

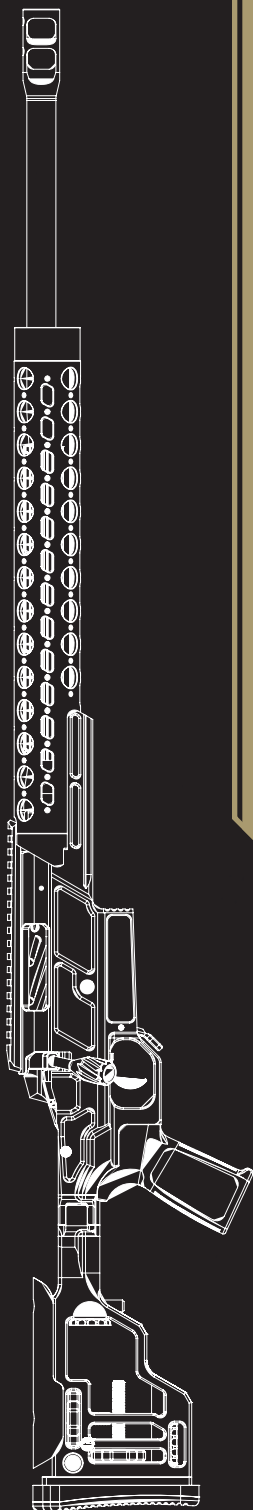
J P ENTERPRISES



MR-19™

OWNER'S MANUAL

Version 04.24.19



READ ALL THE WARNINGS AND
INSTRUCTIONS IN THIS MANUAL
BEFORE OPERATING THIS RIFLE.

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The **MR-19™** represents a collaborative rifle project utilizing the **JP Enterprises Advanced Precision Ambidextrous Chassis (APAC™)**, a custom contour **PROOF Research** barrel, the **Ultimatum Precision Deadline** short action and one of a selection of premium bolt gun triggers. As such, this manual draws relevant information from the manuals and instructions for these various products but does not contain the entirety of the information about them. For more information about these components, refer to the individual manufacturers' websites:

JP Enterprises:	www.jp Rifles.com
PROOF Research:	www.proofresearch.com
Ultimatum Precision:	www.ultimatumprecision.ca

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SAFETY

Firearm ownership, like scuba diving or rock climbing, is an endeavor that demands personal responsibility. If you cannot take responsibility for your actions, firearm ownership is not for you. If carelessly or improperly handled or stored, this or any other firearm has the potential to cause great damage to property and severe injury or death to people and animals. If you are unfamiliar or uncomfortable with the usage of firearms, seek additional training and/or education through qualified instructors or organizations such as local gun clubs or the National Rifle Association. Before using your new rifle, read through the entirety of this manual beginning with this safety section to ensure that you are intimately familiar with its use and operation.

THE DOs AND DON'Ts OF FIREARM OWNERSHIP

These are the four commandments of gun safety. Memorize them and instruct all others in your family or shooting group to make sure that these rules are understood completely and followed explicitly.

1. Treat all firearms as if they were loaded.
2. Do not sweep anyone or anything with the muzzle of your firearm that you are not willing to destroy.
3. Keep your finger out of the trigger guard until you are ready to fire.
4. Be sure of your backstop.

Most all of the safety precautions in this section originate with these rules, and if you take nothing else away from this manual, make sure that you remember and follow these. Due to the importance of this material, though, we will expand further.

DO handle your firearm at all times as if it were loaded. Unless you are presently looking at the empty chamber, the firearm should be treated as a loaded weapon. The only firearm that you can say is unloaded with certainty is the one that you have just checked and which is still in sight. Once it is out of your sight, you can no longer say with absolute certainty that it is unloaded.

DO keep the safety selector lever in the “SAFE” position whenever you are not immediately ready to fire.

DO practice stance, aim, rhythm and breathing with your unloaded firearm before practicing with live ammo, and practice thoroughly with your rifle at the range before going hunting or attempting other shooting sports.

DO instruct children and other members of your household to respect firearms and to follow safety procedures regarding guns, even if they do not shoot them regularly or even at all. If you intend to teach children or family members to shoot, have them trained by a qualified instructor and supervise them while they operate firearms.

DO appoint a knowledgeable and responsible individual to manage the safety of large shooting groups making use of a range facility. You should defer to, and insist that others defer to, that individual’s authority for everyone’s sake. Additionally, you should ensure that you are personally qualified to fill this role if necessary.

