

Stealth Machine Gun?

The Ruger AC-556



by CAPT. MONTY MENDENHALL

The Ruger AC-556 is the full-auto version of Ruger's popular Mini-14 rifle. Though M16s are more common, AC-556s are less expensive. They are priced in the \$900 to \$1400 range. The AC-556 is a good value in today's machine gun market.

The AC-556 is extremely reliable. The author has never experienced a failure to function when using a genuine Ruger magazine. The AC-556 shoots the same cartridge as the M16, 5.56mm NATO.

Ruger describes the AC556 gas system as a "fixed piston, self-cleaning design." Unburned powder particles are vented from the system.

The AC556 has a flash hider that also functions as a grenade launcher. The front sight incorporates an integral, nonpolitically correct, bayonet lug that accepts a standard M7 knife bayonet.

Ruger makes a short-barreled, folding stock version of the AC-556. It is designated as an AC-556K ("K" for Kurtz). Both models are available in stainless steel.

Unlike the M16, the AC-556's barrel is difficult to change. An M16 can quickly be converted to fire 7.62x39, 9mm NATO and .45ACP. This makes the M16 the more versatile of the two guns.

The Ruger Mini-14 is available in 7.62x39 caliber. So there is no technical reason that an AC-556 could not be converted to that caliber. The conversion would be expensive and require the work of a competent gunsmith. The change should be considered as semipermanent.

Because Ruger will not sell a barrel unless they install it themselves and Ruger will not make this conversion for an owner, a Ruger Mini-14 would have to be cannibalized to obtain the 7.62x39 conversion parts. If an owner did convert his AC-556 to 7.62x39, Ruger would not repair it, even if the problem was unrelated to the conversion.

Since President Clinton blocked the importation of inexpensive 7.62x39 ammo in-

to the U.S., there is now no economic advantage in shooting 7.62x39. It is probably best to leave the AC-556 in its 5.56 NATO caliber.

ADVANTAGES

The AC-556 has two minor advantages and one major advantage over an M16. First, the AC-556 is available in stainless steel; the M16 is not. For most users, stainless steel is unnecessary.

Second, the AC-556's gas system does not blow unburned powder and other products of combustion into critical places in the receiver. It should function without cleaning longer than an M16. For nonmilitary use, fouling accumulation is seldom a problem.

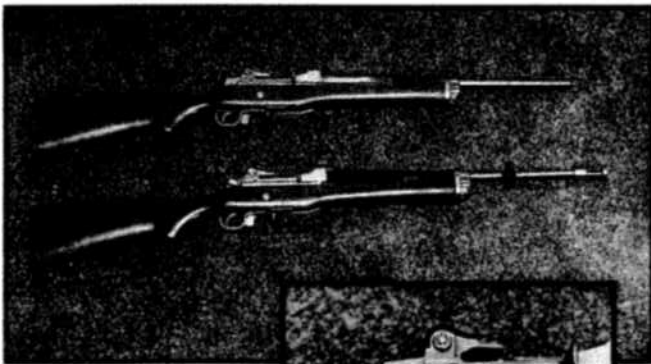
Third, the AC-556 is not readily identifiable as a machine gun. It lacks a prominent pistol grip. It does not look like the news media's dreaded "assault rifle." Its appearance is almost identical with the sporting semi-auto rifle from which it was developed. The AC-556 is a wise choice of firearm when stealth is a requirement.

DIFFERENCES

Differences between an AC-556 and a Mini-14 are subtle. The most obvious difference is the AC-556's combination flash hider and grenade launcher. A non-RKI, would assume that an AC-556 is a Ruger Mini-14. Adding a telescopic sight completes the "sporting rifle" effect. Since the AC-556 looks like an ordinary hunting rifle, it may be carried, without undue attention, anywhere that a hunting rifle may be taken.

Neither AC-556s nor M16s are match-grade target rifles. Both have sufficient practical accuracy for their intended role.

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Above: Mini-14 on top.
AC-556 on bottom.

Right: Mini-14 on top. AC-556 on bottom. Note that the fire control selector is in the "full-auto" position.



Individual guns vary, but in semi-auto, most AC-556s and M16s will shoot five-shot groups under two inches at one hundred yards. If the owner handloads and tests various combinations of bullets and powders, one-inch sized groups are not uncommon.

Serious riflemen sneer at these standards of accuracy. Bear in mind though, the AC-556 is a mass-produced semi-/full-auto machine gun. It is not a hand-fitted bolt action rifle. If an AC-556 is sighted to hit dead center at 300 yards, the bullet will never be more than five inches above or below the line of sight out to 350 yards.

It is always preferable to sight in at the desired range. If a 300-yard range is not available, use the sight table and sight in at the longest range possible. For example, at 150 yards, aim dead center of the target and adjust the sights until the point of impact is 4.8 inches high.

Unlike finely tuned bolt-action rifles, the AC-556 is capable of sustained rapid fire. If the need arises, it can fire full auto as well. The AC-556 reloads quickly with spare thirty-round magazines. Try that you bolt action purists. The highly regarded Marine Corps sniper, Carlos Hathcock, was well aware of a bolt-action rifle's limitations during a fire fight.

The AC-556's barrel is 18.5 inches long. Its muzzle velocity is 3100 fps. The barrel length of the AC-556K is only 13 inches. Surprisingly, its muzzle velocity is only 300 fps less than that of the full-length rifle barrel. An AC-556K receiver and barrel will fit the full-length stock of an AC-556. It makes a short, quick handling package.

Ruger Mini-14s and AC-556s have ergonomic safety levers in the forward trigger guard. They operate identically with those found on an M1 Garand or M14. The fire control selector is on the rear, right side of the upper receiver.

The fire control selector has three positions. The horizontal position, pointing rearward, is full auto. The middle position

is the three-shot burst control. The vertical, most forward position, is semi-auto.

THREE-SHOT BURST

The three-shot burst position needs some explanation. It does not always produce a three-shot burst. The ratcheting "shot counter" does not reset to zero each time that the trigger is released. It merely counts three cycles of the hammer falling and then interrupts the firing sequence.

When the "three-shot burst" is first engaged, the shooter is uncertain where the "shot counter" is set. The first burst might be a burst of one, two or three shots. If the shooter holds the trigger back and lets the "three-shot burst" control interrupt the firing sequence, the next burst will be three shots. If the shooter releases the trigger after firing only two shots, the counter is set at "two." The next burst will be a burst of one.

MAGAZINES

When using Ruger magazines, both the AC-556's and the AC-556K's rate of fire is 750 rpm. With a little practice, most shooters can place the selector in the full-auto mode and fire either two, three or four rounds at will. Most experienced owners do not use the "three-shot burst" position. It is useful when allowing an inexperienced shooter to try the gun.

When using ninety-round magazines, the rate of fire varies from 500 to 650 rpm. The increased magazine spring pressure retards the bolt and slows the rate of fire. Occasionally, when using these magazines, the gun will stop with a round partially into the chamber. A gentle shove on the bolt finishes chambering the round.

Due to the NATO 5.56mm's long range and deep penetration, extra care must be taken when selecting a place to shoot. It must have a very good backstop. A large unoccupied safety area should be behind it. Compared to a pistol caliber, the 5.56mm NATO round is very loud. For these reasons, the author's backyard shooting range is unsuitable for the AC-556.

.22 KITS

Jonathan Arthur Ceiner sells a reliable .22LR conversion kit for the Ruger AC-556. With it, the AC-556 can be shot safely at any range where pistols are welcome. The kit is priced at \$159.00 with one thirty-round magazine and works in both Mini-14's and AC-556's. The standard kit fits serial number prefix 181 thru 187. If your prefix number is 188 you need to add \$10.

The .22LR kit is packed in a sturdy plastic storage case. It installs in the AC-556 with only an Allen wrench. The wrench is supplied with the kit. Installation instructions are complete. First-time installation is a learning experience. It requires about twenty minutes. Subsequent installations need less than ten.

Using CCI .22LR Minimags ammo, the AC-556's rate of fire is 1340 rpm. At that speed, the "three-shot burst" selector is a useful option.

Due to the .22LR's low recoil and high rate of fire, the AC-556's shot dispersion at fifty feet is small. One-half size NRA steel javelina targets are frequently hit by all three bullets in a burst. They appear to leap from the target stand and run for cover.

Occasionally, when shooting at one-half size NRA steel chickens, the chicken is hit on both the front and back side by one burst. The steel chicken stands on only one leg. It turns quickly if it is hit near the edge. Apparently, the first bullet spins the target. The second bullet misses because the target is turned edgewise toward the shooter. As the target continues to spin, it is hit in the back by the third bullet.

