

SABER® M700™ Rifles

Tactical Hunter • Precision Rifle
Tactical Long Range Hunter



Modular by Definition...
Performance Engineered by Design

OWNER'S OPERATOR MANUAL

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Ashbury Precision Ordnance Manufacturing

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Version 170718

Ashbury Precision Ordnance Mfg

Ashbury International Group Inc. was formed in 1995 as a combat systems integrator for US Department of Defense. In 2005 the company's Ashbury Precision Ordnance Manufacturing (APO) business unit commenced a new program to design and engineer advanced modular rifle chassis systems for precision rifles for recreational and target shooting, hunting, long range competition and tactical applications.



The design concept was based on utilizing state of the art high strength light weight materials and advanced manufacturing techniques to improve the man-machine interface for rifles which had changed little in nearly 100 years. Our goal was to engineer an American made precision rifle chassis system that would ergonomically fit a wide range of shooter body types, improve comfort, shoot-ability & accuracy, while reducing felt recoil. We achieved our goal!

The SABER®- FORSST® modular rifle chassis was born after countless hours of extensive input from military snipers, competitive shooting champions, seasoned hunters, and long range shooting specialists. Our engineering and product development team spent many thousands of hours of design engineering, rapid prototyping, field testing and continuous quality improvement that has resulted in being awarded more than twenty one utility and design patents by the US Patent and Trademark Office.

APO's SABER rifle chassis products are manufactured to meet ISO 9001-2008 standards in tactical, multi-sport and hunting configurations. We manufacture more than 55 SABER Rifle Chassis models for seventeen popular production and custom bolt action rifle manufacturers, in both right & left hand operation in calibers from .223 to .50BMG.



Ashbury's custom built hunting, multi-sport and tactical precision rifles and SABER Enhanced Factory Rifles (SEFR) are manufactured by proud American craftsmen and US military Veterans in our Ruckersville, Virginia facility at the base of the Blue Ridge Mountains.

We take this opportunity to thank you for your purchase of the SABER M700 Rifle and for your support of an American small business!

Safe Shooting!

Team Ashbury Precision Ordnance Manufacturing

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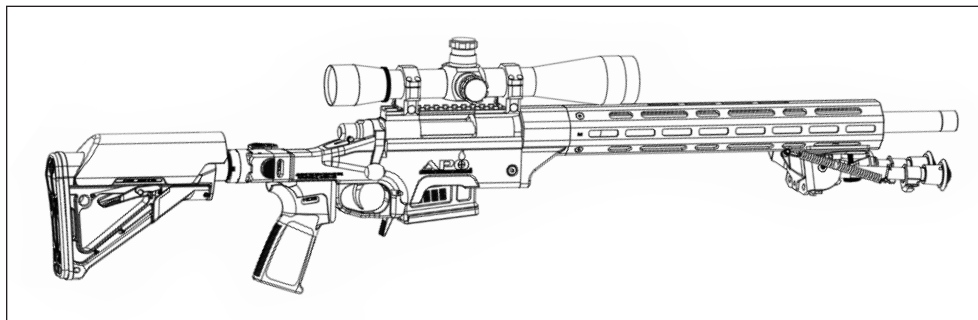
USE OF THIS OWNER'S OPERATOR MANUAL

This Owner's Operator Manual is intended to be a reference booklet on the safe operation and proper use of SABER M700 Rifles. Supplemental information contained in this booklet is provided as a general guide and should be verified for specific applications. It is recommended that the owner and users of this rifle receive qualified safety and firearms training.

The first step in the responsible use of this firearm is to familiarize yourself with its components, features and operation. Before removing your firearm from the box and before using it, it is important to fully understand critical safety, operational and maintenance instructions. Even if you are an experienced firearms owner, read the instructions and warnings in this manual carefully before using this firearm.

Failure to obey these instructions and warnings can result in serious injury or death to yourself and/or others. This SABER M700 Rifle Owner's Operator Manual should always accompany the firearm and be transferred with it upon change of ownership or when the firearm is provided to others.

To obtain additional copies of the SABER M700 Rifle Owner's Operator Manual please visit SABER-M700.com or contact us at (434) 296-8600.



CARDINAL RULES OF FIREARMS SAFETY

RULE 1

TREAT EVERY FIREARM AS IF IT IS LOADED

- Any firearm handled by an individual must be treated as if it is loaded and ready to fire.
- Whether or not a firearm is loaded should not affect how an individual handles the firearm in any instance.
- Individuals must take the appropriate actions to ensure safe firearm status.

RULE 2

NEVER POINT FIREARM AT ANYTHING YOU DO NOT INTEND TO SHOOT & DESTROY

- Individuals must be aware of the orientation of their firearm's muzzle and what is in the path of the projectile if the firearm fires.
- Individuals must ensure the path between the muzzle and target is clear of anything the individual does not want to strike. This includes but not limited to other individuals, deflection and ricochet hazards.
- When this is unavoidable, the individual must minimize the amount of time the muzzle is oriented toward people or objects they do not intend to shoot, while simultaneously applying the other three rules of firearms safety.

RULE 3

KEEP YOUR FINGER STRAIGHT AND OFF THE TRIGGER UNTIL READY TO FIRE

- Individuals must not place their finger on the trigger unless they intend to fire the firearm.
- The individual is the most important safety feature on any firearm.
- Mechanical safety devices are not available on all types of firearms.
- When mechanical safeties are present, individuals must not solely rely upon them for safe operation knowing that mechanical measures may fail.
- Whenever possible, individuals should move the firearm to mechanical safe condition when a target is not present. If the firearm does not have a traditional mechanical safety, the trigger finger acts as the primary safety.

RULE 4

ENSURE POSITIVE IDENTIFICATION OF TARGET, ITS SURROUNDINGS & BACKSTOP

- The individual must positively identify the target and know what is in front of, and what is beyond it.
- The individual is responsible for all projectiles (and spent cartridge casing) fired from their firearm, including the projectile's final destination.
- Applying this rule minimizes the possibility of injuring or killing others, collateral damage, or damage to infrastructure, equipment or animals.
- It also prepares the individual for any follow-on shots that may be required or desired.

YOU ARE RESPONSIBLE FOR FIREARMS SAFETY!

1. **FAILURE TO HEED ANY OF THE FOLLOWING WARNINGS COULD RESULT IN SERIOUS INJURY OR DEATH.**

As a firearms owner, you accept a set of responsibilities for weapon's ownership. How seriously you take these responsibilities can be the difference between life and death. There is no excuse for careless or abusive mishandling of any firearm. At all times handle this firearm, and all other firearms, with intense respect for their power and potential danger. Please read and understand all of the cautions, warnings, notices, proper handling procedures and instructions outlined in this owner's operator manual before using your new firearm.

2. **SECURELY STORE YOUR FIREARM AND AMMUNITION SEPARATELY, BEYOND THE REACH OF CHILDREN.**

Take prudent safeguards to ensure your firearm does not become available to untrained, inexperienced or unauthorized users. Store all firearms in secure, locked cases or a gun safe. Keep your firearm unloaded when not in use.

3. **ALWAYS KEEP THE MUZZLE OF YOUR FIREARM POINTED IN A SAFE DIRECTION AT ALL TIMES, EVEN THOUGH YOU ARE CERTAIN IT IS UNLOADED.**

Never point any firearm at anything you do not intend to shoot and destroy. Be extremely alert and aware of all persons and property within the range of your firearms ammunition.

4. **NEVER TOTALLY RELY ON YOUR FIREARM'S SAFETY MECHANISM. LIKE ANY MECHANICAL DEVICE, A "SAFETY" CAN SOMETIMES FAIL; IT CAN BE JARRED, DAMAGED OR INADVERTENTLY MANIPULATED INTO AN UNSAFE CONDITION.**

The word "safety" describes a firearm's trigger block mechanism, sear block mechanism, hammer block mechanism or firing pin block mechanism. Mechanical "safeties" are designed to place your firearm in a safer status, and no guarantee can be made that the firearm will not fire even if the "safety" is in the "S" or on Safe position. Mechanical "safeties" aid and support safe gun handling. See "Manual Safety Operations" on page 12 of this manual and page 7 of the Remington Model 700 Owners Manual for instructions on the operation of this firearm's safety mechanism. It is critical to read and understand this Owner's Operator Manual which explains the safe operation of this firearm. While it is a good idea to "test" your firearm's mechanical "safety" periodically for proper function, only conduct a test in an appropriate safe location with the firearm unloaded and pointed in a safe direction. If you question the operation or reliability of your safety mechanism, you should obtain firearms training, take your SABER M700 rifle to an authorized Remington Service Center or contact the Ashbury Precision Ordnance Service Department.

5. WHENEVER YOU HANDLE ANY FIREARM, OR HAND IT TO SOMEONE, ALWAYS IMMEDIATELY OPEN THE ACTION, PHYSICALLY AND VISUALLY INSPECT THE FIREARM'S CHAMBER TO INSURE THAT THE FIREARM IS COMPLETELY UNLOADED.

Insure the firearm does not contain any live ammunition. Removing the magazine does not mean the chamber is unloaded. Always keep the chamber empty and the safety mechanism in the "S" or on Safe position unless you have acquired your target, confirmed the backstop and are prepared to shoot.

6. ALWAYS WEAR EAR AND EYE PROTECTION WHEN SHOOTING.

Exposure to repeated gunfire without hearing protection can cause hearing damage. Wear hearing protection (e.g. ear plugs or protective muffs) to aid in preventing such damage. Wear protective eyewear to shield your eyes from flying particles and objects. Allow proper distance (eye relief) between a scope and your eye when firing a scoped firearm. Always wear eye protection when disassembling and cleaning firearms to prevent the possibility of springs, spring-tensioned parts, solvents or lubricants from getting into your eyes. Always keep a safe distance between the muzzle of your firearm and any persons nearby, as muzzle blast, flying debris and hot ejected cartridge cases could inflict or cause serious injury.

7. KEEP FIREARMS IN A SAFE UNLOADED CONDITION DURING TRANSPORT; IN A CASE, BAG, SCABBARD OR OTHER SECURE CONTAINER.

8. EXAMINE EVERY CARTRIDGE YOU LOAD IN YOUR FIREARM.

APO cannot assume any responsibility for the use of unsafe or improper firearm and ammunition combinations or damage or injury caused by damaged ammunition. It is your responsibility to read and heed all warnings in this Owner's Operator Manual and on factory ammunition boxes. See page 25 for more information on the correct ammunition for your firearm.

9. NEVER INSERT A CARTRIDGE OF THE INCORRECT CALIBER INTO ANY FIREARM.

The caliber of your firearm is marked on the barrel. Store all cartridges of different calibers in completely separate and well marked containers. Never store cartridges of mixed calibers in a common container or in your pockets.

10. USE ONLY SAAMI APPROVED AMMUNITION.

The barrel and action of this firearm have been made with substantial safety margins beyond the pressures developed by established American commercial cartridge loadings. Nevertheless, we can assume no liability for incidents which occur through the use of cartridges of nonstandard dimensions or which develop pressures in excess of commercially available ammunition which has been loaded in accordance with standards established by the Sporting Arms and Ammunition Manufacturers' Institute (SAAMI).

11. DROPPING, JARRING OR MISHANDLING A LOADED FIREARM CAN CAUSE A DANGEROUS NEGLIGENT DISCHARGE.

A negligent discharge can occur even with the safety mechanism in the "S" or on Safe position. Exercise care when handling your firearm while conducting target practice, hunting, competition or during any shooting activity to avoid mishandling.

12. BEWARE OF BARREL OBSTRUCTIONS.

Cleaning supplies, debris, mud, snow, twigs and an infinite variety of other objects may inadvertently lodge in a firearms barrel bore. It only takes a small obstruction to cause dangerously increased pressures that can damage your firearm and cause serious injury to yourself and others.

13. BEFORE CHECKING FOR A BARREL OBSTRUCTION, CONFIRM THAT YOUR FIREARM IS COMPLETELY UNLOADED. REMOVE THE MAGAZINE, OPEN AND REMOVE THE BOLT, AND PHYSICALLY AND VISUALLY INSURE THERE IS NOT A LIVE CARTRIDGE IN THE CHAMBER.

After physically and visually confirming that the firearm is completely unloaded, open the bolt action, pull the bolt to the rear and remove it from the receiver. Look through the barrel from the breech end to confirm it is clear of obstructions. If an obstruction is seen, no matter how small it may be, carefully clear and clean the bore with a cleaning rod, jag and patch as described on pages 51 of this Owner's Operator Manual.

14. BE ALERT TO THE SIGNS OF AMMUNITION MALFUNCTION. IF YOU DETECT AN ODD SOUND OR LIGHT RECOIL WHEN A CARTRIDGE IS FIRED, DO NOT LOAD ANOTHER CARTRIDGE INTO THE CHAMBER!

If your firearm fails to fire, keep the muzzle pointed in a safe direction for a minimum of 60 seconds. Rotate the ejection port of the firearm away from you. Carefully retract the bolt opening the action and remove the cartridge from the chamber. If the primer is dented, the defective cartridge should be disposed of in a way that cannot cause harm. If the primer is not indented, your firearm should be examined by a qualified gunsmith and the cause of the malfunction corrected before further use. Remove the bolt and look down the barrel (from the breech end) to make sure there is no bullet lodged in the barrel. Completely clear the barrel before loading and firing again. Failure to follow these instructions can cause extensive damage to your firearm and possible serious injury to yourself and others.

15. INSURE THE AREA WHERE YOU ARE FIRING HAS ADEQUATE VENTILATION. LEAD EXPOSURE CAN OCCUR FROM DISCHARGING FIREARMS IN POORLY VENTILATED AREAS, CLEANING FIREARMS OR HANDLING AMMUNITION.

Lead is a substance that has been known to cause birth defects, reproductive harm and other serious injury. Wash your hands thoroughly after shooting, exposure to ammunition or after cleaning a firearm.

16. DO NOT PULL THE FIREARMS TRIGGER ON AN EMPTY CHAMBER, THE CHAMBER MAY NOT BE EMPTY!

Treat every firearm as if it is loaded. If you are going to conduct dry fire practice, remove all live ammunition from the firearm, magazine and the area. Point the firearm in a safe direction and physically and visually confirm that the firearm and chamber are empty of live ammunition. Use purpose built dummy rounds or snap caps to conduct dry fire marksmanship practice safely and prevent damage to the firearm.

17. KEEP YOUR FINGERS OFF AND AWAY FROM THE TRIGGER WHILE LOADING AND UNLOADING THE FIREARM.

18. INSURE THAT ANY DEVICE SCREWED ON TO THE MUZZLE IS APPROPRIATELY SIZED, ATTACHED AND PROPERLY TIGHTENED.

19. BE SURE OF YOUR TARGET AND BACKSTOP PRIOR TO FIRING THE FIREARM.

Know the range and capability of your ammunition. Never shoot at water or hard objects as they may cause ricochets.

20. ALWAYS UNLOAD YOUR FIREARM'S CHAMBER BEFORE CROSSING A FENCE, CLIMBING A TREE, ENTERING A HUNTING BLIND, JUMPING A DITCH OR NEGOTIATING OTHER OBSTACLES.

Never place your firearm on or against a fence, tree, car or other similar object where it can fall and potentially negligently discharge and/or damage the firearm.

21. NEVER PRESENT OR RECEIVE A FIREARM WITH THE MUZZLE POINTING AT A PERSON.

22. SHOOTING AND HUNTING FROM ELEVATED POSITIONS SUCH AS TREE STANDS AND PLATFORMS IS DANGEROUS.

Firing from elevated platforms may increase the risk of mishandling a firearm. The following rules should always be observed by you and those you shoot and hunt with: Always make certain that the elevated platform being used is safe and stable. Always make certain that your firearm is unloaded when it is being taken up and down from the elevated platform. Always make certain that your firearm is not dropped from the elevated platform, or dropped while it is being taken up or down from the elevated platform. A loaded firearm may discharge when dropped, even with the safety mechanism in the "S" or on Safe position.

23. BE ON GUARD AGAINST UNSAFE GUN HANDLING PRACTICES AROUND YOURSELF AND OTHERS.

Be vocal and proactive regarding firearms safety. If you observe other shooters, hunters or competitors violating any of these safety precautions, politely suggest safer firearms handling practices.

24. BE CERTAIN YOUR FIREARM IS UNLOADED BEFORE CLEANING.

Many firearm accidents occur when a firearm is being cleaned. Special & extreme care should be taken to be sure your firearm is completely unloaded before disassembly, cleaning & reassembly. Keep live ammunition away from cleaning area.

25. TEACH AND SUPERVISE FIREARMS SAFETY TO ALL MEMBERS OF YOUR FAMILY, ESPECIALLY TO CHILDREN AND NON-SHOOTERS.

Closely supervise those new to the shooting sports when around and handling firearms. Encourage their enrollment in firearms safety, marksmanship, competition and hunter safety courses.

26. NEVER DRINK ALCOHOLIC BEVERAGES OR TAKE ANY TYPE OF DRUGS BEFORE OR DURING SHOOTING ACTIVITIES.

Your vision, motor skills and judgment could be dangerously impaired, making your firearms handling unsafe to yourself and to others

27. READ AND HEED ALL WARNINGS IN THIS OWNER'S MANUAL, ON AMMUNITION BOXES AND ALL ACCESSORIES THAT YOU INSTALL ON YOUR FIREARM.

It is your responsibility to secure the most up-to-date information and qualified training on the safe handling procedures of your Ashbury Precision Ordnance Mfg. firearm. We assume no liability for incidents which occur when unsafe or improper firearm accessories or ammunition combinations are used.

