



**RAPTOR 50  
.50 BMG UPPER RECEIVER**

**⚠ WARNING! READ THIS MANUAL CAREFULLY  
BEFORE USING THIS FIREARM**

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# SAFETY

## READ THIS MANUAL BEFORE YOU USE OR MANIPULATE YOUR BIG KAHUNA GUNS PRODUCT.

Big Kahuna Guns Industries, Inc. will not be responsible for injury, death, or damage to property resulting from either intentional or accidental discharge of this firearm or from its function when used for purposes or subjected to treatment for which it was not designed.

It is important that you understand the principles of safe gun handling in general and the features of this product. This manual is not a substitute for training from a qualified instructor. Important safety topics are discussed in this chapter and throughout this manual. This manual should remain with the product and it should be transferred with the product to subsequent owners. Additional manuals can be ordered from Big Kahuna Guns Industries, Inc. or can be downloaded from the company website, [bigkahunaguns.com](http://bigkahunaguns.com). Technical specifications are subject to change without notice. Please ensure you have the most updated revision of this manual by checking [bigkahunaguns.com](http://bigkahunaguns.com).

### SAFETY ALERT SYMBOL AND SIGNAL WORDS



**DANGER**

DANGER- Indicates a hazardous situation, which, if not avoided, WILL result in death or serious injury.



**WARNING**

WARNING- Indicates a hazardous situation, which, if not avoided, could result in death or serious injury.

**NOTICE**

NOTICE- Indicates a situation that could result in damage to the equipment or other property.

# SAFETY

## MUZZLE CONTROL

Always keep the muzzle pointed in a safe direction. Never allow your muzzle to point at anything that you do not intend to shoot. Upon firing, the muzzle device releases high-pressure gas from its ports that can damage objects or cause injuries, keep everything away from the vicinity of the muzzle.

## KEEP YOUR FINGER OFF THE TRIGGER

Keep your finger off the trigger and out of the trigger guard until your sights are aligned on your target and you intend to fire.

## ASSUME EVERY FIREARM IS LOADED

Always treat every firearm as if it were loaded. Look and feel for an empty chamber. Do not trust the extractor to provide an empty chamber.

## KEEP YOUR SAFETY ON

Keep your safety on until your sights are aligned on your target and you intend to fire.

## SAFETY DISTANCE

Bullets fired from this rifle may travel as far as 4 miles. Make certain that you have an adequate backstop and are aware of what is beyond your target.

## HEARING PROTECTION

Always wear adequate hearing protection when the rifle is firing; wear both earplugs and shooting muffs together for maximum protection. This includes observers. Observers should always be behind the shooter.

## EYE PROTECTION

Appropriate eye protection should be worn when both shooting and maintaining your rifle. It is normal for firing to generate airborne dust and debris. Protect your eyes from solvents and uncaptured parts under spring pressure while performing maintenance on your rifle.

# SAFETY

## **AMMUNITION**

Do not use hand loaded, re-manufactured, or surplus ammunition. Always use new, clean, dry, properly stored, and correct caliber ammunition from reputable manufacturers.

## **BEWARE OF BARREL OBSTRUCTIONS**

Ensure the barrel's bore is free of obstructions before you fire your rifle. Even the smallest obstruction such as a stuck patch or grease will cause increased pressures that can rupture the barrel.

## **FAILURE TO FIRE**

If your rifle fails to fire when you pull the trigger, do not open the action. Keep the rifle pointed toward a safe area and wait 2 minutes. If a hang-fire (slow ignition) has occurred, the round will probably fire within two minutes. If the round does not fire, remove and inspect the cartridge. If the primer is indented properly, discard it in a safe manner.

## **ALCOHOL, MEDICATIONS AND DRUGS**

Do not handle or operate your rifle under the influence of alcohol, medication or drugs.

## **MAINTAIN YOUR RIFLE PROPERLY**

Performing proper maintenance, as outlined in this manual, insures that your rifle will be safe to shoot and will perform to design specification for many years. Alterations, modifications or adjustments may damage your rifle, make it unsafe to fire and will void warranty claims.

## **STORE YOUR RIFLE SAFELY**

It is your responsibility to take reasonable precaution to secure your rifle, keep it properly secured and prevent unauthorized use.

## **LEAD EXPOSURE**

Discharging firearms in poorly ventilated areas, cleaning firearms, or handling ammunition may result to exposure to lead and other substances. Maintain adequate ventilation at all times. Thoroughly wash hands after exposure.

# FIREARM

## DESCRIPTION

The Raptor 50 is a single shot, bolt action rifle. The shooter manually loads one single cartridge. The firing pin assembly is cocked when the bolt handle is raised. The bolt is retained in the receiver and is equipped with an extractor to remove a cartridge or shell casing. A manually controlled safety prevents or permits trigger movement.

Barrel Length	Overall Length	Weight	Twist rate
30"	44"	15 lbs	1 in 15", RH
29"	43"	15 lbs	1 in 15", RH
22"	36"	14 lbs	1 in 15", RH
18.5"	32.5"	14 lbs	1 in 15", RH

**SINGLE SHOT:** Chambered for .50 BMG Cartridge

**BARREL:** Lothar Walther Target Barrel, Chrome-Moly, Button Rifled, Twist 1" in 15", Chamber US Mil-Spec.

**MUZZLE BRAKE:** 8 port style

- Standard Scope Mount
- Heavy Duty Hammer and Spring Kit supplied to replace AR15 hammer.