Ceiner's .22LR conversion kit for the AC-556 is unique. It is the only reliable closed bolt .22LR conversion kit that does



AC-556K has been installed in an AC-556 stock.

Range table for an M16 with standard sights or an AC-556 with a scope mounted two inches above the bore.

Norinco 5.56 NATO 55 grain spire point FMJ

Range Yards	Velocity FPS	Impact Inches
Muzzle	3100	
50	2929	1.3
100	2764	3.7
150	2605	4.8
200	2542	4.2
250	2304	3.2
300	2161	0.0
350	2023	-5.0



Top: Scope-sighted Mini-14. Next: Mini-14. Next: AC-556. Bottom: AC-556K.

not use a moving weight to counter "bolt bounce."

All .22LR semi-autos fire from an unlocked breech. The mass of the bolt and the resistance of the operating spring keep the bolt closed during the high pressure

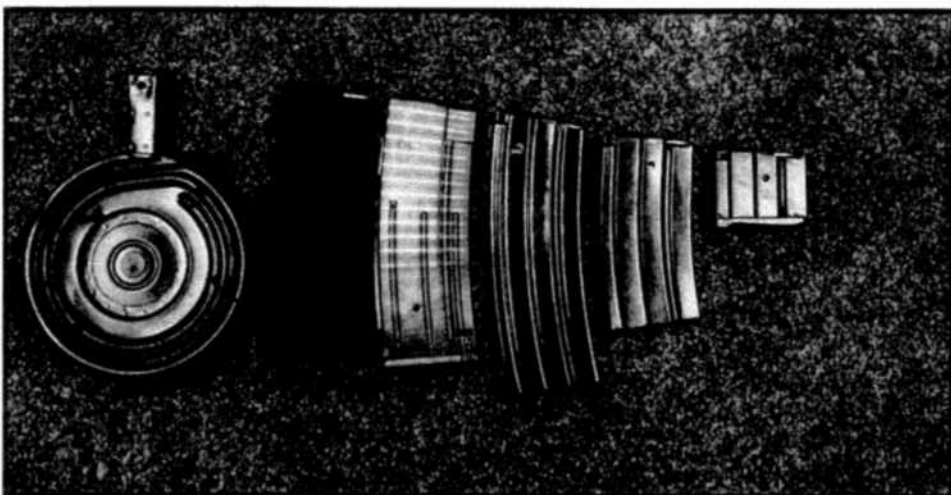
portion of the firing cycle. Residual gas pressure pushes the bolt rearward and compresses the operating spring. The operating spring then pushes the bolt forward. It picks up a fresh round and drives it toward the chamber. The rapidly moving bolt

strikes the face of the breech. If unrestrained, the bolt bounces back a little. The pressure of the operating spring restrains the bolt and pushes it back into battery.

"Bolt bounce" occurs in all semi-auto .22LR guns. It is not a problem for them. The bolt "bounces" and returns to battery before the shooter can release the trigger and pull it again.



The 90-round drum is open, revealing the spiral guide track.



Left to right: The 90-round drum, 30-round Thermold, 30-round Ramline, 30-round Ruger, 20-round Ruger, and 5-round Ruger.

On a full-auto .22LR, the hammer is tripped as the bolt reaches battery. If nothing prevents the bolt from bouncing back, the hammer will strike the bolt as it bounces out of battery. A misfire often occurs.

All reliable .22LR closed-bolt machine guns, except the AC-556, have a moving "antibounce" weight on the bolt. Just as the bolt strikes the breech, but before it can bounce back, the moving weight slides forward. It strikes the bolt and absorbs the bolt's rebounding energy, preventing the bounce.

There is no obvious explanation for why the Ceiner AC-556 .22LR conversion kit works so well without an "antibounce weight." The answer may be the AC-556's massive coil hammer spring. It is much stronger than the hammer spring on an M16. The AC-556 hammer spring may overcome "bolt bounce" with brute force. It appears to push the "bouncing bolt" back into battery while retaining enough energy to fire the cartridge reliably.

The magazine supplied with the Ceiner .22LR conversion kit holds thirty rounds. If it is filled with thirty rounds, it will function reliably for a while. Eventually, the forward portion of the magazine lips, behind the slot for the cartridge's rim, will spread apart. When that happens, the bullet is not guided into the chamber. It strikes the face of the breech above the chamber. In extreme cases, the round "stovepipes."

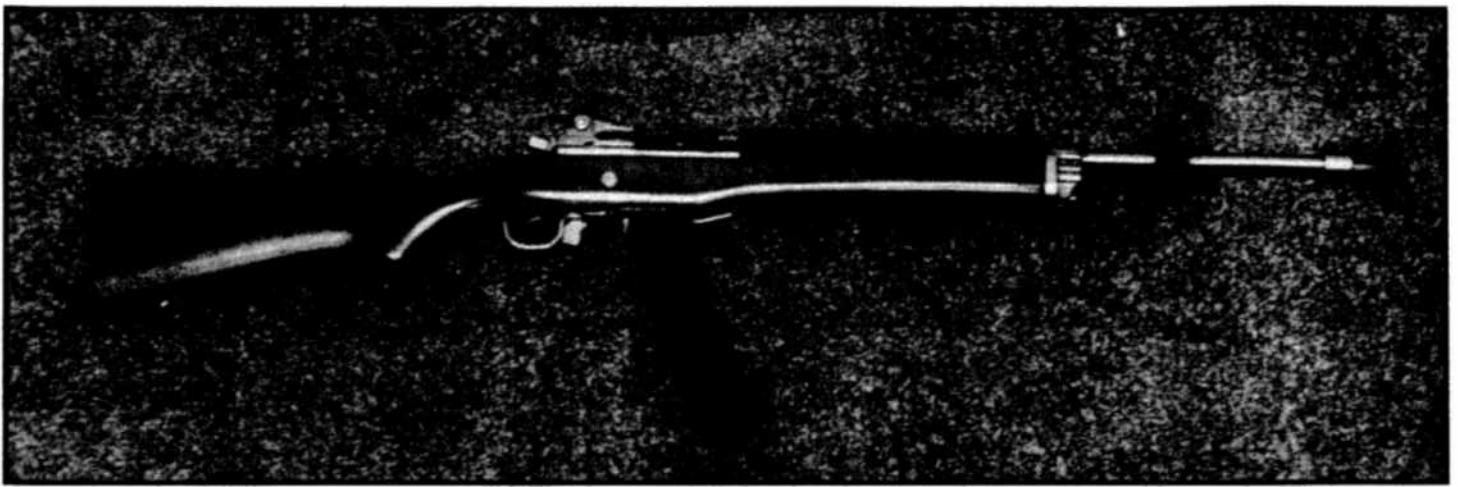
The problem is easily repaired. Use a vice or pliers to gently close the gap in the forward part of the magazine. The correct gap is about .17 to .20 inch. Measure just behind the notch where the cartridge's rim enters the magazine. Dial calipers, at a reasonable price, are available from Dillon Precision. All serious shooters need one.

This magazine problem can be avoided entirely if the user loads only twenty-five rounds. The extra tension, caused by the last five rounds, seems to be the culprit in spreading the lips.

If the .22LR kit is shot a lot, the AC-556's gas system will become blocked with vaporized lead and unburned powder. This blockage does not affect functioning with the .22LR kit. The kit is self-contained and operates on the "blow back" principle.

After removing the .22LR kit, if the gas system is not cleaned, the AC-556 may not function semi-automatically with 5.56mm ammo. It will operate as a straight pull bolt-action rifle.

For safety's sake, after shooting .22LRs, thoroughly clean the chamber before fir-



AC-556 with .22 LR kit installed.

ing any 5.56mm NATO rounds. If the chamber has accumulated much gunk from shooting .22LRs, it may prevent the bolt from closing properly. Firing out of battery is a dangerous condition.

CLEANING

Cleaning the chamber is not difficult. Either an M16 chamber cleaning brush or a .357 pistol brush works well.

Cleaning the gas port takes a little longer. Refer to the AC-556 owner's manual to remove the action from the stock. Be sure that the fire control selector is in the straight up, semi-auto position before disassembly or damage may occur.

The Ruger AC-556's gas system is self-cleaning with 5.56mm NATO ammo. For that reason, the operating manual does not describe how to disassemble or clean it.

