Foris-Carlyle-X5

Premium Inertial Semi-Autos

Instruction Manual

ALWAYS KEEP THIS MANUAL WITH YOUR FIREARM. INCLUDE IT WITH THE FIREARM WHEN IT CHANGES OWNERSHIP.

WARNING: ALL FIREARMS CAN BE DANGEROUS AND CAN CAUSE SERIOUS INJURY, DAMAGE TO PROPERTY OR DEATH. THE FOLLOWING SAFETY RULES ARE AN IMPORTANT REMINDER THAT FIREARM SAFETY IS YOUR RESPONSIBILITY.

WARNING: READ THE ENTIRE MANUAL CAREFULLY BEFORE USING THIS FIREARM. MAKE SURE THAT ANY PERSON USING OR HAVING ACCESS TO THIS FIREARM READS AND UNDERSTANDS THIS ENTIRE MANUAL PRIOR TO USE OR ACCESS.

WARNING: ALWAYS ENSURE THAT THE SAFETY IS FULLY ENGAGED UNTIL READY TO FIRE!

NOTICE: The Manufacturer and/or its Official Distributors assume no liability for product malfunction or for physical injury or property damage resulting in whole or in part from criminal or negligent use of the product, improper or careless handling, unauthorized modifications, use of defective, improper, hand loaded, reloaded or remanufactured ammunition, customer misuse or neglect of the product, or other factors beyond manufacturer's direct and immediate control. In addition to the Basic Safety Rules, there are other Safety Rules pertaining to the loading, unloading, disassembly, assembly and use of this firearm, located throughout this manual.

WE RECOMMEND THE USE OF ORIGINAL SPARE PARTS AND ACCESSORIES. THE USE OF OTHER MANUFACTURERS' SPARE PARTS AND ACCESSORIES COULD CAUSE MALFUNCTIONS AND/OR BREAKAGES THAT WILL NOT BE COVERED BY THE SILVER EAGLE WARRANTY.

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BASIC SAFETY RULES

CAUTION: READ THIS MANUAL CAREFULLY BEFORE USING THE SHOTGUN.

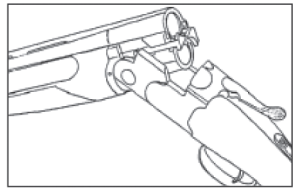
CAUTION: FIREARMS CAN BE DANGEROUS AND CAN CAUSE SERIOUS INJURY, DAMAGE TO PROPERTY OR DEATH, IF HANDLED IMPROPERLY. THE FOLLOWING SAFETY RULES ARE AN IMPORTANT REMINDER THAT FIREARM SAFETY IS YOUR RESPONSIBILITY.

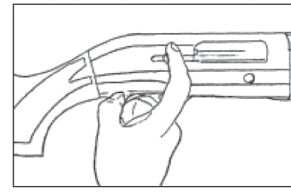
1. NEVER POINT A FIREARM AT SOMETHING THAT IS NOT SAFE TO SHOOT.

Never let the muzzle of a firearm point at any part of your body or at another person. This is especially important when loading or unloading the firearm. When you are shooting at a target, know what is behind it. Slugs and shot can travel farther than their intended range. If you miss your target or if a projectile penetrates the target, it is your responsibility to ensure that the shot does not cause unintended injury or damage.

2. ALWAYS TREAT A FIREARM AS IF IT WERE LOADED.

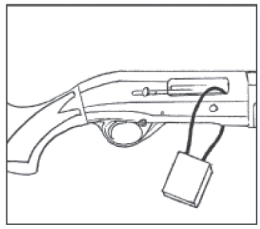
Never assume that a firearm is unloaded. The only certain way to ensure there are no cartridges in a firearm is to open the chamber and visually and physically examine the inside to see if a round is present. Removing or unloading the magazine will not guarantee that a firearm is unloaded or cannot fire. Shotguns can be checked by cycling or removing all rounds and by then opening and inspecting the chamber so that a visual inspection of the chamber for any remaining rounds can be made.





3. STORE YOUR FIREARM SO THAT CHILDREN CANNOT GAIN ACCESS TO IT.

It is your responsibility to ensure that children under the age of 18 or other unauthorized persons do not gain access to your firearm. To reduce the risk of accidents involving children, unload your firearm, lock it and store the ammunition in a separate locked location. Please note that devices intended to prevent accidents - for example, cable locks, chamber plugs, etc., - may not prevent use or misuse of your firearm by a determined person. Firearm storage in a steel gun safe may be more appropriate to reduce the likelihood of intentional misuse of a firearm by a child or unauthorized person.



4. NEVER SHOOT AT WATER OR AT A HARD SURFACE.

Shooting at the surface of water or at a rock or other hard surface increases the chance of ricochets or fragmentation of the bullet or shot, which can result in the projectile striking an unintended or peripheral target.

5. KNOW THE SAFETY FEATURES OF THE FIREARM YOU ARE USING, BUT REMEMBER: SAFETY DEVICES ARE NOT A SUBSTITUTE FOR SAFE HANDLING PROCEDURES.

Never rely solely on a safety device to prevent an accident. It is imperative that you know and use the safety features of the particular firearm you are handling, but accidents can best be prevented by following the safe handling procedures described in these safety rules and elsewhere in the product manual. To further familiarize yourself with the proper use of this or other firearms, take a Firearms Safety Course taught by an expert in firearms use and safety procedures.

6. PROPERLY MAINTAIN YOUR FIREARM.

Store and carry your firearm so that dirt or lint does not accumulate in the working parts. Clean and oil your firearm, following the instructions provided in this manual, after each use to prevent corrosion, damage to the barrel or accumulation of impurities which can prevent use of the firearm in an emergency. Always check the bore and chamber(s) prior to loading to ensure that they are clean and free from obstructions. **Firing with an obstruction in the barrel or chamber can rupture the barrel and injure you or others nearby.** In the event you hear an unusual noise when shooting, stop firing

immediately, engage the manual safety and unload the firearm. Make sure the chamber and barrel are free from any obstruction, such as part of a cartridge stuck inside the barrel due to defective or improper ammunition.