DO clean and maintain your firearm responsibly. (See the **CLEANING AND MAINTENANCE** section of this manual.)

DO use only high-quality, good-condition ammunition in your firearms. (See the **Ammo Selection** section of this manual) Be aware that the ammunition requirements for your MR-19™ rifle may be different from certain other manual rifles.

DO seek medical advice regarding medication you take to determine if it will interfere with your ability to operate a firearm safely.

DO wear ear protection while you or anyone in your vicinity is operating a firearm. Additionally, insist that those around you wear ear protection while in the presence of discharging firearms. Not doing so could result in loss of hearing.

DO wear eye protection and require others to do the same while firearms are being discharged. Flying particles or debris could cause eye damage to the operator or those around him or her.

DO keep clear of the firearm’s ejection port as spent cartridge casings can be expelled from the weapon at high speeds and at temperatures capable of injuring or burning. Ensure that other observers do likewise. In particular, be aware that ejected casings may bounce off walls and other objects in some range situations and enter open-topped clothing causing severe burns. It is always a good idea to wear a cap with a brim while shooting to help deflect spent cases from the face and eyes.

DON'T point the muzzle of the firearm at anything you are not willing to destroy. This includes times when the firearm is unloaded and when it is being inspected and cleared. It is never a good idea to handle a firearm in a situation with people standing all around you. Always clear a safe zone for the muzzle. In the field, rifles should be carried with the muzzle pointing up or down, never at the horizontal.

DON'T trust that the firearm is unloaded merely because you are told so. Visually check it yourself.

DON'T insert your finger into the trigger guard until you are ready to shoot. This decreases the likelihood of an accidental discharge. If you handle firearms long enough, it is a statistical certainty that eventually you will have an accidental discharge. Knowing this should give you added incentive to exercise safe muzzle and trigger control.

DON'T shoot your rifle unless the bore, muzzle, chamber and action are clear of obstruction. Verify that there is no such obstruction only after ensuring that the firearm is unloaded.

DON'T leave your firearm exposed and unattended, whether loaded or not.

DON'T transport your firearm while it is loaded, whether just around the range or over longer distances.

DON'T carry a loaded firearm in such a way that you are not fully in control of the direction of the muzzle. Always carry a rifle muzzle up or muzzle down.

DON'T inflict or allow blunt impact to your firearm, such as dropping it onto a hard surface. The firing mechanism could be triggered causing the gun to fire while not under control. Additionally, components of the firearm may be damaged reducing the overall safety of the weapon. If such damage occurs, have your firearm examined by a qualified gunsmith before further use.

DON'T allow others to operate your firearm unless they are informed and comfortable with the use of such weapons. Make sure that they follow all the preceding and following rules, because while someone is using your firearm, you are responsible. It is always a good idea to allow a new shooter to dry-fire your rifle before loading live ammo.

DON'T discharge your firearm unless you are certain of your backstop's integrity. Be certain that no bullets will pass through the backstop to potentially cause damage or injury. In the field, only fire at game or targets if you are sure that a miss or a bullet passing through the target will be contained in the visible area behind the target.

DON'T attempt to alter or modify your firearm. Alterations to certain components or their relationships with each other can affect the overall safety of the mechanism and potentially result in unexpected discharge, damage or malfunction.

DON'T drink alcohol or use drugs or other substances that may impair brain function, judgment, physical dexterity or vision while operating a firearm.

DON'T shoot at hard surfaces like rocks or at a liquid surface like open water. Doing so may cause the bullet to ricochet and change trajectory unexpectedly.

DON'T use your firearm in poorly ventilated areas. Continued use could result in accumulation of lead and other toxic particulate matter in the air that could be injurious to health.

DON'T use your firearm if water is in the barrel. If your firearm is submerged, exposed to heavy rain or otherwise drenched, dry the water and clean the weapon before use.

DON'T discharge your weapon in the presence of an animal that has not been trained to accept the noise because it may panic and cause damage, injury and confusion.

DON'T allow or partake in "horseplay" with a firearm under any circumstances.



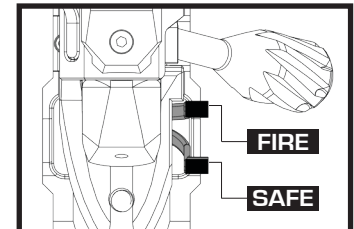
SAFE STORAGE

Your JP rifle includes a rubberized cable lock as a safety device. This lock can be passed through the action of your rifle to render it safe and inoperable without damage. Install this lock whenever the rifle is stored to prevent unauthorized use.