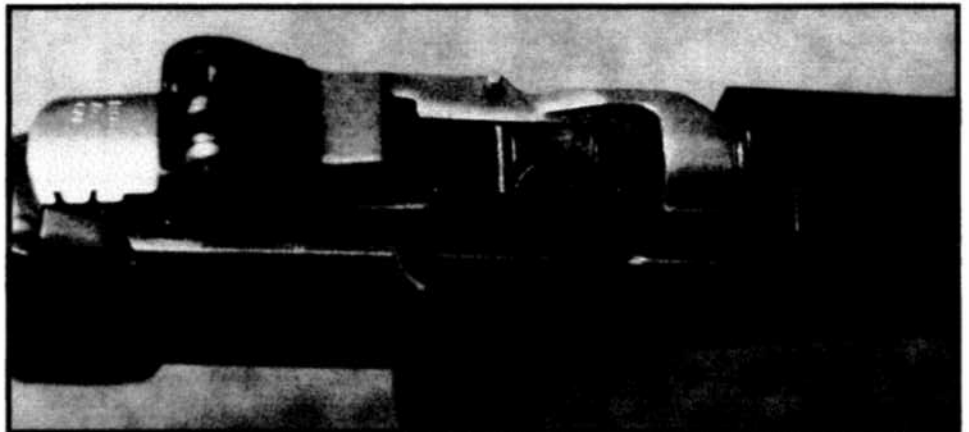
To clean the gas system, field strip the AC-556 per the instruction manual. Note the picture on page 5. It clearly shows the parts in the gas system. Use an Allen wrench to remove the capscrews that clamp the top and bottom halves of the gas block to the barrel. Watch carefully as the lower half is removed from the barrel. The small gas port bushing could fall out. If it stays in its recess, gently pull it out. After it is removed, the gas piston will slide out of the lower half of the gas block.

With finger power only, use a 1/16 inch drill bit to clean the gas bushing. Scrape away the fouling with the bit. Don't enlarge the orifice.

The gas port in the barrel is smaller than 1/16 inch. Use an open paper clip to clean it.

The orifice in the gas piston is larger than the one in the gas bushing. Clean it with a 1/8 inch drill bit. Again, use finger power only. Just scrape out the fouling.

Reassemble the gas system. Avoid over-



A .22LR kit. The black parts are the .22 kit (bolt, chamber adapter and bolt handle).

tightening the capscrews. The threads can be stripped. Run a cleaning rod with a patch through the barrel to remove any fouling that was pushed into the barrel while cleaning the gasport. Finish reassembly per Ruger's instructions.

RUGER MANUAL

AC-556 owners without a manual for their AC-556 can get one free. Write Ruger and politely ask for one. Enclose a copy of your Form 4. Bill Ruger wants everyone to know how to use his guns safely.

The Ruger Company was sued for negligence, as a result of an accidental discharge with one of its single-action revolvers. The injured party was carrying the revolver in a dangerous manner. It was loaded with six rounds. There was a live round under the hammer. In hindsight, it may seem foolish to manufacture a revolver without a transfer bar safety. At the time of its manufacture though, Bill Ruger was simply copying a popular Colt design that has been basically unchanged since 1836.



A .22 kit in storage box.

After this incident, Bill Ruger redesigned his revolvers. He did the responsible thing and retrofitted Ruger owner's old revolvers with transfer bar safeties at no charge. Anyone still having an unconverted old model Ruger single-action revolver should call Ruger to arrange for a free upgrade conversion.

Bill Ruger never intended for any of his full-auto toys to be in public hands. Most of the ones out there came from police departments when they traded them in for newer guns. Only rarely were the owner's manuals passed along with the guns in

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G3 reg. rec. Fleming	\$ 3250
HK53 "sear" gun	\$ 3250
Reg. trigger Pak for HK	\$ 1500
Tec-9 9mm	\$ 1200
MK760 (copy of S&W 76)	\$ 750
L1A1 orig with Trilux + acc.	\$ 5250
25mm Hotchkiss or Petaux with ammo.	CALL
(Several \$3500-5500)	
John Norrell 10/22 Shorty with suppressor	
folding stock full-auto	\$ 1600

DESTRUCTIVE DEVICES

55 Boys	\$ 2500
25mm Hotchkiss	\$ 4000
PTRS matching # w/50-rounds API	\$ 3750
81mm Indian Brandt mortar, nice	CALL
Lahti with mags + Gunners kit	\$ 2950
Lahti-Beautiful	\$ 3000
Solothurn S18-1000 Beautiful	\$ 7500
50mm Russian Mortar	\$ 750

FIREARMS

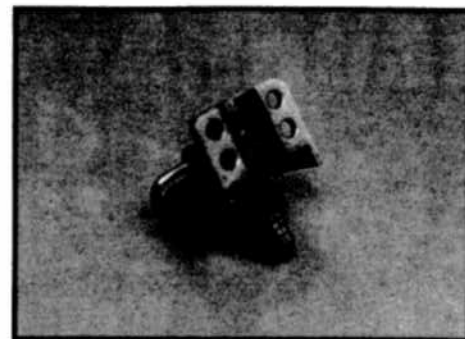
Original FMP (Argentina) L.S.R. (FAL) complete uppers, chrome lined bbls. New units compatible with inch or metric lowers PPD.	\$ 700
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ACCESSORIES

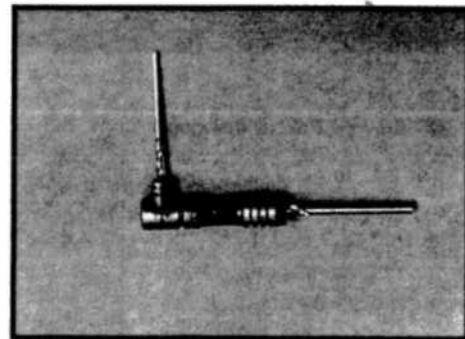
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GATLING GUN—CALL



Lower gas block, gas bushing and gas piston.



Gas bushing and gas piston. 1/16 and 1/8 inch drill bits inserted to remove fouling.

trade.

Even though Ruger did not sell any AC-556s directly to the public, they will repair any owner's unmodified, lawfully owned guns. In the unlikely event of a problem with an AC-556, owners can call (603) 863-3300. Ask for customer service.

There are many good reasons to own a Ruger AC-556. Simply not owning one is reason enough for many. Others rationalize that there is an empty space in their gun safe.

There are more practical reasons, though, to buy an AC-556: at one-third to one-half the cost of an M16, it is more reasonably priced; it is available in stainless steel; with Ruger and certain other magazines, it functions flawlessly; it can pass for a sporting rifle; there is a reliable .22LR kit for it; and the Ruger factory will fix an AC-556 if repairs are needed.

Unless the potential owner needs the option of quick centerfire caliber changes, the M16 has no advantage over the AC-556. An AC-556 is the cost effective choice.

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A BRIEF ACCOUNT OF AN EXTRAORDINARY ACHIEVEMENT: RUGER FIREARMS

One of the few American firearms manufacturers whose management has remained unchanged since starting in business, Sturm, Ruger & Company, Inc., had its beginning in a small machine shop occupying a rented frame building in Southport, Connecticut. In January, 1949, Sturm started production of only \$50,000 and an idea, William B. Ruger and Alexander M. that it became the cornerstone upon which one of the most comprehensive lines of sporting firearms ever made in America was established. After Alex Sturm's death in 1951, William B. Ruger continued to direct the company alone and today, as President and Chairman of the Board, he is actively involved in the creative engineering of new products and continues to provide the leadership which has made this 35 year old company a sound and successful enterprise. Sturm, Ruger & Company, in this relatively short time, has established itself as a leading small arms design organization, developing a unique and broad line of fine quality sporting, military and police firearms to become one of the world's most famous producers of revolvers, pistols, rifles and shotguns.

The Southport, CT, Prescott, AZ and the Newport, NH factory and foundry complex together now comprise over 300,000 square feet of space. From a work force composed of a handful of individuals in 1949, the Ruger facilities together now employ more than 1,400 people. From 1949 thru 1987, Ruger craftsmen have built more than ten million firearms.

During its three decades of growth and progress under the leadership of William B. Ruger, the company has developed a business philosophy and implemented policies which represent a constructive influence in the life of modern America. From the beginning, Sturm, Ruger & Company played a positive role in conservation efforts and has supported the interests of its customers through its membership and participation in the programs of the National Rifle Association, National Shooting Sports Foundation, and many regional sportsmen's organizations. The company has always endeavored to market its firearms for constructive or recreational purposes, to emphasize the traditional aspects of shooting, to render meaningful public services and to encourage shooters in constructive and responsible participation in the shooting sports.

Today, Sturm, Ruger & Company is particularly mindful of those elements which have contributed to the creation of its success, and extend heartfelt thanks to its many loyal employees and customers.

A catalog is available free, upon request to Sturm, Ruger & Co., Inc., Southport, CT 06490.