**MUZZLE VELOCITIES** (approximate) :

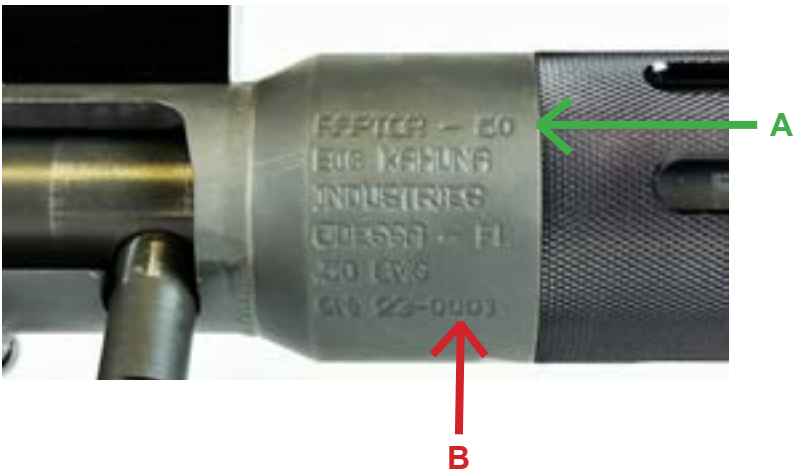
18.5" - 2.285 fps

22" - 2.385 fps

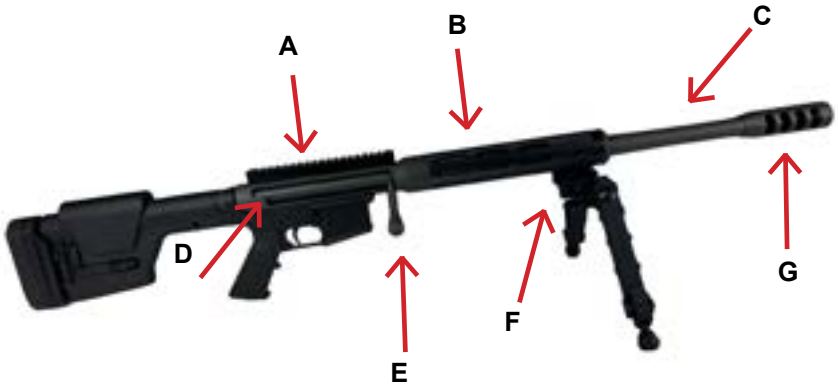
30" - 2.561 fps

## MODEL AND SERIAL NUMBER

The model number (A) and serial number (B) are located on the right side of the firearm.



# PARTS IDENTIFICATION



- a. Scope rail
- b. Hand guard
- c. Barrel
- d. Bolt assembly

- e. Bolt handle
- f. Bipod rail
- g. Muzzle brake

*Note: Lower receiver, stock, and bipod not included. For demonstration purposes only.*

# SET UP INSTRUCTIONS

## AR-15 LOWER RECEIVER SET UP

(READ THESE INSTRUCTIONS THOROUGHLY BEFORE STARTING)

### RECOMMENDED TOOLS:

- Durable Light Adhesive Tape
- 3/32" Punch and Small Hammer
- Small Plastic Bag
- Needle Nose Pliers



*Note: If you have an AR-15 lower with a collapsible stock, it will require replacement with a fixed stock and extension tube.*

1. Remove the current upper from lower receiver at the takedown and pivot pins.



2. Using a 3/32" punch, remove the bolt catch roll pin. Suggestion: place durable tape on the surface of the lower receiver to help prevent scratching the finish.





# SET UP INSTRUCTIONS

(CONT.)

3. After removing the bolt catch roll pin, place all the component parts (the bolt catch, bolt catch roll pin, bolt catch plunger and bolt catch plunger spring) in a plastic bag for safe keeping and storage.

4. Using the punch, gently remove the hammer and trigger pins. Once pins are removed, carefully extract hammer, hammer spring, disconnecter, and disconnecter spring. Keep trigger and trigger spring in receiver.



*Note: The hammer and trigger are under spring pressure and will jump slightly when the pins come free.*

Shown are the parts that comprise the standard fire control group. Set-up of the lower requires only that the trigger and trigger spring be reinstalled.

The stock hammer, hammer spring, disconnecter, disconnecter spring, and pins should be placed in the small parts plastic bag (referenced above) for safe keeping.



The Big Kahuna Heavy Duty Hammer & Spring (included with your upper) will be inserted, oriented as shown. Don't install until step 5.



## SET UP INSTRUCTIONS (CONT.)

5. Reinstall the trigger, and trigger spring without the disconnecter. Use one of the two anti-walk retention pins included with your upper.

Install the Big Kahuna Heavy Duty Hammer & Spring. Use the second anti-walk retention pin included with your upper.



6. Optional: Using a pair of needle nose pliers, install the E-clips on the hammer and trigger anti-walk retention pins. Suggestion: insert the pins so that the undercut is flush with the receiver, lay the pin flat on the receiver and squeeze the clips gently into place. Use caution to avoid scratching the lower receiver finish.



7. Remove the buffer and buffer spring. To do this, depress the buffer retention pin. Note: the buffer is spring loaded and will jump free as the retention pin is depressed. Slide and remove the buffer and buffer spring from the buffer tube.



8. Remove the buffer retention pin and spring. To remove these parts, you will need to unscrew the buffer tube. Important: this step releases pressure on the takedown pin detent and spring. Remove the stock very slowly and be careful not to lose control of the detent and spring or else they will shoot across the room.