7. USE PROPER AMMUNITION.

Use only factory-loaded, new ammunition manufactured to industry specifications: CIP (Europe and elsewhere), SAAMI® (U.S.A.). Be certain that each round you use is in the proper gauge and type for the particular firearm. The caliber or gauge of the firearm is clearly marked on the barrel. The use of reloaded or remanufactured ammunition can increase the likelihood of excessive cartridge pressures, case-head ruptures or other defects in the ammunition that can cause damage to your firearm and injury to yourself or others nearby.

8. ALWAYS WEAR PROTECTIVE GLASSES AND EARPLUGS WHEN SHOOTING.

The chance that gas, gunpowder or metal fragments will blow back and injure a shooter who is firing a gun is rare, but the injury that can be sustained in such circumstances can be severe, including the possible loss of eyesight. A shooter must always wear impact resistant shooting glasses when firing any firearm. Earplugs and other high-quality hearing protectors help reduce the chance of hearing damage from shooting.

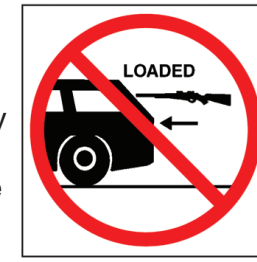
9. NEVER CLIMB A TREE, FENCE OR OBSTRUCTION WITH A LOADED FIREARM..

Open and empty the chamber(s) of your firearm and engage the manual safety before climbing or descending a tree or before climbing a fence or jumping over a ditch or other obstruction. Never pull or push a loaded firearm toward yourself or another person. Always unload a firearm, visually and physically check to see that the magazine, loading mechanism and chamber are unloaded, and action is open before handing it to another person. Never take a firearm from another person unless it is unloaded, visually and physically checked to confirm it is unloaded, and the action is open.

10. AVOID ALCOHOLIC BEVERAGES OR JUDGEMENT/REFLEX IMPAIRING MEDICATION WHEN SHOOTING.

Do not drink and shoot. If you take medication that can impair motor reactions or judgement, do not handle a firearm while you are under the influence of the medication.

11. NEVER TRANSPORT A LOADED FIREARM.



Unload a firearm before putting it in a vehicle (chamber empty, magazine empty). Hunters and target shooters should load their firearm only at their destination, and only when they are ready to shoot. If you carry a firearm for self-protection, leaving the chamber unloaded can reduce the chance of an unintentional discharge.

12. LEAD WARNING.

Discharging firearms in poorly ventilated areas, cleaning firearms, or handling ammunition may result in exposure to lead and other substances known to cause birth defects, reproductive harm, and other serious physical injury. Have adequate ventilation at all times. Wash hands thoroughly after exposure.

CAUTION: It is YOUR responsibility to know and abide by federal, state and local laws governing the sale, transportation and use of firearms in your area.

WARNING: This firearm has the capability of taking your life or the life of someone else! Always be extremely careful with your firearm. An accident is almost always the result of not following basic firearm safety rules.

For information about Firearm Safety Courses in your area, please visit the National Rifle Association's web site at www.nra.org.

ASSEMBLY

Main Components (fig 1) a. Stock, receiver, fore-end, b. Bolt assembly
c. Barrel

Cocking lever Assembly procedure:

1. Insert the cocking lever completely into the bolt (Fig. 2)
2. Unscrew the fore-end cap (Figs. 3-4)
3. Remove the fore-end by sliding it forward along the magazine tube (fig 5.
4. Take the stock-receiver-bolt unit with one hand; with the other hand, using the cocking lever, lock the bolt into open position (Fig 6)

WARNING! Should the bolt fail to engage, move the cartridge drop lever as indicated and repeat the operation (Fig 7). During this operation the bolt group should be completely assembled and placed in the receiver, in open position (rearward).

5. While holding the shotgun with one hand (Fig 8), grasp the breech-barrel-fore end assembly with the other hand.
6. Slide the breech extension into the receiver, making sure that the barrel ring slides onto the magazine tube. (fig 9)
7. Push the barrel-breech-fore-end assembly all the way in (Fig 10) until it clicks into place and is firmly seated. (Slide the fore-end along the magazine tube (Fig. 11)

For synthetic fore ends:
Make sure that the breech extension does not collide against the bolt locking head, but rather that it fits between the cover and the locking head.
8. Screw the fore-end cap and its spring on the magazine tube end. then tighten them firmly until the barrel and the fore-end are perfectly locked to the receiver. (figs 12-13)

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9. Close the bolt by pressing the bolt release (fig 14)

GUN SAFETY

Press the safety button on the trigger guard until its red ring, indicating firing position, is no longer visible. (figs 15-16)

LOADING AND FIRING

Before starting any operation on your shotgun, make sure that the chamber and the magazine are unloaded! (Carefully read the instructions on gun loading and unloading).
NOTE: Make sure that the shotgun safety button is engaged and the hammer cocked (so that the carrier latch can retain the cartridges as they are inserted in the magazine).
NOTE: Verify, by opening the bolt, the shotgun is unloaded and the chamber is empty, then close the bolt again.
1. The red dot on the cartridge drop lever indicating that the hammer is cocked (fig 17) must be clearly visible. To bring lever to this position, press the bolt release and open the bolt by hand, then bring it to close position again (fig 18)

2) With the bolt closed and the hammer cocked, reverse the gun, pointing the barrel downwards
3) Insert a cartridge into the magazine (fig 19) push it until it is retained by the carrier latch, which engages automatically (fig 20) Repeat the operation until the magazine is fully loaded.
NOTE: The gun must be loaded with the hammer cocked so that the carrier latch can retain the cartridges as they are inserted in the magazine. Now the gun cannot be fired unless a cartridge is placed in the barrel through one of the following procedures:

A) Direct procedure:

1) Open the bolt and at the same time insert a cartridge into the ejection port, allowing it to drop onto the carrier.(fig 21)
2) Release the cocking lever: the bolt will push the cartridge on the carrier into the chamber and stop in the closed position.(fig 22)

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B) Indirect procedure:

1) Open the bolt and hold it in this position pushing, at the same time, the cartridge drop lever; in this way the first shell in the magazine will be deposited onto the carrier (fig 23)
2) Release the cocking lever: the bolt will push the cartridge on the carrier into the chamber and stop in the closed position (fig 22)

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NOTE: With the procedure B the number of cartridges in the magazine will be reduced by one round. A new cartridge can be inserted - see above - to fill the magazine completely.