WHY NO WARRANTY CARD HAS BEEN PACKED WITH THIS NEW RUGER FIREARM

The Magnuson-Moss Act (Public Law 93-637) does not require any seller or manufacturer of a consumer product to give a written warranty. It does provide that if a written warranty is given, it must be designated as "limited" or as "full" and sets minimum standards for a "full" warranty.

Sturm, Ruger & Company, Inc. has elected not to provide any written warranty either "limited" or "full", rather than to attempt to comply with the provisions of the Magnuson-Moss Act and the regulations issued thereunder.

There are certain implied warranties under state law with respect to sales of consumer goods. As the extent and interpretation of these implied warranties varies from state to state, you should refer to your state statutes.

Sturm, Ruger & Company wishes to assure its customers of its continued interest in providing service to owners of Ruger firearms.

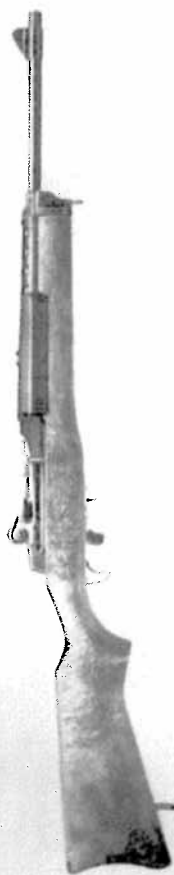


INSTRUCTION MANUAL FOR

RUGER®

MINI-14 RIFLE .223 (5.56mm) Caliber

This Instruction Manual applies only to Mini-14 Rifles having serial numbers beginning with prefix numbers 181 thru 185. NOT FOR USE WITH MINI THIRTY RIFLES (cal. 7.62 x 39mm)



**READ THE INSTRUCTIONS AND WARNINGS
IN THIS MANUAL CAREFULLY
BEFORE USING THIS FIREARM**

**THIS INSTRUCTION MANUAL SHOULD ALWAYS ACCOMPANY THIS FIREARM
AND BE TRANSFERRED WITH IT UPON CHANGE OF OWNERSHIP.
OR WHEN THE FIREARM IS LOANED OR PRESENTED TO ANOTHER PERSON.**

A COPY OF THE INSTRUCTION MANUAL FOR EACH MODEL RUGER FIREARM
IS AVAILABLE FROM THE FACTORY ON REQUEST.
THESE INSTRUCTION MANUALS CONTAIN IMPORTANT WARNINGS
WHICH MUST BE UNDERSTOOD BEFORE USING THESE FIREARMS.

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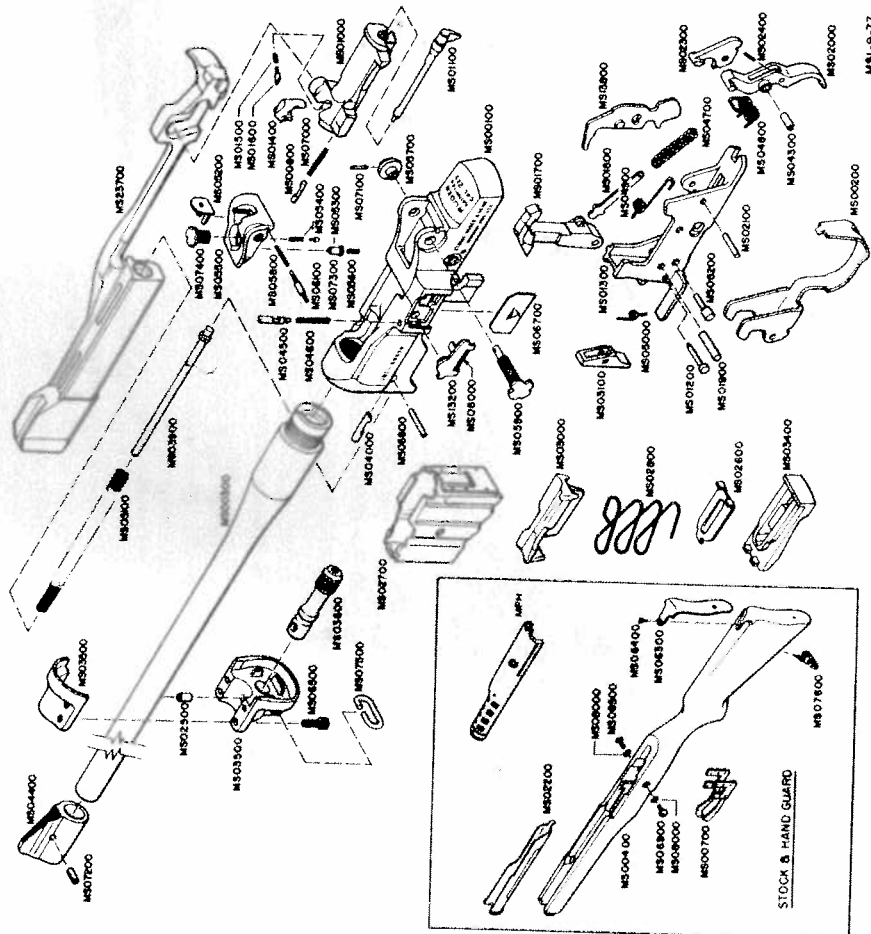
ALL RUGER FIREARMS ARE DESIGNED AND MANUFACTURED
IN RUGER FACTORIES IN THE UNITED STATES OF AMERICA

Order parts by Part Number and Part Name, and state whether the rifle is Blued or Stainless steel.

Parts designated by asterisk (*) must be factory fitted. The price shown for these parts does not include *minimum* net labor charge of \$10.00. All factory fitted parts are replaced on an exchange basis only. We will not return the replaced parts. After factory fitting of barrels and certain other components, the rifle is proof-tested with Industry Proof Loads. See "Warning To Parts Purchasers", page 18.

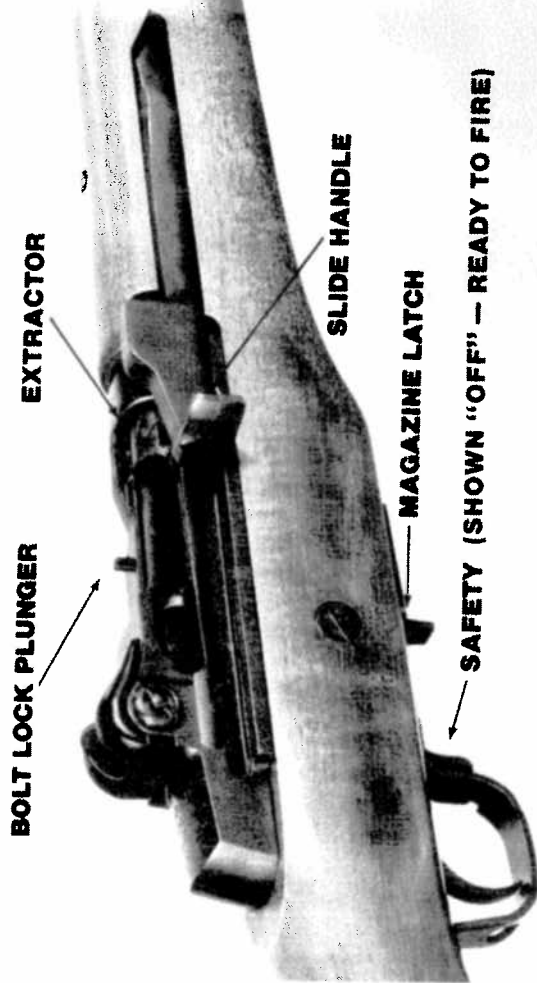
Because it is a serial numbered component, the Mini-14 receiver is defined as a "firearm" by Federal law and is not sold as a separate component.

WARNING: Firearms users are cautioned that a gun containing modified, broken, malfunctioning, or badly worn parts should not be fired!



