



THUREON DEFENSE  
OWNER MANUAL 2022



THUREON  
D E F E N S E



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## **CLEARING YOUR RIFLE**

***KEEP YOUR RIFLE CLEARED WHEN NOT IN USE.***

1. Place safety lever on SAFE.
2. Remove the Magazine by depressing the magazine release button and pulling the magazine down.
3. Lock the bolt to the rear by pulling the charging handle to the rear and pushing it in. (toward the lower receiver),
4. Check the receiver and chamber to ensure that these areas contain no ammunition.

## **SAFETY CHECK**

***WARNING! MAKE SURE YOU RIFLE IS CLEAR OF ANY AMMUNITION!***

1. Pull the charging handle away from the gun to release it. Place the safety on SAFE. Pull the trigger. The hammer should not fall.
2. Place the Safety on Fire and pull the trigger. The hammer should fall. Hold the trigger to the rear. Pull the charging handle to the rear and release it. Release the trigger and you should hear a click as the trigger resets. Squeeze the trigger again and the hammer should fall.





## OPERATING PROCEDURE: LOADING

***WARNING! POINT MUZZLE IN SAFE DIRECTION.***

1. Lock the bolt to the rear (pull the charging handle to the rear and push the charging handle in). Place the Safety in the SAFE position. Check that the chamber and bore are clear.
2. Insert the magazine in to the magazine well. Push upward until the magazine catch clicks and holds the magazine firmly in place. You should pull downward on the magazine to ensure it is properly seated.

***CAUTION: USE ONLY FACTORY MADE AMMUNITION IN GOOD CONDITION AND OF THE CORRECT CALIBER FOR YOUR RIFLE!***

## CHAMBERING AND FIRING A ROUND WITH BOLT LOCKED TO THE REAR

1. Insert the magazine.
2. Pull the bolt handle outward to release the bolt.
3. Move the safety to the FIRE position.
4. Hold the rifle firmly
5. Squeeze the trigger to fire.

## WITH BOLT FORWARD

1. Insert the magazine.
2. Pull the bolt handle completely to the rear and release the bolt.
3. DO NOT RIDE THE BOLT FORWARD!!
4. Move the safety to the FIRE position.
5. Hold the rifle firmly
6. Squeeze the trigger to fire.

***CAUTION: IF YOU HOLD THE RIFLE LOOSELY IT MAY RESULT IN THE RIFLE FIRING TWO SHOTS (THE SECOND AS THE RIFE RECOVERS FROM RECOIL) THIS IS NOT A "DOUBLING" MALFUNCTION.***

# **MAINTENANCE PROCEDURES**

## **(FIELD STRIPPING): CLEAR THE RIFLE**

1. Place safety lever on SAFE.
2. Remove the Magazine by depressing the magazine release button and pulling the magazine down.
3. Lock the bolt to the rear by pulling the charging knob to the rear and pushing it in.
4. Check the receiver and chamber to ensure that these areas contain no ammunition.

## **(FIELD STRIPPING): UPPER AND LOWER RECEIVERS**

1. Push forward and rear take down pins.
2. Separate Upper and Lower receivers

## **(FIELD STRIPPING): CHARGING HANDLE AND BOLT**

1. Hold charging knob with one hand.
2. Push the bolt out of the bottom of the upper receiver.
3. Turn the bolt with the extractor down.
4. Push the firing pin forward and this will release the firing pin retaining pin.



## CLEANING AND INSPECTION

### CLEANING SOLVENTS AND LUBRICANTS

A combination of carbon, lead, and copper solvent is recommended for cleaning. Any high quality non graphite lubricant can be used for protection.

In addition to the cleaning solvents and lubricants the basic cleaning equipment needed includes a cleaning rod, brass bore brush, tooth brush, pipe cleaner, patches, and a lint free cloth.