(Re)install a fixed stock. Important: Do not use a collapsible stock; it is not designed for large caliber recoil.



**THE LOWER SET UP IS COMPLETE.**

## **SET UP INSTRUCTIONS**

### **ATTATCH LOWER AND UPPER**

1. Attach the Raptor upper to the set-up lower receiver, at the takedown and pivot pins.



2. Operate the bolt and trigger several times to confirm correct installation, good hammer/trigger engagement and trigger pull weight. If the trigger does not engage with the hammer or if the trigger pull weight is lighter than you like, please contact us for troubleshooting.



### **TO SET UP A STRIPPED LOWER, INSTALL THE FOLLOWING FROM A LOWER PARTS KIT:**

- Trigger guard
- Pivot pin
- Trigger & trigger spring
- Big Kahuna Heavy Duty hammer and spring (included with your upper)
- Anti-walk pin (included with your upper)
- Fire control switch and detent
- Grip
- Takedown pin



## FIELD STRIPPING & CLEANING

1. Use a 3/8" std wrench and turn counter clockwise to loosen the bolt handle.



2. Separate the bolt from the tube. Slide the bolt tube from the back of the upper. Remove bolt head and follower from the side of the receiver.



3. Remove the firing pin from the front of the bolt tube.

4. Clean and lube the firing pin thoroughly. Inspect it carefully. If you find unusual wear to the firing pin or damage to the tip, please contact us immediately for troubleshooting. Do not fire any firearm that shows signs of damage in any part of the action.



## FIELD STRIPPING & CLEANING (CONT.)

5. Clean and lube the bolt head thoroughly. The extractor and follower are located using spring-loaded steel balls. If you choose to remove these parts in cleaning, use caution to prevent the balls/springs from being lost.

While cleaning the bolt head, inspect it for signs of unusual wear or damage.



Clean all parts of the upper thoroughly using high quality cleaning components, a good quality rod.

6. Reassemble by reversing the above operations.

To reduce the risk of damaging the firing pin tip, insert the pin into the bolt tube bushing prior to inserting the tube into the upper. Carefully slide the bolt head into place.



7. To confirm correct assembly, press the back of the firing pin several times through the bolt tube window. The pin should pass through the bolt face smoothly and easily and retract quickly. If you encounter any problems, after reattempting assembly, please contact us.



8. Operate the bolt and trigger several times to confirm correct installation, good hammer/trigger engagement and trigger pull weight. If the trigger does not engage with the hammer or if the trigger pull weight is lighter than you like, please contact us for troubleshooting.



# **FIELD STRIPPING & CLEANING**

## **(CONT.)**

### **BARREL BREAK-IN AND CLEANING SUGGESTIONS**

Many break-in and cleaning methods work well. This is our present method and some of the products we are using with success. Let the chemicals do their job over time.

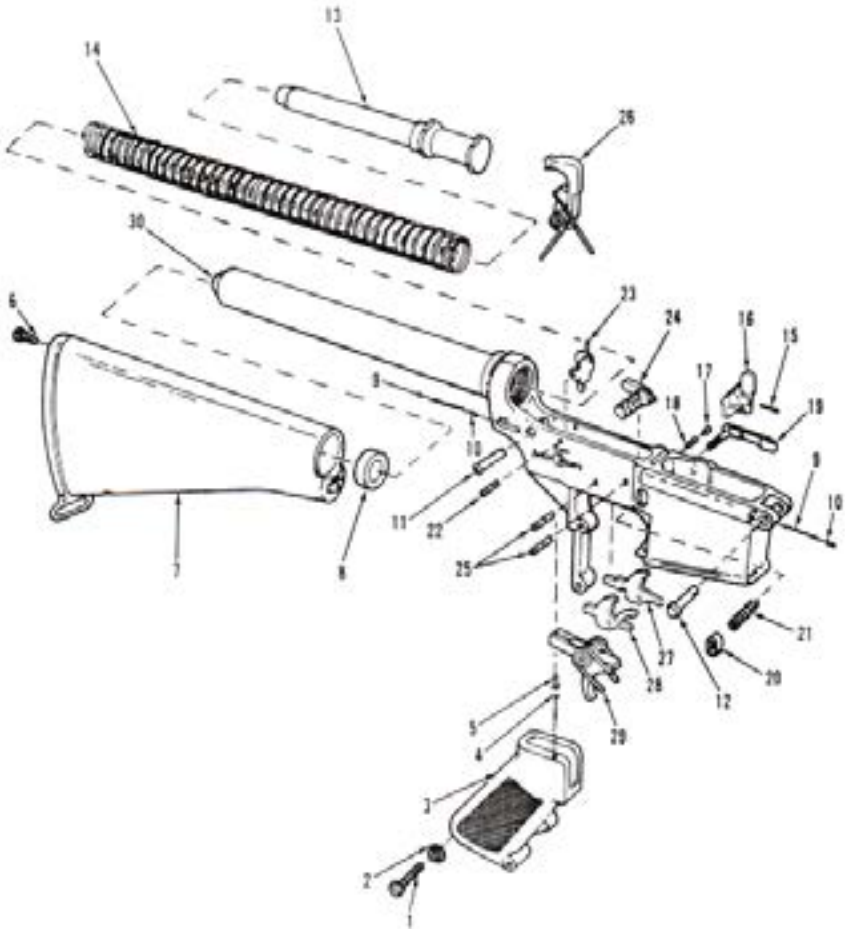
- Always push breech to muzzle in all procedures.
- If you use a brush, do not reverse your brush and drag it back through barrel.
- Push lightly lubricated patches through the barrel to remove any particles that may be present in the barrel and provide initial lubrication. Repeat, until clean (two or three should be sufficient). Run a dry patch.
- Always dry the chamber with a mop or patch to protect against liquid buildup in the chamber.
- Shoot the gun, using common sense and safe practices.