S#191-05506

Part No.	Description	Suggested Retail Price
MS00300	*Barrel	Blued \$44.75 Stainless \$71.00
MS01000	*Bolt	27.25 28.00
MS13200	Bolt Lock Assembly (with Buffer Spring)	3.00 3.00
MS06000	Bolt Lock Buffer Spring	— .50
MS06700	Bolt Lock Cover Plate	.50 .50
MS04500	Bolt Lock Plunger	.50 .75
MS04600	Bolt Lock Plunger Spring	— .50
MS06300	Butt Plate	.75 .75
MS06400	Butt Plate Screw (2 Req'd)	.50 .50 (pair)
MS00800	Ejector	.75 .75
MS07000	Ejector Spring	— .50
MS01400	Extractor	3.25 3.50
MS01600	Extractor Plunger	1.00 1.25
MS01500	Extractor Spring	— .50
MS01100	*Firing Pin	— .50
MS02200	Forearm Liner & Stock Cap Assembly	17.00
MS04400	Front Sight	4.00 6.00
MS07200	Front Sight Cross Pin	3.25 3.75
MS03500*	*Gas Block (Top & Bottom)	15.00 15.75
MS06500	Gas Block Screw (4 Req'd.)	.50 .50 (2 pcs.)
MS02500	Gas Port Bushing	.50 .50 (set of 4)
MS03900	Guide Rod	.50 .50
MS01700	*Hammer	.50 .50
MS01900	Hammer Pivot Pin	11.00 11.00
MS04700	Hammer Spring	9.50 9.50
MS01800	Hammer Strut	18.00 18.00
MS12700	Handguard Assembly (Fiberglass)	.75 1.25
MS12702	Magazine, 5 Shot, Complete (not shown)	.50 .50
MS04000	Magazine, 20 Shot or 30 Shot, Complete (not shown)	2.25 2.25
MS03100	Magazine Catch Retaining Pin	.50 .50
MS03100	Magazine Catch	.50 .50
MS01200	Magazine Latch Pivot Pin	.50 .50
MS05000	Magazine Latch Spring	2.00 3.00
MS03600	Piston (Gas Pipe)	6.25 6.25
MS05501	Rear Sight Assembly, Complete	4.25 4.25
MS05500	Rear Sight Base	.50 .50
MS07300	Rear Sight Elevation Detent Plunger	— .50
MS05600	Rear Sight Elevation Detent Spring	.50 .50
MS07400	Rear Sight Elevation Screw	.50 .50
MS05300	Rear Sight Elevation Plunger	.75 1.00
MS05400	Rear Sight Nut	.50 .50
MS05200	Rear Sight Peep	.50 .50
MS06100	Rear Sight Windage Detent Plunger	.50 .50
MS05800	Rear Sight Windage Detent Spring	.50 .50
MS05900	Rear Sight Windage Screw	1.50 1.50
MS07100	Rear Sight Windage Plunger	.50 .50
MS00100	Receiver (Not offered for sale)	— .50
MS05100	Recoil Spring (Slide Spring) KMS05101	— 1.25
MS13800	Safety Assembly	1.25 2.75
MS04900	Safety Detent Spring	.50 .50
MS06200	Safety Spring Retaining Pin	.50 .50
MS02300	*Secondary Sear	3.00 3.00
MS02400	Slide Assembly	— .50
MS23700	Sling Swivel, Front	44.75 48.25
MS07500	Sling Swivel Assembly, Rear	1.50 2.00
MA-132	Sling, Carrying, Nylon	1.25 3.25 5.00



BORE OBSTRUCTIONS WARNING

Before loading or shooting the Mini-14 Rifle, be certain the bore is unobstructed. *Firing the rifle with any obstruction in the bore may result in severe damage to the rifle and serious injury to the shooter and other persons nearby.* (Note: In this Manual the word "bore" includes the hole in the barrel which extends from the rear-most portion of the chamber to the foremost portion of the barrel, including any muzzle device.)

A MISFIRE or unusual report (sound) upon firing is always a signal to cease firing and immediately examine the bore of the firearm. It is not sufficient to retract the slide handle and examine the chamber. You must remove the magazine, clear the chamber, lock the bolt open and inspect the bore visually - and with a rod if necessary - to be certain it is completely clear of any obstruction. Failure to detect and remove a bore obstruction can result in serious injury to the shooter and bystanders, and damage to the firearm.

Rifles like the Mini-14 Rifle which are chambered for small caliber, high velocity cartridges, are particularly susceptible to damage from firing when the bore is obstructed. Excess oil, grease, cosmoline, or condensation of water or raindrops may form an obstruction which could cause damage and injury. If you suspect that your rifle may possibly have excess oil, grease or cosmoline in the barrel, or if it may have been exposed to humid conditions which could cause condensation, or to rain or snow which might have entered the bore, open the bolt and clean out the barrel. Inspect the bore visually to be sure that it is perfectly clear (see Warnings in "Ammunition" section and "Care and Cleaning" section).

A gun user should recognize that a lodged bullet is a fairly common form of bore obstruction. Therefore the following information on how a bullet may become lodged in the bore, and how it should be removed, deserves most careful reading and heeding!

- 1)—A bullet may become lodged in the bore if (assuming the trigger has been pulled with a live cartridge in the chamber) the cartridge contains no powder, or the powder fails to ignite, and only the primer charge ignites, resulting in insufficient force to propel the bullet out of the bore.
 - 2)—A bullet may become lodged in the bore if, in unloading an unfired cartridge from the rifle, the cartridge case only is removed, thus leaving the bullet lodged in the bore. This can happen when the bullet is not tightly crimped in the cartridge case.
- Experience indicates that the two conditions described above occur most frequently with reloaded ammunition.

When either of the above described (1 or 2) situations occurs, proceed as follows with the rifle pointing in a safe direction:

(a) If the rifle is cocked, move the safety to the "ON" position. (b) Remove the magazine from the rifle.

(c) Retract the slide handle and lock in the open position by pressing in the bolt lock plunger in the top of the receiver. Retracting the slide handle should remove the cartridge case. Be certain the safety is in the "ON" position.

(d) Check the chamber to be certain there is no cartridge case in it — if there is, extract it before proceeding with steps (e) and (f).

(e) Inspect the bore from the muzzle end of the barrel. If the bore is obstructed, insert a proper size cleaning rod (without a tip or brush) into the bore from the muzzle and dislodge and remove the bullet. If the bullet does not readily dislodge, it may be necessary to lightly tap the handle end of the cleaning rod. If such efforts fail to dislodge the bullet, take the rifle to a gunsmith. **DO NOT ATTEMPT TO REMOVE A LODGED BULLET USING A BLANK CARTRIDGE, OR A CARTRIDGE FROM WHICH THE BULLET HAS BEEN REMOVED, OR BY ANY MEANS OTHER THAN THE USE OF THE PROPER SIZE CLEANING ROD AND REASONABLE FORCE APPLIED TO THE ROD. BE CERTAIN ALL LOOSE POWDER HAS BEEN REMOVED FROM THE BORE AND ACTION BEFORE INTRODUCING THE ROD INTO THE BORE.**

(f) Reinspect the bore to be certain it is free of unburned powder particles or any other debris. At the same time clean the magazine, the magazine-well and other areas of the mechanism of unburned powder grains.

It is absolutely essential that the steps (a) through (f) be followed if there is any suspicion that a bullet may be lodged in the bore because of the situations described in 1 or 2 above. Remember that a bullet can be lodged in the bore of a rifle just where the rifling begins, and a live cartridge can still be chambered and the bolt closed and locked. This can occur because the bullet in the chambered cartridge is pushed back into the cartridge case far enough to give the shooter the impression that the loaded cartridge has chambered normally.

Always check the bore for an obstruction if you experience difficulty in chambering a cartridge, experience a failure to extract, have a misfire, or the rifle does not make a normal loud report on firing.

RELOADERS SHOULD USE ONLY CANNELURED BULLETS AND BE SURE TO CRIMP THEM SECURELY IN THE CARTRIDGE CASE. Note: Sturm, Ruger & Co. specifically does not recommend the use of reloaded, hand loaded or remanufactured cartridges. Please see AMMUNITION NOTICE elsewhere in this manual.

EJECTION OF FIRED CASES WARNING

When firing the Mini-14 Rifle, be sure that other shooters and bystanders are well clear of the shooter and standing a safe distance to the rear. Empty cartridge cases are ejected from the receiver to the right with some velocity and could cause injury to any person who is standing too closely alongside the shooter. Left-handed shooters should be particularly cautious concerning ejected cartridge cases and should wear shooting glasses to avoid the possibility of injury from ejected cartridge cases and particles of powder. All shooters should wear suitable shooting glasses when firing the Mini-14 Rifle. The Mini-14 Rifle should be fired from the right shoulder.

BOLT LOCK MECHANISM

The Mini-14 Rifle is designed so that the bolt remains open after the last shot has been fired, provided there is a magazine in the rifle. When the magazine is empty, the slide and the magazine follower actuates the bolt lock which is designed to retain the bolt and slide in their rearward position.

WARNING: The bolt lock is *not* a safety device. It should not be used to hold the bolt back when there are cartridges in the magazine. A slight jar to the butt end of the rifle will cause the bolt lock to disengage and to feed a cartridge into the chamber.