SAFETY FEATURES

SAFETY SELECTOR

Located to the rear of the action, the selector lever has two positions: FIRE and SAFE. When set forward, the lever is in the FIRE position. In this position, with a live round in the chamber and the bolt assembly engaged, the rifle will fire a single shot when the trigger is squeezed. With the lever to the rear, the mechanism is in the SAFE position. While in this position, the trigger mechanism is interrupted and cannot be pulled.

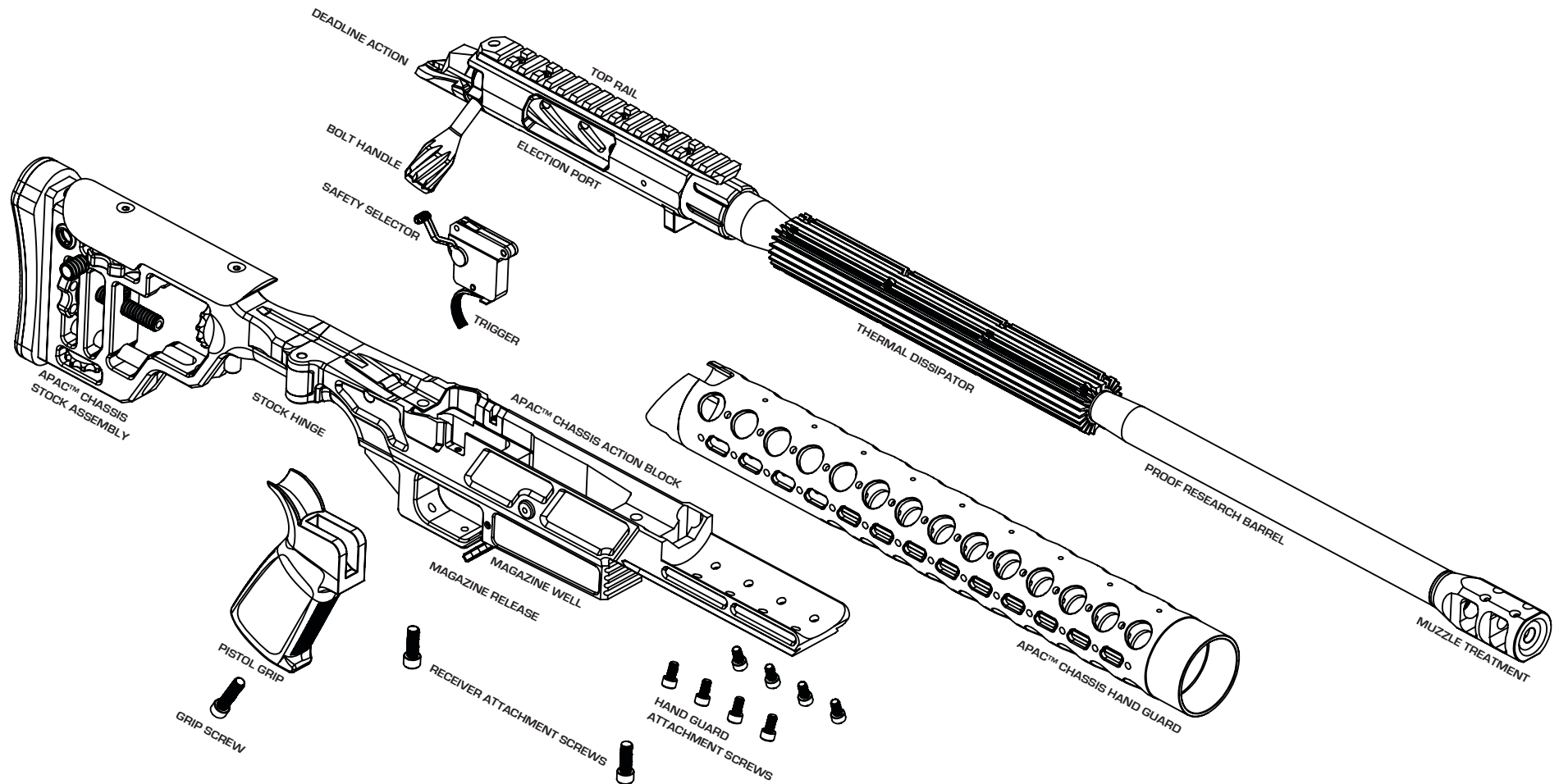


Check the function of the safety from time to time with the rifle unloaded. Verify that the rifle is clear, cycle the bolt, place the safety selector in the SAFE position and squeeze the trigger. The trigger should have no perceptible movement, and the striker should not fall. Remember that the safety selector is a mechanical device that can fail, and use of the safety mechanism is not a substitute for safe firearm handling practices. The safety should be kept in the SAFE position until immediately before pulling the trigger.