28. PRACTICE PERIODIC MAINTENANCE, AVOID UNAUTHORIZED SERVICING.

Your firearm is a mechanical device and all mechanical devices require qualified periodic maintenance to remain in proper working order. Firearms are subject to wear and require periodic inspection, adjustment and service. Ashbury Precision Ordnance Mfg. firearms should be serviced by Ashbury's factory authorized Remington Service Center Facility in Ruckersville, Virginia. We cannot assume any responsibility for injuries suffered or caused by unauthorized servicing, alterations or modifications of Ashbury Precision Ordnance Mfg. firearms.

29. WE RESERVE THE RIGHT TO REFUSE SERVICE ON FIREARMS THAT HAVE BEEN ALTERED, ADDED TO OR SUBSTANTIALLY CHANGED.

Removal of metal from the barrel, or modifications of the firing mechanism and/or operating parts, may lead to a refusal of warranty service on such firearms. We will charge you for parts and labor to return the firearm to original specifications. The trigger assembly on your rifle may permit the adjustment of the trigger pull force by the user. On rifles that are so equipped, the trigger pull force is adjustable without removing the action from the chassis.



ONLY THE TRIGGER PULL FORCE IS ADJUSTABLE. FOR SAFETY'S SAKE, NEVER MAKE ADJUSTMENTS OR ALTERATIONS TO ANY OTHER PARTS OF THE TRIGGER ASSEMBLY OR RIFLE. FAILURE TO OBEY THIS WARNING MAY RESULT IN INJURY OR DEATH TO YOURSELF OR OTHERS.

PACKAGE CONTENTS

Your SABER M700 rifle includes the following:

- One - SABER M700 Rifle
- One - M700 Bolt (*packaged separately*)
- One - 5-rd PMAG® 5 762AC™ AICS Short Action Magazine 7.62x51mm NATO (*packaged separately*)
- One – 1/16" Hex Wrench
- One – SABER M700 Rifle Owner's Operator Manual
- One – Remington Model 700 Owner's Manual
- One – Gun Lock

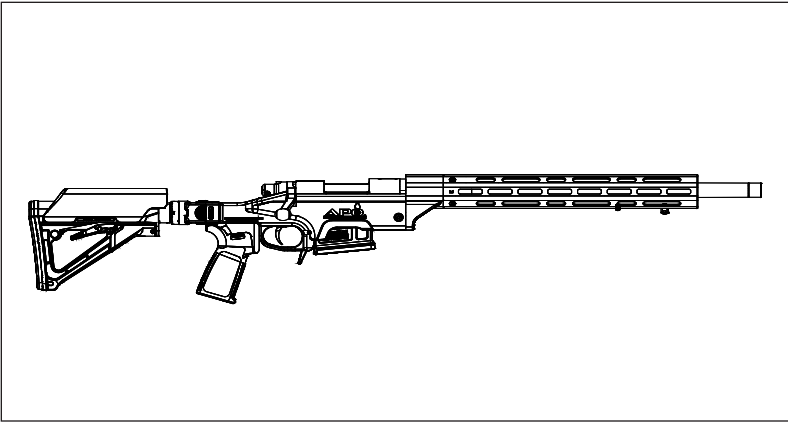


Figure 1 - Fully Assembled SABER M700 Rifle

MAJOR PARTS IDENTIFICATION

The SABER M700 Rifle is a magazine fed turn bolt action operated repeating rifle. The rifle is built using the Remington Model 700® SPS AAC®-SD™ barreled action and patented SABER modular rifle chassis system. The rifle is comprised of the following major parts. Further information can be located in the Remington Model 700 Owner's Manual included with your rifle.

SHOULDER STOCK

The SABER M700 Rifle utilizes a Magpul CTR shoulder stock with a $\frac{3}{4}$ " Cheek Riser. *Optional SABER ergonomically adjustable shoulder stocks are available.*

BUFFER TUBE

The shoulder stock is mounted on a six position Mil-Spec (1.148" x 7.125") carbine length Buffer Tube.

STOCK JOINT

The SABER M700 Rifle shoulder stock assembly is joined with the Center Chassis Section by a Double Locking Hinge that is tension adjustable.

CENTER CHASSIS SECTION

The SABER Center Chassis Section RSA-A3 is precision engineered for the Remington Model 700 short action receiver with an ambidextrous paddle lever magazine release. The Remington Model 700 long action receiver uses the SABER RLA-A1A and A1B Center Chassis Sections. The Center Chassis Section includes an AR hand grip with an adjustable grip angle and grip to trigger distance adjustment.

MAGAZINE

The standard magazine for the SABER M700 Rifles chambered in small calibers is an AICS type Magpul PMAG 5 762AC with capacity of 5 cartridges. Optional 10rd magazines are available. SABER M700 Rifles chambered in long action calibers use AICS type 5rd single stack magazines.

BOLT ACTION RECEIVER

The bolt action receiver for .308 Winchester and 6.5 Creedmoor is the Remington Model 700 short action and the bolt action receiver for .30-06 Springfield, .300 Winchester Magnum and .338 Lapua Magnum is the Remington Model 700 long action.

BOLT

.308 Winchester and 6.5 Creedmoor caliber SABER M700 Rifles use the Remington Model 700 short action 2-lug bolt. .30-06 Springfield, .300 Winchester Magnum and .338 Lapua Magnum calibers use the Remington Long Action 2-lug bolt.

TRIGGER

The fire control mechanism for the SABER M700 Rifle is the Remington X-Mark Pro Trigger. For additional information on the trigger, its operation and adjustment refer to the Remington Model 700 Owner's Manual.

BARREL

SABER M700 Rifles use a carbon steel barrel with a 5/8-24 TPI threaded muzzle with a protective thread cap. Optional stainless steel barrels are available from the APO Custom Shop.

HAND GUARD

The AR-08 octagonal hand guard features the M-LOK accessory attachment system and a forward positioned bipod/sling stud. Other SABER hand guards are available.

MANUAL SAFETY OPERATION



WHEN OPERATING THE RIFLE'S SAFETY MECHANISM, DO NOT TOUCH THE TRIGGER, OR INSERT YOUR FINGERS INSIDE THE TRIGGER GUARD WHEN OPERATING THE SAFETY LEVER. DOING SO CAN RESULT IN THE RIFLE FIRING ACCIDENTALLY.

Note: The safety lever can only be moved into the on "SAFE" position when the rifle is cocked by cycling the bolt.

The SABER M700 Rifle safety mechanism is a factory Remington X-Mark Pro model. It can be identified on the rifle as the cerated knob on top of a lever located on the tang area behind the bolt. The lever is attached to a safety mechanism in the trigger.

The manual safety is a two-position safety mechanism that when pulled to the rear is placed into the "S" or on Safe position. When pushed forward it is in the "F" or Fire position. The rifle can be unloaded with the safety mechanism in the "S" or Safe position.

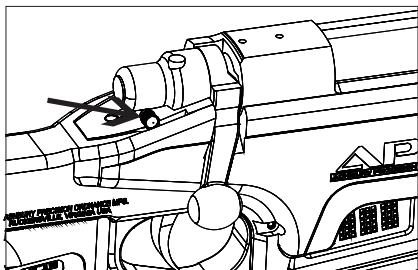


Figure 2 - Safety in SAFE Position

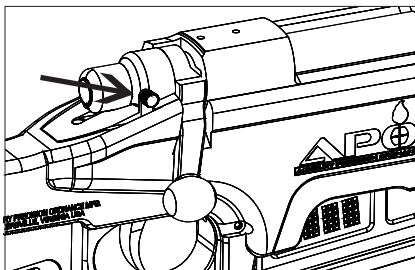


Figure 3 - Safety in FIRE Position

Fig 2 The safety lever is pulled completely to the rear into the "S" or on Safe position where you will feel a distinct click and the safety is engaged.

Fig 3 The safety lever is pushed completely forward into the "F" or Fire position and the rifle is ready to fire. The rifle's trigger can be pulled and the rifle fired with the safety mechanism off and in this position.

ENGAGING THE SAFETY ("S" / SAFE POSITION)

1. To engage the safety mechanism placing it in the "S" or on Safe position, pull safety lever fully to the rear position. (See Fig 2)
2. To unload the SABER M700 Rifle or inspect the chamber of the rifle, you must open the bolt, and that should be done with the safety lever in the "S" or on Safe position.

3. The safety mechanism is a mechanical device and can fail if the rifle is dropped, jarred or mishandled.
4. Always adhere to the rules of firearms safety even when your loaded rifle has the safety engaged. Even with the safety on, never point the muzzle at anything you do not intend to shoot.

DISENGAGING THE SAFETY ("F" / FIRE POSITION)

1. To disengage the safety mechanism and place it in the "F" or Fire position, push the safety lever to the fully forward position. (See Fig 3)



2. When the safety lever is in the **forward position** (see Fig 3) the rifle can be fired. Keep your finger outside of the trigger guards and do not touch the trigger while moving the safety.
3. The rifle should never be carried loaded with the safety lever in the "F" or Fire position.

SAFETY FUNCTION CHECK

The safety function check is designed to test the safety features of the rifle in a static situation, at a safe location without live ammunition. It demonstrates that the safety and all mechanical interfaces operate properly as designed.

1. Point the muzzle in a safe direction.
2. Physically and visually ensure rifle magazine is removed and the chamber is clear of live ammunition.
3. Close the bolt on the rifle on an empty chamber.
4. Place the rifle's safety lever into the "S" or on Safe position squeeze the trigger. The firing pin striker should not release.
5. Without opening the bolt, place the rifle's safety lever into the "F" or Fire position. The firing pin still must not release.
6. **Note:** This observation verifies that the trigger squeeze given in step 4 did not "stage" the firing pin to release when the safety is taken off.
7. Again squeeze the trigger and this time the firing pin will release and an audible "snap" will be heard as the firing pin is released.
8. If any part of the safety function check fails, contact the Ashbury Precision Ordnance Service Department for inspection and repair.

TECHNICAL SPECS - SABER M700 PRECISION RIFLE

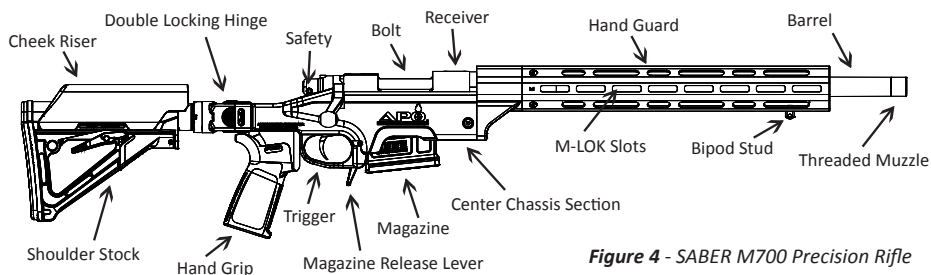


Figure 4 - SABER M700 Precision Rifle

1.	Caliber(s)	.308 Winchester and 6.5 Creedmoor
2.	Action	Remington Model 700 Short Action
3.	Bolt	M700 Short Action Bolt 2-Lug
4.	Trigger	Remington X-Mark Pro Adjustable
5.	Safety	Tang Mounted, Lever Activated Trigger Block
6.	Barrel	Carbon Steel / 20 inch / 1:10 Twist / .308Win <i>or</i> Carbon Steel / 22 inch / 1:8 Twist / 6.5 Creedmoor
7.	Threaded Muzzle	5/8-24 TPI w/Protective Thread Cap
8.	Rifle Chassis	SABER MRCS-AR Modular Rifle Chassis System
9.	Shoulder Stock	Magpul CTR with ¾" Cheek Riser
10.	Buffer Tube	Carbine Length Mil-Spec 1.148" x 7.125"
11.	Length of Pull	Adjustable 6-Position
12.	Stock Joint	Double Locking Hinge (Tension Adjustable)
13.	Center Chassis Section	SABER RSA-A3
14.	Magazine	Detachable Box Magpul PMAG 5 762AC (5-rd) <i>Optional:</i> Magpul PMAG 10 762AC (10-rd)
15.	Magazine Release	Ambidextrous Paddle Lever
16.	Hand Grip	Magpul MOE
17.	Grip Angle	17.5° standard, <i>Optional:</i> 11° and 27°
18.	Hand Guard	AR-08 Octagonal Alloy w/M-LOK, <i>Optional:</i> Composite Sporter, Quattro Alloy, Quattro Carbon Fiber
19.	Accessory Mount	M-LOK Accessory Attachment System
20.	Bipod Attachment	Hand Guard Stud
21.	Finish	M700 Barreled Action – Black Phosphate Coating SABER MRCS-AR Rifle Chassis – Black Hard Anodized
22.	Length	308 - OAL Extended 42" / OAL Folded 29 3/4" 6.5CM - OAL Extended 44" / OAL Folded 31 3/4"
23.	Weight	Approx. 9.5 lbs

OPTIONS		
24.	Scope Base	<i>Optional:</i> 20 MOA Picatinny Receiver Rail 5.5" inch #6-48 Monolithic 20 MOA Picatinny Rail 20 inch #8-40
25.	SABER Ergonomic Shoulder Stock(s)	<i>Optional:</i> Ergonomically Adjustable SABER HTA, TASS or PBA-H w/ Premium Limbsaver Recoil PadW
26.	Muzzle Brake	<i>Optional:</i> APO muzzle brake

BOLT ACTION RIFLE FUNCTION

The SABER M700 rifle is a bolt-action repeating rifle that operates by lifting the bolt handle upward, pulling the bolt rearward and then sliding the bolt forward and rotating the bolt downward until it stops. This process takes a cartridge from the magazine and loads it into the rifles chamber for firing. A manually controlled safety mechanism prevents or permits operation of the trigger to fire the rifle.

CYCLE OF FUNCTIONING

It is commonly thought that the cycle of functioning pertains to semi-automatics and automatics, but in reality all repeating rifles have a cycle of operation and understanding it can greatly improve the user's ability to reduce malfunctions and keep the rifle operating. There are 8 steps in the cycle and since the rifle is first loaded with a full magazine, that is the starting point with the bolt open and fully pulled to the rear.

Step #1 - Feeding

The cartridge is held in the magazine with the top of the case rising above the lips of the magazine. The loaded magazine is inserted into the magazine well until the magazine lever "clicks" and a tug on the magazine confirms it to be fully locked in place. As the bolt is pushed forward and the top cartridge is contacted by the bottom edge of the bolt nose, the cartridge starts sliding forward, towards the chamber. At this point feeding begins.

Step #2 - Chambering

Chambering is the act of the cartridge leaving the magazine and entering the chamber. Once the cartridge has moved far enough forward it comes out from between the lips of the magazine and is pushed up the feed ramp into the chamber. When the cartridge reaches the front of the chamber it comes to rest. The cartridge is now chambered.

Step #3 - Locking

As the bolt continues forward the extractor rides over the rim of the cartridge case and the ejector is being compressed. Once this is completed, the face of the bolt comes to rest against the rear of the cartridge case. The bolt handle is then pushed forward and turned down until it comes to rest against the side of the action. This rotation causes the locking lugs of the bolt to engage with the integral abutments of the receiver. The action is now locked.

Step #4 - Firing

Squeezing the trigger rearward pulls the trigger from under the sear bar & allows the firing pin to move forward, impacting the cartridge primer. As the primer detonates it blows hot gases into the combustion chamber of the cartridge case, igniting the propellant powder. At this time firing has taken place. The bullet travels down the bore until it leaves the muzzle. The user releases the trigger and lifts the bolt handle.

Step #5 - Unlocking

Unlocking is simply the lifting of the bolt handle which rotates the bolt locking lugs out of engagement with the integral lugs in the receiver.

Step #6 - Cocking

Cocking also takes place as the bolt handle rotates the bolt counter clockwise which draws the firing pin striker back to the cocked position.

Step #7 - Extracting

Extracting takes place when the extractor claw, which is grasping the base rim of the empty cartridge case, pulls it out of the chamber as the bolt is being pulled to the rear. Extracting continues until the front of the empty case clears the front edge of the ejection port. *Extracting is the act of removing the cartridge from the chamber.*

Step #8 - Ejecting

Ejection occurs when the front of the cartridge case clears the front of the receiver ejection port allowing the ejector spring to push the ejector into the base of the case. As the case starts to move, it is still held by the extractor causing the case to pivot out of the ejection port, throwing it free of the rifle as the bolt is retracted. *Ejecting is the act of removing the cartridge from the rifle.*

OPERATING THE SABER MODULAR RIFLE CHASSIS SYSTEM

SABER MRCS-AR MODULAR RIFLE CHASSIS SYSTEM

The patented SABER MRCS-AR rifle chassis system is completely modular, adjustable and maintainable by the user with simple hand tools. The MRCS-AR rifle chassis is compatible with many AR accessories and also forward compatible with numerous SABER chassis components and accessories.

SHOULDER STOCK ASSEMBLY

The SABER M700 Rifle utilizes a Magpul CTR butt stock that is installed on a carbine length 6-position Mil-Spec (1.148" x 7.125") buffer tube. The shoulder stock can be retracted and locked into position to adjust the length of pull. A $\frac{3}{4}$ " Cheek Riser is attached to the shoulder stock to provide increased comb height to properly use a rifle scope. Optional SABER ergonomically adjustable shoulder stocks are available from Ashbury.