The bolt lock should be relied on only to hold the bolt in its rearward position when the chamber is empty and an empty magazine is in place in the action. The only purpose of the bolt lock is for convenience in the rapid changing of magazines and for holding the bolt in its rearward position when the rifle is unloaded for the purpose of cleaning or inspection.

To release the slide (which allows the bolt to go forward) either:

1. Remove the magazine, draw the slide handle to the rear and release, or;
2. With the magazine in place, draw the slide handle fully to the rear. Then depress the magazine follower slightly with the thumb and allow the slide to go forward.

To manually engage the bolt lock to keep the bolt open:

1. Pull the slide handle all the way to the rear.
2. Depress the bolt lock plunger and allow the slide to move forward until it stops.

SAFETY MECHANISM

The manual safety mechanism is located forward of the trigger and is "ON" when in the rearward position and intruding into the trigger guard. (See Figure A). The safety can be moved to "ON" (extreme rearward position) only when the hammer is cocked. When the safety is "ON", it blocks both the hammer and sear.

WARNING: The user should never depend on a safety mechanism or any other mechanical device to justify careless handling or pointing the rifle in an unsafe direction.

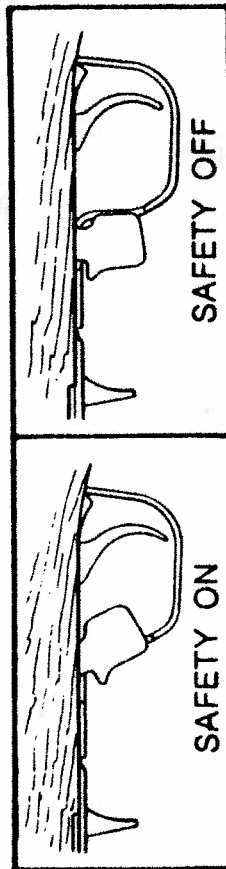


Figure A.

LOADING THE MAGAZINE

Use only clean ammunition of the proper caliber and loading, in good condition, which has been produced by a reputable manufacturer. (See Notice and Warnings in other sections of this Manual pertaining to Ammunition.)

The magazine is a staggered column design. To load the magazine, align each cartridge with the bullet forward (pointing toward the hole in the front of the magazine body) and push downward until the cartridge snaps into place. Do not attempt to load more than the designated number of cartridges for which the magazine has been designed. Ruger Mini-14 Rifles are sold with 5 round Ruger magazines.

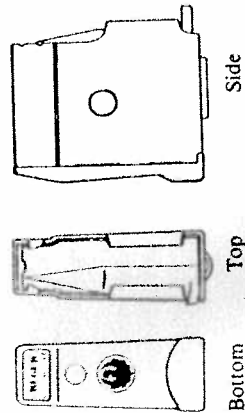
The Ruger Mini-14 magazine is *not* interchangeable with Ruger Mini Thirty magazines. We cannot guarantee that non-Ruger magazines will function correctly. See "ALTERATION WARNING" p.2.

Ruger Mini-14 magazines are identified by having three vertical creases in the side of the magazine versus one vertical crease in the Ruger Mini Thirty magazine. The bottom of the Mini-14 magazine is more rectangular than the generally tapered bottom of the Mini Thirty magazine, and the follower, visible from the top of the magazine, is distinctly more pointed on the Mini Thirty (see illustrations below).

Do not attempt to use Mini Thirty magazines in the Ruger Mini-14 Rifles.

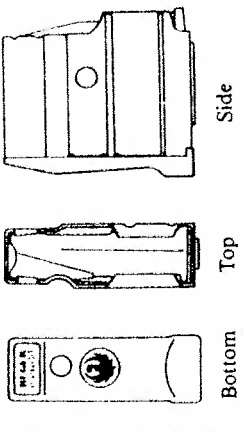
Ruger Mini Thirty Magazine (Incorrect)

For Caliber 7.62 x 39mm
Ammunition Only



Ruger Mini-14 Magazine (Correct)

For Caliber .223 or .222 Ammunition Only.
Do not use in Ruger Mini Thirty



Never attempt to use 7.62 x 39mm ammunition in Ruger Mini-14 Rifles, as it will not chamber correctly and will "jam" the action.

INSERTING THE MAGAZINE

See Figure B. The magazine may be inserted with the bolt either in the closed or open position (See "Bolt Lock Mechanism" Section).

1. Hold the magazine at an angle as shown and insert all the way up into the magazine well.

NOTE: There is a hole in the top-front portion of the magazine that mates with a stud on the inside of the receiver.

2. Pull the bottom of the magazine toward the trigger guard until the magazine latch at the rear of the magazine well engages. Check to be sure that the magazine is securely latched into place.

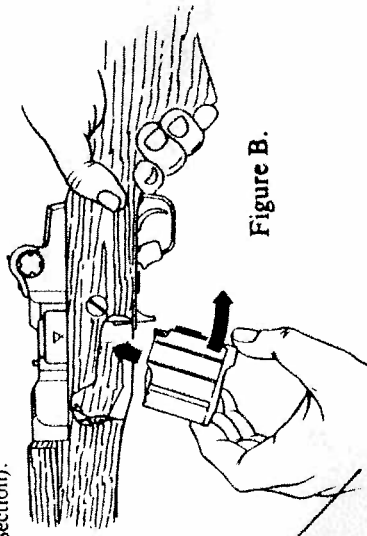


Figure B.

OPERATION OF THE RIFLE

Always check to be sure your Mini-14 Rifle is unloaded before handling. "dry-firing", cleaning, disassembly or storage.

TO LOAD AND FIRE:

(Rifle must be pointing in a safe direction.)

1. Before inserting loaded magazine, engage the bolt lock so the bolt is held open. Check chamber to be certain it is empty. **MOVE THE SAFETY TO THE "ON" POSITION.** (See Figure A).

2. Insert a loaded magazine into the magazine-well, and immediately...
3. Draw the slide handle all the way to the rear and release it, allowing the slide to snap forward under full spring force. A cartridge will be stripped from the magazine and chambered by the motion of the bolt.

WARNING: If cartridges do not feed smoothly from the magazine into the chamber, *then do not use the rifle until the problem is corrected.*

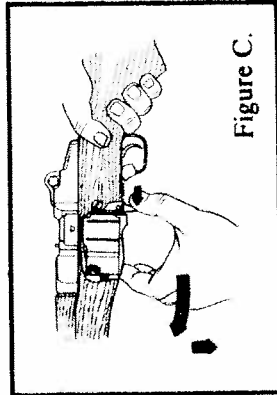


Figure C.

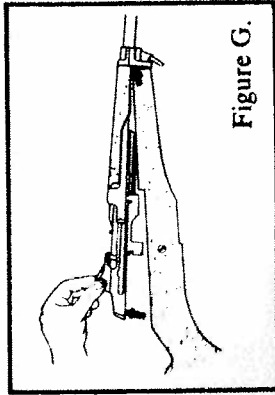


Figure G.

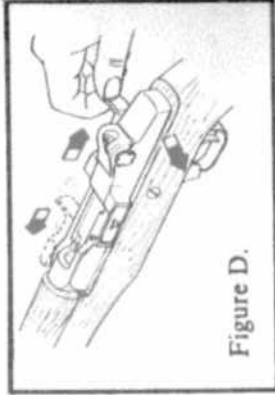


Figure D.

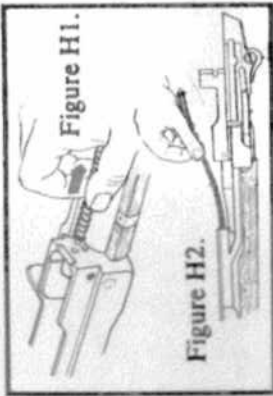


Figure H1.

Figure H2.

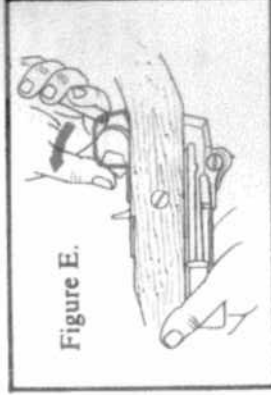


Figure E.

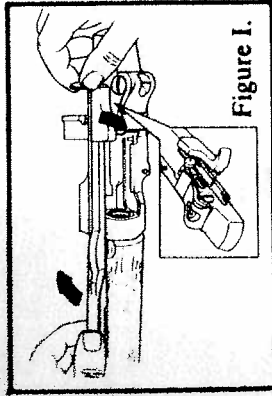


Figure I.

