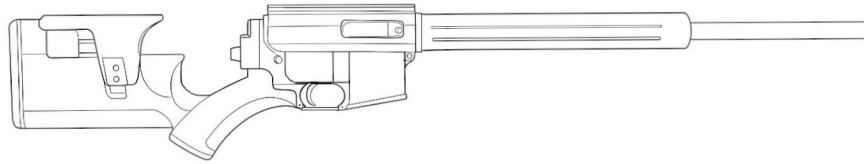


OPERATION AND SAFETY MANUAL



LW30A

JAMES PRECISION LLC.,

WARNING: BEFORE USING THIS FIREARM,
READ AND FOLLOW THESE INSTRUCTIONS

761A Miami Cir NE

Atlanta , GA 30324

<https://www.james-precision.com/>

Safety

Warnings and Notifications



WARNING:

IF THIS FIREARM IS CARELESSLY OR IMPROPERLY HANDLED, UNINTENTIONAL DISCHARGE COULD RESULT AND COULD CAUSE INJURY, DEATH OR DAMAGE TO PROPERTY.



CAUTION:

CAREFULLY READ THIS MANUAL PRIOR TO LOADING AND FIRING, FOLLOW ALL INSTRUCTIONS ON THE PROPER HANDLING AND SAFE USE OF THIS FIREARM – LIVES MAY DEPEND ON IT! If unfamiliar with firearms, seek further advise through safe handling courses

run by your local gun clubs, NRA approved instructor or similar qualified organizations.



CAUTION:

USE ONLY CLEAN, DRY, HIGH QUALITY COMMERCIALLY MANUFACTURED AMMUNITION IN GOOD CONDITION which is appropriate to the Caliber of your firearm. We do not recommend the use of remanufactured or hand loaded ammunition because it may damage your rifle. Use of improper ammunition will void your warranty.



WARNING:

THIS FIREARM COULD CHAMBER A ROUND if it is dropped or jarred with a loaded magazine in place – either with the Bolt Carrier Assembly to the rear, or in its forward position.



WARNING:

CHILDREN ARE ATTRACTED TO AND CAN OPERATE FIREARMS THAT CAN CAUSE SEVERE INJURIES OR DEATH. Prevent child access by always keeping your firearm locked away and unloaded when not in use. If you keep a loaded firearm where a child obtains and improperly uses it, you may be fined and sent to prison.

Before this rifle left the factory, this firearm was tested, carefully inspected and packaged. AJames Precision cannot control product handling after it leaves the factory, therefore please examine this firearm carefully at the time of purchase to ensure that it is unloaded and undamaged.

Safe Handling Procedures

- Do **NOT** alter or modify your AM Model firearm!
- **ALWAYS HANDLE YOUR FIREARM AS IF IT IS LOADED!**
- **NEVER** point your firearm at anything you don't intend to shoot.
- Always make sure your firearm is not loaded and the bolt is latched open and to the rear before laying it down or handing it to someone else.

- **NEVER LEAVE A LOADED FIREARM UNATTENDED!**
- Always be sure the bore, muzzle, chamber and action are clear of obstruction.
- Always check that ammunition is clean and undamaged.
- Never drink alcoholic beverages or use drugs before or during shooting.
- Always wear ear and eye protection when shooting.
- Always keep the safety on “SAFE” when the firearm is loaded and a round is chambered until you are ready to shoot.
- NEVER attempt to fire if water is in the bore.
- NEVER indulge in horseplay when holding your firearm.

ALWAYS PRACTICE SAFE FIREARMS HANDLING!

Dangerous Procedures

- Be sure the cam pin is installed in the bolt assembly. If it isn't, your rifle can still fire but it could possibly explode, causing personal injury or death.
- Do NOT exchange or switch bolt assemblies from one rifle to another. It could cause harm to you and others and damage your rifle.
- If your firearm fails to fire, hold it, keep it pointed towards the target and wait 30 seconds. If a hangfire has occurred, the round will fire within 30 seconds. If the round does not fire (misfire), remove magazine, eject round and examine the primer. If firing pin indent is light, misaligned or non-existent, have your firearm examined by a certified armorer. If firing pin indent on primer appears normal (in comparison to previously fired rounds) assume faulty ammunition; appropriately dispose of misfired round from other live ammunition, reload and resume firing.
- If your bolt fails to unlock and you try to free it by banging the buttstock on the ground, keep yourself clear of the muzzle!
- If there is water in the barrel, do NOT fire the rifle, it could explode!
- If you notice a difference in sound and recoil, STOP FIRING. Either condition could indicate an incomplete powder burn and/or a bullet stuck in the bore.