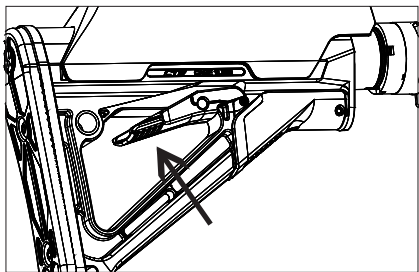


Figure 7 - CTR LOP Adjustment Lever

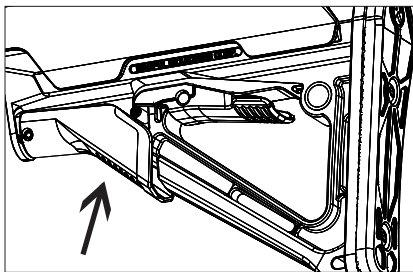


Figure 8 - CTR LOP Locking Mechanism

CTR Shoulder Stock Length of Pull (LOP) Adjustment

1. Point the muzzle of the rifle in a safe direction, remove the magazine and insure both physically and visually that the chamber is clear of live ammunition.
2. Place the rifle with the CTR Shoulder Stock extended in front of you on a clear, stable flat surface.
3. Grasp the CTR Shoulder Stock by the top buffer tube housing and with your fingers depress the stock LOP release lever.
4. With the lever depressed you can move the CTR shoulder stock fore and aft to one of the six (6) pre-set positions on the buffer tube.
5. Once set into one of the six pre-set buffer tube positions, engage the CTR lock mechanism which is found forward of the LOP release lever. This locks the CTR Shoulder Stock length of pull (LOP) into place.

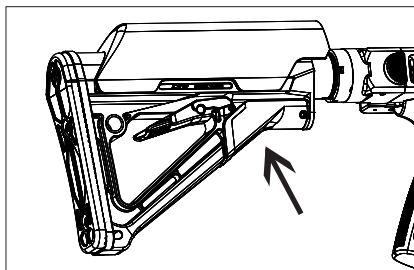


Figure 9 - CTR LOP Locked

For safety of use, the rifle should only be fired when the shoulder stock is locked into place and provides the correct length of pull and eye relief from the rifle scope.

Double Locking Hinge

The shoulder stock assembly is attached to the Center Chassis Section using a Double Locking Hinge. The hinge locks securely in both the extended and folded positions. The rifle should only be fired with the shoulder stock extended, and hinge in the locked position.

Folding the Shoulder Stock

To fold the shoulder stock from the extended position, the large unlock button on the side of the hinge is depressed and held.

The shoulder stock can now be folded against the left side of the rifle moving it in a clockwise direction. You will hear an audible click when it locks against the side of the rifle.

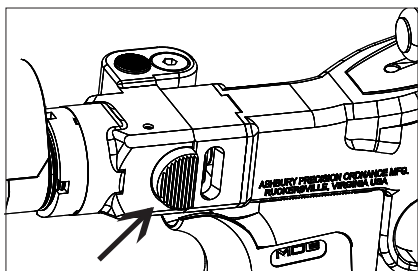


Figure 10 - Large Unlocking Button

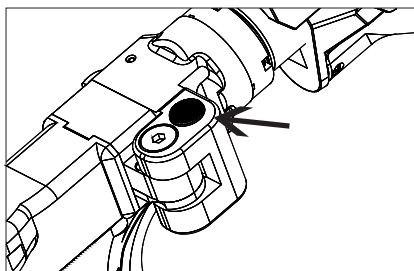


Figure 11 - Small Unlocking Button

Unfolding the Shoulder Stock

1. To extend the shoulder stock from the folded position, depress the small unlocking button on top of the hinge joint
2. Pull the shoulder stock around counter-clockwise until it locks into place in the extended position. You will hear an audible click when it locks into place.

Adjusting Hinge Tension

On the underside of the Double Locking Hinge there are two tension adjustment screws that allow you to adjust the tension on the opening and closing of the hinge. At the factory they are adjusted to provide moderate tension. However, over time with use, they may loosen. **Note:** A small amount of thread locker will secure the screws from loosening.

1. To tighten the two tension screws use a 3/32" hex wrench and adjust them both equally to your preferred tightness.

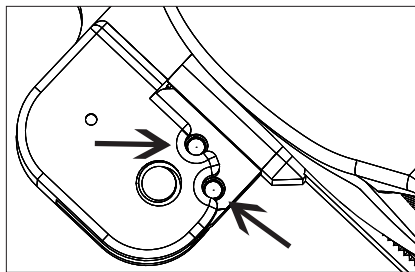


Figure 12 - Hinge Tension Adj Screws

2. To loosen the two tension screws use a 3/32" hex wrench and adjust them equally.

CENTER CHASSIS SECTION

The Center Chassis Section of your rifle is precision engineered to mount the short or long Remington M700 bolt action receivers. The magazine release lever is located in front of the trigger guard and to the rear of the magazine well. The magazine well holds the detachable box magazine in the rifle.

Center Chassis Sections

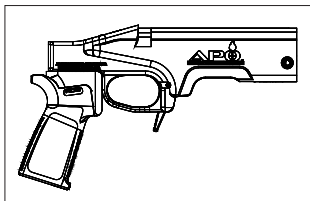


Figure 13 - RSA-A3

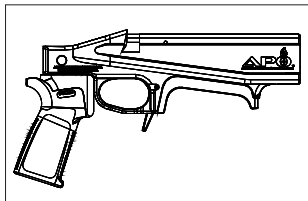


Figure 15 - RLA-A1B

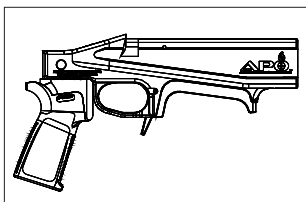


Figure 14 - RLA-A1A

Magazine Release Lever

The Paddle Lever magazine release is operated by a “push forward” to release. This unlocks the detachable box magazine and allows it to be removed from the rifle.

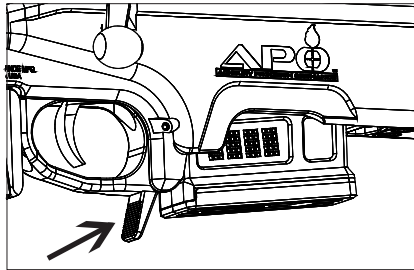


Figure 16 - Magazine Release Lever

Hand Grip Distance to Trigger Adjustment

1. To adjust the Grip-to-Trigger distance, remove the base of the hand grip with the tip of a cartridge or like item.
2. Set the base to the side. Using a 3/16" long handle hex wrench loosen the grip screw.
3. When the Grip Angle Adapter begins to separate from the Center Chassis Section teeth, it can then be moved fore and aft for adjustment. Place it to the desired position that best fits your hand and lock the teeth in place by tightening the hand grip screw. Hand-tighten taking care not to over tighten the screw.

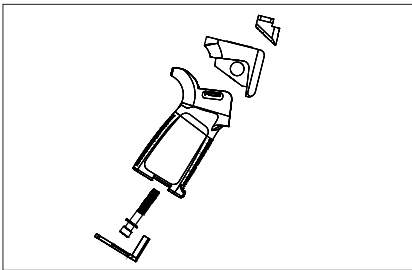


Figure 17- Hand Grip Screw Loosen

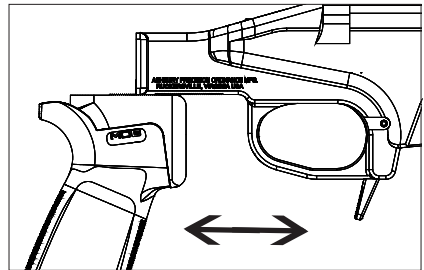


Figure 18 - Hand Grip Distance Adj

4. Replace the base of the hand grip.

Hand Grip Angle Adapter

1. To change the Hand Grip Angle adapter from 17.5°, remove the base of the hand grip with the tip of a cartridge or like item.
2. Set the base to the side. Using a 3/16" long handle hex wrench to loosen the grip screw until the grip can be pulled free from the Chassis Center Section.

3. When the Hand Grip and Grip Angle Adapter are detached, select the preferred grip angle.

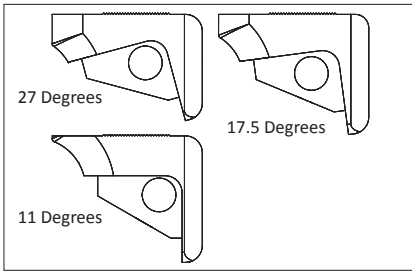


Figure 19 - Grip Angle Adapters

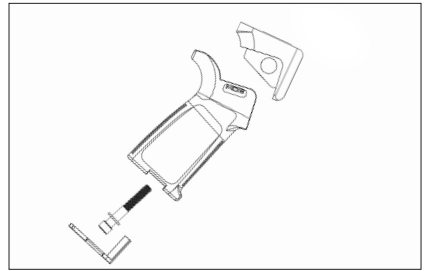


Figure 20 - Grip Angle Install

4. Remove the existing Grip Angle Adapter from the hand grip and press the newly selected Grip Angle Adapter into the hand grip, re-insert the grip screw, and tighten making sure the correct screw hole is used. Hand-tighten taking care not to over tighten the screw. **Note:** The fit between the hand grip and Grip Angle Adapter is extremely tight and the use of a non-marring hammer may be required to separate them.
5. Replace the base on the Hand Grip.

AR-08 HAND GUARD WITH M-LOK ACCESSORY ATTACHMENT SYSTEM

The AR-08 octagonal alloy hand guard is an innovative AR design that incorporates the M-LOK accessory attachment system. It provides the SABER M700 bolt action rifle with AR ergonomics, accessory compatibility, and functionality. **Note:** It is only compatible with other SABER forends and hand guards.

Bipod Attachment

On the lower end of the hand guard there is a stud located at the 6 o'clock position. You can attach a bipod or sling to this mounting point.

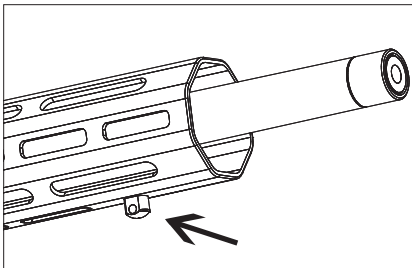


Figure 21 - Hand Guard Bipod Stud

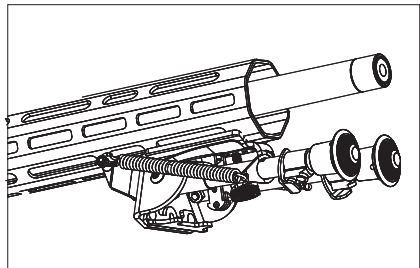


Figure 22 - Bipod Installed

M-LOK Accessories Attachment System

M-LOK is an accessories attachment technology developed by Magpul. It allows users to attach a wide range of accessories to a rifle to include Picatinny Accessory Rails, Sling Swivel Sockets, etc. For more information on the M-LOK Accessories Attachment System view the following video and documents:

<http://bit.ly/mlck-vid>

<http://bit.ly/mlck-faq>

<http://bit.ly/mlck-tips>

INSTALLING & REMOVING THE BOLT

IF ANY RESISTANCE IS FELT WHILE YOU ARE ATTEMPTING TO INSERT AND CLOSE THE BOLT IN THE RECEIVER – STOP! PULL THE BOLT REARWARDS AND CHECK THE RECEIVER BODY AND CHAMBER AREA FOR OBSTRUCTIONS.

INSTALLING THE BOLT

1. Point the muzzle of the rifle in a safe direction, remove the magazine and ensure both physically and visually that the chamber is clear of live ammunition.
2. Installing the bolt can be done with the shoulder stock assembly folded or extended. You will have a better view of the receiver if the shoulder stock is folded to the side.
3. Place the safety mechanism of the SABER M700 Rifle in the “S” or on Safe position.
4. Orient the bolt handle to point in approximately the 2 o'clock direction; align the

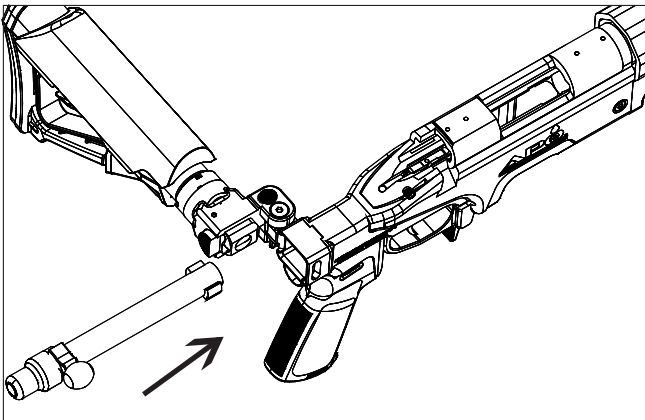


Figure 23 - Bolt Lugs Oriented into Receiver Raceway

lugs at the front of the bolt with the receiver raceway.

5. Slide the bolt forward into the receiver. (Fig 23)
6. To close the bolt once it is pushed all the way into the receiver, rotate and push the handle downward until it stops at the bottom of the bolt channel notch.
7. After installing the bolt, cycle the bolt all the way to the rear to ensure the bolt retention/release function is working. Take care not to intentionally engage the release lever. If the bolt comes out of the receiver and the bolt stop is not working, contact the Ashbury Precision Ordnance Service Department for assistance.

REMOVING THE BOLT

1. Always point the muzzle in a safe direction.
2. Place the safety mechanism of the SABER M700 in the "S" or on Safe position.
3. Do not touch the trigger while moving the safety mechanism into the "S" or on Safe Position. Keep your fingers and objects outside of the trigger guard.
4. Raise and lift the bolt handle.
5. Pull the bolt all the way back to its furthest rearward point.
6. Turn the rifle over and look up inside the top of the trigger guard.
7. Locate the bolt release inside the trigger guard on the underside the SABER Center Chassis Section. It is in front of the trigger.

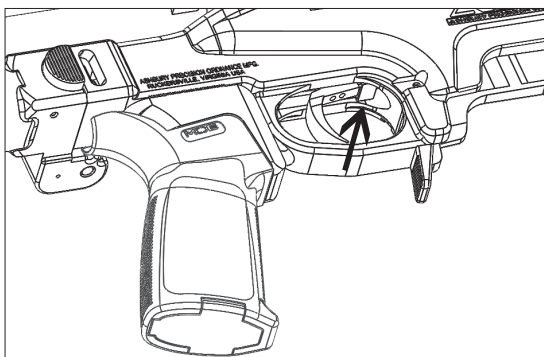


Figure 24 - Bolt Release Lever Location

8. Push, depress and hold the bolt stop release with your finger, releasing the bolt.
9. Slide the bolt out and away from the receiver.
10. Operation complete.

MOUNTING A SCOPE



BEFORE MOUNTING A SCOPE, SIGHT OR OTHER ACCESSORIES TO YOUR RIFLE, KEEP THE MUZZLE POINTED IN A SAFE DIRECTION; REMOVE THE MAGAZINE PLACE THE SAFETY MECHANISM IN THE "S" OR ON SAFE POSITION. OPEN THE BOLT AND PHYSICALLY AND VISUALLY MAKE CERTAIN YOUR RIFLE IS COMPLETELY UNLOADED. INSURE THERE IS NO LOADED AMMUNITION IN THE WORK AREA. FAILURE TO FOLLOW THESE WARNINGS COULD RESULT IN SERIOUS INJURY OR DEATH.

The top of the bolt action receiver is factory drilled and tapped for scope bases. The four scope base holes are sized #6-48 and are fitted with filler screws.

NOTICE

ALWAYS USE THE CORRECT SCOPE BASES FOR THIS RIFLE AND THE APPROPRIATE LENGTH SCREWS.

1. Place your rifle in a gun vise, maintenance cradle or on a clean, flat, stable surface with the top of the receiver oriented upward. Protect the finish of your rifle with clean rags or other padding.
2. Remove the bolt from the rifle as instructed on page 29.
3. You should have (short or long action) M700 compatible one- or two-piece style scope bases and four #6-48 screws of the correct length. **Note:** The one-piece short action scope base is 5.500" and the long action is 6.300" in length.
4. Remove all four filler screws from the top of the M700 receiver using a very small, thin-bladed gunsmithing-type screwdriver.
5. Clean all oil, grease or dirt from the receiver top, screw holes and from the scope base parts.
6. Pre-position the bases on the receiver top to determine the appropriate orientation of the scope base(s).
7. Insert the screws through the bases and screw them into the receiver top using the correct tool to fit the type of screw head.

Note: You must use screws of the appropriate length to ensure proper thread engagement. Once the scope base(s) are installed, check inside the receiver to verify that the base mounting screws are not too long and interfering with the operation of the bolt.

Note: Use a drop of thread locking compound to assure the screws stay tight. Make sure the thread locking compound does not get into the action. Be careful to assure that the threads of each screw engage properly in the receiver threads to prevent stripping the threads or cross threading going in the receiver.

8. Tighten the screws to the recommended torque, but do not over tighten.
9. Mount your scope rings and scope as outlined in the instructions supplied with your scope rings and/or scope.
10. Always ensure that your reticle is straight, and you have the proper eye relief from the rifle scope ocular.

AMMUNITION



ONLY USE FACTORY AMMUNITION OF THE CALIBER INSCRIBED ON YOUR RIFLES BARREL. EXAMINE EVERY CARTRIDGE YOU PUT IN YOUR FIREARM TO ASSURE THAT ITS UNDAMAGED, CLEAN AND THE CORRECT CALIBER.

ASHBURY PRECISION ORDNANCE WILL NOT WARRANTY ANY DAMAGES OR BE LIABLE FOR INJURIES OR DEATH(S) DUE TO THE USE OF FAULTY, NON-STANDARD OR IMPROPERLY HAND-LOADED AMMUNITION.

AMMUNITION CONTAINS LEAD. HAVE ADEQUATE VENTILATION AT ALL TIMES WHILE FIRING AND WASH YOUR HANDS THOROUGHLY AFTER HANDLING.