WARNING: During this operation, always point the gun in a safe direction, even though the safety catch is engaged (see Gun safety catch). Now the gun is loaded: when the safety catch is moved to firing position (red ring visible), the gun is ready for use.

• To fire, disengage the safety and pull the trigger.
• After firing, release the trigger completely to reset the trigger for the next shot.
• The gun will fire the shell in the chamber, and automatically feed the next shell from the magazine
• When the last shell has been fired, the breech bolt remains open, indicating that the magazine is empty.
• Engage the safety.

NOTE: When your shotgun is new and before beginning to use it normally, a break-in period may be required before your shotgun works perfectly with light target loads. If you experience any initial functioning problems, we recommended firing three or four boxes of standard hunting loads to allow for this break-in period.

RECHAMBERING SHELLS

This operation must be carried out with the gun safety catch engaged and barrel pointed in a safe direction. To replace a cartridge in the chamber, two procedures can be followed:

A) Manual replacement (when the cartridge is not coming from the magazine)
1) Rest the stock on your hip and pull the cocking lever to open the bolt: the cartridge in the chamber is extracted and ejected from the gun (fig 24)
2) Insert a new cartridge into the chamber through the ejection port (fig 25) and release the cocking lever to close the bolt again.

B) Using the cartridge drop lever
(when the cartridge is coming from the magazine)
1) Rest the stock on your hip and pull the cocking lever to open the bolt: the cartridge in the chamber is extracted and ejected from the gun (fig 24)
2) Press the cartridge drop lever (fig 23) which will cause a shell to be released from the magazine onto the carrier. Release the cocking lever to close the bolt.

UNLOADING

(This operation must be carried out with the gun safety catch engaged and the barrel pointed in a safe direction) To unload the shotgun, proceed as follows:
1) Open the bolt: the cartridge in the chamber will be extracted and ejected (fig 24)
2) Close the bolt by gently releasing the bolt handle (Fig. 26).
3) Turn the gun upside - down, and while pushing the carrier in, press the cartridge drop lever (fig 23), releasing a shell from the magazine (Fig. 28). The cartridge drop lever must be pressed to release each cartridge.

• After confirming that the magazine is empty, press the carrier stop button, which will drop the carrier and allow the bolt to lock open in the next step.
• Holding the firearm upright, firmly pull back the bolt handle to eject any live shell that may remain in the chamber. With the bolt locked open, you can visually inspect the chamber to confirm that no shell is present.

The above steps constitute the LOAD CHECK, which should always be performed prior to using or transporting the firearm!
• When the firearm is available for use or is being transported, the bolt should always be locked open.
• When accepting the firearm or handing it to someone else, ALWAYS perform the load check!
• For storage, it is recommended that tension be released from the hammer spring. Using the following steps:
• After performing the Load Check to confirm that the gun is unloaded, press the bolt release button while guiding the bolt closed.
• Keeping the firearm pointed in a safe direction, disengage the safety and pull the trigger. (It is recommended that a “snap cap” or dummy round be used to reduce wear on the firing pin.)
• Engage the safety.

TROUBLESHOOTING

Before starting any operation on your shotgun, make sure that the chamber and the magazine are unloaded! Carefully read the instructions on gun loading and unloading!

The gun fails to fire

1) Check the safety catch: if it is engaged, push the button to the fire position.
2) Check that there is a cartridge in the barrel. If necessary, insert a cartridge following the loading instructions.
3) Check the firing mechanism. If necessary, clean and lubricate it.
4) Ensure the fore-end cap is fitted with spring and, especially after the first few shots, check that it is tightened firmly, to keep the barrel firmly against the receiver.

Ammunition

Inertially operated shotguns use the kinetic energy generated by the recoil to work the action. Always use ammunition that is powerful enough to fully cycle the action. When your shotgun is new, a break-in period may be required before it cycles perfectly with light target loads. If you experience any initial functioning problems, we recommended firing three or four boxes of standard hunting cartridges. (1 1/8oz, 1250fps or greater)

AMMUNITION

WARNING: The manufacturer and distributor assume no liability for physical injury or property damage resulting from the use of defective, improper, hand-loaded, reloaded or remanufactured ammunition. Serious damage or injury, even death, may be caused by the use of ammunition that is not suitable, loaded with force, or loaded with obstructions in the barrel.

WARNING: Never use cartridges that do not correspond to the indications on the barrel.

WARNING: Only use cartridges with a length equal to or less than the chamber length indicated on the barrel.

WARNING: To avoid using improper ammunition, always check the characteristics stamped on the cartridge box and on the cartridge. Be sure to use the right cartridge gauge and length for your firearm.

STEEL SHOT

The barrel and choke tubes are designed for use with factory steel shot cartridges loaded to international standard specifications. When steel shot cartridges are fired, the best results are obtained by using open chokes (C, IC, M). Tighter choke constrictions (IM, F) when using steel shot, do not increase pattern density and will accelerate wear and tear. The use of reloaded or remanufactured ammunition can increase the likelihood of excessive pressure, case rupture or other defects in the ammunition.
Your shotgun is chambered for either 3” and shorter shells (Carlyle, X5) or 3.5” and shorter shells (Foris). You will find markings for the gauge and chamber length on the side of the barrel. **Never use a shell longer than that indicated on the barrel of your gun.**

CHOKE TUBES

Your Silver Eagle shotgun’s choke tubes are similar to the popular “Crio Plus” used by many manufacturers, although compatibility with other brands cannot be assured. In addition to the choke tubes supplied with your gun and available from T R Imports as accessories, we recommend Trulock tubes (www.trulock.com) which have been manufactured in the USA to our exact thread pitch specifications, and which are available in a wide variety of flush and extended models.

CHOKE TUBE IDENTIFICATION

Included tubes range from Cylinder (least restricted) to Full (most restricted). Choke is designated by index notches cut into the rim (separate from the larger notches engaged by the choke tube wrench).