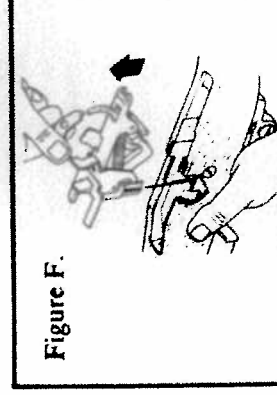


Figure F.

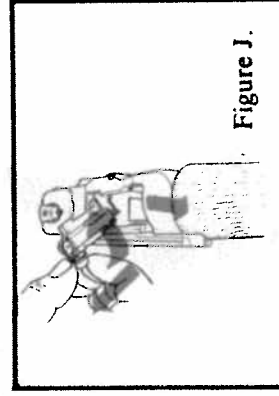


Figure J.

NOTE: The Mini-14 Rifle is like the M1 Garand, and many other types of semi-automatic, gas operated rifles in that the hammer can fall if the trigger is pulled when the bolt is partially retracted. It is important for the shooter to realize that the firing pin cannot contact the cartridge until the bolt is safely locked, regardless of the position of the slide.

CARE AND CLEANING

Before cleaning, be certain the rifle and its magazine contain no cartridges.

A firearm must be free of rust, dirt, grease and firing residues to function safely and reliably. Periodic maintenance, which includes inspection of components to determine if they are in proper working order, is absolutely essential.

Basic cleaning equipment includes: A correct size Cleaning Rod equipped with bore brushes (fiber and brass) and a tip in which a cloth patch can be inserted, Patches, Powder Solvent, Lubricant, Small lint-free Cloths and a Toothbrush.

Some hints for effective use of the equipment: use correct size brushes and patches; if they are too small they don't do the job; if too large they bind in the bore. Insert rod from the muzzle end and push firmly so the patch or brush emerges from the chamber. Don't reverse the rod when a brush or patch is being used — it may bind. Don't use patches or brushes dripping with solvent or oil. Wet them, and squeeze out excess before using. Use rod and brushes with care so as not to damage gun.

1. To clean the rifle thoroughly, disassemble to the extent described above, taking care to put pins, screws and similar easily mislaid and 'rolling' components in a tray.

2. Push-pull a solvent-wetted patch through the bore several times. Next, using a solvent-wetted brush, run it the full length of the bore as many times as is necessary to completely remove all foreign matter from the bore and chamber. Dry the bore with clean patches and examine it. If bore remains fouled, repeat the brushing *because bullet fouling can greatly reduce accuracy and grease can interfere with proper chambering of the cartridge*. Complete the cleaning by dry-patch wiping of bore and chamber. Wipe the cleaning rod with a dry patch frequently to remove abrasive residues.

3. Use a clean, solvent-wetted patch to remove firing residue and dirt from all components and 'reachable' surfaces inside the receiver. Carefully clean the bolt and bolt face with solvent, then dry and lubricate very lightly. Use the solvent-wetted toothbrush to dislodge caked dirt from components and from surfaces inside the receiver that can't be reached with a patch. Thoroughly clean the gas piston and gas chamber in the front end of the slide, and the steel liner in the forearm portion of the stock. Now use cleaning patches or the cloth to dry off the solvent.

4. Wipe all surfaces — internal and external — with oil-wetted patch or cloth that will deposit only a very light and sparing coat of oil. Apply a small drop of lubricant to all pivot points in the trigger guard assembly. Oil and similar preparations 'collect' dirt particles, and may congeal in cold weather, which can interfere with reliable functioning of the rifle. Therefore, use these preparations very sparingly.

5. Periodically disassemble, clean and *lightly* lubricate the magazine. See the Parts Drawing in this manual for guidance on magazine disassembly. If the magazine is dented or if the magazine feed lips are deformed, failure to feed may occur.

WARNING: Damaged magazines should not be used.

6. Reassemble the rifle and carefully wipe all solvent, lubricating and preservative preparations from the stock.

7. If the rifle is to be stored for an extended period, rewire all external surfaces with the cloth containing the oil or preservative.

CAUTION: Do not store the rifle in a leather case or scabbard. Leather attracts moisture, even though it may appear to be dry.

WARNING: Never store a firearm in such a manner that it may unintentionally be dislodged. *A firearm should be stored securely and unloaded.*

LUBRICATION WARNING

Firing a rifle with oil, grease, or any other material even partially obstructing the bore may damage the rifle and injure the shooter and those nearby.

Do *not* spray or apply lubricants directly on ammunition. If the powder charge of a cartridge is affected by the lubricant, it may not be ignited, but the energy from the primer may be sufficient to push the bullet into the bore where it may become lodged. Firing a subsequent bullet into the obstructed bore may damage the rifle and injure the shooter and those nearby. *Use lubricants properly.* You are responsible for the proper care and maintenance of your firearm.

MAINTENANCE OF STAINLESS STEEL RIFLES:

Firearms and components made of stainless steel are more resistant to corrosion than those of blued steel. However, in the interest of proper operation and long life of a stainless steel firearm inspect it frequently and clean, lubricate and apply an appropriate rust preventative.

Sometimes discoloration occurs from perspiration or from contact with some types of gun cases. Rusting may occur as a result of the firearm being exposed to moisture, salt air or chemicals.

Minor discoloration can usually be removed by rubbing the stained area with an abrasive ink eraser, crocus cloth, or a "metal polishing" compound. When using any of these abrasives, proceed with care and use light pressure to achieve a blending of "color" with those areas that are not discolored.

External surfaces most subject to rusting from handling, or from exposure to the elements should be cleaned and wiped dry after use or after exposure to adverse conditions. If the rifle is to be stored, coat it with a light film of oil or preservative. Where the rifle is in continuing use, and the presence of oil or grease would be objectionable, then the external surfaces can be coated (after cleaning and drying) with a paste wax formulated for use on metals. Apply the wax sparingly, allow time for it to dry hard, then buff lightly with a soft cloth. When applying the wax, take care that it does not get into the mechanism or on the functioning parts or in the bore.

PERIODIC MAINTENANCE: At regular intervals, or whenever your Mini-14 Rifle has been exposed to sand, dust, extreme humidity, condensation, immersion in water, or other adverse conditions, disassemble it and clean and oil as outlined above. Proper periodic maintenance is essential to the reliable functioning of any firearm.

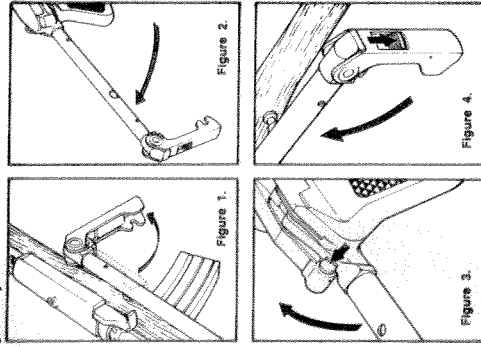
OPERATION OF THE FOLDING STOCK (on rifles so equipped)

To Open the Stock:

1. Swing the Butt Plate downward until it latches in its open position. (See Figure 1.)
2. Swing the Stock Tube Assembly to the rear until it locks in its open position. (See Figure 2.)

To Close the Stock:

1. Press upward on the Hinge Latch as shown in Figure 3 and swing the Stock Tube Assembly forward.
2. Press downward on the Butt Plate Latch and swing Butt Plate upward so that it latches over the Catch Stud which protrudes from the side of the wooden stock as shown in Figure 4.



REMOVAL AND REPLACEMENT OF FIBERGLASS HANDGUARD:

1. Make certain the rifle contains no cartridges and that it is pointing in a safe direction.
2. Remove the magazine. Move the slide rearward one half inch.
3. With the rifle flat on its left side, apply substantial thumb pressure, with both thumbs, to the projecting underside of the handguard in the area of the retaining spring. (The spring is located underneath the circular projection on the top of the handguard.) The pressure should be applied so as to raise the rear portion of the handguard first.
4. To replace the handguard, put the forward end of the handguard under the top portion of the gas block (as far forward as possible) and squeeze the handguard down over the barrel.

SERVICE AND PARTS POLICY

If you have any questions with regard to the performance of your rifle, please write to our Newport, N.H. Service Department, full describing the problem.

If you should return your rifle to the factory for repair, or order parts for it, please comply with the following suggestions for prompt service:

SHIPPING FIREARMS FOR REPAIR:

Ruger Mini-14 Rifles returned to the factory for repair should be sent to: Sturm, Ruger & Co., Inc., Service Department, Newport, N.H. 03773. Phone (603) 863-3300.