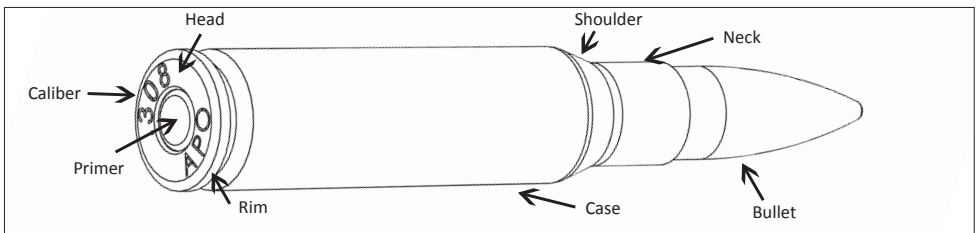


Figure 25 - Cartridge Nomenclature (Centerfire Cartridge)

- Use only commercial grade ammunition in its original packaging that corresponds with the caliber of your rifle. The correct caliber is inscribed on the barrel of the rifle. You are responsible for selecting ammunition that meets industry standards and is appropriate in type and caliber.
- Never use wet, oily, corroded, bent, dented, damaged or waxed ammunition in your rifle.
- Never mix ammunition calibers.

- Never use reloaded, refurbished, hand-loaded, non-standard ammunition or ammunition of a different caliber in your rifle.
- Never leave ammunition unattended.
- Store ammunition separately from your rifle in a secure location.

LOADING THE RIFLE

The SABER M700 Rifle is a bolt action repeater that feeds cartridges from a detachable 5-rd box magazine when the manually operated turn bolt is cycled by hand. The SABER M700 can be loaded using several methods:

- Magazine
- Single Feed from Magazine
- Single Shot Block

Additional information on loading rifles can be located in the Remington Model 700 Owner's Manual.

FILLING THE DETACHABLE BOX MAGAZINE WITH CARTRIDGES

1. Orient the magazine so that the open end is up and the magazine feed lips are pointing towards the 3 or 9 o'clock direction in front of you.
2. Select the correct caliber cartridge and quantity from a box of factory ammunition.
3. Place a cartridge base first onto the magazine follower in the front of the box magazine. **Note:** Bullets are pointing to the front open end of the box magazine.
4. With downward pressure slide the cartridge rearward under the magazine feed lips until it stops against the rear of the magazine body.
5. Repeat step #4 until the magazine is full with five cartridges and are all seated against the back wall of the box magazine.

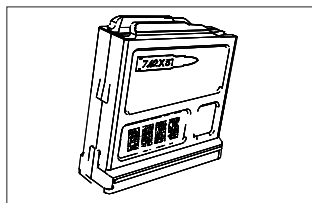


Figure 26 - Box Magazine

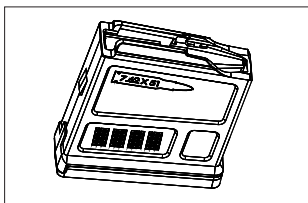


Figure 27 - Magazine Top

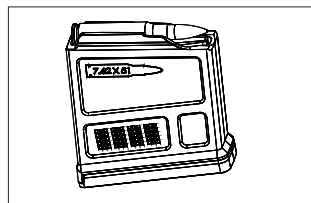


Figure 28 - Loaded Magazine

LOADING THE RIFLE FROM THE MAGAZINE

1. Point the muzzle of the rifle in a safe direction.
2. Insure that the correct ammunition is being loaded into the rifle.
3. Raise the bolt handle until it stops.
4. Place the rifle's safety mechanism in the "S" or on Safe position.
5. Pull the bolt handle completely to the rear.
6. Insert the magazine into the magazine well until you hear an audible click indicating the magazine has locked into place.
7. Push the bolt handle forward stripping a cartridge from the box magazine putting it into the rifle's chamber.
8. Push the bolt handle down until it stops in the bolt notch locking the cartridge into the rifles chamber.

**THE RIFLE IS NOW COCKED, LOADED AND READY TO FIRE.
KEEP FINGERS OUTSIDE OF THE TRIGGER GUARD.**

9. The rifle is now loaded with four cartridges in the magazine and a live cartridge in the chamber. The rifle is cocked with the safety mechanism in the "S" or on Safe position.

To Fill Magazine to Full 5rd Capacity

1. Continue to point the rifle's muzzle in a safe direction.
2. Push the magazine release lever forward and remove the box magazine from the rifle.
3. Insert one cartridge of the correct caliber, base first into the box magazine. Insure that all cartridges are seated to the rear of the magazine.
4. Re-insert the magazine into the rifle.
5. To fire the rifle, acquire the target and move the safety mechanism to the "F" or Fire position. Pull the trigger rearward and the rifle will discharge.

SINGLE SHOT LOADING THE RIFLE WITH AN INSERTED EMPTY MAGAZINE

1. Point the muzzle of the rifle in a safe direction.
2. Insure that the correct ammunition is being loaded into the rifle.
3. Raise the bolt handle until it stops.
4. Place the rifles safety mechanism in the "S" or on Safe position.
5. Pull the bolt handle completely to the rear.

6. Insert the empty magazine into the magazine well until you hear an audible click indicating the magazine has locked into place.
7. Place a single cartridge on top of the magazine with the bullet pointed towards the chamber.
8. Push the bolt handle all the way forward moving the cartridge from on top of the magazine into the rifles chamber.
9. Push the bolt handle down until it stops in the bolt notch locking the cartridge into the rifles chamber.

**THE RIFLE IS NOW COCKED, LOADED AND READY TO FIRE.
KEEP FINGERS OUTSIDE OF THE TRIGGER GUARD.**

10. The rifle is now loaded with an empty magazine and a live cartridge in the chamber ready to fire with the safety mechanism in the "S" or on Safe position.
11. To fire the rifle, acquire the target and move the safety mechanism to the "F" or Fire position. Pull the trigger rearward and the rifle will discharge.

SINGLE SHOT BLOCK LOADING THE RIFLE

1. Point the muzzle of the rifle in a safe direction.
2. Insure that the correct ammunition is being loaded into the rifle.
3. Raise the bolt handle until it stops.
4. Place the rifles safety mechanism in the "S" or on Safe position.
5. Pull the bolt handle completely to the rear.
6. Insert the Single Shot Block into the magazine well until you hear an audible click indicating the magazine has locked into place.
7. Place a single cartridge on top of Single Shot Block feed tray with the bullet pointed towards the chamber.
8. Push the bolt handle all the way forward moving the cartridge from on top of the feed tray into the rifles chamber.
9. Push the bolt handle down until it stops in the bolt notch locking the cartridge into the rifles chamber.

**THE RIFLE IS NOW COCKED, LOADED AND READY TO FIRE.
KEEP FINGERS OUTSIDE OF THE TRIGGER GUARD.**

10. The rifle is now loaded with a live cartridge in the chamber ready to fire with the safety mechanism in the "S" or on Safe position.
11. To fire the rifle, acquire the target and move the safety mechanism to the "F" or Fire position. Pull the trigger rearward and the rifle will discharge.

UNLOADING & CLEARING THE RIFLE

1. Point the muzzle of the rifle in a safe direction.
2. Place the rifles safety mechanism in the "S" or on Safe position.
3. Keep your fingers off the trigger and outside of the trigger guard.
4. Push the Paddle Lever Magazine Release forward to unlock the detachable box magazine from the rifle. (Fig 29)
5. Grasp the detachable box magazine and remove it from the rifle. (Fig 30)

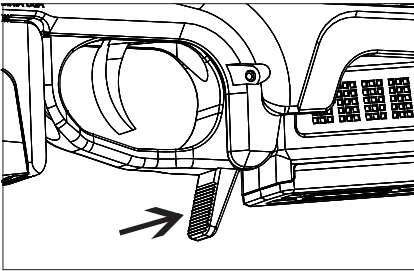


Figure 29 - Magazine Release Lever

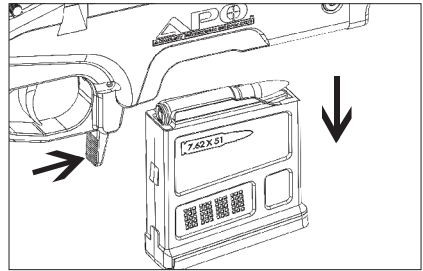


Figure 30 - Magazine Removal From Rifle

6. Lift the bolt handle until it stops. Pull it to the rear extracting and then ejecting the loaded or fired cartridge from the chamber.
7. Completely unload the detachable box magazine and place all unloaded ammunition back into the correct cartridge box.
8. Physically and visually confirm that the detachable magazine is completely unloaded and re-insert it into the rifle.
9. Physically and visually confirm that there is no live ammunition in the chamber or inside the receiver.
10. Where possible the bolt should be left open to indicate to others that the rifle is in a completely safe unloaded condition.

11. If the bolt is required to be closed, again confirm physically and visually that the chamber is empty.

Pull and hold the trigger while closing the bolt.

This action is typically taken for long term storage of the rifle.

Insert an empty magazine into the rifle last.

12. Put the rifle into a case or secure storage location separate from the ammunition.

FIRING THE RIFLE

The following sequence of activities will be of assistance when operating and firing the SABER M700 Rifle.

1. Point the muzzle of the rifle in a safe direction on a firing range.
2. Open the bolt and inspect the receiver to insure the chamber is empty and there are no obstructions.
3. Pull the safety mechanism into the "S" or on Safe position.
4. Insert a loaded magazine into the rifle with the proper caliber ammunition.
5. Close the bolt chambering a live cartridge.
6. Adjust the telescopic sight eyepiece to bring the reticle into sharp focus and adjust the parallax dial (if your rifle scope has one) to match the distance to your target.
7. Be sure of your target, backstop and what lies beyond it.
8. Put the reticle on the target and set the elevation and windage on the rifle scope as required.
9. Establish a stable firing position.
10. Push the safety mechanism to "F" or Fire position.
11. Aim at the target and pull the trigger.
12. Follow through and observe the target.
13. Confirm bullet impact.
14. Keep the reticle on target while cycling the bolt.
15. Reload and make ready for a follow on shot if required.

CYCLING THE BOLT

The following procedure is recommended to minimize disturbing the rifle and body during the firing sequence (right hand operations only).

1. To open the bolt, place the thumb of the right hand on top of the bolt shroud and grasp the bolt knob with the fingers of same hand.
2. Bring the fingers towards the thumb. If any resistance is felt during initial extraction of the fired case (primary extraction) increase upward pressure on the bolt handle with the fingers. Insure that the bolt handle is lifted fully upward until stopping.
3. Pull the bolt fully rearwards to eject the fired cartridge case and pickup of next round from the detachable box magazine.
4. Push the bolt firmly forward to feed next round into the chamber.
5. Push the bolt handle down until it stops in the bolt notch locking the cartridge into the rifles chamber.
6. Repeat the sequence for each round fired.

RELOADING THE RIFLE WITH A LOADED MAGAZINE

1. With the bolt pulled completely to the rear.
2. Place the safety mechanism in the "S" or on Safe position.
3. Remove the empty magazine by pushing the magazine release lever forward towards the muzzle.
4. Push and hold the magazine lever fully forward allows the magazine to drop free from the rifle.
5. Insert a loaded magazine.
6. Push the bolt firmly forward to feed next round into the chamber.
7. Push the bolt handle down until it stops in the bolt notch locking the cartridge into the rifles chamber.
8. The rifle is now reloaded and ready to continue firing.

BREAKING IN THE RIFLE BARREL

Individual rifle barrels, powder, primer, bullet combinations and number of rounds fired between cleaning vary widely which affects accuracy. Therefore breaking in your rifle's barrel is important. Barrel break-in is performed in order to smooth out any microscopic roughness in the bore that may occur after initial projectiles are shot through the barrel.

The first few rounds fired will typically leave an uneven and possibly excessive distribution of copper in the barrel bore which is why it is sometimes necessary to use copper solvent to remove it. Removal of all copper fouling may not be possible or necessary. See Cleaning the Rifle on page 53.

Barrel break-in should be conducted with standard copper jacketed projectiles. Break-in with specialty bullets is not recommended. To begin the break-in process of your barrel, perform the following steps.

BREAK-IN STEPS

1. Follow all firearms safety procedures.
2. Fire three (3) cartridges and then clean the barrel (use the cleaning instructions on page 53)
3. Visually inspect the barrel for fouling.
4. Fire three (3) additional cartridges and clean the barrel again.
5. Visually inspect the barrel for fouling.
6. Fire five (5) additional cartridges and clean the barrel again

It is recommended that you do not overheat your barrel, especially with a new barrel. Experience has shown that the bore becomes less prone to fouling over time and that accuracy may increase as this occurs.

DISASSEMBLY



BEFORE DISASSEMBLING YOUR RIFLE, KEEP THE MUZZLE POINTED IN A SAFE DIRECTION; REMOVE THE MAGAZINE PLACE THE SAFETY MECHANISM IN THE "S" OR ON SAFE POSITION. OPEN THE BOLT AND PHYSICALLY AND VISUALLY MAKE CERTAIN YOUR RIFLE IS COMPLETELY UNLOADED. ENSURE THERE IS NO LOADED AMMUNITION IN THE WORK AREA. FAILURE TO FOLLOW THESE WARNINGS COULD RESULT IN SERIOUS INJURY OR DEATH.

The SABER M700 Rifle is built on the patented SABER modular rifle chassis system and as such can be easily be maintained and reconfigured by the user. The below procedures can be used to disassemble the rifle. Further disassembly should only be done by the Ashbury Precision Ordnance Service Department.

SHOULDER STOCK REMOVAL

The CTR Shoulder Stock can be removed for repair or replacement with other carbine length AR shoulder stocks. Optionally users can also select any of the three (3) SABER ergonomically adjustable shoulder stocks as a replacement. See the Accessories section on page 62.

1. Point the muzzle of the rifle in a safe direction, remove the magazine, bolt and insure both physically and visually the chamber is clear of live ammunition.

2. Using a gun vise or rifle maintenance cradle, securely place the rifle upside down in the fixture with the shoulder stock extended securing it in place. (Fig 31)

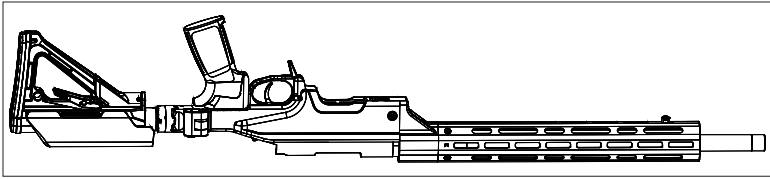


Figure 31 - SABER M700 Upside-Down

3. Locate the release lever on the CTR shoulder stock and note that it is spring loaded and when you push down on the lever it returns to its original position. (Fig 32)

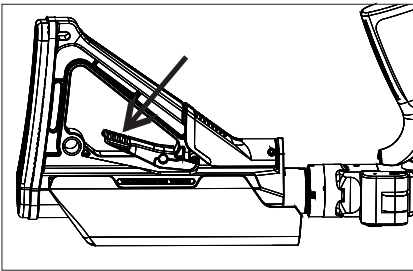


Figure 32 - CTR Release Lever

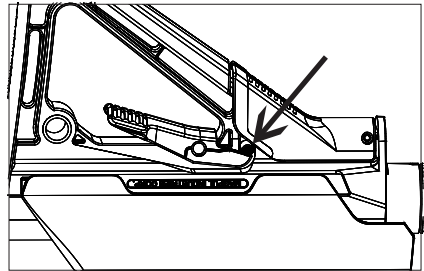


Figure 33 - CTR Release Lever Crosspin

4. On the opposite end of the lever you will see a crosspin that extends out from each side of the mechanism. When you press on the release lever, the cross pin moves upward. (Fig 33)
5. With one hand pushing down on the CTR release lever, use your other hand to pull up on the spring loaded cross pin. **Note:** The spring is very strong and this action will require some strength to pull it further upwards.

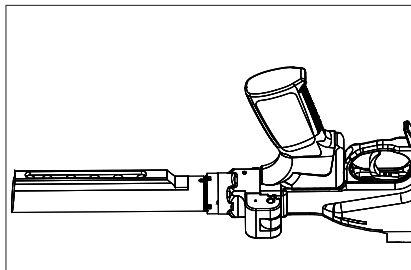


Figure 34 - CTR Shoulder Stock Removed

6. While doing both actions at the same time, use your hand pressing down on the release lever to slide the CTR shoulder stock off of the Buffer Tube. This will take a bit of effort and hand coordination.

7. At this time you can replace, repair or set the shoulder stock aside as you perform other actions on the rifle.

BUFFER TUBE & HINGE SUB-ASSEMBLY REMOVAL

1. Point the muzzle of the rifle in a safe direction, remove the magazine, bolt and insure both physically and visually the chamber is clear of live ammunition.
2. Using a gun vise or rifle maintenance cradle, securely place the rifle chassis right side up in the fixture with the shoulder stock extended securing it in place.

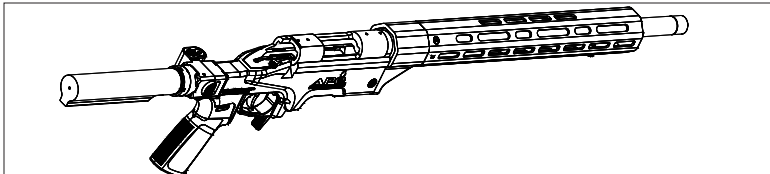


Figure 35 - SABER M700 Upright

3. Open the Double Locking Hinge located at the end of the Buffer Tube by pressing the large half circle button in and rotate the buffer tube assembly to the 9 o'clock position. (Fig 36)
4. With the Double Locking Hinge open you will see a 5/32" long handle hex screw. Using a long handle hex wrench loosen and remove this screw. **Note:** This screw is stiff and requires constant hex wrench pressure.