Rim Notches	Standard Designation
I	F (Full)
II	IM (Improved Modified)
III	M (Modified)
IIII	IC (Improved Cylinder)
IIIII	C (Cylinder/Skeet)

REMOVAL OF CHOKE TUBES

• Unscrew the choke tube by turning it counterclockwise using the supplied choke tube wrench (or by hand, for extended tube and pull it out of the muzzle (fig 50)

WARNING: Always check that the shotgun is unloaded (empty cartridge chamber, empty receiver, empty magazine). Inspect the firearm by looking through the ejection port, the loading gate and the chamber. If it is not empty, unload it as instructed in “Unloading the Firearm”, above. Ensure the hammer is decocked.

WARNING: Never look into the muzzle or change the tube of a loaded gun, even with the safety engaged.

CLEANING OF CHOKE TUBES

• The choke tube interior is best cleaned by leaving it in place while cleaning the barrel, as described under ROUTINE MAINTENANCE, below.
• After removing the choke tube, carefully clean the choke tube recess using a suitable solvent and, if necessary, a barrel brush. Dry it using a suitable gun cleaning patch.
• Make sure the choke tube is perfectly clean inside and outside. It may be necessary to use a metal brush to remove heavy carbon deposits on the outside of the choke tube.

INSTALLATION OF CHOKE TUBES

WARNING: Always check that the shotgun is unloaded (empty cartridge chamber, empty receiver, empty magazine). Inspect the firearm by looking through the ejection port, the loading gate and the chamber. If it is not empty, unload it as instructed in “Unloading the Firearm”, above. Ensure the hammer is decocked.

WARNING: Never look into the muzzle or change the tube of a loaded gun, even with the safety engaged.

• Apply a thin coat of gun grease to the outside of the choke tube and its threads. NOTE: using gun grease rather than oil will provide a better seal between the tube and the choke tube recess, minimizing carbon buildup and reducing the chance of a seized choke tube.
• Insert the desired choke tube into the muzzle. Using the choke tube wrench provided, turn it clockwise until it has fully bottomed into the recess.

WARNING: Periodically check that the choke tube is tightened correctly, ensuring that the shotgun is unloaded (empty cartridge chamber, empty receiver and empty magazine) and breech bolt in the open position. If necessary, firmly tighten the choke tube with the supplied choke tube wrench. Correct tightening of the choke tube will avoid the occurrence of shotgun damage or injury.

WARNING: The choke must be kept correctly tightened in the barrel at all times,even during storage and cleaning. Cleaning the barrel without the choke tube installed may lead to dirt becoming lodged in the barrel thread and preventing the choke tube from screwing in properly, or to the formation of rust or obstructions. Keeping a choke tube installed at all times also improves the impact resistance of the muzzle end.

WARNING: Never shoot without inserting a choke tube. Shooting without a choke tube in the barrel is very dangerous, as residues of lead or debris may become lodged in the thread creating an obstruction within the barrel. Also, not using a choke tube will damage the threading of the barrel irreparably and result in irregular shot spread.

ROUTINE MAINTENANCE

Clean and lubricate your shotgun any time combustion residue, grease or dirt have built up in any of the mechanisms. Cleaning and lubrication of the firearm after each use is the best way of ensuring that the components are protected against corrosion resulting from combustion residues or use in humid or salty environments.

At the end of a shooting day, carry out the Routine Maintenance as described below.

WARNING: Excess oil or grease in the bore are dangerous when firing, and may damage the shotgun or injure the shooter or bystanders. Never apply lubricants to shotshells.

BARREL

• Carefully clean the inside of the barrel with a suitable gun cleaning patch and solvent to remove fouling and plastic residue deposited by shot cups. For heavy deposits, it may be necessary to use a bronze bore brush.
• Thoroughly clean the locking recesses of the barrel breech.
• When you believe you have removed all deposits, push a clean patch through the barrel. A clean barrel will have a mirror-like appearance.
• Because the bore is plated with hard chrome, it is not necessary to oil it.
• Check the barrel. The barrel and cartridge chamber must be clean and free of obstructions.

BREECH BOLT and TRIGGER ASSEMBLIES

• Thoroughly clean accessible parts with a suitable solvent and small brush.
• Dry with a soft cloth and lightly oil.

RECEIVER

• Maintain as described for the breech bolt and trigger assemblies. Lightly oil the slide rails of the breech bolt inside the receiver.

MAGAZINE TUBE

• Clean the outside of the magazine tube with a suitable solvent.
• Dry and then lightly oil it.

Every 3000-5000 shots (depending on type of ammunition used) and always before storing the gun for a long period, in addition to Routine Maintenance, perform the Special Maintenance, described on the next page.

SPECIAL MAINTENANCE

Every 3000-5000 shots (depending on environment and type of ammunition used) and always before storing the gun for a long period, in addition to Routine Maintenance, perform the following Special Maintenance.

BREECH BOLT ASSEMBLY

• Remove the breech bolt assembly as described in DISASSEMBLY, below.
• Thoroughly clean all components with a suitable solvent and small brush.
• Dry and then lightly oil the surfaces of the bolt and all accessible parts.
• Inspect the firing pin and extractor for cleanliness and freedom of motion. When pressed, the firing pin should extend beyond the face of the bolt. When released, it should retract fully.
• Inspect the locking surfaces and other parts for freedom of motion and absence of damage and excessive wear.

TRIGGER ASSEMBLY

• Remove the trigger assembly as described in DISASSEMBLY, below.
CAUTION: if the hammer is cocked, restrain it while pulling the trigger and allow it to uncock slowly.
• Thoroughly clean all components with a suitable solvent and brush.
• Dry and then lightly oil all accessible parts.
• Inspect all moving parts for cleanliness, freedom of motion, and the absence of damage and excessive wear.

DISASSEMBLY

Before starting any operation on your shotgun. make sure that the chamber, carrier and magazine are unloaded! Carefully read the instructions on gun loading and unloading.