### **CLEANING / BREAK-IN PROCESS:**

- Repeat this procedure until the fouling is minimal. Normally 10-20 repetitions of one shot and clean. Then shoot 2 shots. If no increase in fouling is observed, start shooting 2 to 3 three shot groups and clean as directed. If a fouling problem occurs, start over.
- Push 2 patches wetted with a copper cleaner through the barrel and let the product sit in the barrel for 5 minutes to work on the copper.
- Push a dry patch through and inspect the patch for indications of copper. If present push another wet patch through. If it shows copper or other fouling present, let the product work again for 5 minutes. Repeat this procedure until copper fouling is COMPLETELY removed.
- Dry the bore with dry patches. Some use alcohol additionally to remove cleaners.
- Lubricate the bore with one lubricated patch followed by a dry patch, high temperature synthetic gun oil is best.
- Start working on groups. Remember velocity is normally increasing during the process and consistent after 100 rounds to make your final load selection. The first 40 rounds will be relatively slowest. Velocity will start increasing between 40-70 rounds.



## INSTRUCTIONS FOR REPLACING THE HAMMER



First remove the hammer pin pull the old hammer out, replace the old hammer with the new one (make sure you note the way the spring is facing).

Remove the Safety Selector Lever, then pull the trigger group out and remove the Disconnecter. (The disconnecter is located in the channel of the trigger that is held in by the pin, remove the disconnecter spring that supports the disconnecter).

# INSPECT FOR AMMUNITION



**DANGER**

- A loaded firearm may discharge unintentionally.
- Point firearm in a safe direction while inspecting for ammunition.

1. Place safety selector on SAFE.

*Note: If hammer is not cocked, safety selector can not be placed on SAFE.*



2. Grasp firearm while keeping your finger off trigger.

3. Pull bolt handle rearward and look into receiver to verify that there is no ammunition in chamber. With safety selector pointing toward SAFE, allow bolt handle to go forward.



4. Follow this inspection procedure before storage, before cleaning, transporting, before handing to another person or when handed to you.

# AMMUNITION



## DANGER

- Death, serious injury and damage can result from the use of wrong ammunition, bore obstructions, powder overloads or incorrect cartridge components.
- Failure to use proper gauge or caliber of ammunition will cause your firearm to fail when firing.
- ALWAYS use factory new ammunition (not reloaded or remanufactured), made by a reputable commercial ammunition manufacturer in the appropriate caliber and bullet weight for the firearm's chamber and rifling. **DO NOT USE MILITARY SURPLUS AMMUNITION.**
- Always use ammunition that meets industry standards and is specifically designed for use in this firearm.

## WARNING

- A loaded firearm may discharge unintentionally
- Point firearm in a safe direction while inspecting for ammunition.

# CHOICE OF AMMUNITION

## WARNING

- ⚠ ALWAYS use only the correct ammunition for your gun.** Only cartridges designed for a particular gun can be fired safely in that gun. Most guns have the ammunition type stamped on the barrel. Ammunition can be identified by information printed on the box and sometimes stamped on the cartridge. Do not shoot the gun unless you know you have the proper ammunition.
- ⚠ DO NOT USE MILITARY SURPLUS AMMUNITION.** Big Kahuna Industries, Inc. recommends in the strongest possible terms against using military surplus ammunition, as quality and performance will likely vary widely depending upon manufacturer, age, lot, storage method and any number of any other factors. **YOUR HEALTH AND SAFETY IS NOT WORTH THE RELATIVELY SMALL ECONOMIC SAVINGS.**
- ⚠ Reloaded Ammunition.** We recommend strongly against using reloaded ammunition, and doing so will void your product warranty. If you should, however, choose to reload, a thorough knowledge of bullets, powder, primers, brass and safety precautions is necessary, and you should use only high quality new components and practice all current safety measures. It has been said that reloading is like a math test, where if you're wrong, you lose a hand. Use of reloaded ammunition voids your product warranty.

This firearm has been designed for ammunition of a specific caliber and type. The firearm and ammunition work together as a system. You must use the correct ammunition for your firearm. Locate caliber mark on firearm. This designates ammunition caliber that must be used in firearm.



# LOADING

## WARNING

- ⚠ WARNING - LOADED CHAMBER**  
Never rely on your memory to know if a gun is loaded. Always visually check the chamber by retracting the bolt and examining the chamber to be sure whether it is empty or loaded.
- ⚠ WARNING - HANDLING**
- Point barrel of firearm in a safe direction when loading or unloading.
  - If dropped or struck with the safety “off”, any firearm may fire. Keep chamber empty unless actually firing. Keep the firearm pointed in a safe direction at all times. Keep safety “on” unless actually firing.

**Remember to clean the firearm before first use.** The firearm has been treated at the factory to prevent corrosion. Chamber, bore, and exterior surfaces must be cleaned to remove excess oil.