Be aware that if you replace the factory trigger with another trigger, you must verify function of the safety selector. Consult the manual for your Deadline action to ensure a proper, safe installation of the new trigger.

RIFLE OVERVIEW

This diagram displays the standard components of an MR-19™ rifle. Your configuration may vary. For more detailed information about the internal components of the Ultimatum Precision Deadline action or your particular trigger, consult the instruction manuals for those components found on the manufacturers' websites.



ASSEMBLY AND SETUP

Your MR-19™ rifle will come fully assembled with the exception of the bolt assembly. With the bolt assembly installed, the rifle should be ready for immediate use. However, you may wish to personalize your rifle's setup.

BOLT ASSEMBLY

To install the bolt assembly, first engage the safety lever on the rifle and verify that the chamber is clear of ammunition.

1. Insert the bolt face end of the bolt assembly into the rear of the receiver with the bolt handle angled to the right or left of the receiver (depending on the handedness of the rifle) at slightly above 90°.
2. Press the bolt further until it engages the bolt stop, which will then ride in the channel running the length of the bolt assembly.
3. Insert the bolt completely until it stops, and then rotate the bolt handle downwards to the fully closed position.

To remove the bolt assembly, reverse this process while engaging the bolt stop lever to allow the bolt assembly to slide completely out of the receiver.

BUTTSTOCK

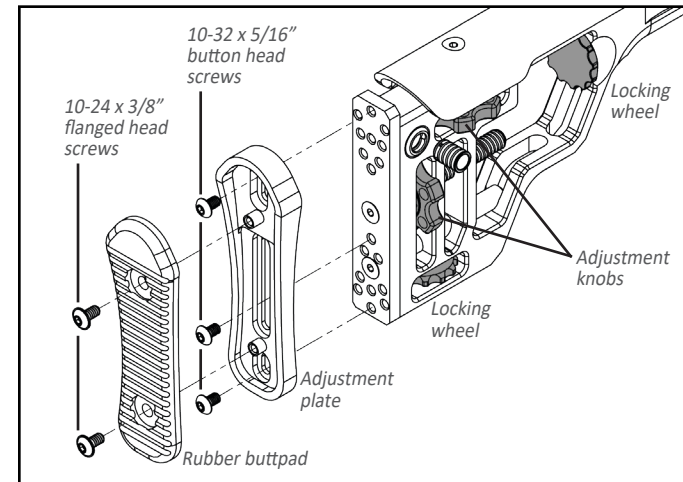
The buttstock of the APAC™ chassis is fully customizable for cheek height, length of pull and buttpad cant. These instructions will walk you through setting up the stock of your MR-19™ to suit your frame.

1. Unscrew the two 10-24 x 3/8" flanged head screws retaining the buttpad on the adjustment plate. Remove the rubber buttpad.
2. Unscrew the three 10-32 x 5/16" button head screws that retain the adjustment plate.
3. Using the various threaded holes in the adjustment plate, reinstall these screws to attach the adjustment plate as desired for optimal fit for height and cant. When you've decided on a final position, use a small amount of blue Loctite® 242 (or equivalent thread locker) on each screw and torque to 32 inch-pounds.

While the adjustment plate can be attached using only two screws, we strongly recommend securing the plate at three points using all three screws.

4. Insert the rubber buttpad into the adjustment plate and secure with the two 10-24 x 3/8" flanged head screws.

5. Loosen the buttstock locking wheels 1/4 to 1/3 of a rotation to enable adjustment of the cheek riser and extension of the buttpad assembly. Do not over-loosen the locking wheels or they will fall out of assembly.
6. Adjust the cheek riser and buttpad assembly using the adjustment knobs to the desired configuration.
7. Retighten the locking wheels to retain these adjustment positions. You can also add blue Loctite® 242 to the adjustment wheels to secure your settings.



The APAC™ features a folding stock assembly to maximize storage potential. To unfold the stock, simply pull the stock arm away from the chassis block with sufficient force. Once straight back, the hinge will engage the stock arm and lock it in position. To collapse again, press the button on the side of the hinge while rotating the stock back to the folded position. If the button appears stuck after a period without use, it might require a little application of oil on a taper pin. A little tap with a plastic hammer or pressing the button up against a hard surface should be all that is required to loosen it.

