

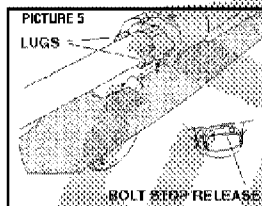
To Install the Bolt Assembly: The bolt assembly locks the cartridge into the chamber.



1. Point the firearm in a safe direction.
2. Put the safety mechanism in the 'S' position.
3. Align the lugs on the bolt assembly with the receiver.

See Picture 5.

4. Slide the bolt into the receiver and push all the way in.
5. To place the bolt in the lock position, push the bolt handle down.



To Remove Bolt Assembly:

1. Point the firearm in a safe direction.
2. Put the safety mechanism in the 'S' position.
3. Do not touch the trigger while moving the safety mechanism.
4. Raise the bolt handle.
5. Pull the bolt handle all the way back.
6. Push the bolt stop release in trigger guard. See Picture 5.
7. Slide the bolt assembly from the firearm.

Trigger Adjustment/Alteration Warnings

The Model XR-100™ Rangerstar® Single Shot Target Rifle is equipped with a trigger assembly which is adjustable for trigger pull weight from 1 1/2 lbs. - 3 1/2 lbs. Adjustments to the trigger must strictly adhere to the instructions and warnings in this manual.

WARNING! DO NOT ATTEMPT TO ADJUST THE TRIGGER ASSEMBLY OF THE TRIGGER TRIGGER ASSEMBLY IF YOU HAVE NOT READ, OR DO NOT UNDERSTAND THE INSTRUCTIONS PROVIDED IN THIS MANUAL. NEVER MAKE ANY ADJUSTMENTS TO THE TRIGGER ASSEMBLY OTHER THAN THE TRIGGER PULL WEIGHT ADJUSTMENT AS SPECIFIED IN THE INSTRUCTIONS OF THIS MANUAL.

WARNING! IMPROPER ADJUSTMENTS TO THE TRIGGER ASSEMBLY CAN CREATE A HAZARDOUS CONDITION IN THE RIFLE AND RESULT IN PERSONAL INJURY OR DEATH.

Usage Limitations

WARNING! The Model XR-100 rifle is specially designed and intended for use by competitive target shooters ONLY. Because of its adjustable and highly sensitive trigger mechanism, the rifle must NEVER be carried in the field with a round in the chamber. This rifle is to be used ONLY under the following conditions:

- (1) This rifle is for use ONLY by experienced and responsible shooters in a controlled target shooting environment where the rifle is NEVER loaded with a live round of ammunition EXCEPT when it is in the ready-to-fire position with the muzzle pointed safely down range, AND
- (2) If a cartridge loaded into the chamber is not fired, it is to be IMMEDIATELY unloaded from the rifle; NEVER move the rifle away from the down range position without first unloading the round from the chamber. Failure to follow these limitations in use could result in an accident resulting in personal injury or death.

Firearm Sale Or Transfer

WARNING! BECAUSE THE MODEL XR-100™ RANGERSTAR® SINGLE SHOT TARGET RIFLE IS A "TARGET" RIFLE WITH A "TARGET" STYLE TRIGGER ASSEMBLY, IT IS NOT TO BE USED BY ANYONE OTHER THAN THE PERSON IN POSSESSION OF THIS RIFLE WHO HAS READ THIS MANUAL.

- (1) When the purchase or receipt of your rifle, the rifle is equipped with a "target" style trigger assembly intended for use in a controlled target shooting environment only and should never be used in any other manner.
- (2) Give the purchaser or recipient of a firearm manual for review and reference.

WARNING! NEVER SLIP OR MOVE ANY PART OF THE TRIGGER ASSEMBLY OR ANY PART OF THE Firing MECHANISM. IMPROPER ALTERATIONS CAN CREATE A HAZARDOUS CONDITION IN THE RIFLE AND RESULT IN PERSONAL INJURY OR DEATH.

WARNING! NEVER PUT YOUR FINGER ON THE TRIGGER UNLESS YOU ARE GOING TO FIRE THE FIREARM.