

Condensed Instruction Manual for the Thureon Defense “GA” Carbine

As always, remember the 4 rules for firearms safety

1. Treat all firearms as if they were loaded.
2. Always keep the muzzle pointed in a safe direction.
3. Keep your finger off of the trigger until the sights are on the target.
4. Be sure of your target and what is behind it.

Be sure that the ammunition you are using is in good condition and matches the caliber stamped on your Carbine.

The “GA” carbine is designed for **semi-automatic operation, only**. Any attempt to modify the rifle to fire full auto will cause an unsafe condition, perhaps resulting in injury.

Thureon Defense **STRONGLY RECOMMENDS** that the shooter and any observers wear both eye and ear protection.

Thureon Defense LLC is not liable for any injuries or death resulting from the use or misuse of our products.

Initial assembly of the “GA” carbine-

1. Be sure that the rifle is unloaded.
2. With the muzzle pointed in a safe direction, remove the lower receiver by pushing the two push pins toward the ejection port side of the rifle. Pull the pins out as far as possible. They are retained in the lower receiver. When the pins are pulled out all the way, the lower receiver will be free from the upper receiver. Remove the lower receiver and set it aside.
3. Holding the upper receiver upside down with the muzzle pointing away. Remove the bolt assembly by pushing it against the spring pressure and about ¼” into the stock. Tip the front of the bolt assembly up and out of the receiver.
4. Insert the charging knob into the rear of the keyhole slot and slide it forward, almost to the back of the barrel.
5. Reinsert the bolt assembly, placing the rear of the bolt against the buffer and pressing it ¼” into the buffer tube.
6. Holding the bolt against the spring pressure, tip the bolt back down into the upper receiver. Lower the bolt onto the charging knob, rotating the charging knob as necessary, until the bottom of the bolt is flush with the bottom of the upper receiver. Slowly slide the bolt forward until it stops against the back of the barrel. Be careful not to pinch your fingers while doing this!
7. Reinstall the lower receiver by nesting the parts together and pressing the push pins back through the assembly.

Operation of the "GA" carbine-

1. With the carbine pointed in a safe direction, insert a loaded magazine into the bottom of the magazine well opening. Push upward until the magazine locks in place. Pull downward to be certain that the magazine is locked in place.
2. Pull the charging knob as far rearward as it can go. Release the charging knob. The rifle is now loaded.
3. Pivot the safety selector vertical so that the pointer is pointing to "F". The rifle is now ready to fire.
4. The bolt will not stay open after the magazine is emptied.
5. **To lock the bolt back pull the charging knob to the most rearward position and push it toward the gun. This will lock it back. To release the bolt pull the charging knob out.**

Maintenance of the "GA" carbine-

1. Blow-back firearms are inherently dirty. Frequently cleaning the powder residue from the moving parts is recommended to insure reliable operation.
2. The bolt may be removed for cleaning by removing the lower receiver (see above) and tipping the bolt out of the upper receiver. The charging knob will usually be retained in the key slot. Wipe the powder residue from the external surfaces of the bolt.
3. After cleaning the outside of the bolt, remove the firing pin by removing the 3/16" dia. firing pin retainer pin and pulling the firing pin out of the rear of the bolt. Wipe any accumulated residue from the firing pin. When re-installing the firing pin, be sure that it floats freely inside the bolt. If the firing pin were to jam in the forward position, a situation could occur whereby the rifle would fire in a "full auto" condition. It is the shooter's responsibility to maintain the rifle so this does not happen.
4. Be sure not to lose the 3/16" dia. firing pin retainer pin. This is the only device keeping the firing pin in the bolt.
5. Use a light lubricant on the moving parts. A drop of oil on the 4 sides of the bolt body where they contact the upper and lower receiver is recommended. Another drop on the top of the hammer will reduce the friction between the top of the hammer and the bottom of the bolt.
6. Clean the barrel the same way you clean any other rifle barrel. This carbine must be cleaned from the muzzle. It will be easiest to clean the barrel with the bolt removed from the upper receiver.
7. Re-install the bolt by aligning the rear of the bolt with the center of the stock buffer. Pushing the bolt toward the rear, tip the front of bolt down into the upper receiver. Orient the charging knob so the flat spot is toward the top of the receiver and lower the bolt onto the charging knob. Allow the bolt to slide forward until it rests against the back of the barrel. Be careful not to pinch your fingers while doing this!

If you have ANY QUESTIONS, please phone Thureon Defense LLC at

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