poorly ventilated areas, cleaning firearms, or handling ammunition may lead to exposure. Other substances may cause congenital disabilities, reproductive harm, cancer, and other serious physical injuries. Have adequate ventilation at all times. Wash hands thoroughly after exposure.

REPLACEMENT MANUALS

This instruction manual should always accompany this firearm. When you lend, give, or sell this firearm, be sure that this manual goes with it. If your instruction manual becomes lost or destroyed, contact us directly for a replacement. Please include your serial number and the information on the left side of your firearm.

Address: 5597 Oak Street, Fort Worth, TX 76140 | **Email:** info@santantactical.com

FIREARM RECORD

Print/copy this page for your records

Model: _____

Serial Number: _____

Caliber: _____

Purchased From: _____

Date Purchased: _____

Purchase Price: _____

Additonal Notes:

RESOURCES

- Customer Service: **info@santantactical.com** or **(817)-752-5423**
- Repairs and Maintenance: **<https://santantactical.com/rma-form/>**
- Video Tutorials: **<https://santantactical.com/resources>**
- Warranty Information: **<https://santantactical.com/warranty/>**

LET'S GET SOCIAL

Ready to show off your San Tan Tactical gear to the world? Tag us in all of your product photos and videos for a chance to be featured on our social media pages and website.

Get engaged by:

- Following us on social media: **@SanTanTactical**
- Using hashtag: **#SanTanTactical**
- Leaving us a review on our Facebook Page
- Reaching out about brand collaboration opportunities: **info@santantactical.com**
- Wearing STT swag: **<https://santantactical.com/shop-gear/>**

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