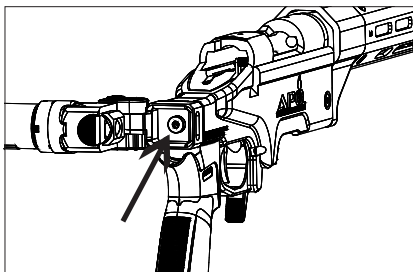


Figure 36 - Double Locking Hinge Internal View

5. Remove the screw and the double locking hinge and the buffer tube assembly will detach from the Center Chassis Section.
6. At this time you can replace, repair or set the buffer tube assembly aside as you perform other actions on the rifle.

AR-08 HAND GUARD

The AR-08 hand guard is one of several modular hand guards available for Ashbury's line of SABER modular rifle chassis. To remove the hand guard to access the barreled action in the Center Chassis Section, or to replace the hand guard the below procedures can be used. See the Accessories section on page 62.

1. Point the muzzle of the rifle in a safe direction, remove the magazine, bolt and insure both physically and visually the chamber is clear of live ammunition.
2. Using a gun vise or rifle maintenance cradle, securely place the rifle chassis upside down in the fixture where the hand guard mounting screws are visible.

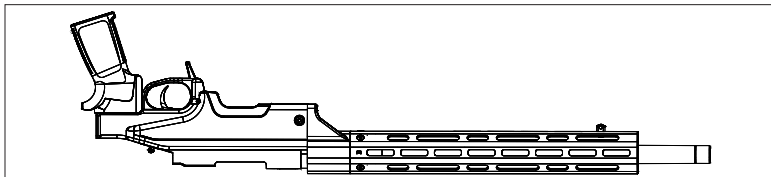


Figure 37 - SABER M700 Upside-Down

3. The hand guard attachment screws can be identified as **the pair of 3/16"** screws positioned side by side in front of the magazine well. (Fig 38)

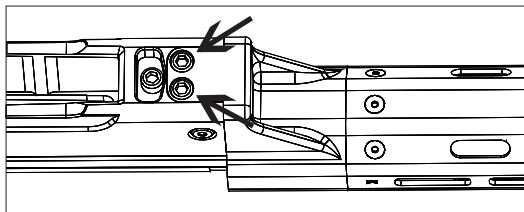


Figure 38 - Hand Guard Screws

4. Unscrew each of the two screws and place them securely to the side.
5. Next remove the two hand guard lock screws located on both the left and right side of the Center Chassis using a 1/8" hex wrench. Place the screws securely to the side. (Fig 39)

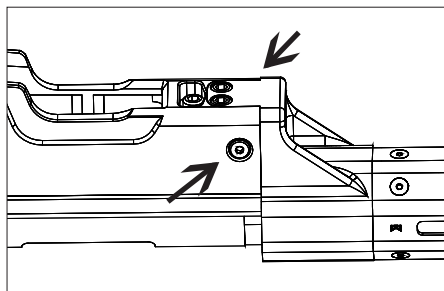


Figure 39 - Hand Guard Screws

6. The AR-08 hand guard is fitted to the Center Chassis Section. Lift the hand guard from the maintenance cradle, grasping the hand guard in one hand and the Center Chassis Section with the barreled action in the other and carefully pull them apart separating them into two pieces.

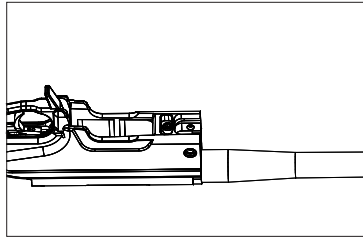


Figure 40 - Hand Guard Removed

7. At this time you can replace, repair or set the AR-08 hand guard aside as you perform other actions on the rifle.

BARRELED ACTION DISASSEMBLY FROM CENTER CHASSIS SECTION

The Center Chassis Section is one many modular precision engineered bolt action receiver mounts available for Ashbury's line of SABER modular rifle chassis. To remove the barreled action from the Center Chassis Section for maintenance, cleaning or repair, the below procedures can be used.

1. Point the muzzle of the rifle in a safe direction, remove the magazine, bolt and ensure both physically and visually the chamber is clear of live ammunition.
2. Using a gun vise or rifle maintenance cradle, securely place the rifle upside down in the fixture where the action mounting screws are visible.

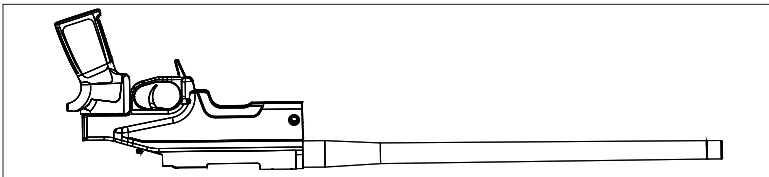


Figure 41 -Barreled Action / Center Section

3. The action mounting screws can be identified as the two 3/16" screws positioned to the front and rear magazine well.

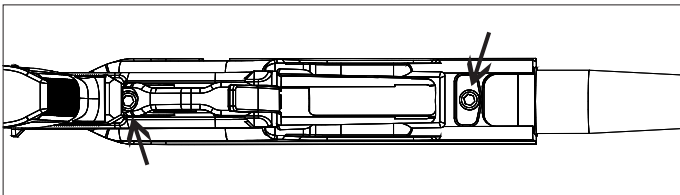


Figure 42 - Action Mounting Screws

4. Unscrew each of the two screws and place them securely to the side. Note that they are different lengths with the short screw used in the tang and the long screw used in the front of the action.

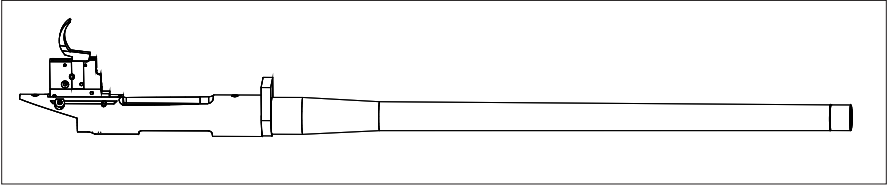


Figure 43 - Barreled Action Separated from Center Chassis Section

5. At this time you can clean, repair or set the barreled action aside as you perform other actions on the rifle.

REASSEMBLY

The re-assembly of the SABER M700 Rifle is a logically sequenced procedure. The below procedure can be used to re-assemble the rifle.

RE-ASSEMBLING THE BARRELED ACTION INTO THE CENTER CHASSIS SECTION

To reinstall the barreled action into the Center Chassis Section the below procedures can be used.

1. Point the muzzle of the rifle in a safe direction, remove the magazine, bolt and insure both physically and visually the chamber is clear of live ammunition.
2. Using a gun vise or rifle maintenance cradle, securely place the barreled action upside down in the maintenance cradle so that the action mounting screw holes are visible.

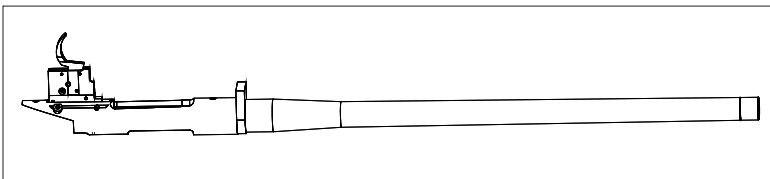


Figure 44 - Barreled Action Upside-Down

3. The action mounting screws can be identified as the two 3/16" screws positioned to the front and rear magazine well.
4. Insert the short screw in the tang screw hole next to the trigger guard and the long action screw in the action screw hole in front of the magazine well. **Note:** Do not mix up the screws and the correct hole location or the bolt action receiver will not work properly.

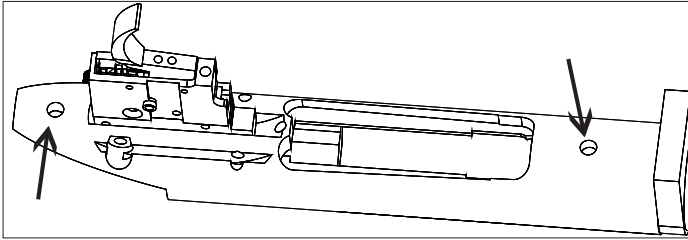


Figure 45 - Action Mounting Screws

5. The barreled action can now be screwed together with the Center Chassis Section. Starting with the front action screw, alternately tighten the screws with a long handle 3/16" hex wrench until tight. Then use a torque wrench to torque each to 65 in/lbs in the same manner.
6. At this time you can proceed to re-assemble the AR-08 hand guard.

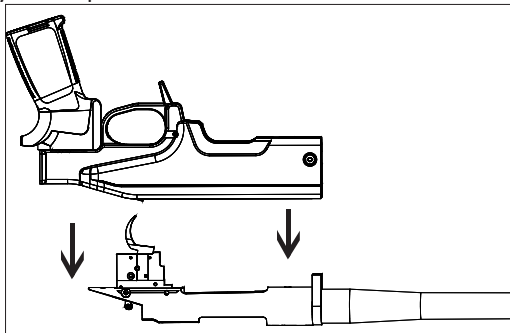


Figure 46 - Barreled Action Together Center Chassis Section

RE-ASSEMBLING AR-08 HAND GUARD

To re-assemble the AR-08 hand guard onto the SABER MRCS-AR Center Chassis Section the below procedures can be used.

1. Point the muzzle of the rifle in a safe direction, remove the magazine, bolt and insure both physically and visually the chamber is clear of live ammunition.
2. Slide the AR-08 hand guard on to the rifle's barrel towards the Center Chassis Section.

3. Using a gun vise or rifle maintenance cradle, securely place the barreled action with Center Chassis Section attached upside down in the fixture so that the hand guard mounting screws holes are visible.

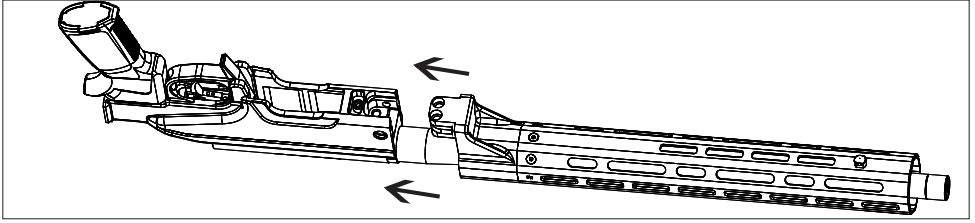


Figure 47 - SABER M700 Upside-Down

4. The hand guard attachment screw holes on the Center Chassis Section can be identified as the pair of 3/16" screw holes positioned side by side in front of the magazine well. They match up with corresponding holes in the AR-08 hand guard lug. (Fig 48)

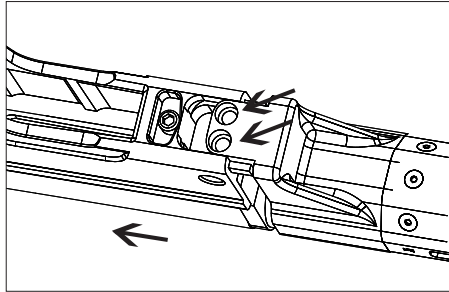


Figure 48 - Hand Guard Lug Screw Holes

5. The AR-08 hand guard should carefully be pushed into the bayonet type lug mount that is fitted to the Center Chassis Section. (Fig 49)

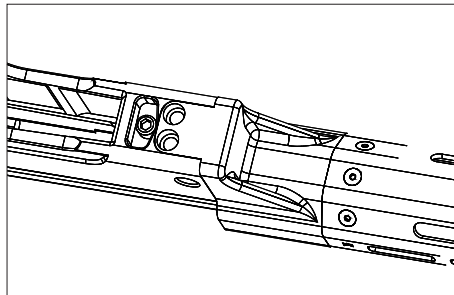


Figure 49 - Center Chassis Section Hand Guard Screw Holes Aligned

6. Screw each of the two screws into the Center Chassis Section holes by hand and with a long handle 3/16" hex wrench, bottom them out and back them off one complete turn.

7. Next, screw the two hand guard lock screws snugly on both the left and right side of the Center Chassis, ensuring that the hand guard is straight using a long handle 1/8" hex wrench. (Fig 50)

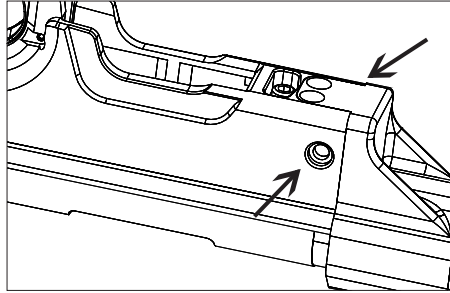


Figure 50 - Hand Guard Screws

8. Bottom them out and back them off one complete turn. Then torque them each to 45 in/lbs.
9. Return to the two primary 3/16" hand guard screws bottom them out and with a torque wrench torque them each to 65 in/lbs.
10. At this time you can proceed to re-attach the buffer tube Double Locking Hinge assembly.

BUFFER TUBE & HINGE RE-ASSEMBLY

1. Point the muzzle of the rifle in a safe direction, remove the magazine, bolt and insure both physically and visually the the chamber is clear of live ammunition.
2. Using a gun vise or rifle maintenance cradle, securely place the barreled action in the Center Chassis Section and hand guard right side up in the fixture.

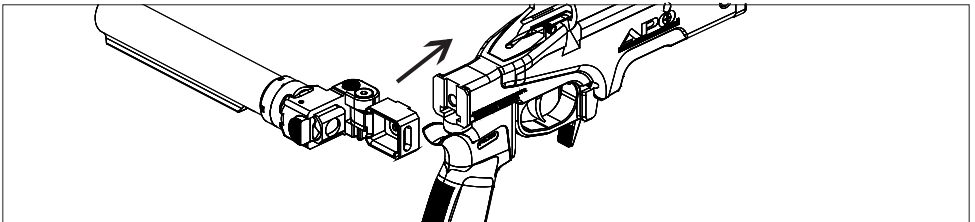


Figure 51 - SABER M700 Upright

3. With the Double Locking Hinge open, insert the male end into the corresponding female Center Chassis Section slot behind the trigger guard. (Fig 51)

4. With the Double Locking Hinge open you will see a screw hole for a 5/32 hex screw. Insert the screw and start it into the threads by hand.

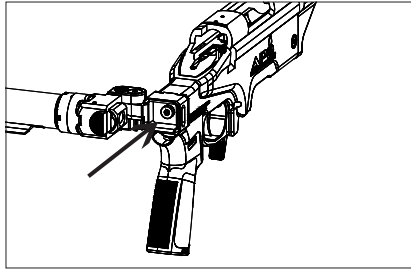


Figure 52 - Double Locking Hinge Internal View

5. Using a long handle hex wrench tighten this screw until tight and then using a torque wrench tighten to 65 in/lbs.
6. At this time you can proceed to re-attach the shoulder stock.

SHOULDER STOCK RE-ASSEMBLY

1. To re-assemble the CTR Shoulder Stock onto the rifle the following procedures can be used.
2. Point the muzzle of the rifle in a safe direction, remove the magazine, bolt and insure both physically and visually the chamber is clear of live ammunition.

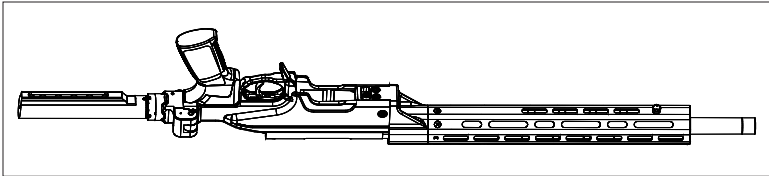


Figure 53 - SABER M700 Upside-Down

3. Using a gun vise or rifle maintenance cradle, securely place the rifle upside down in the fixture with the buffer tube extended securing it in place.

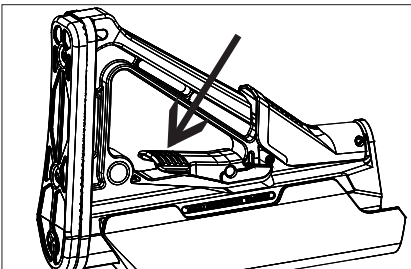


Figure 54 - CTR LOP Release Lever

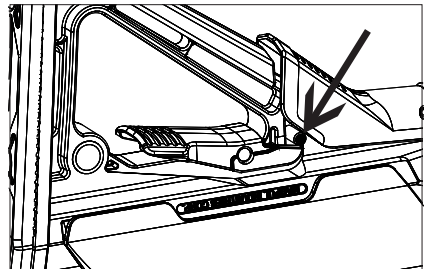


Figure 55 - CTR LOP Release Lever Crosspin

4. Locate the release lever on the CTR shoulder stock. Note that it is spring loaded and when you push down on the lever it returns to its original position. (Fig 54)
5. On the opposite end of the lever you will see the crosspin that extends out from each side of the mechanism. When you press on the release lever, the pins move upward. (Fig 55)
6. With one hand pushing down on the CTR release lever, use your other hand to pull up on the spring loaded pins. **Note:** the spring is very strong and this action will require some strength to lift it further upwards.

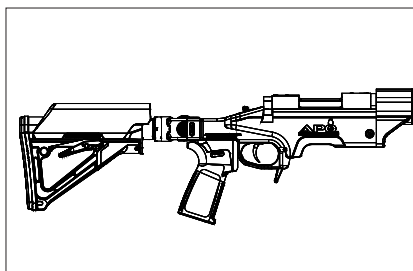


Figure 56 - CTR Shoulder Stock Re-Installed

7. While doing both actions at the same time, use your hand pressing down on the release lever to slide the CTR Shoulder Stock onto the Mil-Spec Buffer Tube. This will take a bit of effort and hand coordination.
8. Once the CTR Shoulder Stock is re-assembled you can set the appropriate length of pull.
9. At this time you have re-assembled the SABER M700 Rifle

RIFLESPORTS SHOOTING ACCESSORIES

RIFLE SCOPE

Fixed and variable power magnification rifle scopes with optical objective sizes ranging from 20mm to 56mm, with higher quality units having diopter, focus and parallax adjustments are very popular in RifleSports. You can choose from a wide range of illuminated and non-illuminated reticle patterns depending on your RifleSports activity. Elevation and windage adjustments are available in Minute of Angle (MOA) or Milliradian (MILS) and recommended to match reticles using subtention lines. Rifle scopes are available with 1", 30mm, 34mm and 35mm main body tubes. Ensure that your rifle scope objective clears the hand guard leaving a small gap when mounted.