### UPPER RECEIVER AND BARREL ASSEMBLY

***NOTE: DON'T REVERSE THE DIRECTION OF THE BORE BRUSH WHILE IT IS IN THE BORE. USE CLEANING SOLVENT ON THE BORE, CHAMBER, AND ALL SURFACES WHERE POWDER FOULING, CORROSION, DIRT OR DUST MAY ACCUMULATE.***

1. Use a cleaning rod, bore brush, and cleaning solvent. Run the rod through the camber and bore several times.
2. Take the bore brush off the rod and install a clean swab. Apply solvent to the swab and push it through the chamber and bore. Allow the solvent for several minutes and then swab it clean.
3. Install a fresh swab, apply lubrication to swab. Apply a light coat of lubrication to the chamber and bore.
4. Lightly lubricate the inside and outside of the upper receiver.

### CHARGING KNOB AND BOLT ASSEMBLY

1. Clean all parts and outer surfaces of the bolt assembly with a swab saturated with cleaning solvent.
2. Clean the firing pin, firing pin retaining pin, and firing pin spring with rag saturated with solvent.
3. Clean firing pin hole and firing pin retaining pin hole with pipe cleaner saturated with solvent.
4. Clean charging handle with solvent coated rag.
5. Lightly lubricate the firing pin and firing pin retaining pin.
6. Lightly lubricate the bolt.



## BUFFER TUBE ASSEMBLY

1. Clean the buffer and recoil spring with a solvent coated rag.
2. Lightly lubricate the buffer and spring.

## LOWER RECEIVER ASSEMBLY

**CAUTION: DO NOT USE A WIRE BRUSH OR ANY TYPE OF ABRASIVE MATERIAL TO CLEAN ALUMINUM SURFACES.**

1. Wipe dirt from the trigger assembly with a swab saturated with solvent.
2. Use a swab and cleaning brush to clean powder fowling, corrosion, and dirt from the lower receiver.

## REASSEMBLY: UPPER RECEIVER ASSEMBLY

1. Insert buffer spring and buffer

## CHARGING HANDLE AND BOLT ASSEMBLY

1. Reinstall the firing pin, firing pin spring, and firing pin retaining pin.
2. Reinstall the charging handle and bolt into the upper receiver.
  - With upper receiver upside down place back of bolt assembly slightly into buffer tube assembly
  - Slide charging knob into large opening opposite the ejection port.
  - Move charging handle forward. Rotate so that the cutout portion of the end of the charging knob is facing up, toward the bolt.
  - Slide the bolt down onto the charging knob. Bolt should be flush with the upper receiver.

## UPPER AND LOWER RECEIVERS

1. Make sure hammer is cocked in the rear position .
2. Join the upper and lower receiver.
3. Align the take down pin holes.
4. Push in the take down pins.



## TROUBLE SHOOTING

PROBLEM	CHECK FOR	WHAT TO DO
WON'T FIRE	SELECTOR LEVER ON SAFE	PUT IT ON FIRE
	Improper assembly of firing pin.	Assemble correctly. NOTE: the retaining pin goes behind the firing pin shoulder.
	Too much oil in firing pin hole.	Wipe out with pipe cleaner.
	Defective ammunition	Remove and discard
	Too much carbon/powder fowling in firing pin hole.	Clean
WON'T EXTRACT	Broken extractor	Replace
	Dirty, corroded, or reloaded ammunition.	Remove and discard.
WON'T FEED	Dirty, corroded, or reloaded ammunition	Remove and discard.
	Dirty or defective magazine	Clean or replace
	Too many rounds in magazine	Remove excess rounds
	Magazine not fully seated	Completely seat the magazine or replace.
DOUBLE FEED	Defective magazine	Replace
WON'T CHAMBER	Dirty corroded or defective ammunition	Remove and discard
	Feed ramp missing	Reinstall feed ramp