HAND GUARD

The APAC™ chassis features a modified design of our MK III Rapid Configuration Hand Guard System. Accessory rails, barricade braces and sling swivels can be mounted directly to the tube at the 3:00, 9:00 and 45° positions as well as the 6:00 position if you are not using our Arca-Swiss adaptor in this position. These accessories attach using their included 10-32 flathead screws.

TRIGGER

The trigger mechanism of your MR-19™ may include adjustment features. Refer to the manufacturer's website for details on its use and adjustment.

RIFLE USE

Before taking your MR-19™ out to the range for the first time, there are several issues discussed in this section that contribute to its optimal and enjoyable use.

DRY FIRE PRACTICE

Dry fire practice is a tool used by all pro-level shooters to enhance their skills. It doesn't cost anything, can be done at home if safety precautions are taken and will make your live-fire practice much more productive and efficient. As mentioned in the section on safety, you should practice your stance, aim, trigger control and breathing with your unloaded rifle to accustom yourself to the weight of the weapon and how to move with it. It is, however, imperative that you conduct such practice in a very controlled situation with a secure backstop and no live ammo or loaded magazines available. You will obviously want to clear your rifle for these sessions, but conduct them as if your weapon were loaded to ingrain safe handling habits. If you choose to perform such practice in your home, such as in your basement, do so only in a secure environment that will unquestionably prevent a fired round from escaping the secured portion of the building uncontrolled or impacting volatile targets like gas lines. Make sure to use a backstop adequate to obstruct and retain expended rounds of the caliber you are using and to situate the backstop against a ballistically secure surface.

In the case of the MR-19™, some will warn about the long-term effects of dry firing and potential damage it may cause to the bolt. If this is a concern for you, we recommend the use of a "snap cap" insert, which is available from most firearm accessory retailers.

AMMO SELECTION AND RELOADING

As a rule, we strongly recommend using only new, high-quality ammunition or remanufactured ammunition from companies with a reputation for quality. Any ammunition used in your rifle must conform to SAAMI (Sporting Arms and Ammunition Manufacturers Institute, Inc.) specifications.

Reloading ammunition is a very precise craft that should be left to experts. Use of remanufactured or "hand-loaded" ammunition carries various risks:

- Overpressured ammunition due to excessive powder
- Improperly seated projectiles that may become lodged in the barrel
- Poor quality components or construction

Any damage resulting from the use of remanufactured or hand-loaded ammunition is not covered by this rifle's warranty.

When choosing ammunition for the MR-19™, use only cartridges with a caliber headstamp that matches the caliber of your rifle's chamber. Do not mix ammunition,

and never attempt to use ammunition of another caliber. Likewise, ensure that all ammunition is in serviceable condition and avoid cartridges that are:

- dirty
- corroded
- damaged
- deformed
- oily

Such cartridges might rupture during live fire and cause damage to the rifle and injury to those nearby.

MAGAZINE SELECTION

Like the ammunition you choose, the magazine can also have a dramatic effect on the function of your rifle. The feed port of the Deadline action and the magazine well of the APAC™ chassis are designed to accept Accuracy International Chassis System (AICS) and Arctic Warfare (AW) style magazines. Currently, there are a number of higher-quality aftermarket magazines designed specifically for long-term durability and improved function, including the Magpul™ composite magazines, which we recommend. Magazines are relatively cheap, and you will likely own a number of them. Become acquainted with each one, and consider going so far as to number them so you can remember their personalities. Some may be more reliable than others, and if any magazine produces reliably produces a certain malfunction, service or replace it.

LOADING, FIRING AND UNLOADING

If you haven't done so already, read the above advisory regarding ammunition selection for your rifle and purchase accordingly. While loading, make sure to keep the rifle pointed in a safe direction, and do not touch the trigger. The following steps will walk you through the complete sequence of preparing your rifle, firing it and reloading it to fire again. If you are using your rifle for the first time, make sure to read and follow the **Break-In Procedure** section below to achieve the best future performance from your MR-19™ rifle.

BARREL OBSTRUCTION CHECK

Prior to live fire, it is critical to perform an obstruction check on your rifle to verify that the barrel and chamber are clear. Even a small obstruction could cause a catastrophic failure resulting in damage to the rifle and injury to those in the vicinity.