Guns should be sent prepaid. *We will not accept collect shipments.*

The Federal Gun Control Act, as well as the laws of most States and localities, does not prohibit an individual (who is not otherwise barred from purchasing or possessing a firearm) from shipping a firearm directly to the manufacturer for repair. However, before you ship your rifle to us, be certain that your State or locality does not have a law or regulation which will prohibit you from receiving the rifle from us after it has been repaired. If such receiving is prohibited, then please have a Federally Licensed firearms dealer ship the gun to us. If your rifle is sent to us by a dealer, it will be returned to him after being repaired. If a handgun (pistol or revolver) is shipped by an individual who does not hold a Federal Firearms License, it *must* be shipped via UPS. Persons who do not hold a Federal Firearms License are prohibited by Federal law from shipping a handgun by Mail. Handguns mailed in violation of the law are impounded by the Post Office.

Please do not include rifle case, sling, telescopic sight, or custom accessories with a firearm being shipped to the factory for service. Rifles and shotguns may be shipped via Parcel Post. Always insure your shipment.

Enclose a letter which includes your name, address, telephone number, and serial number and model of the firearm. Describe in detail the trouble you have experienced with your firearm, or the work you wish to have done. Merely stating that the firearm "needs repair" is inadequate information.

Work performed will bear a net minimum labor charge of \$10.00 plus \$5.00 shipping and handling charge. The charge for metal refinishing the Mini-14 Rifle is \$35.00 plus \$5.00 shipping and handling charge.

WARNING: Before shipping any firearm, be absolutely certain that it and its magazine are unloaded. Do not ship cartridges with a firearm.

IMPORTANT - REGARDING PARTS ORDERING

The Mini-14 rifle is manufactured in Blued steel and Stainless steel versions. WHEN ORDERING PARTS BE SURE TO STATE WHETHER YOUR MINI-14 IS A BLUED OR STAINLESS MODEL ALSO, INCLUDE THE COMPLETE SERIAL NUMBER. Please note that not all parts are manufactured in both Stainless steel and in Blued steel version. (See Parts list.)

—If a part shows a price under only the "Stainless" column then that part is made only in Stainless steel *but it is for use in both Blued and Stainless models.*

—If a part shows a price under only the "Blued" column then that part is made only in Blued steel *but it is for use in Blued and Stainless models.*

—If a part shows a price under both Blued and Stainless columns then the part is made in Blued steel and Stainless steel and you must order the version of the part which is the same as your rifle — Blued or Stainless.

The Part Numbers listed below tie in with the Part Numbers of the drawing below. Refer to that drawing if there is a question as to which part you need.

Send parts orders for the Mini-14 rifle to:

Sturm, Ruger & Co., Inc., Service Dept., Newport, N.H. 03773.

Payment — in the form of a check or money order — must accompany the parts orders. We cannot comply with open account, credit card or COD requests. Minimum parts order is \$1.00. Please include \$1.50 for shipping and handling.

AVOIDING MALFUNCTIONS ("JAMS")

It is well known that autoloading firearms of all makes and types are susceptible to occasional malfunctioning due to a cartridge not feeding from the magazine to the chamber, or due to a cartridge (or fired case) not being extracted and ejected as it should be.

To minimize the possibility of such occurrences the gun user should:

- Use ammunition of the correct caliber and type which is loaded to Industry Specifications. Avoid reloads, remanufactured cartridges, and cartridges that are deformed.
- Clean and lubricate the gun in accordance with the instructions in this Manual.
- If the mechanism shows signs of not functioning correctly, or if a part is damaged or broken — don't use the gun. Have it inspected, and repaired.
- Use only genuine Ruger Mini-14 magazines and carefully load the magazine. Do not exceed the stated magazine capacity.

—Do not 'ride' the slide handle when chambering a cartridge from the magazine. The slide should be drawn fully to the rear and then be permitted to snap forward under the full force of the recoil spring. If a cartridge does not fully chamber, do not 'pound' on the slide handle to force the bolt closed. Rather, retract the slide, eject the cartridge and determine the cause of the problem. (See "Bore Obstructions Warning" elsewhere in the manual.)

—To minimize the probability of an unfired cartridge being jammed should it 'fall back' onto the magazine, remove the magazine *before* retracting the slide. When extracting an unfired cartridge, tip the right side of the rifle towards the ground so that gravity will assist the cartridge to fall clear of the magazine well. Always retract the slide briskly whenever extracting a live cartridge. Take care to see that a cartridge is not forcibly ejected against a surface where the primer might be set off.

TO CLEAR A MALFUNCTION ("JAM")

If a jam occurs, immediately put the safety "on" and be certain the muzzle of the carbine is at all times pointing in a safe direction.

Before "doing something", study the situation to determine the nature of the jam and how best to clear it.

—When attempting to free a jammed cartridge, do not use any type of tool that is likely to act as a 'firing pin' and discharge the cartridge should the tool impact on the primer. Never use a cartridge as a 'tool'.

—After clearing a jam, inspect the gun mechanism to determine if dirt or debris might be the cause of the problem. Excess lubricant or grease can cause cartridges to feed sluggishly. An accumulation of grease, dirt or powder grains in the magazine can contribute to cartridge feeding problems.

—After clearing a jam, inspect all cartridges that have been removed from the gun. Safely dispose of any cartridges which are dented or nicked or have bullets that are loose or improperly positioned in the cartridge case.

—If it appears that the gun and magazine are not at fault and that the jam was caused by the type of cartridge being used, then try another type.

—If the above procedures do not result in a smooth and reliable feeding firearm, don't use the gun until it feeds cartridges smoothly and reliably. The rifle should be returned directly to our Newport Service Department for repair. See the Service and Parts Policy section of this manual for packing and shipping information.

Another precaution: Form the habit of examining fired cartridge cases from time to time. If fired cases have bulged heads or show splits on any part of the case, the rifle should be returned to the factory for inspection.

—If a cartridge or shell is caught between the bolt and receiver, retract the slide and lock it in the open position. Remove the magazine; then remove the jammed case.

—If a fired case is in the chamber, use a cleaning rod to knock it out.

—If an unfired cartridge is stuck in the chamber, effect its removal from the breech-end rather than trying to dislodge it with a cleaning rod inserted from the muzzle. (Because of the inherent danger in the latter method.) Use a piece of 3/16" brass rod which has one end shaped like a screwdriver tip. Insert the tip in the extractor groove of the cartridge, use the face of the receiver ring as a fulcrum and pry out the cartridge. Vigorously brush-clean the chamber with solvent after clearing any jam involving the chamber.

BASIC DISASSEMBLY AND REASSEMBLY

To disassemble for cleaning, follow the instructions on this page and refer to the illustrations on the opposite page (12) which are in sequence first from top to bottom of the left column and then from top to bottom of the right column.

DISASSEMBLY WARNING: Never clean, lubricate, disassemble or work on a firearm while it or its magazine is loaded.

1. Remove the magazine by pushing catch forward to release magazine, while drawing magazine down and forward (Figure C).

2. Pull the slide handle all the way to the rear and release. Put safety "ON" (Figure D). **NOTE: Hammer must be cocked and safety must be "ON" to accomplish disassembly and reassembly.**

3. Use a 1/4" diameter steel rod, punch, screwdriver shank, or other suitable instrument to spring open the trigger guard from its latched position (Figure E).

WARNING: Do not use a cartridge to unlatch the trigger guard because of the danger of loosening the bullet in the cartridge case. (See Warnings in "Ammunition" section.)

4. Remove trigger housing assembly (Figure F).

5. Remove barrel receiver assembly from stock (Figure G).

6. Remove guide rod and recoil spring (Figure H1 and H2).

CAUTION: The recoil spring is heavily compressed — use care when disassembly and reassembly to prevent the buffer guide rod and spring from escaping forcibly and possibly causing injury.

7. Pull slide handle to the rear. Align locking projections on slide with disassembly notch on receiver. Remove slide (Figure I).

8. Pull the bolt forward until it can be pivoted out of receiver. Align firing pin projection with slot in lower receiver bridge and remove bolt from receiver (Figure J).

Removal of the gas block assembly is not necessary and is not advisable. The gas block assembly is factory fitted using special fixtures and torque tools. Attempting to fit the gas block assembly without the required special equipment can result in damage to the components and malfunctioning of the rifle. **(The handguard can be removed if necessary. See page 14.)**

Further disassembly of the Mini-14 Rifle is not required for normal cleaning purposes and should only be performed by a person who is experienced in firearms repair. Reassembly is accomplished in the reverse order of the Disassembly sequence.

Although the Mini-14 Rifle can be disassembled, reassembled, and cleaned in almost any surrounding, it is preferable to carry out these procedures on a workbench or table which has a covered top. A piece of shallow nap rug or an old blanket is an ideal covering. Such a covering keeps the rifle from slipping and being scratched.