## **BE A RESPONSIBLE GUN OWNER**

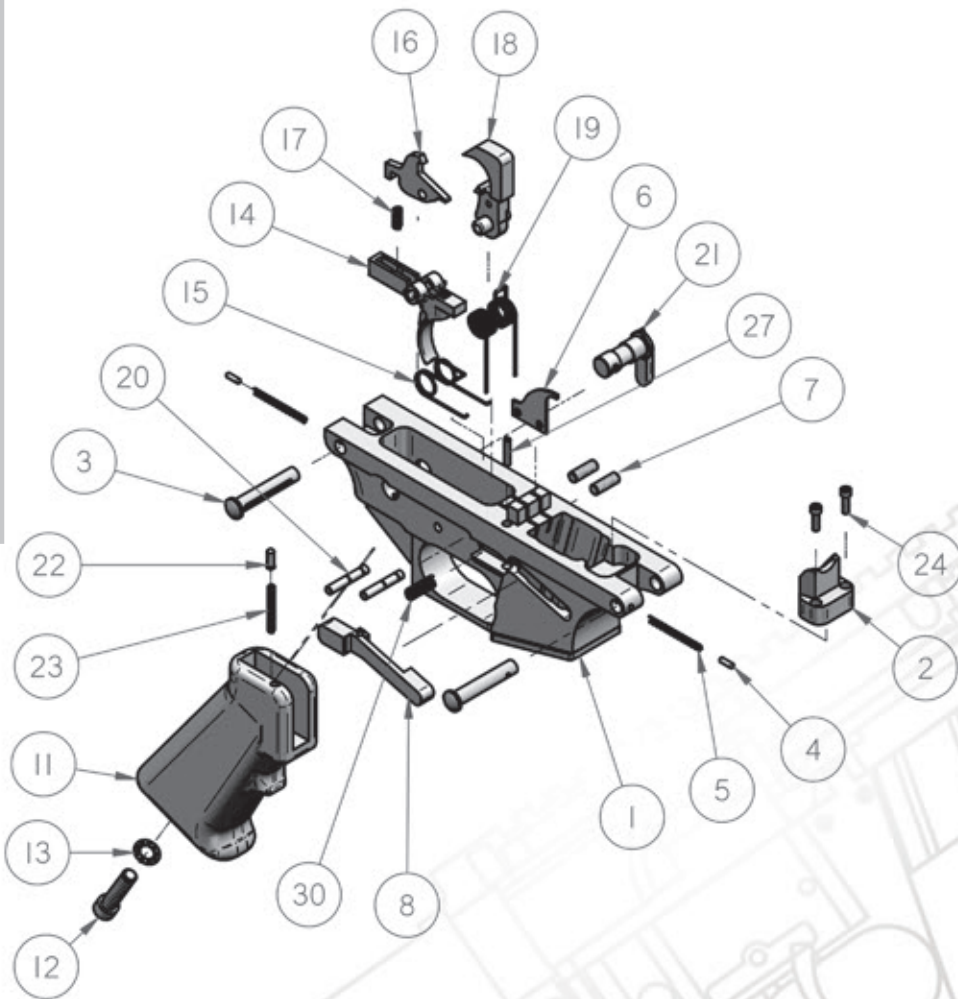
- Always keep the muzzle pointed in a safe direction.
- Never point a gun at anything that you do not intend to shoot.
- Keep your finger off the trigger and out of the trigger guard until you are aiming at your target and ready to shoot.
- Always keep the safety on, especially when the gun is loaded and cocked, until you are ready to shoot.
- Be sure of your target and backstop before you shoot (ask yourself what your bullet will hit if it misses or goes through the target).
- Be sure your barrel is clear of obstructions, including excessive oil and grease, before shooting.
- Always keep and carry your gun with an empty chamber until you intend to shoot, so your gun cannot be fired unintentionally.
- Firearms should be unloaded when they are not actually in use.
- Treat every gun as if it is loaded **AT ALL TIMES**.
- Store guns and ammunition separately beyond the reach of children.
- Wear hearing protection when shooting.
- Never shoot at hard, flat surfaces or water bullets will ricochet.
- Do not alter or modify your gun.