1. Inspect firearm for ammunition if you have not done so. See Inspect for Ammunition on page 16.
2. Verify that safety selector is in SAFE position.

*Note: If hammer is not cocked, safety selector can not be placed on SAFE.*

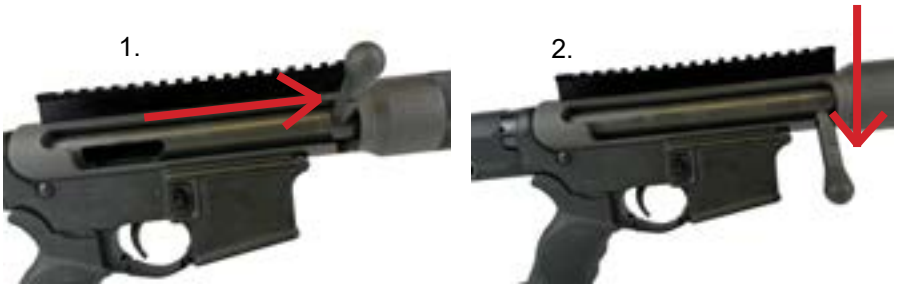


## LOADING (CONT.)

3. With the rifle pointed in a safe direction, lift the bolt handle and draw it to the rear. Inspect each cartridge for signs of damage. Do not load damaged ammunition. Insert a cartridge into the chamber. Insert a cartridge into the chamber.



4. Push the bolt handle fully forward and then downward into the locked position.



5. Your firearm is now in battery and ready to fire.

### WARNING

DO NOT ATTEMPT TO FORCE A CARTRIDGE INTO THE CHAMBER BY FORCING THE BOLT CLOSED. IF THE BOLT WILL NOT CLOSE EASILY, REMOVE THE CARTRIDGE AND EXAMINE IT FOR DAMAGE OR DEFECTS. CHECK THE CHAMBER FOR OBSTRUCTIONS.

### WARNING

VERY IMPORTANT: ALWAYS CHECK TO SEE IF FIRING PIN MOVES FREELY. IF NOT, NEVER RELOAD THE RIFLE.

# FIRING

## DANGER

- **Do not fire this weapon** if you have a weak heart, are taking medication, have osteoporosis (weak or fragile bones), a recent shoulder injury, muscle or joint disease, are susceptible to eye retinal separation, have high blood pressure or have any medical condition that may be exacerbated by the recoil of magnum weapons. If you are uncertain, check with your doctor prior to shooting the Raptor 50.
- With every shot of a .50 BMG, you are applying tremendous force upon your body, as with any other magnum type rifles be aware of overuse. If you start to hurt or feel discomfort stop shooting. Ignoring this warning may result in permanent muscular, joint and/or bone damage.

## DANGER

### **ALWAYS KNOW YOUR TARGET AND WHAT IS BEYOND:**

- Be absolutely sure you have identified your target beyond any doubt. Equally important, be aware of the area for 3000 yards beyond your target. This means observing your prospective area for fire before you shoot. When shooting in areas with lots of rock, water or other potentially deflecting items, be aware of the ricochet risk and make sure that no people are within at least 6000 yards of your target. Never fire in a direction in which there are people or any other potential for mishap. Additionally if the bullet goes through the tree, berm, elk, elephant – what will it hit next? Think first, shoot second.
- The backstop for shooting the 50 BMG must be extremely thick, debris free and high. Be extra careful of ranges with a high buildup of old lead – the bullets can hit an old pile of lead and ricochet right over the backstop.

## **FIRING (CONT.)**

### **WARNING ALTERATIONS**

This product was designed to function properly in its original condition. Alterations can make it unsafe. Do not alter any part or add or substitute parts or accessories not made by Big Kahuna Industries, Inc. Such alterations may void the product warranty.

**SCOPE:** Be very careful in choosing your scope. We recommend a minimum of 4 inches of relief. On some of the higher scopes the eye relief can be reduced to less than 2 inches, which is potentially hazardous.

### **WARNING**

**DO NOT CHANGE THE MUZZLE BRAKE.** Big Kahuna Industries, Inc. installs a muzzle brake that has been tested with the Raptor 50. Do not use any muzzle brake with the Raptor 50 that is from any other manufacturer.

On 50 BMG rifles especially, be extra careful of the huge amount of gas expelled by the muzzle brake. Use even more caution on our 18.5" barrel. If shooting with others make sure no one is on either side of you when shooting, because large amounts of gas will be sent in their direction. Be careful of any objects that may be on the shooting bench because the gas will send the items flying.

### **WARNING**

#### **WARNING - ALTERATIONS**

This product was designed to function properly in its original condition. Alterations can make it unsafe. Do not alter any part or add or substitute parts or accessories not made by Big Kahuna Industries, Inc. Such alterations may void the product warranty.



# FIRING (CONT.)

## WARNING

You must follow all safety guidelines for the safe use of a firearm. Failure to follow these basic firearm safety guidelines may result in an unintended discharge which could cause serious injury or death.

- Always point firearm in a safe direction.
- Be aware of others. Persons in vicinity of shooting may unintentionally walk into the line of fire.
- Keep bystanders clear of blast which exits the muzzle brake parts.

## WARNING

- Stay clear of ejected shell casings.
- Always wear appropriate eye and ear protection while firing. Be sure others in the vicinity have proper eye and ear protection as well.
- **ALWAYS BE CAREFUL OF MUZZLE BLAST.** Use extra caution on our 18.5" barrel. A very substantial amount of hot gas and debris will be blasted from the muzzle brake. Be sure that people and objects are clear of the firing area.