1) Unscrew the fore-end cap (figs. 3-4). Remove the fore-end making it slide forward along the magazine tube (fig 5) (synthetic fore-end only).
21 Take the gun in one hand and with the other open the bolt (fig 29) Should the bolt fail to engage, move the cartridge drop lever as indicated and repeat the operation (fig 30). While resting the shotgun on your hip, hold it with one hand (fig 31) and with the other hand pull the breech-barrel-fore-end assembly out of the receiver (fig 32).

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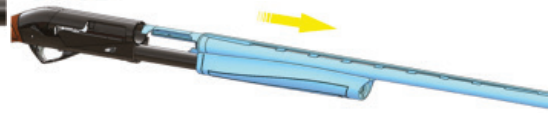

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4) While holding the bolt assembly with one hand (fig 33) so as to counter balance the thrust of the recoil spring, push the bolt release button and ease the bolt forward until the recoil spring no longer pushes it. (fig 34)
5) Pull the bolt assembly out of the receiver, sliding it along its guides (fig 35)
6) Remove the firing pin retaining pin from the bolt assembly, while holding the firing pin and firing pin spring in place (fig 36).
7) Remove the firing pin and firing pin spring from the bolt (fig 37)
8) Remove the locking head rotating pin from its seat (fig 38)
9) Remove the bolt locking head from the bolt (fig 39)
10) Remove the recoil spring from its seat in the bolt (fig 40)
All dismantled parts require lubrication.

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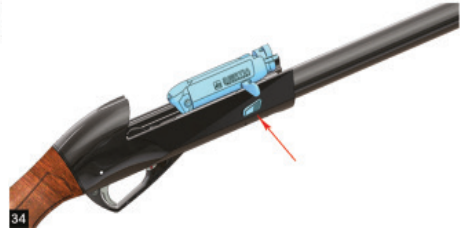

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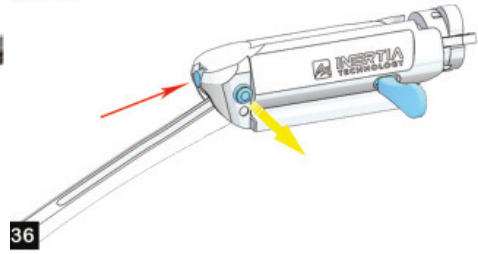

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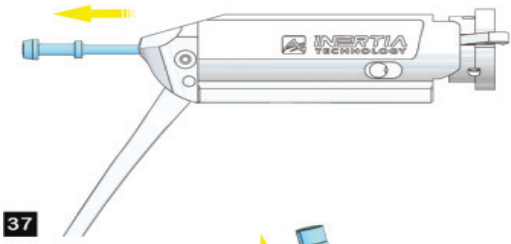

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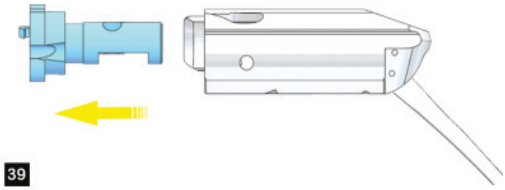

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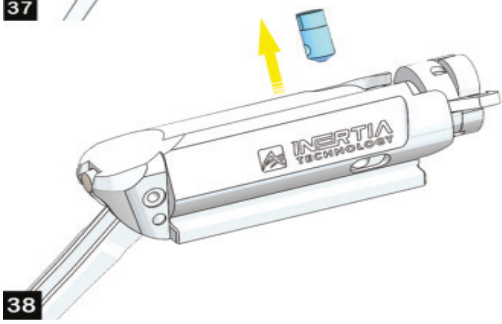

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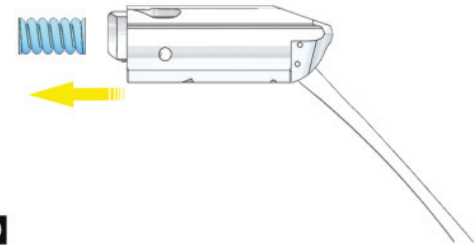

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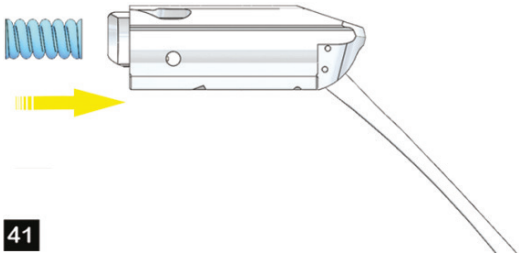
REASSEMBLY

For correct assembly after cleaning and maintenance operations, proceed as follows:
1) Slide the bolt recoil spring into its appropriate position (FIG 41)
WARNING: Always make sure that the bolt recoil spring is positioned between the locking head and the bolt itself, in order to avoid a shot being fired during closing.
2) Slide the locking head into the bolt, making sure that the hole on its stem coincides with the slot on the bolt (fig 42)
WARNING: The slanted surfaces on the locking head's stem should not be visible once the bolt locking head is mounted.



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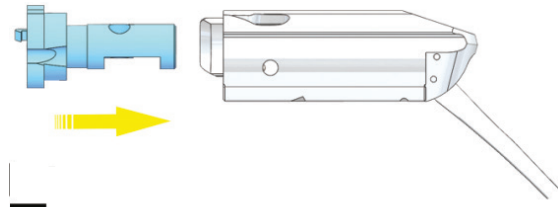