## LOWER RECEIVER PARTS LIST

Item #	Title	Quantity
1	Lower Receiver	1
2	Feed Ramp	1
3	Pivot Pin	2
4	Pivot Pin Plunger	2
5	Pivot Pin Plunger Spring	2
6	Ejector Blade	1
7	Ejector Blade Screw	2
8	Magazine Release - GA	1
11	Pistol Grip	1
12	Pistol Grip Screw	1
13	Pistol Grip Lock Washer	1
14	Trigger	1
15	Trigger Spring	1
16	Disconnecter	1
17	Disconnecter Spring	1
18	Hammer	1
19	Hammer Spring	1
20	Trigger/ Hammer Pin	2
21	Selector	1
22	Selector Detent	1
23	Selector Detent Spring	1
24	Feed Ramp Screw	2
27	Magazine Release Screw - GA	1
30	Magazine Release Spring - GA	1

## LOWER RECEIVER SCHEMATIC

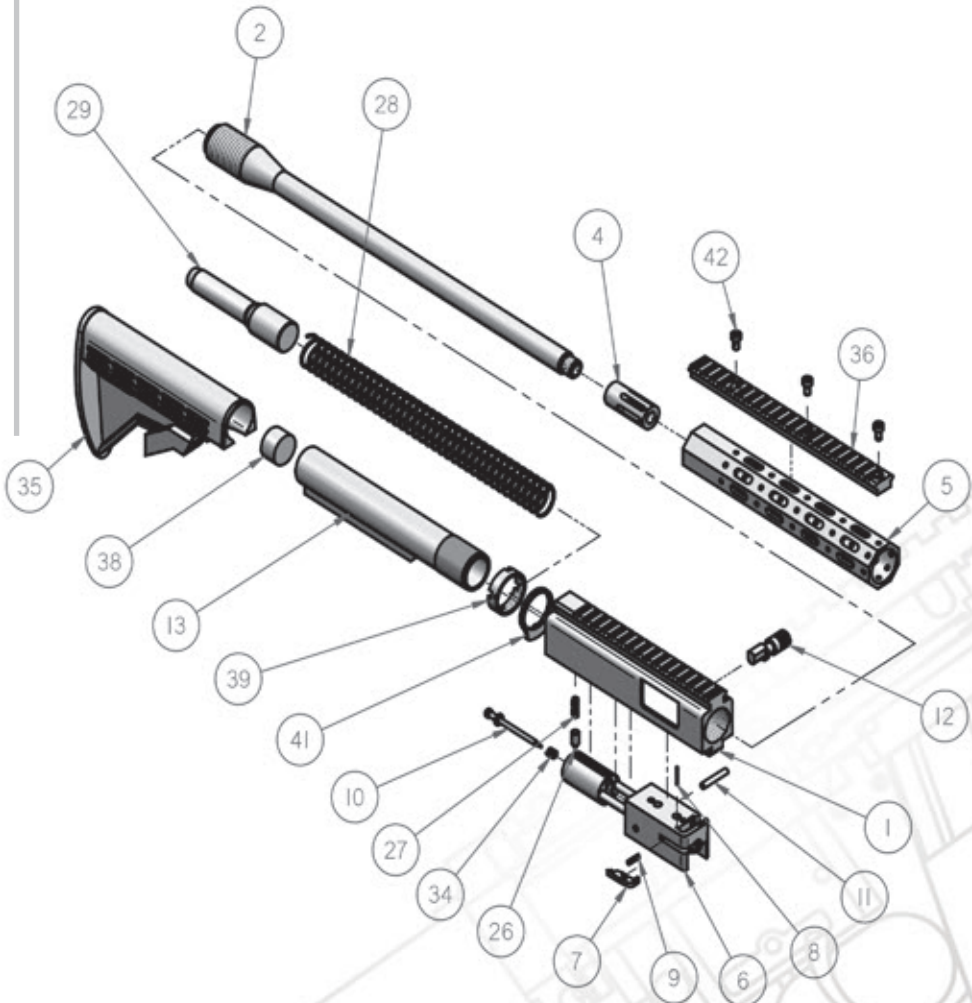


## UPPER RECEIVER PARTS LIST

Item #	Title	Quantity
1	Upper Receiver	1
2	Barrel	1
4	Compensator	1
5	Handguard	1
6	Bolt Assembly	1
7	Extractor	1
8	Extractor Pin	1
9	Extractor Spring	1
10	Firing Pin	1
11	Firing Pin Retainer	1
12	Charging Knob	1
13	Commercial Tube	1
26	Buffer Retaining Pin	1
27	Buffer Retaining Spring	1
28	Buffer Spring	1
29	Buffer Body	1
34	Firing Pin Spring	1
35	Buttstock - Telescoping	1
36	Rail - Hand Guard	1
38	Bumper	1
39	Castle Nut	1
41	Mount - Single Point Sling	1
42	Screw - Socket Head Cap	3