## **FIRING (CONT.)**

This cartridge has an Absolute Maximum Effective Range, which is a measure of the cartridge's area of potential lethality that is measured in 1000s of yards. Always use extreme caution when firing any firearm. Always know what is behind your target. Prior to each and every use, inspect the firearms for signs of visible damage- do not fire any gun that shows even the slightest sign of damage. And always use common sense when using any weapon.

Out of Battery detonations ("OOBD") are a risk with any firearm. With a big-bore cartridge, the risk of serious bodily harm from a OOBD is very significantly magnified. It is recommended that the operator visually and tactilely inspect (i.e., swipe his finger across the bolt face, before each reload) to assure that the firing pin is not protruding from the bolt face.

**!! ALWAYS BE CERTAIN THAT THE BOLT IS COMPLETELY FORWARD AND CLOSED. NEVER PULL THE TRIGGER IF THE BOLT AND BOLT HANDLE ARE NOT COMPLETELY CLOSED.** As noted above, the operator should visually and tactilely (i.e., swipe his finger across the bolt face) inspect the bolt face between each reload, to be certain that the firing pin is not protruding from the bolt face.

### **WARNING**

**THE SHOOTER MUST BE POSITIONED DIRECTLY BEHIND THE RIFLE WITH THE RECOIL PAD HELD FIRMLY AGAINST THE SHOULDER. FIRING THE RIFLE IN ANY OTHER POSITION COULD RESULT IN INJURY BY CONTACT WITH THE RIFLE, OR RIFLE SCOPE.**

1. Grasp firearm with one hand on handguard and the other on the grip.
2. Move safety selector to FIRE.
3. Place buttpad against shoulder. Aim at target and gently pull trigger with finger to fire. Release trigger and point firearm in a safe direction.
4. Remove finger from trigger.

# UNLOADING AND CLEARING

## WARNING

- Firearms must be unloaded when not in use. Completely unload firearm as soon as you are finished shooting. Unload firearm before storing it, traveling, laying it down or entering a vehicle or building. Always verify that a firearm is unloaded. Do not take anyone's word that a firearm is unloaded. Never pass your firearm to another person until both you and the other person have visually checked that it is unloaded. Keep your firearm unloaded and safely stored when not in use.
- Always point the firearm in a safe direction.

1. Move safety selector to SAFE.
2. Lift the bolt handle upward and pull it to the rear to eject a chambered cartridge or spent shell casing.
3. With the bolt pulled fully to the rear, look into the chamber to make sure that the cartridge or shell casing has been removed. Visually and physically ensure the chamber is empty.

# MALFUNCTIONS

## WARNING

- If firearm is not operating properly, stop firing immediately.
- Any malfunction is a signal to immediately stop using the firearm, until the problem can be determined.
- If firearm stops firing with a live round in the chamber (a hang fire condition – which is an unexpected delay between the firearm being triggered and the initiation of the propellant), point barrel in a safe direction and wait at least 2 minutes before pulling the bolt back to clear the round. It is important not to immediately remove the round from the chamber, because if a hang fire has occurred, a round detonating outside of the weapon could cause serious fragmentation injury.
- If round cannot be removed, wait 15 minutes with barrel pointing in a safe direction (round could detonate from heat of the barrel.) Safely store firearm and take it to a qualified gunsmith for inspection.

# TROUBLESHOOTING

MALFUNCTION	CAUSE	CORRECTIVE ACTION
<b>FAILURE TO CHAMBER AND LOCK</b>	Damaged cartridge	Remove and replace cartridge
	Dirty or obstructed chamber	Clean chamber
<b>FAILURE TO FIRE</b>	Faulty ammunition (primers dented in center of sufficient depth to fire)	Replace ammunition
	Bolt handle not down fully	Ensure bolt handle is down fully
<b>FAILURE TO EXTRACT</b>	Broken or worn extractor	Replace extractor
	Broken or worn extractor spring	Replace extractor spring
	Extractor moving freely	Clean extractor, extractor spring and recess
	Dirty ammunition or chamber	Clean chamber and ensure ammunition is clean
	Broken case rim	Clear with cleaning rod
<b>FAILURE TO EJECT</b>	Damaged cartridge	Remove and replace cartridge
	Dirty or obstructed chamber	Clean chamber
<b>VERY HARD RECOIL</b>	Faulty or hot ammunition	Replace ammunition
	Muzzle brake missing	Assemble properly
	Improper shooter position	Clean and lubricate cocking piece

# **TROUBLESHOOTING (CONT.)**

## **TROUBLESHOOTING EXTRACTIONS**

After firing the Upper, should you experience difficulty in extracting the empty cartridge, close the bolt handle again to the firing position, then unlock the bolt handle with a fast upward motion to extract the empty cartridge. If you are not successful NEVER hammer the bolt handle, this can cause breakage to the handle and damage the Upper. The easiest means of extracting the empty cartridge is to leave the bolt handle at the open position, and then drive a 3/8" rod through the barrel, this will release the cartridge.

# CLEANING AND LUBRICATION

## WARNING

Regularly clean your firearm, including your upper. Carefully inspect your firearm and upper for signs of wear and damage. Do not fire a damaged firearm.

## NOTICE

NOTICE - Risk of firearm damage. Some cleaning solutions and solvents may damage your firearm. Use a cleaning solution that is designed for use on firearms.