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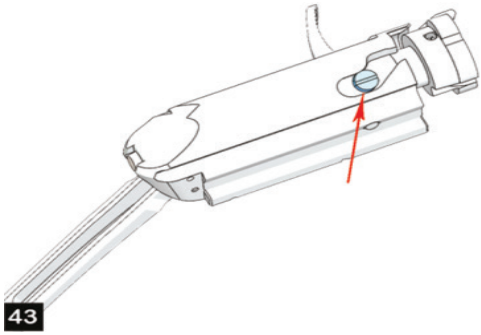
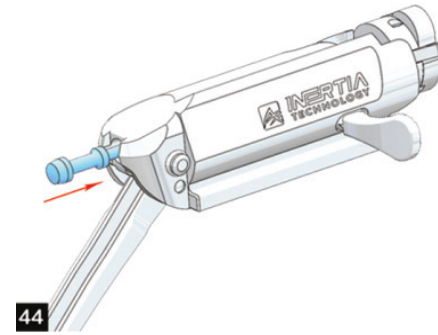
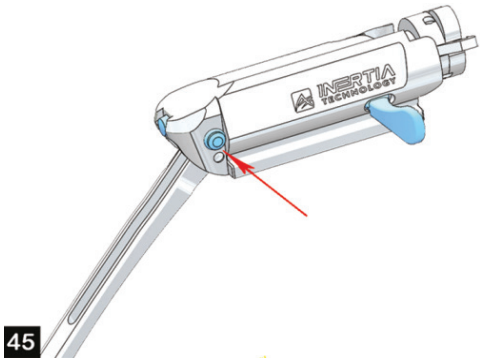
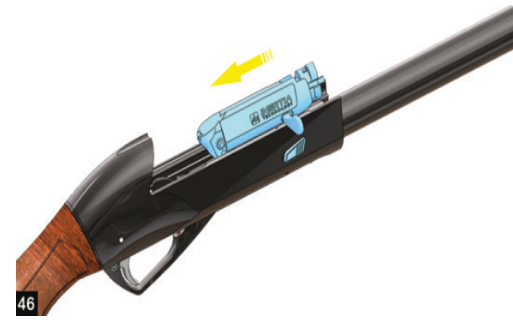
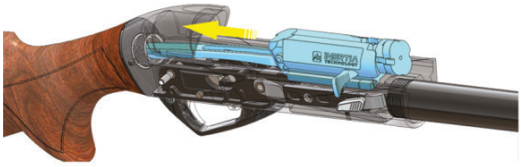
3) Insert the locking head pin in its hole on the locking head's stem, through the slot on the bolt (fig 43)
NOTE: The reference line on top of the pin must be visible and aligned with the bolt assembly longitudinal axis (fig 43)
4) Insert the firing pin and the firing pin spring into the bolt (fig 44)
NOTE: Always make sure that the firing pin spring has been mounted.
Insert the firing pin retaining pin firmly into its seat, (fig 45)
6) Hold the stock receiver assembly almost horizontally and insert the bolt assembly in its guide on the receiver (fig 46)
WARNING: Make sure that the bolt link slides over the trigger guard assembly, positioning on the recoil spring guide pin inside the receiver, once the mounting has been completed (fig 47)
7) Push the bolt fully to the rear to lock it. If the bolt doesn't remain in the opened position, push the cartridge drop lever in the direction shown by the arrow (fig 48) and repeat the procedure. Finish assembling the shotgun by following all the steps outlined under the section "Shotgun Assembly").











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ACCESSORIES & ADJUSTMENTS

Before beginning any operation on your shotgun, always make sure that chamber and magazine have been completely emptied! (Carefully read loading and unloading instructions).
Your shotgun is supplied with a shim kit (fig 49) which enables you to adjust the gun's drop and cast. The kit consists of one stock locking plate (steel) plus drop change shims (plastic]. Each unit is marked with the corresponding drop and cast letter. The kit enables you to obtain four different drop patterns (as specified in the following table] and two different casts (right hand or left hand).

Drop Change Schedule			
Cast Shim (plastic)	**Stock Locking Plate (steel)**	**Drop Shim (plastic)**	**Drop at Heel (mm)**
Reference Letter	**Reference Letter**	**Reference Letter**	
RH	**W RH**	**W**	**45**
LH	**W LH**		
RH	**Z RH**	**Z**	**50**
LH	**Z LH**		
RH	**A RH**	**A**	**55**
LH	**A LH**		
RH	**B RH**	**B**	**60**
LH	**B LH**		

Determine if your stock drop fits you perfectly, or is too high or too low for you.
Matching instructions: the drop change kits are identified by letters. To ensure a correct drop always match locking plates and shims that have the same letters. E.g.: W-W RH-RH
If it is too low, you need to select the previous adjustment set in alphabetical order [e.g. if the shim supplied on the shotgun is marked with a C, you must select the B, together with the corresponding stock locking plate). The replacement procedure is very simple:
1) Unscrew the two butt plate screws and remove the butt plate 1-7 using a phillips-head screwdriver). CAUTION: To avoid damaging the butt plates, apply a light coat of Vaseline or grease to the shaft of the screwdriver.
2) Unscrew the stock bolt (2)
3) Take the bolt (2), lock washer (3), stock locking plate (4), stock (8), the cast shim (5) and the drop shim (6) out of the recoil spring tube.
4) Assemble the drop shim (6) you have selected onto the recoil spring tube with the stamped letter facing the stock.
5) Reassemble the selected cast shim (5) with the stamped letter (RH or LH) facing toward the stock.
6) Point the barrel towards the floor and assemble the stock; insert the plate (4) in the stock itself with the stamped letter facing the butt plate.
7) Assemble the lock washer (3) and bolt (2) on the recoil spring tube and tighten firmly.
8) Reassemble the butt plate (1) after aligning it perfectly with the stock.

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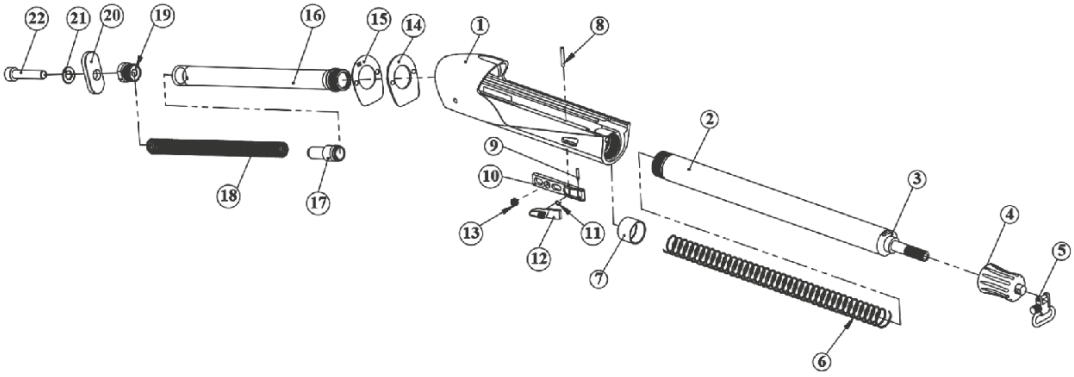
CAUTION: Always use drop shims (6), cast shims (5) and stock locking plates (4) with the corresponding lettering, e.g. W-W RH-RH or A-A RH-RH.
The use of component parts with different letters may cause permanent deformation of the recoil spring tube with as result, bolt sliding problems.