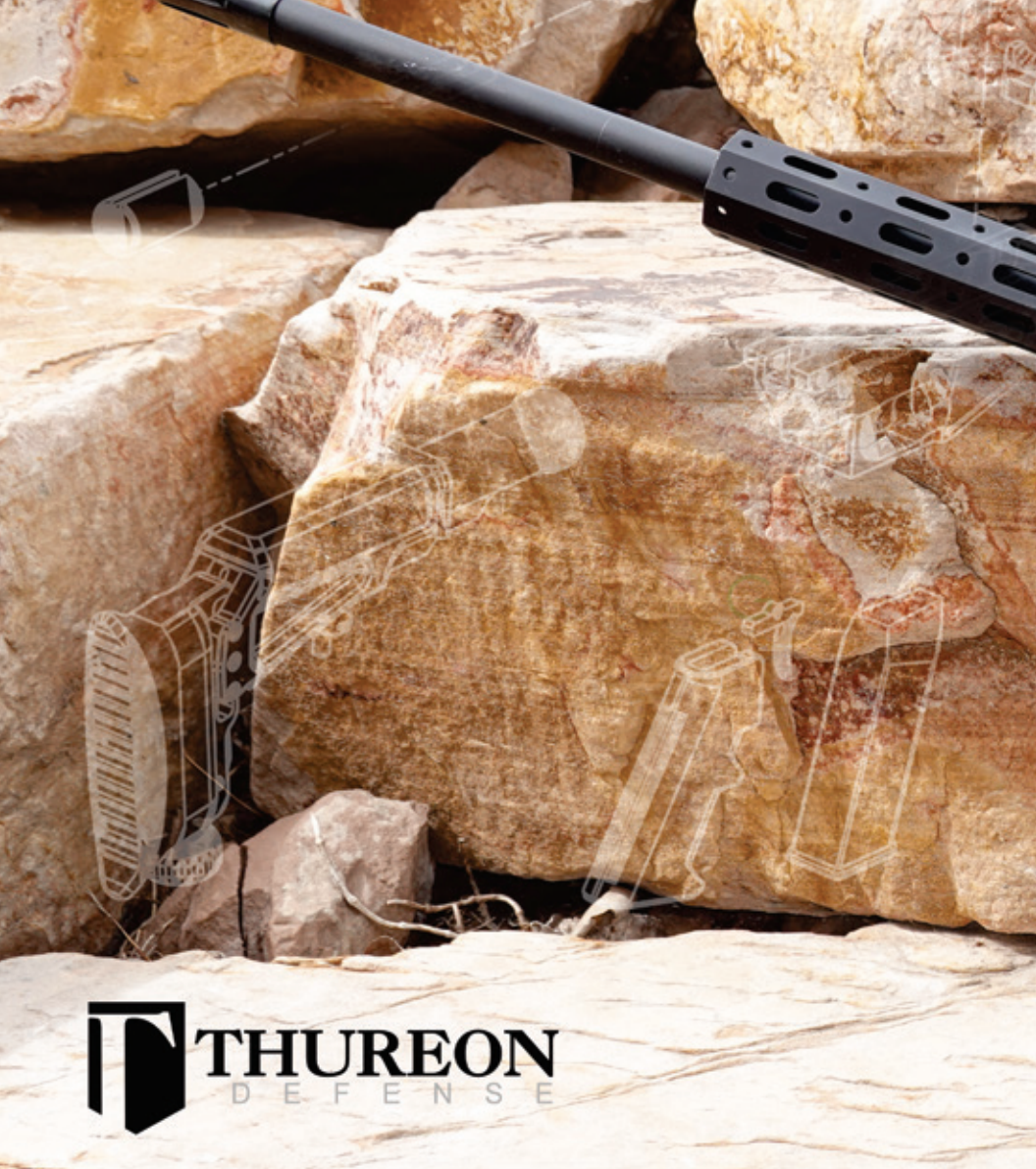


## UPPER RECEIVER SCHEMATIC









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