- Use a high quality firearm cleaning kit that includes a cleaning rod, swab holder, cotton flannel bore patches, a small toothbrush, brass wire bristle bore and chamber brushes and a Cleaner/Lubricant/Preservative.
- Before initial use and after firing, clean your firearm as soon as possible to make the job easier and to avoid allowing the development of any corrosion.
- When your firearm has not been fired, you should clean it at least once or twice a year if you live in a temperate climate, or as often as once a week in a tropical climate.
- If you get your firearm wet, clean it as soon as possible.

## **CLEANING AND LUBRICATION (CONT.)**

### **WARNING**

- Wear eye protection while cleaning the firearm.
- Regular cleaning is important in order for your firearm to operate correctly and safely. Taking proper care of it will also maintain its value and extend its life. Your firearm should be cleaned every time it is used.
- A firearm brought out of prolonged storage should also be cleaned before firing. Accumulated moisture and dirt, or solidified grease and oil, can prevent the firearm from operating properly.
- Before cleaning your firearm, make absolutely sure that it is unloaded. The firearm action should be open during the cleaning process. Also make sure that no ammunition is present in the cleaning area.
- During each cleaning, thoroughly inspect your firearm – including your upper receiver for signs of wear and damage. Firing a worn or damaged firearm is unsafe.

### **CLEANING PROCEDURE:**

1. The rifle should be cleaned and lubricated after each shooting session. Regular cleaning prevents the corrosive effects of moisture.
2. Apply cleaning solvent to a chamber brush and clean the chamber. (Heavy Bore Cleaner) is recommended.
3. Apply cleaning solvent to a bore brush and clean the bore. (Heavy Bore Cleaner) is recommended.
4. Clean the muzzle brake with a stiff plastic brush and bore solvent. It is best to clean the muzzle brake at the same time the barrel is being cleaned as the bore solvent will help loosen the carbon build-up on its interior walls.
5. Clean the bolt face with bore solvent. Use a stiff plastic brush to remove carbon from both the extractor and the ejector. Depress the ejector and extractor by hand to test their smooth function.
6. Use dry patches as necessary to remove cleaner from the bore and chamber.
7. Clean the remainder of the rifle with cotton-tipped swabs, general-purpose brushes and rags. Make sure all metal surfaces are coated with preservative oil.



## **CLEANING AND LUBRICATION (CONT.)**

### **CHECK:**

- Check the bolt for cracks or fractures. Bolts with any pitting extending into the firing pin hole must be replaced.
- Check the firing pin to see if it is bent, cracked, too blunt, too sharp or if the tip is pitted. If so, it must be replaced.
- Verify that the firing pin moves freely forward and rearward when inserted into the bolt.
- Check firing pin retainer to see if it is bent or badly worn. If so, it must be replaced.
- Check the extractor to see if it deformed, particularly in the area of the two tangs that engage the slot in the bolt head. If its worn to the point where a lot of up and down movement of the extractor is allowed, it must be replaced.

### **LUBRICATING:**

#### **RECEIVER**

Lightly lubricate with Cleaner/Lubricant/Preservative:

1. The inside of the receiver, bore and chamber using the cleaning rod and a patch.
2. The outer surfaces of barrel.
3. The guide rod and action spring.

#### **TRIGGER**

Lightly lubricate with Cleaner/Lubricant/Preservative:

1. All moving trigger parts including the trigger, hammer, safety, and their various pins and detents. Including the takedown pin, pivot pin and detents.
2. Wipe the trigger and any other components clean of fingerprints.

## **BOLT CARRIER GROUP**

Lightly lubricate with Cleaner/Lubricant/Preservative:

1. The firing pin and the firing pin recess in the bolt.
2. The bolt
3. The extractor and extractor pin.

# STATE BY STATE WARNINGS

Certain states require, by law, that their own specified warning notices, in larger-than-normal type be conspicuously included by the manufacturer, distributor, or retail dealer with firearms sold in that state. Big Kahuna Guns sells its products in compliance with applicable laws and regulations. Because our products may be sold in these states, we include the following:

**CALIFORNIA:** “With the exception of certain law enforcement agencies, the State of California has restricted the possession of .50 BMG rifles. Possession of an unregistered .50 BMG rifle in California is a felony. Other jurisdictions are considering similar restrictions. You are responsible for understanding and complying with restrictions imposed on .50 BMG rifles.”

**WARNING** “Children are attracted to and can operate firearms that can cause severe injuries or death. Prevent child access by always keeping firearms locked away and unloaded when not in use. If you keep a loaded firearm where a child obtains and improperly uses it, you may be fined or sent to prison.”

**ADVERTENCIA** “A los niños atraen las armas de fuego y las pueden hacer funcionar. Ellos pueden causarse lesiones graves y la muerte. Evite que los niños tengan acceso a las armas de fuego guardándolas siempre con llave y descargadas cuando no las esté utilizando. Si usted tiene una arma de fuego cargada en un lugar en que un niño tiene acceso a ella y la usa indebidamente, le pueden dar una multa o enviarlo a la cárcel.”

**CONNECTICUT:** “UNLAWFUL STORAGE OF A LOADED FIREARM MAY RESULT IN IMPRISONMENT OR FINE.”

**FLORIDA:** “IT IS UNLAWFUL, AND PUNISHABLE BY IMPRISONMENT AND FINE, FOR ANY ADULT TO STORE OR LEAVE A FIREARM IN ANY PLACE WITHIN THE REACH OR EASY ACCESS OF A MINOR UNDER 18 YEARS OF AGE OR TO KNOWINGLY SELL OR OTHERWISE TRANSFER OWNERSHIP OR POSSESSION OF A FIREARM TO A MINOR OR A PERSON OF UNSOUND MIND.”