SCOPE RINGS

Optical rifle scopes are mounted in scope rings that attach to the scope tube body. Scope

rings are manufactured in both aluminum alloy and steel. The scope ring size must match the scope body tube to provide a proper secure mount. Generally for use on the SABER M700 Rifle scope rings we recommend 1.125" to 1.500" in height so the scope objective clears the AR-08 hand guard.

SCOPE BASE

Scope bases are made as one-piece or two-piece units also from both aluminum alloy and steel with 0 to 30 MOA slope designs. Picatinny rail type one piece scope bases provide a range of eye relief adjustment and also allow the attachment of select accessories. Scope bases are attached to the receiver using four #6-48 screws. The SABER M700 Rifle short action uses a 5 ½ " one-piece scope base and the long action uses a 6.300" scope base. You can also use a longer SABER one-piece monolithic rail for co-linear mounting of rifle scopes and clip-on night vision and thermal imager weapon sights.

BIPOD

A bipod can be attached to the underside of the rifle's hand guard. It aids the user to keep the rifle stable and level when firing from a bench or other field firing positions.

ANTI-CANT DEVICE

The Anti-Cant Device attached to the rifle scope body or scope base, aids the user to keep the rifle level when in a firing position, as canting the rifle degrades accuracy when shooting.

ANGLE COSIGN INDICATOR (ACI)

The Angle Cosign Indicator (ACI) attached to the rifle scope body or scope base, aids the user to quickly determine the gravity distance to target when shooting in mountains and valleys (e.g. up and down angles)

SLING

A sling can be used with your rifle as a shooting stability aid and also to carry the rifle over your shoulder in the field.

MUZZLE BRAKE

Recoil reducing muzzle brakes can be fitted to the SABER M700 Rifles which have a 5/8-24 TPI threaded muzzle as a standard feature. Insure that the through hole is properly sized for the caliber of the rifle. Muzzle brakes and muzzle brake suppressor adapters are both compatible with this rifle.

SUPPRESSOR

Sound suppressors are designed as direct thread-on or using a muzzle brake adapter are compatible with the SABER M700 Rifle 5/8-24 TPI threaded muzzle.

CLEANING KIT

A complete rifle cleaning kit with a fixed or jointed cleaning rod of the correct caliber and bore guide for your rifle is a necessity. In addition to cleaning solvents, copper remover, oil lubricant, and grease you'll need cleaning patches, jags, bore brushes (bronze, stainless steel) and plastic tooth brushes. A small flashlight and basic tools are also very handy additions.

BALLISTIC SOFTWARE AND CALCULATORS

As your proficiency with the rifle grows and you become involved in different rifle sports, target engagement ranges will increase. A ballistic calculator provides ballistic solutions that allow you to accurately engage targets at extended ranges. There are ballistic software packages that run on ruggedized hand held computers (PDA's), smart phones and density altitude based ballistic calculators that require no batteries.

If you need assistance with selecting RifleSports accessories for your rifle please Ashbury's Customer Support and Inside Sales Department at

(434) 296-8600 x998

or shop online at THE ARMORY
Store.AshburyPrecisionOrdnance.com

RIFLE MAINTENANCE



BEFORE PERFORMING MAINTENANCE ON YOUR RIFLE, KEEP THE MUZZLE POINTED IN A SAFE DIRECTION; REMOVE THE MAGAZINE PLACE THE SAFETY MECHANISM IN THE "S" OR ON SAFE POSITION. OPEN THE BOLT AND PHYSICALLY AND VISUALLY MAKE CERTAIN YOUR RIFLE IS COMPLETELY UNLOADED. ENSURE THERE IS NO LOADED AMMUNITION IN THE WORK AREA. FAILURE TO FOLLOW THESE WARNINGS COULD RESULT IN SERIOUS INJURY OR DEATH.

SURFACE CLEANING

Dirt, mud, debris and even cleaning fluids will contaminate the surface of the rifle. The rifle chassis is coated with a Mil-Spec hard anodized finish and can be easily cleaned with a damp cloth. The barreled action is phosphate and can also be wiped clean with a damp cloth, then dried and the wiped down with a light coating of oil.

MAINTENANCE TOOLS

General maintenance on the SABER M700 rifle can be performed with the following hand tools:

- 1/16" long handle hex key wrench
- 1/8" long handle hex key wrench
- 3/32" hex key wrench
- Torque wrench set for 45 in/lbs. & 1/8" hex bit
- 3/16" long handle hex key wrench
- 5/32" long handle hex key wrench
- Torque wrench set for 65 in/lbs. & 3/16" hex bit
- Torque wrench set for 20 in/lbs. with bits for scope rings screws

FASTENER TIGHTENING SPECIFICATIONS

1.	SABER M700 Rifle Action Screws Front Action Screw 3/16" Hex ¼-28 x 1 ½) Rear Action Screw 3/16" Hex ¼-28 x ¾)	65 in/lbs
2.	AR-08 Hand Guard Mount Screws 3/16" Hex (1 ¼-28 x ½)	65 in/lbs
3.	Hand Guard Side Lock Screws 1/8" Hex (¼-28 x ½)	45 in/lbs
4.	Receiver Scope Rail #6-48 Screws	20 in/lbs
5.	Scope Ring Base Nuts	65 in/lbs
6.	Scope Ring Cap Screws	20 in/lbs
7.	Hand Grip Screw 3/16" Hex	Hand Tight per Mfg.
8.	Shoulder Stock Joint Screws (inside hinge joint) 5/32" Hex (5/16-18 x ½)	65 in/lbs
9.	Hinge Tension Screws 3/32" Hex	Preferred Tightness
M-LOCK Accessory Rails		
10.	For attaching metal accessories to metal hand guards	35 in/lbs
	For attaching polymer or metal accessories to polymer hand guards	15 in/lbs
	For attaching polymer accessories to metal hand guards	15 in/lbs
Optional SABER Rifle Chassis Accessories		
11.	Fixed Joint (external)	20 in/lbs
12.	HTA/TASS/PBA-H Recoil Pad Screws	40 in/lbs
13.	Adjustable Cheek Piece Screws	Hand Tight
14.	Monolithic Scope Rail #6-48 Screws	20 in/lbs
15.	Monolithic Scope Rail #8-40 Screws	20 in/lbs
16.	Butt Hook/Monopod Screw	20 in/lbs

VISUAL INSPECTION

It is a good practice to conduct a visual inspection of your rifle prior to shooting and when conducting routine maintenance. A general check list is provided below.

1. **External Rifle Surfaces**

Inspect all external surfaces and mechanisms for any signs of damage, dents, dings, cracks, rusted, corroded, bent or broken parts. Be aware of dirt or debris that may be lodged in the hand guard, magazine well, trigger guard and shoulder stock.

2. **Bolt Action Receiver**

Remove the bolt and inspect it for any signs of excessive wear, damage, dents, dings, cracks, rusted, corroded, bent or broken parts. Insure that the bolt travels freely, does not bind, lock and unlocks. Look inside the receiver and inspect the raceways to insure they are free of debris and have a light coating of grease. Insure that the bolt stop is functioning properly by locking and unlocking the bolt, then removing and re-inserting it into the rifle.

3. **Barrel**

Visually inspect the barrel externally and down the chamber and bore for any corrosion, dents, bulges, gouges, or excessive fouling (e.g. copper). Next push a dry patch down the bore to remove any excess lubrication left behind from a previous cleaning or long term storage. The muzzle crown should be inspected to ensure that no nicks or dings exist.

4. **Rifle Scope**

Inspect the rifle scope's ocular, and objective cleanliness. Check the diopter, focus and parallax mechanism to insure they are in good working order. For scopes with illuminated reticles this is also a good time to also check the battery power. Insure that the elevation and windage adjustment turrets set screws are tight along with all other fasteners.

5. **Magazine**

Inspect magazines to insure they are free of dirt and debris, that the feed lips are not bent, broken or damaged and that the follower moves freely up and down.

6. **Accessories**

Inspect the connection points for all accessories. Slings should adjust smoothly and be free of dirt and debris. Bipods should be checked to insure that all leg and adjustment functions work. If M-LOK accessories are being used on the hand guard all fasteners should be checked for appropriate tightness.

SAFETY FUNCTION CHECK

1. The safety function check is designed to test the safety features of the rifle in a static situation, in a safe location without live ammunition. It demonstrates that the safety and all mechanical interfaces operate as designed.

2. Point the muzzle in a safe direction.
3. Physically and visually ensure rifle magazine is removed from the rifle and the chamber is clear of live ammunition.
4. Close the bolt on the rifle.
5. Place the rifle's safety lever into the "S" or on Safe position and with the bolt closed, squeeze the trigger. The firing pin striker should not release.
6. Without opening the bolt, place the rifle's safety lever into the "F" or Fire position. The firing pin still must not release. (this observation verifies that the trigger squeeze given in step 4 did not "stage" the firing pin to release when the safety is taken off.
7. Again squeeze the trigger and this time the firing pin will release and an audible "snap" will be heard of the firing pin release.
8. If any part of the safety function check fails, return the rifle to Ashbury Precision Ordnance Service Department for inspection and repair.

TROUBLESHOOTING

If the rifle, magazine(s) and ammunition are kept clean, maintained correctly and in good working order, few stoppages or problems should occur. However, should you encounter a situation where the rifle does fail to fire or operate properly the following actions can be taken to remedy the situation and get the rifle back into operation. Practice all rules of firearms safety.

Malfunction		Cause	Corrective Action
1.	Failure to Chamber and Lock Bolt Closed	1. Damaged cartridge 2. Dirty or obstructed chamber	1. Remove & replace cartridge 2. Clean chamber
2.	Failure to Feed	1. Magazine not inserted properly	1. Remove magazine, visually inspect, re-insert & lock into place 2. Magazine dirty or damaged
3.	Failure to Fire	1. Defective ammunition (primers dented in center of sufficient depth to fire) 2. Misfire 3. Hang fire 4. Light primer strike 5. Firing pin or firing pin spring broken or damaged 6. Bolt handle not down fully	1. Replace ammunition 2. Reference A, Page 48 3. Reference B, Page 48 4. Reference C, Page 48 5. Return complete bolt assembly for repair 6. Ensure bolt handle is down fully

4.	Squib Round (Pop & No Kick)	1. Cartridge fires but projectile does not have enough velocity to exit the barrel.	1. Reference D, Page 49
5.	Failure to Extract	1. Broken or worn extractor 2. Broken or worn extractor spring 3. Extractor not moving freely 4. Dirty ammunition or chamber 5. Broken case rim	1. Replace extractor 2. Replace extractor spring 3. Clean extractor, extractor spring & recess 4. Clean chamber & ensure ammunition is clean 5. Clear with cleaning rod
6.	Failure to Eject	1. Broken or worn ejector 2. Broken or worn ejector spring 3. Ejector not moving freely	1. Replace ejector 2. Replace ejector spring 3. Clean ejector, ejector spring and recess
7.	Very Hard Recoil	1. Faulty or over pressure ammunition 2. Muzzle brake missing 3. Improper shooter position	1. Replace ammunition, cool if hot 2. Contact Ashbury for accessory part 3. Firmly shoulder the buttstock or contact Ashbury for training



FAILURE TO FIRE: IF THE RIFLE FAILS TO FIRE, MAINTAIN AIM IN A SAFE DIRECTION FOR AT LEAST 60 SECONDS BEFORE ATTEMPTING TO OPEN THE BOLT. THE CARTRIDGE'S PRIMER MAY BE BURNING SLOWLY AND MAY CAUSE WEAPON TO FIRE UNEXPECTEDLY. IN ALL CIRCUMSTANCES, CARE MUST BE TAKEN WHEN THE BOLT IS OPENED - A DEFECTIVE CARTRIDGE CAN STILL FIRE.

- A. **Misfire.** Wait 60 seconds, remove defective cartridge. Inspect it to see if the primer was sufficiently struck by the firing pin. Reload the weapon. Attempt to fire. If rifle will still not fire, contact the Ashbury Precision Ordnance Service Department.
- B. **Hangfire.** Wait 60 seconds, clear the rifle after its delayed discharge and then inspect the rest of the ammunition for date validity corrosion or properly seated primers. If the problem persists do not continue to shoot that particular box of ammunition.
- C. **Light Primer Strike.** Wait 60 seconds, remove defective cartridge. Inspect it to see if the primer was sufficiently struck by the firing pin. If the firing pin appears to have had sufficient impact on the primer, then it was a faulty primer or cartridge. Reload the rifle and try to fire again. If the problem persists then obtain new ammunition. If this does not remedy the problem consult a qualified gunsmith and/or contact the Ashbury Precision Ordnance Service Department.

- D. **Squib Round “Pop and No Kick”**. A Squib round is where the cartridge discharged but did not have enough energy to push it out of the barrel, resulting in a bullet lodged in the barrel. Depending on where the projectile is in the barrel, you can try to use a cleaning rod to push out the projectile. If the round is closer to the chamber you can carefully insert a cleaning rod and attempt to push the round towards the chamber. If the round is closer to the muzzle than you can try to use the cleaning rod to push out the projectile towards the muzzle. If it doesn't come out, **DO NOT** attempt to clear it by firing another round through the barrel. Ensure the chamber is clear, remove the bolt, and magazine making the rifle completely safe. Immediately consult a qualified gunsmith and/or contact the Ashbury Precision Ordnance Service Department.



IF ANY RESISTANCE IS FELT WHILE YOU ARE ATTEMPTING TO INSERT AND CLOSE THE BOLT IN THE RECEIVER – STOP! PULL THE BOLT REARWARDS AND CHECK THE RECEIVER BODY AND CHAMBER FOR OBSTRUCTIONS.

FAILURE TO FIRE: IF THE RIFLE FAILS TO FIRE, MAINTAIN AIM IN A SAFE DIRECTION FOR AT LEAST 60 SECONDS BEFORE ATTEMPTING TO OPEN THE BOLT. THE CARTRIDGE'S PRIMER MAY BE BURNING SLOWLY AND MAY CAUSE WEAPON TO FIRE UNEXPECTEDLY. IN ALL CIRCUMSTANCES, CARE MUST BE TAKEN WHEN THE BOLT IS OPENED - A DEFECTIVE CARTRIDGE CAN STILL FIRE.

PRIMARY RIFLE STOPPAGE DRILL

The Primary Rifle Stoppage drill should be carried out to determine the nature of the stoppage or malfunction.

1. Point the rifle in a safe direction.
2. Follow the 60 second rule above.
3. Open the bolt and slowly pull it to the rear; a live round may be ejected.
4. Inspect the inside of the receiver and chamber.
5. The next action will depend on what you see inside the receiver.

CARTRIDGES IN THE MAGAZINE

If there are cartridges in the magazine but none in the chamber, the magazine could be incorrectly inserted or the bolt may not have been cycled correctly.

1. Check that the magazine is correctly inserted in the rifle, if necessary remove and re-insert.
2. Pull the bolt fully rearwards, then push it forward and close.

3. Place the safety mechanism in the "S" or on Safe position or continue firing if appropriate.

NO CARTRIDGES IN THE MAGAZINE

1. Remove the empty magazine.
2. Insert a loaded magazine into the rifle's magazine well.
3. Pull the bolt fully rearwards then push it forward and close.
4. Place the safety mechanism in the "S" or on Safe position or continue firing if appropriate.

OBSTRUCTION IN THE RECEIVER BODY—FAILURE TO EJECT

If there is a live round or empty case present, it must be removed.

1. Remove the magazine.
2. Carefully remove the obstruction (if possible).
3. Do not reload the removed live round until it has been inspected and deemed safe.
4. Check the chamber to insure it's clear.
5. Re-insert the magazine.
6. Pull the bolt fully rearwards then push it forward and close.
7. Place the safety mechanism in the "S" or on Safe position or continue firing if appropriate.

You should check for damage or obstructions that may impede the ejection of cartridge cases. Consistent failures to eject should be evaluated by a qualified gunsmith or contact Ashbury Precision Ordnance Service Department for assistance.

OBSTRUCTION IN THE CHAMBER—FAILURE TO EXTRACT

If a live round or empty cartridge case is present in the chamber, it must be removed. Remove the magazine.

1. Close the bolt fully.
2. Open the bolt to clear the obstruction.
3. Check that chamber is clear. If yes, re-insert the magazine.
4. Pull the bolt fully rearwards, then push forward and close.

5. Place the safety mechanism in the "S" or on Safe position or continue firing if appropriate.

Should the above procedure not clear the obstruction, check the bolt and extractor for damage. Consistent failures to extract should be evaluated by a qualified gunsmith or contact Ashbury Precision Ordnance Service Department for assistance.



CLEARING AN OBSTRUCTION IN THE CHAMBER—FAILURE TO EXTRACT

If an empty cartridge case is present in the chamber, it must be removed. A rigid cleaning rod may be used to remove a spent or EMPTY cartridge case.

