



**ARMSCOR**

**USER'S MANUAL**  
**MODEL 1600**  
**SEMI AUTOMATIC RIFLE**

**WARNING**

**READ THE INSTRUCTIONS AND SAFETY PRECAUTIONS IN THIS MANUAL CAREFULLY BEFORE USING THIS FIREARM.**

**DISCHARGING FIREARMS IN POORLY VENTILATED AREAS, CLEANING FIREARMS OR HANDLING AMMUNITION MAY RESULT IN EXPOSURE TO LEAD AND OTHER SUBSTANCES KNOWN TO THE STATE OF CALIFORNIA TO CAUSE BIRTH DEFECTS, REPRODUCTIVE HARM AND OTHER SERIOUS PHYSICAL INJURY. HAVE ADEQUATE VENTILATION AT ALL TIMES. WASH HANDS YOUR THOROUGHLY AFTER EXPOSURE.**

**M 1600 OPERATING INSTRUCTIONS**

**This rifle is shipped from the factory fully assembled and ready to shoot after removing the grease from its bore.**

**TO LOAD MAGAZINE:**

**Hold the magazine box firmly with one hand and, with the other, insert cartridge at the throat of the magazine. Push the cartridge against the spring follower head down and forward towards the supporting notch until it is securely locked. A maximum of fifteen rounds can be loaded.**

**TO ATTACH MAGAZINE:**

Load the magazine into the magazine box clearance of the trigger guard housing. Keep it ahead of the magazine catch by pushing it inward until it locks in place.

**TO DETACH MAGAZINE:**

Press magazine release and, simultaneously, pull the magazine from guard. The catch opens up and releases the magazine from lock.

**TO MAKE GUN SAFE:**

Safety lever is at the right side of the receiver and rearward of the bolt operating handle. Pull safety latch towards the "S" mark engraved on the receiver. Trigger is locked up in the process and gun can no longer be fired.

**TO LOAD CHAMBER:**

Draw safety on and insert a loaded magazine into the rifle. Retract bolt handle fully to the rear of the receiver slot and release. Allow the bolt to be snapped back under the full force of the operating springs. Bolt automatically picks up a cartridge from the magazine and feeds it into the chamber. Do not ease bolt forward.

**TO FIRE:**

Be sure gun is pointed at a safe target. Release safety and pull the trigger. Pressure from the burning powder opens up bolt, ejects empty shell, and reloads the chamber for the next shot. Pull the trigger again. Gun fires as fast as the trigger is pulled until magazine is empty.

**TO UNLOAD WITHOUT FIRING:**

Draw safety on and release the magazine from guard. Work action several times to remove any cartridge left inside the chamber. Slide bolt handle rearward and lock piece. Inspect the chamber to make sure no cartridge is left. Empty magazine can be placed back if desired.

## **I. DISASSEMBLY**

### **A. STOCK AND TRIGGER GUARD HOUSING**

- 1. Remove the magazine by depressing the magazine catch.**
- 2. Remove front screw of trigger guard housing and detach barrel-receiver assembly from the stock.**

### **B. TRIGGER GROUP**

- 1. Remove the trigger by punching out trigger stop pin and pivot pin.**
- 2. Remove the trigger spring and spring follower at the end of the housing.**
- 3. Loosen the rear and front (trigger) housing hold down screws to disengage the housing from the receiver.**

**CAUTION: Step number 3 is not recommended unless necessary. If it could not be avoided, make sure to apply “Loctite” or Epoxy Glue on rear screw threads when re-attaching the housing to the receiver.**

### **C. BOLT ASSEMBLY**

- 1. Loosen the receiver cap lock screw and unscrew the receiver cap. Be careful as springs inside are under compression.**
- 2. Pull out the unit assembly (recoil spring, recoil spring retainer and guide sleeve, firing pin spring and firing pin spring guide head and stem). Keep all of this in order together with the receiver cap to avoid confusion I re-assembly.**
- 3. With the muzzle pointing in an upward direction, retract bolt handle fully to the rear end of the receiver slot.**
- 4. Push firing pin forward so as to align its tail end approximately even with the receiver cap lock screw. (Firing pin is visible and is even with the rear end of the bolt).**
- 5. Pull out bolt handle and operating stud and remove bolt from the receiver.**

## **II. ASSEMBLY**

### **A. BOLT ASSEMBLY**

- 1. Place firing pin at the rear end of the slot.**

2. Push bolt and firing pin into the receiver and align them with respect to the receiver slot so that the bolt handle can be inserted through it past the bolt and firing pin stud clearance. Slide bolt forward with bolt handle and stud already inserted into it until it stops against the rebound lever.
3. While holding the trigger back with one hand, use any pointed object to trip the rebound lever by moving it to the rear away from the sear in the direction indicated by an arrow on the rebound lever. (See small sketch engraved on the trigger housing).
4. Push bolt handle forward sliding the bolt over the rebound lever. Release the trigger.
5. Insert recoil spring guide sleeve and retainer sleeve in recoil spring.
6. Insert firing pin spring guide into the firing pin spring.
7. Insert assembly #6, spring end first, into the recoil spring through the guide sleeve (shorter sleeve).
8. Insert the entire unit inside the receiver, shorter sleeve resting against the bolt. Place the receiver cap at the rear end of the unit assembly and compress the springs carefully to return receiver cap into its original position. Tighten the receiver cap lock screw.
9. Pull bolt handle back and forth several times to check the action of bolt and trigger assembly.