With the bolt assembly removed (see the ASSEMBLY AND SETUP section above), visually inspect the barrel from the rear to ensure that it is clear of all obstructions, even minor ones. If you notice an obstruction, you can attempt to clean the barrel if the material appears to be minor. If you cannot clear it, consult a professional gunsmith.

1. With the shorter front end of the magazine facing forward, place the rear of the cartridge downwards ahead of the magazine lips. Then, push the round rearwards underneath the magazine lips after it is depressed far enough to do so. Place the next round on top of the previous cartridge and repeat until capacity is reached.
2. With the safety lever in the SAFE position, push the magazine up into the magazine well until the magazine catch engages and holds the magazine in place.
3. If the bolt handle is closed, lift the handle up and pull it back to its rear-most position to open the action.
4. Press the bolt all the way forward again. This will feed the top round off of the magazine into the chamber. Rotate the bolt handle downward to close it.
5. Place the safety selector lever in the FIRE position.

The rifle is now loaded and ready to fire. Before continuing, verify the safety of the shooting environment, including the quality of the backstop and the absence of people, animals or property in the line of fire.

6. Rest the hand guard (and the stock, at your discretion) on a bipod, tripod, sand bag, shooting bag or similar rest. Grasp the pistol grip firmly with one hand and steady the rifle by grasping the hand guard with the other. Seat the buttstock comfortably but snugly against your shoulder. Your optic should be mounted to allow for a firm (but not too tight) cheek weld with the stock.
7. Placing your finger in the trigger guard, take aim with the rifle and gradually squeeze the trigger until the chambered round is discharged.
8. Release the pistol grip and cycle the rifle by raising the bolt handle and swiftly pulling it fully to the rear to eject the spent case. Press the bolt handle forward again to chamber the next round and rotate the bolt handle downward to fully close the bolt. Continue this loading/firing/reloading cycle for subsequent rounds.
9. Open the bolt to eject the final spent casing and leave it open to confirm the rifle is safe.
10. Place the safety selector lever in the SAFE position.
11. Press the magazine catch, and pull the magazine out of the magazine well.
12. Remove any live rounds remaining in the magazine by sliding each forward and out.

13. Collect live ammunition for safe storage and spent cartridge cases for disposal.

BREAK-IN PROCEDURE

Barrel break-in is performed in order to smooth out any micro-roughness in the bore that may occur after initial projectiles pass through the barrel. The first few rounds will typically leave an uneven, and possibly excessive, distribution of copper in the bore, which is why it is sometimes necessary to use copper solvent. However, it's not necessary to remove every trace of copper.

Never use bullets coated with molybdenum compounds (moly-coated) during the break-in period. Moly-coated ammunition should not be used until at least 100 rounds of standard copper-jacketed bullets have been fired. The use of moly-coated ammunition is not recommended in general.

Your rifle has been test-fired for function, but the barrel has not been truly broken in. We recommend fully breaking in your rifle's barrel during your first live fire session to obtain its optimum accuracy potential. Our recommended barrel cleaning process is detailed below in the **CLEANING AND MAINTENANCE** section. Fire three shots through the rifle, and then perform this cleaning process. Then, fire three more shots and clean again. Finally, fire five more shots, and clean again.

During this break-in, we also recommend using the included J-B® bore compound, which will have a mild lapping effect in your new barrel. The J-B® compound is not necessary for every cleaning but will serve as an excellent copper fouling remover when necessary.



CLEANING AND MAINTENANCE

This section details the cleaning and maintenance routine for the barrel and chassis of your MR-19™ rifle. Complete instructions for the disassembly and maintenance of the Deadline action can be found in the most recent instruction manual available on their website: www.ultimatumprecision.ca.

CLEANING THE BARREL

In order for it to function safely and reliably, the PROOF Research barrel of your MR-19™ should be routinely cleaned and made free of rust, dirt, grease and firing residue. Always clean your firearms before and after long-term storage. Clean your firearms whenever it's been exposed to moisture or dirt, mud, sand or grime. Dirt, powder residue or oil in the chamber can cause malfunctions. Any failure to feed or extract a round may indicate a dirty chamber.

To perform the cleaning regimen described below, begin by removing the bolt assembly and verifying that the chamber is empty. You will need the following tools and substances. PROOF Research recommends the accompanying brands and products for use with their barrels.:

- Cleaning solvent (Butch's Bore Shine, Hoppe's #9, Shooter's Choice)
- Copper remover (KG12, CR-10, Butch's Bore Shine)
- One-piece cleaning rod (Dewey, Parker-Hale, Outers)
- Cotton flannel patches cut to fit snugly into the bore
- Bronze wire brush (Sinclair International, Brownell's)
- Bore guide (Possum Hollow, Sinclair International)
- Brush cleaner (CRC Brakleen)

PROOF Research recommends always using a bore guide to protect the barrel throat from bowed or misaligned cleaning rods. Do not use brushes made from materials other than nylon or bronze as they can damage the internal surface of your barrel.