1. Remove the magazine.
2. Close the bolt fully.
3. Open the bolt to clear the obstruction. If the rifle is hot allow it to cool.
4. Close the bolt fully.
5. Check to see if the chamber is clear. If not...
6. Remove the bolt.
7. Carefully insert the rod into the muzzle taking care not to damage the crown.
8. Insure that the cleaning rod goes down into the spent cartridge case.
9. With hammer or similar object lightly begin tapping the end of the cleaning rod until the case is dislodged and free of the chamber.
10. When the case is free of the chamber and receiver body, remove the cleaning rod from the bore.
11. Inspect the chamber and bore for damage.
12. If no damage is evident and the bolt and extractor are intact, re-insert the bolt and cycle it to insure that it functions properly.
13. Place the safety mechanism in the "S" or on Safe position.
14. With the bolt open, re-insert the magazine then push forward and close chambering a live round.
15. Place the safety mechanism in the "S" or on Safe position or continue firing if appropriate.

Consistent failures to extract should be evaluated by a qualified gunsmith or contact Ashbury Precision Ordnance Service Department for assistance.



ALWAYS ENSURE THE CLEANING ROD IS REMOVED FROM THE BARREL BEFORE CONTINUING TO FIRE.

If there is a live cartridge stuck in the chamber and it cannot be extracted. Stop any further firing activity with the rifle. Point the muzzle in a safe direction, remove the bolt and magazine. Immediately contact a qualified gunsmith for assistance.



OBSTRUCTION IN THE BARREL—MUZZLE IS PLUGGED

If a projectile or debris is present in the bore, it must be removed.

1. Point the muzzle in a safe direction.
2. Remove the magazine.
3. Open the bolt.
4. Put the safety mechanism in the “S” or on Safe position.
5. Remove the bolt.
6. Inspect the Chamber and bore to determine the nature of the obstruction. Use a flashlight if necessary.
7. If the muzzle is plugged with dirt, mud, snow or debris then fold the shoulder stock and using a fixed cleaning rod with a jag and patch, carefully push the rod through the bore from the breech end and out of the muzzle to clear the obstruction.
8. Confirm that the bore is clean and clear before attempting to fire. Discharging the rifle with a bore obstruction may result in catastrophic failure of the rifle and/or death to the user and bystanders.
9. Ensure there has been no damage done to the bore.
10. Re-insert magazine, insert and close the bolt.
11. Place the safety mechanism in the “S” or on Safe position or continue firing if appropriate.



ALWAYS ENSURE THE CLEANING ROD IS REMOVED FROM THE BARREL BEFORE CONTINUING TO FIRE.

OBSTRUCTION IN THE BARREL—SQUIB ROUND

If a projectile is lodged in the bore while firing, it must be removed and the barrel inspected for damage.

1. Point the muzzle in a safe direction.
2. Remove the magazine.
3. Open the bolt.
4. Put the safety mechanism in the "S" or Safe position.
5. Remove the bolt.
6. Inspect the Chamber and bore to determine the nature of the obstruction. Use a flashlight if necessary.
7. If a projectile is found in the bore. Fold the shoulder stock and using a fixed cleaning rod with a jag and patch, carefully push the rod through the bore from the breech end and out of the muzzle to clear the obstruction.
8. Confirm that the obstruction is clear and there has been no damage done to the bore.
9. If you are unable to clear the obstruction, do not fire the weapon. Make the rifle completely safe, secure it and contact a qualified gunsmith or the Ashbury Precision Ordnance Service Department.
10. Stop any further firing activity with the rifle.

CLEANING THE RIFLE

Rifles should be cleaned upon completion of firing, exposure to water, and/or adverse weather or dirty field conditions. As with any weapon, proper care should be given to the rifle to maintain its reliability, accuracy and performance.

SUPPLIES

Select caliber appropriate supplies to clean your rifle.

- | | | |
|--------------------------|------------------|---------------------------|
| • Cleaning Solvent | • Copper Remover | • Oil Lubricant |
| • Grease (High Temp) | • Bore Guide | • Fixed Cleaning Rod |
| • Jag | • Cotton Patches | • Brass Bore Brush |
| • Chamber Brush (30 cal) | • Chamber Swab | • All Purpose Nylon Brush |
| • Flashlight | • Clean Rag | • Safety Glasses |



BEFORE CLEANING YOUR RIFLE, KEEP MUZZLE POINTED IN A SAFE DIRECTION. REMOVE THE MAGAZINE PLACE THE SAFETY MECHANISM IN THE "S" OR ON SAFE POSITION. OPEN THE BOLT & PHYSICALLY & VISUALLY MAKE CERTAIN YOUR RIFLE IS COMPLETELY UNLOADED. ENSURE THERE IS NO LOADED AMMUNITION IN THE WORK AREA. FAILURE TO FOLLOW THESE WARNINGS COULD RESULT IN SERIOUS INJURY OR DEATH.

BORE AND CHAMBER

1. Secure the rifle for the cleaning process in a maintenance cradle or on a stable flat clean surface to prevent accidental damage.
2. Remove the suppressor (if attached) from the rifle and place it to the side. Check the threaded muzzle for damaged threads or crown.
3. Remove the bolt and magazine from the action and insert the appropriate bore guide in the breech of the receiver. The rifle is to be cleaned from the breech end towards the muzzle so as not to damage the barrel crown.
4. Using a suitable and caliber specific cleaning rod, attach a jag and wrap a clean cotton patch around the jag. Soak the cotton patch with bore cleaning solvent and swab the bore with two (2) to three (3) patches. Thoroughly soak the bore with cleaning solvent by pushing the patches through the bore towards the muzzle. Wipe any excess solvent off the cleaning rod.
5. Push two (2) dry clean cotton patches through the bore to remove all fouling and used cleaning solvent.
6. If copper fouling is seen. Using a caliber specific brass brush, push the brush thru the bore and allow it to come out of the muzzle. Saturate the brass brush with Copper Remover and brush the bore with approximately six (6) strokes. Re-apply Copper Remover every six (6) strokes for a total of 18-24 strokes.
7. If the rifle bore is heavily fouled with copper jacket material (or experience indicates barrel needs this step) let the Copper Remover soak in the barrel bore for 10-15 minutes.
8. Push two (2) dry clean cotton patches through the bore to remove all of the Copper Remover.
9. Swab the bore with two (2) to three (3) clean cotton patches soaked in bore cleaning solvent to completely remove the Copper Remover.
10. Swab the chamber with an appropriate chamber swab or patch on a chamber brush with bore cleaning solvent.
11. Clean the barrel crown and/or muzzle brake area with a multi-purpose nylon brush, clean rag or patch using bore cleaning solvent. Inspect the crown for nicks, dents or damage. **Note:** *You should see a concentric pattern of fouling at the muzzle indicating an even undamaged crown.*
12. Push two (2) dry clean cotton patches through the bore to remove all the bore cleaning solvent from the bore, muzzle and muzzle brake.
13. Swab the chamber dry with patch on a chamber brush and clean & dry the barrel crown and/or muzzle brake area with a clean rag or patch.
14. To prepare the rifle for future field use and a consistent cold bore POA/POI you can fire a fouling shot if possible and/or necessary.

RECEIVER

1. With the bolt removed from the receiver, perform a complete detailed visual inspection of the entire receiver using a flashlight.
2. Inspect the receivers, bolt stop, raceways and exterior for any damage, dents, dings, cracks, rusted, bent or broken parts.
3. Remove any debris and fouling from the inside of the receiver with a oversized nylon bore brush and/or an all purpose nylon brush and cleaning solvent.
4. Wipe clean any excess solvent and residue from the inside and outside of the receiver with a clean rag.
5. Lightly lubricate the inside of the receiver using a high quality gun oil in the raceways and a small amount of high temperature grease on the lug abutments.
Note: *This is an excellent time to inspect and confirm the tightness and torque on the scope base rail, scope mount to base and scope ring clamp screws.*

BOLT

1. Inspect the bolt body, shroud, cocking piece, head, face, extractor, ejector, firing pin hole and lugs for any damage, dents, dings, cracks, rusted, bent, broken or galled parts.
Note: *Occasionally and after firing under dirty conditions, the bolt should be disassembled inspected, cleaned and lubricated by a qualified gunsmith or a user with appropriate armorer training.*
2. Remove any dirt, debris and fouling from the bolt using the all purpose nylon brush and cleaning solvent. Pay close attention to the bolt face, locking lugs and extractor.
3. Wipe clean any excess solvent and residue from the bolt with a clean rag.
4. Lightly lubricate the bolt and locking lugs with a high temperature grease.



WHEN DISASSEMBLING THE MAGAZINE, WEAR EYE PROTECTION TO PREVENT INJURY FROM SPRING LOADED PARTS, PARTICULARLY WHEN DISASSEMBLING THE MAGAZINE FLOOR PLATE.

DISASSEMBLING AND CLEANING THE MAGAZINE

Note: Disassembling the magazine is not required as a matter of routine maintenance, but it may become necessary for repairs or after use under extreme conditions.

1. Physically and visually inspect the magazine to ensure all live ammunition has been removed prior to beginning magazine disassembly.
2. Orient the magazine with the floor plate (or bottom of the magazine) upright with one hand gripping the magazine body. Place the flat end of the supplied magazine dust cover, 1/8th inch punch or similar item on the grey detent located on the magazine floor plate.
3. Gently depress the grey detent downward approximately one ¼" below the floor plate. This disengages the magazine spring locking plate from the floor plate and allows you to slide the base plate off the magazine body.
4. The floor plate will only slide towards the front of a magazine. If you have successfully disengaged the locking plate but are unable to remove the floor plate from the magazine body, visually inspect the magazine to ensure you have correctly oriented it before attempting to proceed.
5. Use the thumb of the hand gripping the magazine body to guide the floor plate forward. Maintain control of the magazine spring as the base plate is removed. Withdraw the magazine spring and magazine follower from magazine tube. At this point the magazine can be disassembled into 3 pieces (below).

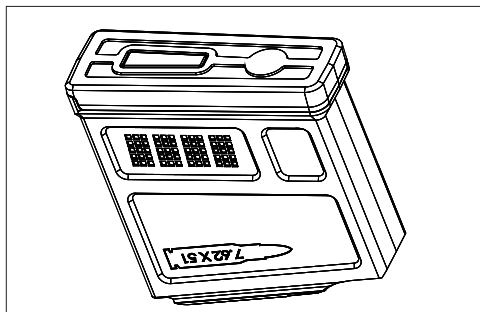


Figure 57 - Magazine Floor Plate

Note: The follower and locking plate are attached to the magazine spring. It is not necessary or recommended that you attempt to remove the follower or locking plate from the magazine spring.

6. Wipe clean all 3 parts of the magazine. Visually inspect the magazine spring, follower and locking plate to ensure they are serviceable and free of debris.
7. Inspect the magazine feed lips for any visual signs indicating they are cracked, warped or otherwise damaged. Damaged or unserviceable magazines should be replaced prior to use as they are likely to cause a malfunction while attempting to fire the rifle.



WHEN ASSEMBLING THE MAGAZINE, WEAR EYE PROTECTION TO PREVENT INJURY FROM SPRING LOADED PARTS, PARTICULARLY WHEN ASSEMBLING THE MAGAZINE FLOOR PLATE.

ASSEMBLING THE MAGAZINE

Note: The magazine locking plate is slightly larger than the follower. This is a design feature intended to prevent the magazine spring from inadvertently being reassembled incorrectly. In order to successfully insert and fully compress the magazine spring below the edge of the magazine body the follower must be inserted first.

1. Install magazine follower and magazine spring into magazine body. Compress the magazine spring below the level of the magazine body to ensure the floor plate can slide securely over the locking plate.
2. The floor plate can only be reinserted onto the magazine body in one direction. Ensure the open end of the floor plate is inserted towards the magazine body. The floor plate is secured once the grey locking plate detent has successfully snapped in place.
3. After the magazine has been reassembled, check for proper functioning pushing downward on the magazine spring. The magazine spring should compress easily without binding the magazine follower allowing the follower to travel smoothly up and down.

BOLT DISASSEMBLY

1. Remove the bolt assembly from the rifle. See page 29.
2. Using a sturdy bench, gun vise or other appropriate object metal with a metal edge, place the firing pin notch over the edge.

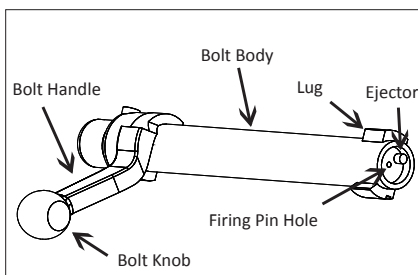


Figure 59a - Bolt Nomenclature

3. As you pull away from the notch, you will see a gap appear behind the bolt shroud, insert a coin in this gap. See Remington M700 Owner's Operators Manual, page 17.

4. Hold the bolt assembly and turn the body counter clockwise until the firing pin assembly can be removed from the bolt assembly.

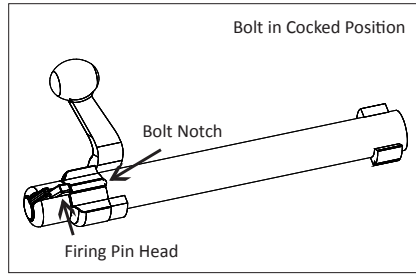


Figure 59b - Bolt Nomenclature

5. Clean the firing pin sub-assembly as a complete unit with a cleaning solvent.
6. When complete, dry with a clean cloth rag & apply a light coating of lubricating oil.

BOLT RE-ASSEMBLY

1. Insert the firing pin sub-assembly into the bolt body.
2. Tighten the bolt shroud into the bolt body using your hand.
3. Carefully remove the coin from the slot in the firing pin head.
4. Turn the bolt shroud until the firing pin head goes into the small notch on the rear rim of the bolt body.
5. The bolt is now cocked. **Note:** The bolt must be cocked to be inserted into the rifle.
6. The bolt can now be re-inserted into the rifle's receiver.

TRIGGER

1. Inspect the trigger body, hanger, mounting pins, shoe, face, adjustment screws and safety mechanism for any damage, dents, dings, cracks, rusted, corroded, bent, broken or galled parts.

Note: Occasionally and after firing under dirty conditions the trigger should be removed inspected, cleaned, lubricated and checked for pull weight by a qualified gunsmith or a user with appropriate armorer training.

2. Remove any dirt, debris and fouling from the trigger using the all purpose nylon brush and cleaning solvent.
3. Wipe clean any excess solvent, residue and lubricant from the trigger with a compressor air hose and clean rag.
4. Lightly lubricate the trigger with a high quality oil lubricant.

FIRING RANGE PREPARATION CHECKLISTS

CHECK EQUIPMENT		
SABER M700 Rifle	Angle Cosine Indicator	Sun Block, Lip Balm
Rifle Scope & Mount	Anti-Cant Device	Insect Repellent
Scope Lens Covers	Data Book, Pen & Pencil	Spare Parts
Bipod	Calculator, Solor Powered	Spare Batteries/Chg Cables
Supressor & Thermal Cover	Hand-held Weather Station	Gloves, Knee & Elbow Pads
Shooting Sling	Laser Range Finder	Sun Glasses & Spare Glasses
Ammunition	Shooting Bags (front/rear)	Hot/Cold/Foul Weather Gear
Eye & Hearing Protection	Rifle Cleaning Kit	Hats
Shooting Mat	Optic Cleaning Kit	Quality Footwear
Portable Bench	Tools	Targets & Range Supplies
Ballistic Calculator	First Aid Kit	

PRE-SHOOT RIFLE INSPECTION						
1.	Action Screws	Torque		9.	Bolt	Lube
2.	Scope Base Screws	Torque		10.	Cocking Piece	Visual
3.	Scope Cap Screws	Torque		11.	Bolt Release	Visual
4.	Suppressor	Tightness		12.	Magazine(s)	Visual
5.	Muzzle Brake	Visual		13.	Magazine Well	Visual
6.	Bore	Visual		14.	Chassis Fasteners	Torque
7.	Chamber	Visual		15.	Chassis Screws	Torque
8.	Raceways	Visual				

PARTS LIST & EXPLODED RIFLE VIEW

SHOULDER STOCK ASSEMBLY PARTS		
1.	Magpul CTR Butt Stock (Blk)	730-193V-0002-00 BLK
2.	Magpul ¾" Cheek Riser	730-193V-0006-00 BLK
3.	Buffer Tube, 6-Position Carbine Mil-Spec	730-193V-0003-00 BLK
4.	AR-15 Buffer Tube Castle Nut	730-193V-0003-00
5.	Double Locking Alloy Hinge	731-03V-0005-00
6.	Folding Hinge Screw LHSCS 5/16"-18	725-86V-0005-00
M700 CENTER CHASSIS SECTION SHORT ACTION		
7.	RSA-A3 Center Chassis Section	700-03V-0025-00 BLK
8.	Magazine Lever Replacement Kit (APO-494-B Lever, Spring, Pin)	732-03V-0009-00
9.	Magpul PMAG5 762AC (5rd)	760-193V-0001-00
M700 CENTER CHASSIS SECTION LONG ACTION A1A		
10.	RLA-A1A Center Chassis Section	700-03V-0029-00 BLK
11.	Magazine Lever Replacement Kit (APO-494-B Lever, Spring, Pin)	732-03V-0009-00
M700 CENTER CHASSIS SECTION LONG ACTION A1B		
12.	RLA-A1B Center Chassis Section	700-03V-0029-01 BLK
13.	Magazine Lever Replacement Kit (APO-494-B Lever, Spring, Pin)	732-03V-0009-00
COMMON PARTS FOR CENTER CHASSIS SECTIONS		
14.	Front Action Screw SHCS 1/4-28x1 1/2" AVP	730-86V-0011-01
15.	Rear Action Screw SHCS 1/4-28x3/4" AVP	700-86V-0001-00
16.	17.5° Grip Angle Adapter	735-03V-0003-00
17.	Grip Clamp	735-130V-0004-00
18.	Magpul MOE Hand Grip (BLK)	730-193V-0004-00 BLK
19.	Hand Grip Screw w/ Washer 1/4-28x1 3/4" AVP	735-86V-0002-01
20.	1/4-28x1/2" AVP	730-86V-0021-00
AR-08 HAND GUARD		
21.	APO-MRCS-AR ALLOY Hand Guard Forend Sub-Assembly	705-03V-0009-00BLK
22.	¼"-28 x 1¼" Socket Head Cap Screw, AVP Quantity (2)	730-86V-0005-00

HOW TO OBTAIN PARTS & SERVICE FROM ASHBURY PRECISION ORDNANCE MFG.