#### **B. TRIGGER ASSEMBLY**

1. With gun in upside down position, insert trigger spring follower into the trigger spring and mount it onto the spring hole.
2. Insert the trigger, locating the catch of the rebound lever with the rear catch.
3. Insert the trigger stop pin and pivot pin into their respective holes.
4. Squeeze trigger several times to check the action of trigger spring. (Pull bolt handle back and forth several times to check if trigger will release cocked firing pin spring).

**CAUTION**

The safety in your firearm is correctly designed, fitted and tested. However, any mechanical device can fail. Never point your firearm at anything but a safe target and never rely upon the safety to justify careless handling. **USE HIGH VELOCITY CALIBER 22 LONG RIFLE CARTRIDGES ONLY.**

When loading, pull bolt handle fully rearward and allow it to snap forward sharply.

Breech area and magazine should be cleaned thoroughly.

**SPECIFICATIONS**

- Model : 1600 Cal.22LR Semi-automatic Rifle**
- Barrel Length : 18 inches (457.20 mm)**
- Overall Length : 38.375 inches (720.73 mm)**
- Weight : 6.5 lbs. (2.95 kg.)**
- Magazine Capacity : 15 rounds**
- Sights : Fixed peep rear sight, Post front sight**
- Stock : Wooden stock, black finish**
- Safety : Positive thumb operated safety**

<b>Part No.</b>	<b>Part Name</b>
<b>A. Barrel Receiver Assembly</b>	
<b>1601</b>	<b>Barrel receiver cross pin</b>
<b>1602</b>	<b>Barrel</b>
<b>1603</b>	<b>Ejector</b>
<b>1604</b>	<b>Muzzle brake</b>
<b>1605</b>	<b>Muzzle brake set screw</b>
<b>1606</b>	<b>Front sight</b>
<b>1607</b>	<b>Front sight stud</b>
<b>1608</b>	<b>Front sight stud lock screw</b>
<b>1609</b>	<b>Front sight set screw</b>
<b>1610</b>	<b>Rear sight carrying handle</b>

1611	Rear sight carrying handle screw
1612	Rear sight carrying handle lock screw
1613	Rear sight leaf
1614	Rear sight leaf screws
1615	Flash deflector
1616	Receiver
1617	Receiver cap
1618	Receiver cap lock screw

#### **B. Bolt Assembly**

1619	Bolt
1620	Bolt operating handle
1621	Bolt operating stud
1622	Bolt handle locating bearing
1623	Bolt handle locating spring
1624	Extractor
1625	Extractor plunger
1626	Extractor spring
1627	Firing pin
1628	Firing pin spring
1629	Firing pin spring guide head and stem
1629a	Firing pin spring guide head insert
1630	Recoil spring
1631	Recoil spring guide sleeve
1632	Recoil spring retainer sleeve

#### **C. Trigger Housing Assembly**

1633	Magazine catch
1634	Magazine catch button
1635	Magazine catch pivot pin
1635a	Magazine catch stop pin
1635b	Magazine catch spring

1636	Safety latch
1637	Safety latch button
1638	Safety latch bearing
1639	Safety latch spring
1640	Safety latch screw
1641	Sear
1642	Sear pivot pin
1643	Sear stop pin
1644	Sear spring
1645	Sear spring pin
1646	Trigger
1647	Trigger pivot pin
1648	Trigger stop pin
1649	Trigger spring
1650	Trigger spring follower
1651	Rebound lever
1652	Rebound lever pivot pin
1653	Rebound lever safety pin
1654	Rebound lever spring
1655	Rebound lever spring bearing
1656	Trigger housing
1657	Trigger housing hold down screw (front)
1657a	Trigger housing hold down screw washer (front)
1658	Trigger housing hold down screw (rear)
1658a	Trigger housing hold down screw washer (rear)