1. Fit your cleaning rod with the bronze bore brush.
2. With your bore guide in place, run three patches wet with solvent through the full length of the barrel from chamber end to muzzle end. Let the barrel sit for five to ten minutes (or as instructed by the solvent manufacturer).
3. Run one wet patch soaked with solvent through the barrel to remove any dissolved powder residue.
4. For heavier fouling, soak the bronze wire brush with solvent and brush the barrel several times. Push the brush through the bore until it extends beyond

the muzzle. (Never reverse the direction of the brush while in the bore) Run three more wet patches through the barrel and let the solvent work for another ten minutes.

5. Run dry patches through the barrel until the patches come out dry.
6. Repeat steps 2 through 5 until the patches come out clean.
7. After all fouling has been removed and the chamber and bore are dry, pass a slightly oiled patch through it for storage. A fine, light gun oil is recommended. Make sure to remove any oil from the chamber and bore before the next life fire session.

CLEANING THE MAGAZINE

It is advisable to also clean the magazine(s) whenever the firearm is cleaned. To do so, consult the cleaning/disassembly instructions of your magazine's manufacturer. Verify that the magazine is empty before cleaning. As a general rule, you'll want to clean all the internal components and wipe the magazine spring with a light coat of oil. Leave all other components dry and reassemble the magazine. Use powdered graphite to lubricate the magazine after it is loaded. Never use oil on the magazine body or follower.

PERIODIC MAINTENANCE

In addition to the cleaning barrel cleaning regimen explained here and the action cleaning detailed in the Ultimatum Deadline action manual, we recommend the following maintenance and inspections to be performed periodically to ensure the longevity of your MR-19™ rifle:

- Inspect the bore for copper fouling and remove. Modern cartridge jackets are made mainly of copper. Copper residue sticks to the barrel and can require more rigorous cleaning. A copper solvent may be necessary to remove copper fouling. Follow the manufacturer's directions when using a copper solvent.
- Clean the rifle of all dirt, dust and grit. Lubricate all steel components with a light coat of oil to inhibit rust.
- Verify the trigger function and smoothness. Clear the internal components with compressed air, and as necessary, use cleaning solution and tools to remove debris from the housing followed by fresh lubrication according to the manufacturer's specifications.
- If your rifle is equipped with a sling, verify the retention strength of the hardware and lubricate as necessary.
- Disassemble the bolt assembly and perform a thorough cleaning and inspection of all components as laid out in the Deadline action manual
- Check the function of the bolt assembly's components, including the extractors and ejectors.

- Clean the muzzle treatment
- Verify the attachment of the scope and any other mounted accessories. Reattach as necessary.
- Check tightness of all screws and attachments. If you find that permanent attachments such as the hand guard to the chassis block are loose, remove and degrease the screws before reinstalling with a suitable thread locker.
- Check the function of the stock hinge. Clean and reapply gun oil to the taper pin of the hinge as necessary.

SPECIAL CLEANING CONSIDERATIONS

Beyond regular maintenance, you should be aware of certain conditions that will necessitate immediate or specific cleaning procedures. Before firing your rifle, you should check the barrel and chamber to ensure that they are clean and dry. After firing, expect to disassemble and clean the rifle within a 24-hour period to make the job easier and to allow less time for any corrosion to start. Check it again within a few days to ensure that no further cleaning is necessary. If your firearm has not been used for some time, you should perform a routine cleaning at least once or twice a year in a temperate climate. If you carry a loaded firearm, unload it and clean it when necessary or at least once a month. If you get your firearm wet, clean it as soon as possible. Below is a listing of environmental factors and how they should affect your firearm maintenance routine.

Extreme Cold

- Clean and lubricate your rifle with a degreasing agent and keep it free from moisture like condensation. In freezing conditions, apply a dry lubricant sparingly in place of oil. We recommend powdered graphite like a locksmith would use. Most oils will harden and cause excessive hydraulic friction and subsequent malfunctions.
- At intervals, operate the rifle's controls through their entire range to keep them from freezing up.
- If your rifle is being kept outside unused, protect it with a cover. If you are using the rifle in extreme cold conditions, it is wise not to bring it into a warm humid situation like a cabin, but rather leave it cased or racked in the cold.