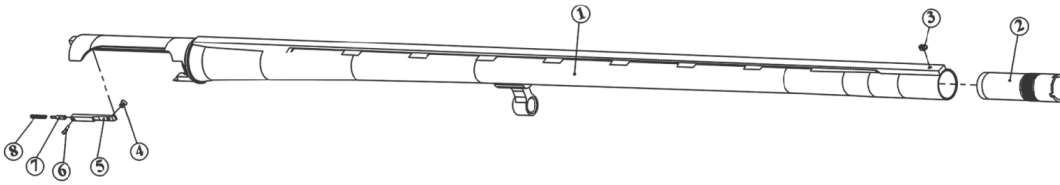
CAUTION: Once the stock has been replaced, make sure that it is correctly retained to the receiver. After having fired the first few rounds, repeat check and if necessary, fix the stock again by remove the butt plate and retighten the bolt using an appropriate wrench.

Having altered the stock drop of the shotgun, you have also obviously altered the firing position as well: it is therefore necessary that you first practice by executing some shots in order to make sure that the firing position is suitable for your size and shooting style.

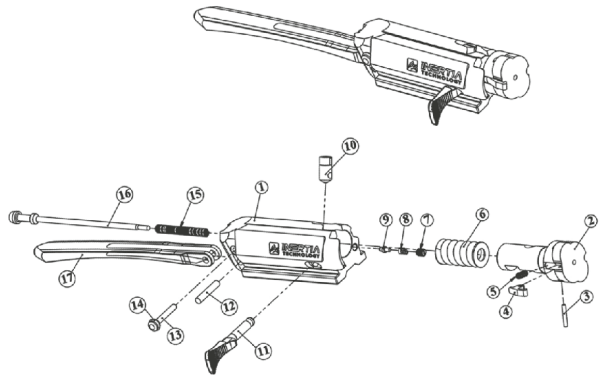
GENERAL PARTS LIST



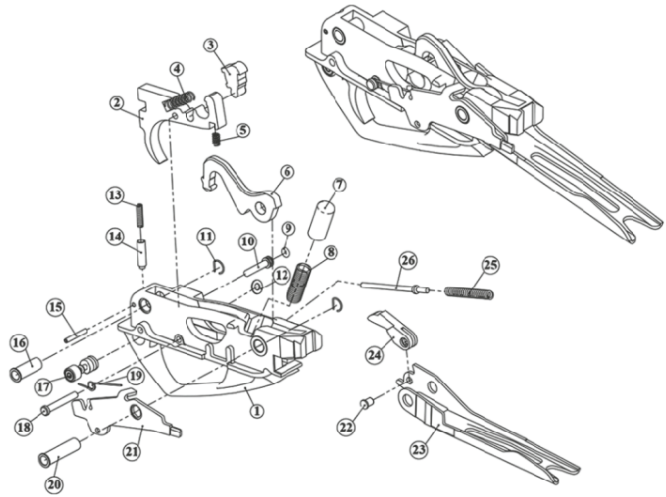
No	Name	Stock Code
1	Receiver	INT-KAS-01
2	Magazine Tube	INT-BOR-01
3	Magazine Screw	INT-VID-01
4	Magazine Cap	INT-SMN-02
5	Removable Sling Swivel	INT-KYS-01
6	Magazine Spring	INT-YAY-01
7	Magazine Follower	INT-GRD-01
8	Carrier Latch Pin	INT-PIM-02
9	Latch Pin	INT-PIM-01
10	Carrier Latch	INT-SAC-01
11	Latch Spring	INT-YAY-07



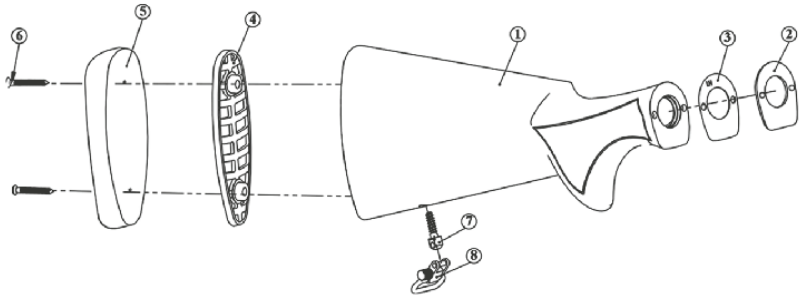
BARREL		
NO	STOCK NAME	STOCK CODE
1	BARREL (71)	INT-NAM-11
2	CHOKE	INT-MSK-01/02/03/04/05
3	FRONT SIGHT	INT-ARP-01
4	REAR EJECTOR RETAINING SCREW	INT-VID-09
5	EJECTOR CAP	INT-KVN-02
6	EJECTOR STOP PIN	INT-PIM-04
7	REAR EJECTOR PIN SPRING	INT-PIM-03
8	EJECTOR SPRING	INT-YAY-09



BOLT ASSEMBLY, PARTIAL		
NO	STOCK NAME	STOCK CODE
1	BOLT ASSEMBLY,PARTIAL	INT-MKZ-01
2	LOCKING HEAD	INT-DNR-01
3	EXTRACTOR PIN	INT-PIM-08
4	EXTRACTOR	INT-TRN-01
5	EXTRACTOR SPRING	INT-YAY-15
6	BOLT ASSEMBLY,PARTIAL SPRING	INT-YAY-06
7	BOLT HANDLE PIN SET SCREW	INT-STK-08
8	BOLT HANDLE REATINING SPRING	INT-YAY-14
9	BOLT HANDLE PIN	INT-KIL-01
10	LOCKING HEAD PIN	INT-PIM-05
11	BOLT HANDLE	INT-KKL-01
12	DOWEL	INT-PIM-07
13	NEEDLE LIMIT PIN	INT-PIM-06
14	NEEDLE SPRING	INT-YAY-13
15	NEEDLE	INT-IGN-01
16	BIPOD	INT-AYK-01