#### **D. Magazine Box Assembly**

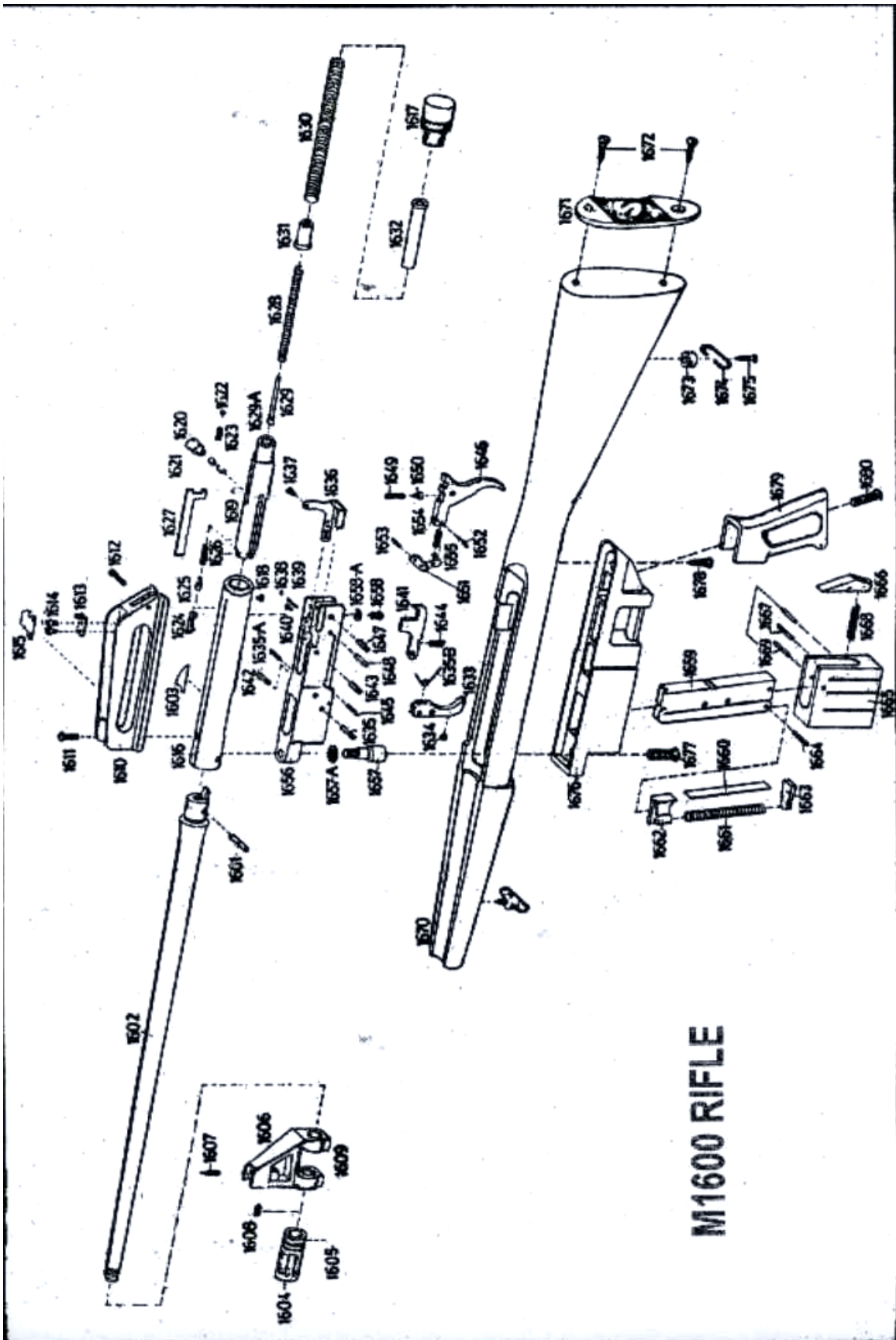
1659	Magazine box
1660	Magazine box inner strip
1661	Magazine spring
1662	Magazine spring follower

<b>1663</b>	<b>Magazine spring retainer</b>
<b>1664</b>	<b>Magazine spring retainer pin</b>
<b>1665</b>	<b>Magazine cover</b>
<b>1666</b>	<b>Magazine release</b>
<b>1667</b>	<b>Magazine release pivot pin</b>
<b>1668</b>	<b>Magazine release spring</b>
<b>1669</b>	<b>Magazine box retainer pin</b>

**E. Gun stock Assembly**

<b>1670</b>	<b>Gun stock</b>
<b>1671</b>	<b>Butt plate</b>
<b>1672</b>	<b>Butt plate retainer screw</b>
<b>1673</b>	<b>Swivel head</b>
<b>1674</b>	<b>Swivel ring</b>
<b>1675</b>	<b>Swivel screw (front)</b>
<b>1676</b>	<b>Swivel screw (rear)</b>
<b>1677</b>	<b>Grip</b>
<b>1678</b>	<b>Grip screw</b>





M1600 RIFLE

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