Hot, Humid Climates

- Inspect the rifle and any bipod you may use more frequently, especially the hidden surfaces of the bolt assembly and trigger. Make sure they are lubricated appropriately. Use a good gun oil or rust preventative on any steel components to prevent corrosion.
- When handling, make sure to wipe dry, as moisture can cause corrosion. After drying, lubricate with gun oil.

- Because of the adverse effects of humidity, be prepared to perform routine cleaning as often as every week. In particular, salt spray environments may require daily service even on stainless components.

Hot, Dry Climates

- Perform regular cleaning more often and make generous use of gun lubricant in the action when oiling the rifle.

Dusty or Sandy Environments

- Clean and generously lubricate the rifle more frequently.
- Keep sand away from the rifle's interior parts when inspecting, lubricating or assembling the rifle. Apply only a light amount of lubrication on the outside of the rifle.
- Use a magazine bag and muzzle cap for dust and sand protection.

STORAGE

Store your firearm and ammunition separately in a securely locked location out of the reach of children and other unauthorized users. Do not store your firearm in an airtight container, and do not seal or attempt to seal the barrel to exclude dust, as the internal steel surface is more likely to corrode.

If you intend to store the firearm long term, adhere to the following recommendations:

- Perform a thorough cleaning of the rifle
- Clear your rifle and magazines of all cartridges
- Remove the magazine from the action
- Remove the bolt assembly
- Purchase a sealing anti-corrosion bag designed for long-term storage

When taking the firearm out of storage, be sure to run a clean swab through the barrel to remove any oil film before use.

TROUBLESHOOTING

This section is intended to address some of the most common problems encountered by the operators of manual rifles. Most problems are easily remedied with a combination of patience, minor adjustment and observation. If you would prefer to have JP Enterprises, Inc. or a qualified gunsmith inspect your rifle, make sure to carefully note all details regarding the malfunction as well as the positions of the cartridges and mechanisms involved.

The rifle fails to fire when the trigger is pulled...

Hangfire

If, while operating your rifle, you depress the trigger and hear the hammer fall, but the weapon does not discharge, keep the muzzle pointed towards a safe backstop for 30 seconds. If a hangfire (slow ignition) has occurred, the weapon will discharge in that time. If it does not discharge, remove the magazine. Then, keeping the rifle pointed downrange, open the bolt quickly to clear the chamber. Examine the primer of the faulty round. If the indent from the firing pin is light, off-center or non-existent, have your firearm examined by a qualified gunsmith. If the indent seems consistent with previously fired rounds, assume that the cartridge was faulty and segregate it from other ammunition and shells. Dispose of misfired cartridges as instructed by the manufacturer. If you extract a cartridge with no bullet, a projectile may be lodged in the bore. Refer to the "Projectile Lodged in Bore" section below.

Projectile Lodged In Bore

If a popping sound is audible while firing the rifle instead of a full report or you experience reduced recoil, remove the magazine, open the bolt, clear the chamber and switch the safety selector lever to "SAFE." Visually check or insert a cleaning rod into the bore to determine if a round or some jacket material is lodged inside. If so, cease all use of the rifle and contact JP Enterprises, Inc. or a qualified gunsmith. Firing another round behind a projectile lodged in the barrel will destroy the barrel and may cause serious injury to the shooter and bystanders.

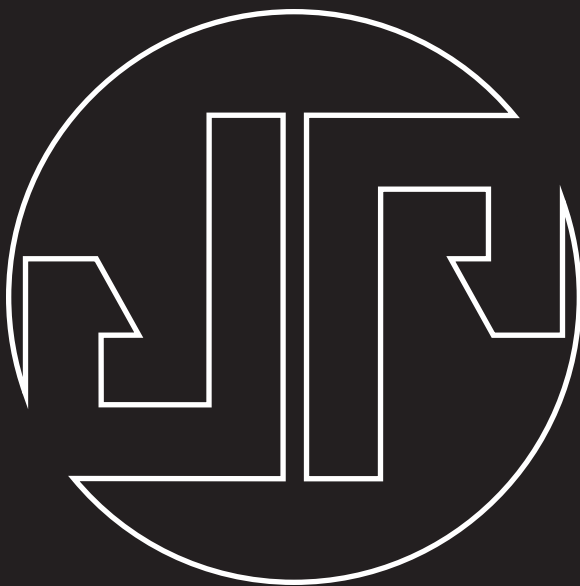
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