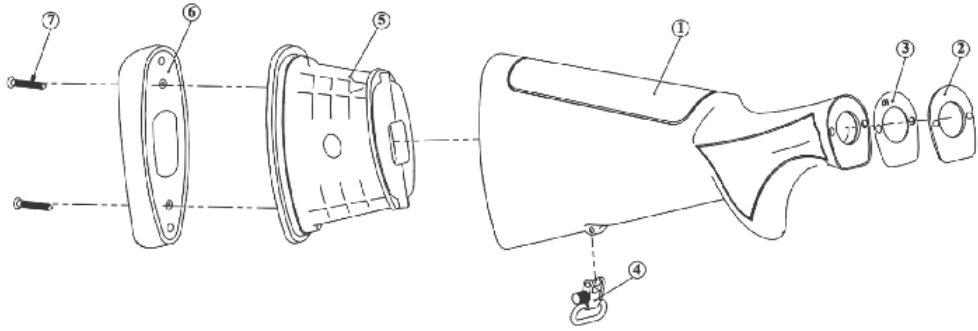


TRIGGER GUARD GROUP		
NO	STOCK NAME	STOCK CODE
1	TRIGGER GROUP	INT-KRK-01
2	TRIGGER	INT-TET-01
3	DISCONNECTOR HAMMER	INT-AYK-01
4	DISCONNECTOR SPRING	INT-AYK-02
5	TRIGGER SPRING	INT-YAY-19
6	HAMMER	INT-HRZ-01
7	HAMMER CAP	INT-KVN-01
8	HAMMER SPRING CAP	INT-YAY-11
9	TRIGGER GUARD PIN O-RING	INT-ORG-02
10	TRIGGER PIN BUSH	INT-PIM-17
11	TRIGGER GUARD PIN SPRING	INT-YAY-16
12	BOLT LATCH PIN	INT-PUL-03
13	SAFETY PLUNGER SPRING	INT-YAY-08
14	SAFETY SPRING RETAINING PIN	INT-PIM-09
15	SAFETY SPRING DOWEL	INT-PIM-10
16	PIPE PIN	INT-PIM-12
17	SAFETY	INT-EMN-01
18	TRIGGER PIN	INT-PIM-13
19	CARTRIDGE DROP LEVER SPRING	INT-YAY-10
20	HAMMER TUBE PIN	INT-PIM-15
21	CARTRIDGE DROPE LEVER	INT-SAC-02
22	BOLT STOP TOOTH PIN	INT-PIM-14
23	CARRIER	INT-KSK-01
24	BOLT STOP TOOTH	INT-ATB-01
25	CARRIER SPRING	INT-YAY-03
26	BOLT LATCH PIN	INT-PIM-16



WOOD STOCK		
NO	STOCK NAME	STOCK CODE
1	WOOD STOCK	INT-DIP-01
2	CAST SHIM (Z-W-B-A)	INT-PLS-2/3/4/5
3	DROP CHANGE SHIM (LH-RH)	INT-PLS-01
4	BUTT PLATE PLASTIC	INT-PLS-06
5	POLYURETHANE RECOIL PAD	INT-OMZ-01
6	BUTT PLATE SCREW	INT-VID-07
7	SLING SWIVEL SCREW	INT-VID-08
8	SLING SWIVEL	INT-KYS-01

FORE-END ASSEMBLY (WOOD)		
NO	STOCK NAME	STOCK CODE
1	FORE-END ASEEMBLY(WOOD)	INT-KUN-01
2	FORE-END FOLLOWER ASSY	INT-BRC-01
3	FORE-END PIN (WOOD)	INT-PIM-18
4	FORE-END (WOOD) NEEDLE PIN	INT-YAY-01
5	FORE-END (WOOD) SCREW PIN	INT-VID-05



PLASTIC STOCK		
NO	STOCK NAME	STOCK CODE
1	PLASTIC STOCK	INT-DIP-02
2	CAST SHIM (Z-W-B-A)	INT-PLS-02/03/04/05
3	DROP (LH-RH)	INT-PLS-01
4	SLING SWIVEL	INT-KYS-01
5	PLASTIC STOCK SEPERATOR	INT-SPR-01
6	POLYURETHANE RECOIL PAD	INT-OMZ-01
7	BUTT PLATE SCREW	INT-VID-07

FORE-END ASSEMBLY (PLASTIC)		
NO	STOCK NAME	STOCK CODE
1	FORE-END ASEEMBLY(PLASTIC)	INT-KUN-02
2	FORE-END (PLASTIC) ASEEMBLY SCREW	INT-VID-06
3	FORE-END (PLASTIC) PIN	INT-PIM-19
4	FORE-END (PLASTIC) NEEDLE PIN	INT-YAY-04

WARRANTY INFORMATION

This firearm carries a two-year limited warranty to the original purchaser for defects in materials or workmanship. If the original purchaser registers his firearm with TRI, he automatically receives an additional three years of warranty coverage for a total of five years. For more detailed information, please visit www.trimports.com/support. If you do not have access to the internet, call and we will assist you in registering your gun.

HOW TO OBTAIN SERVICE

For fastest service, contact us directly:

T R Imports Inc
5778 Park Vista Circle
Suite 302
Fort Worth, TX 76244

Telephone: 817-750-2291

Fax: 817-581-4222
Email: support@trimports.com
Web: trimports.com

For questions, suggestions, or to discuss anything not covered in this manual, please call us, 9am-5pm Central, Monday-Friday. We thank you for the confidence you have shown in our products, and we look forward to hearing from you.

Thank you!

Scan the QR code for easy warranty registration:

Quick Reference Guide

Ammunition and Cycling Issues	**pages 14-15**
Accessories and Parts	**pages 23-29**
Assembly	**page 8**
Choke Tubes	**page 16**
Disassembly	**page 19**
Warranty Information	**page 30**

IMPORTANT NOTE: Before returning your gun to the retailer, contact T R Imports!