To order parts you can contact us at sales@saber-m700.com or call (434) 296-8600 Ext. 308 for our Service Department, Monday through Friday, 8:30am to 5:30pm EST. You can also obtain information on all of Ashbury's firearm related products and services at <http://AshburyIntlGroup.com>

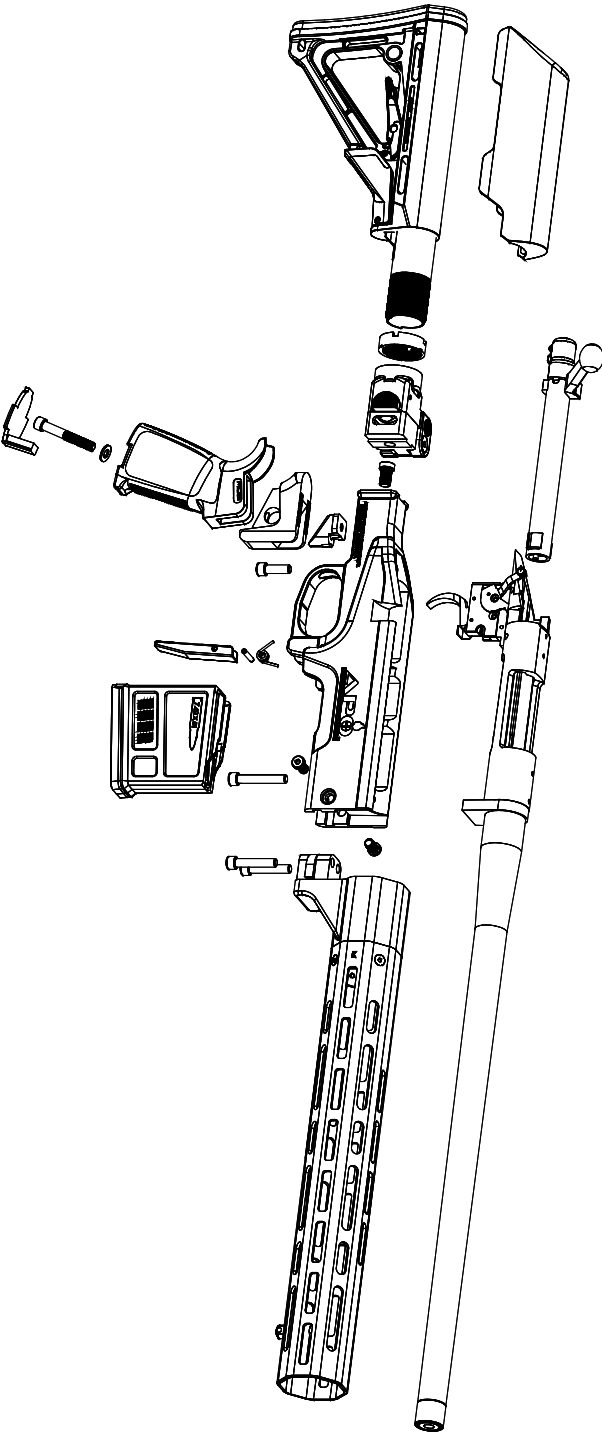


Figure 60 - Exploded View of SABER M700 Precision Rifle

ACCESSORIES

Accessories for the SABER M700 Rifle can be ordered through our online store at <http://store.AshburyPrecisionOrdnance.com> or contacting the Customer Support & Inside Sales Department at Ashbury Precision Ordnance Mfg. (434) 296-8600 Ext 998.

MRCS-AR STOCK JOINTS		
1.	Fixed Stock Joint	731-03V-0006-00
2.	Double Locking Hinge	731-03V-0005-00
SABER SHOULDER STOCKS		
3.	HTA Shoulder Stock (ergonomically adjustable)	730-03V-0009-00
4.	TASS Shoulder Stock (ergonomically adjustable)	730-03V-0009-02
5.	PBA-H Shoulder Stock (ergonomically adjustable)	730-03V-0004-00
SABER SHOULDER STOCK JOINTS		
6.	Fixed Stock Joint	731-03V-0003-00
7.	Folding Lockable Hinge	731-03V-0001-00
8.	Detachable Break Down Joint	731-03V-0002-00
9.	Double Locking Hinge	731-03V-0004-00
SABER SHOULDER STOCK JOINTS ACCESSORIES		
10.	SABER Monopod	031-03V-0001-00
11.	Monopod Foot	745-138V-0001-00
12.	Butt Hook	730-138V-0001-00
13.	Limbsaver Recoil Pad for MOE/CTR	700-87V-0002-00
HAND GRIP ACCESSORIES		
14.	11° Grip Angle Adapter	735-130V-0001-00
15.	17.5° Grip Angle Adapter	735-130V-0002-00
16.	27° Grip Angle Adapter	735-130V-0003-00
17.	Ergo Slimline Hand Grip Black Olive Drab Flat Dark Earth	735-152V-0001-00 BLK 735-152V-0001-00 ODG 735-152V-0001-00 FDE
18.	Magpul MOE Hand Grip Black Olive Drab Flat Dark Earth	730-193V-0004-00 BLK 730-193V-0004-00 ODG 730-193V-0004-00 FDE

19.	20 MOA Remington M700 Short Action Rail 5.500"	820-35V-0011-00
20.	20 MOA Remington M700 Long Action Rail 6.300"	820-35V-0012-00
REMINGTON MODEL 700 MONOLITHIC SCOPE RAILS		
21.	20 MOA Remington M700 Short Action Rail 20"	820-03V-0029-20
22.	30 MOA Remington M700 Long Action Rail	820-03V-0035-30
M-LOK® ACCESSORIES		
23.	M-LOK Accessory Rail/Tripod Attachment Kit	815-03V-0001-00
24.	M-LOK T-Nut Replacement Set	815-193V-0008-00
25.	M-LOK Aluminum Rail, 3 Slots	815-193V-0005-01
26.	M-LOK Aluminum Rail, 5 Slots	815-193V-0004-01
27.	M-LOK Aluminum Rail, 7 Slots	815-193V-0003-01
28.	M-LOK Aluminum Rail, 9 Slots	815-193V-0002-01
29.	M-LOK QD Sling Mount	815-193V-0007-00
30.	M-LOK Tripod Adapter	815-193V-0006-00
BOX MAGAZINES		
31.	PMAG® 5 7.62 AC™ – AICS Short Action 7.62x51mm (5-round)	760-193V-0001-00
32.	PMAG® 10 7.62 AC™ – AICS Short Action 7.62x51mm (10-round)	760-193V-0001-10
33.	PMAG® 5 AC™ L, Standard – AICS Long Action (5-round 30-06)	760-193V-0014-00
34.	PMAG® 5 AC™ L, Magnum – AICS Long Action (5-round 300WM)	760-193V-0015-00
35.	338 Lapua Mag 3.775" Steel 5-round (BLK)	760-120V-0013-00
36.	Single Shot Block, RSA-A3	760-03V-0011-00
37.	Single Shot Block, RLA-A1A	760-03V-0012-00
38.	Single Shot Block, RLA-A1B	760-03V-0013-00
HAND GUARDS / FORENDS		
39.	AR – Octagonal K Model Handguard (for 16.5" BBL)	705-03V-0017-00
40.	AR – Octagonal K Fast Back Handguard (for 16.5" BBL)	705-03V-0017-01
41.	Sporter, Composite (forend complete)	705-138V-0002-00
42.	Quattro Alloy – Standard w/M-LOK Alloy Series K M-LOK Standard Forend	705-03V-0006-01
43.	Quattro Alloy – SuperSport w/M-LOK Alloy Series K M-LOK SuperSport Forend	705-03V-0006-02
44.	Quattro Carbon Fiber MOD-0	705-151V-0001-00
45.	Quattro Carbon Fiber MOD-1	705-03V-0003-00

MUZZLE BRAKES		
46.	Arclight III (magnum calibers) 5/8-24 TPI	781-03V-0004-00
47.	Arclight II (small calibers) 5/8-24 TPI	781-03V-0005-00

MAINTENANCE TOOLS		
48.	SABER Field Multi-Tool	795-137V-0001-00
49.	Field Optics Care Kit	795-137V-0001-00
50.	Precision Rifle Field Tool Kit	795-137V-0001-00

Ashbury Precision Ordnance Mfg.

Customer Support & Inside Sales Department

84 Business Park Circle, Ruckersville, Virginia 22968

Tel (434) 296-8600 Ext 998 Fax (434) 296-9260

sales@saber-m700.com

SABER-M700.com

INSTRUCTIONS FOR REPAIR SERVICE

REPAIR SERVICES

If you have a problem with your Ashbury Precision Ordnance SABER M700 Rifle that you believe (i) is, or should be covered under warranty, (ii) you would like Ashbury to address at your cost and expense, (iii) or you would like to otherwise discuss with Ashbury, please contact our Service & Repair Department (434) 296-8600 Ext 308.

Do not send your firearm or other item to Ashbury without first (a) calling the above number, (b) discussing your equipment problem with an Ashbury representative, (c) obtaining a Service Request Document (request email, USPS or fax), (d) and receiving a Service Repair document and RMA number.

To the extent that you seek Warranty coverage, please review the Ashbury and Remington firearms warranties and note that you can void your Warranty by taking actions without first contacting Ashbury.

CONTACT CUSTOMER SERVICE

Ashbury Precision Ordnance Mfg.
Service and Repairs Department
84 Business Park Circle, Ruckersville, Virginia 22968
Tel (434) 296-8600 x308 Fax (434) 296-9260
service@saber-m700.com

INSTRUCTIONS

- Call or e-mail the Customer Service Department for a service repair authorization document and shipping instructions.
- Ensure that the firearm is unloaded.
- **DO NOT SHIP ANY AMMUNITION UNLESS SPECIFICALLY REQUESTED TO DO SO.**
- Enclose a letter which includes your identifying information (name, organization, and address), daytime telephone number, e-mail address, the serial number of the firearm, and details of the problem experienced (stating the brand and type of ammunition used when the problem occurred) or work desired.
- Record the serial number before shipping, in case you wish to check on the repair status of your firearm.
- Remove all custom parts and accessories, such as special sights and scopes, or slings from your firearm before returning.
- Place the firearm in lockable case or in a similar container and pack it securely.

LIMITED LIFETIME WARRANTY

This warranty is granted by Ashbury International Group, Inc./Ashbury Precision Ordnance Mfg., the Manufacturer, as to the **SABER® M700™ Rifle**; is effective from the date of purchase; and applies only to the original owner of this firearm. This warranty supersedes any and all other warranties.

The **SABER M700 Rifle is warranted to be free from defects in material and workmanship for the life of the original owner.** Any such defects of which Ashbury International Group, Inc./Ashbury Precision Ordnance Mfg. receives written notice from the date of purchase by the original owner, will be remedied by Ashbury International Group, Inc./Ashbury Precision Ordnance Mfg. without charge within a reasonable time after such notification and delivery of the firearm as provided below. Warranty claims must be in writing and must accompany the firearm, which must be delivered to Ashbury International Group, Inc./Ashbury Precision Ordnance Mfg.'s Customer Service Department at the address set out below, or at such other address as may be directed by Manufacturer, at owner's expense. Warranty claims must state the model and serial number of the firearm concerned and the description of the difficulty experienced. It is recommended that shipments be insured by the owner, since Manufacturer accepts no responsibility for loss or damage in transit. Transportation and insurance charges necessary to return the firearm to the owner at the original location to which the firearm was shipped when purchased, or to such other location of the owner closer to the repair facility of Manufacturer as may be designated by the owner, will be paid by Manufacturer if the claim is covered by the warranty. If the claim is not covered by the warranty the firearm will be returned to owner only after arrangements for payment satisfactory to Manufacturer for inspection, repair if any, transportation, and insurance charges are made by the owner. The warranty period for warranty repairs shall be for the life of the original owner.

CERTAIN COMPONENTS USED IN THE SABER M700 RIFLE ARE PROVIDED BY REMINGTON ARMS COMPANY, LLC AND MAGPUL INDUSTRIES CORPORATION, AND MAY BE WARRANTED BY THOSE ENTITIES.

THIS WARRANTY IS EXCLUSIVE AND IS GIVEN IN LIEU OF ANY AND ALL OTHER WARRANTIES, EXPRESS OR IMPLIED.

NO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE ARE GIVEN AND ANY AND ALL LIABILITY FOR BREACH OF ANY IMPLIED WARRANTY OR WARRANTY CREATED BY LAW IS DISCLAIMED.

UNDER NO CIRCUMSTANCES SHALL ASHBURY INTERNATIONAL GROUP, INC./ASHBURY PRECISION ORDNANCE MFG. BE RESPONSIBLE FOR INCIDENTAL OR CONSEQUENTIAL DAMAGES WITH RESPECT TO ECONOMIC LOSS, INJURY, DEATH OR PROPERTY DAMAGE, WHETHER AS A RESULT OF BREACH OF THIS WARRANTY, NEGLIGENCE OR OTHERWISE.

Ashbury does not warrant against any type of defect to the firearm that Ashbury did not cause including but not limited to:

- Failure to provide proper care and maintenance,
- Accidents, abuse or misuse,
- Barrel obstruction,
- Hand loaded, reloaded or improper ammunition,
- Unauthorized adjustments, repairs, modifications, or
- Normal wear and tear

Ashbury International Group, Inc./Ashbury Precision Ordnance Mfg. reserves the sole and exclusive right to determine what constitutes ordinary wear and tear, improper use, inadequate maintenance, disregard of operating instructions, excessive load or stress, careless handling, use of defective or improper ammunition, use of components or spare parts not specified or approved by the Manufacturer, and whether adjustments or modifications were made or attempted to be made not using Manufacturer's authorized procedures.

NOTE: THIS WARRANTY IS VOID AND ALL LIABILITY IS EXCLUDED IN THE EVENT THAT THE INSTRUCTIONS IN THE MANUAL ACCOMPANYING THE FIREARM ARE NOT OBSERVED.

WARRANTY REGISTRATION

*Please complete and return this form by mail within 10 days from the date you purchased your rifle. Failure to do so may void your warranty.
Electronic options for registration at the bottom of this page.*

First Name: _____ **Last Name:** _____

Address: _____

City: _____ **State:** _____ **Zip Code:** _____

Phone: _____ **Email:** _____

Date of Purchase: _____ **Location:** _____

Model: _____ **Serial Number:** _____

Caliber: _____ **Price Paid:** _____

What types of rifle shooting do you participate in?

- ☐ Recreational Shooting ☐ Plinking ☐ Competition ☐ Target ☐ Big Game Hunting
☐ Predatory/Varmint Hunting ☐ Long Range Shooting ☐ Tactical Law Enforcement
☐ Home Defense ☐ Personal Protection
- ☐ YES! I want to receive offers and information from Ashbury.
☐ YES! I want to receive offers or communications from industry partners.

Mail Completed Form to
Ashbury Precision Ordnance, Mfg
Warranty Registration Department
84 Business Park Circle
Ruckersville, VA 22968

Alternatively You May Register Online at
SABER-M700.com/warranty-registration

or Scan QR Code to Register From Your Smartphone



NOTES

This image shows a full page of blank, lined paper. It features approximately 20 evenly spaced horizontal grey lines across its entire width, typical of notebook or primary school writing paper. The background is white, and there are no margins, text, or other markings present.

NOTES

This image shows a single sheet of white paper with horizontal ruling lines. The lines are evenly spaced and run across the width of the page. There are no margins, text, or other markings on the paper.



Custom Built Long Range Precision Rifles
Custom Reflex Sight Enabled Pistols
APOCustomShop.com



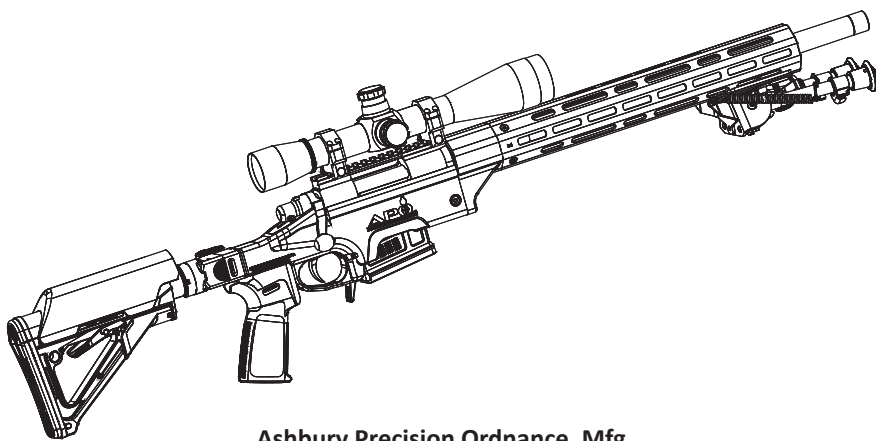
Rifle Marksmanship and Hunter Training
APORiflecraft.com



RifleSports Lifestyle Experiences
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APOExperience.com



Ashbury Precision Ordnance, Mfg

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