**MAINE:** “ENDANGERING THE WELFARE OF A CHILD IS A CRIME. IF YOU LEAVE A FIREARM AND AMMUNITION WITHIN EASY ACCESS OF A CHILD, YOU MAY BE SUBJECT TO FINE, IMPRISONMENT OR BOTH. KEEP FIREARMS AND AMMUNITION SEPARATE. KEEP FIREARMS AND AMMUNITION LOCKED UP. USE TRIGGER LOCKS.”

MARYLAND: "WARNING: Children can operate firearms which may cause death or serious injury. It is a crime to store or leave a loaded firearm in any location where an individual knew or should have known that an unsupervised minor would gain access to the firearm. Store your firearm responsibly!"

MASSACHUSETTS: "WARNING FROM THE MASSACHUSETTS ATTORNEY GENERAL: This handgun is not equipped with a device that fully blocks use by unauthorized users. More than 200,000 firearms like this one are stolen from their owners every year in the United States. In addition, there are more than a thousand suicides each year by younger children and teenagers who get access to firearms. Hundreds more die from accidental discharge. It is likely that many more children sustain serious wounds, or inflict such wounds accidentally on others. In order to limit the chance of such misuse, it is imperative that you keep this weapon locked in a secure place and take other steps necessary to limit the possibility of theft or accident. Failure to take reasonable preventative steps may result in innocent lives being lost, and in some circumstances may result in your liability for these deaths." "IT IS UNLAWFUL TO STORE OR KEEP A FIREARM, RIFLE, SHOTGUN OR MACHINE GUN IN ANY PLACE UNLESS THAT WEAPON IS EQUIPPED WITH A TAMPER RESISTANT SAFETY DEVICE OR IS STORED OR KEPT IN A SECURELY LOCKED CONTAINER."

NEW JERSEY: "IT IS A CRIMINAL OFFENSE TO LEAVE A LOADED FIREARM WITHIN EASY ACCESS OF A MINOR."

NEW YORK CITY, NY: "THE USE OF A LOCKING DEVICE OR SAFETY LOCK IS ONLY ONE ASPECT OF RESPONSIBLE FIREARMS STORAGE. FOR INCREASED SAFETY, FIREARMS SHOULD BE STORED UNLOADED AND LOCKED IN A LOCATION THAT IS BOTH SEPARATE FROM THEIR AMMUNITION AND INACCESSIBLE TO CHILDREN AND OTHER UNAUTHORIZED PERSONS."

NORTH CAROLINA: Any person who resides in the same premises as a minor, owns or possesses a firearm, and stores or leaves the firearm (i) in a condition that the firearm can be discharged and (ii) in a manner that the person knew or should have known that an unsupervised minor would be able to gain access to the firearm, is guilty of a Class 1 misdemeanor if a minor gains access to the firearm without the lawful permission of the minor's parents or a person having charge of the minor and the minor: (1) Possesses it in violation of G.S. 14-269.2(b) (2) Exhibits it in a public place in a careless, angry, or threatening manner; (3) Causes personal injury or death with it not in self defense; or (4) Uses it in the commission of a crime.

TEXAS: "IT IS UNLAWFUL TO STORE, TRANSPORT, OR ABANDON AN UNSECURED FIREARM IN A PLACE WHERE CHILDREN ARE LIKELY TO BE AND CAN OBTAIN ACCESS TO THE FIREARM."

WISCONSIN: "IF YOU LEAVE A LOADED FIREARM WITHIN THE REACH OR EASY ACCESS OF A CHILD YOU MAY BE FINED OR IMPRISONED OR BOTH IF THE CHILD IMPROPERLY DISCHARGES, POSSESSES, OR EXHIBITS THE FIREARM." Please check with your licensed retailer, state police, or local police for additional warnings, which may be required by local law or regulation. Such regulations change constantly, and local authorities are in the best position to advise you on such legal matters.

# WARRANTY

Congratulations on your new purchase! Before your firearm left the factory, it was tested, carefully inspected and packaged. Big Kahuna Guns cannot control product handling after it leaves the factory. Therefore, please examine this firearm carefully at the time of purchase to insure that it is unloaded and undamaged.

## Warranty:

For one year from date of purchase, Big Kahuna Industries, Inc. (BKII), warrants to the original owner, that this product was manufactured free of defects in materials and workmanship. BKII will correct any defect covered under the warranty by repair or replacement with the same or comparable model. BKII will not be responsible for injury, death, or damage to property resulting from either intentional or accidental discharge of this firearm or from its function when used for purposes or subjected to treatment for which it was not designed. BKII will not honor claims involving this product which result from careless or improper handling, unauthorized adjustment or parts replacement, corrosion, neglect, the use of the wrong caliber ammunition, or the use of other than commercially manufactured ammunition in good condition, or any combination thereof. Please visit [bigkahunaguns.com](http://bigkahunaguns.com) for any additional information. This guarantee is voided by misuse, abuse, improper maintenance, alterations or modifications of the product (as determined by Big Kahuna Industries, Inc.) and does not cover any normal wear that might occur. All guarantee claims should be sent directly to Big Kahuna Industries, Inc. via prepaid and insured delivery.