ALWAYS PRACTICE SAFE FIREARMS HANDLING!

About your LW Model Firearm

Description

Your LW Model rifle is a lightweight, gas operated, air-cooled, magazine-fed, shoulder-fired firearm that is fired in a semi-automatic mode. The upper and lower receivers are easily opened for cleaning and inspection. The bolt assembly and barrel extension are designed with locking lugs that lock the bolt assembly to the barrel extension. The Forged or Billet upper and lower receivers reduce the weight of the rifle.

Parts of Your Rifle

The orientations of Figures 1 and 2 below refer to the sides of your rifle when it is shouldered.

RIGHT SIDE VIEW

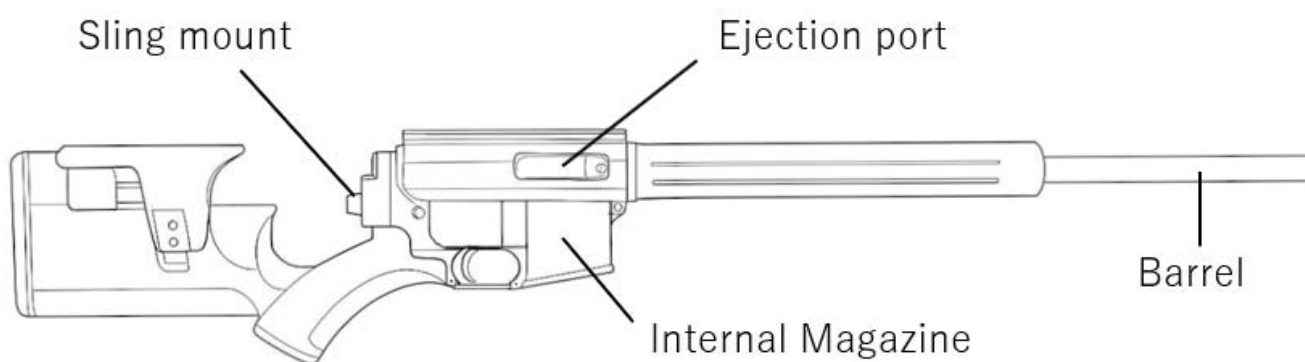


Figure 1

LEFT SIDE VIEW

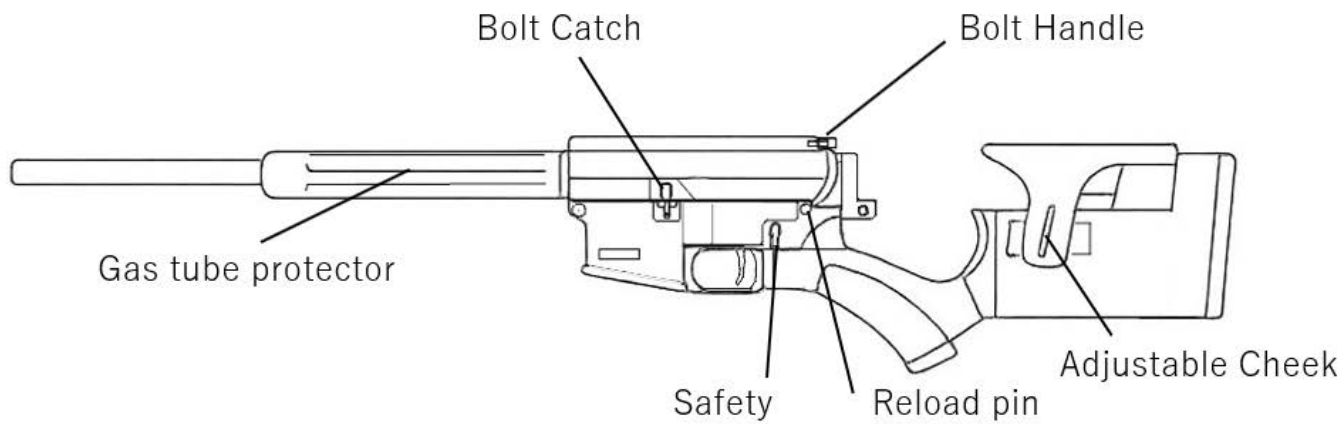


Figure 2

BOLT ASSY

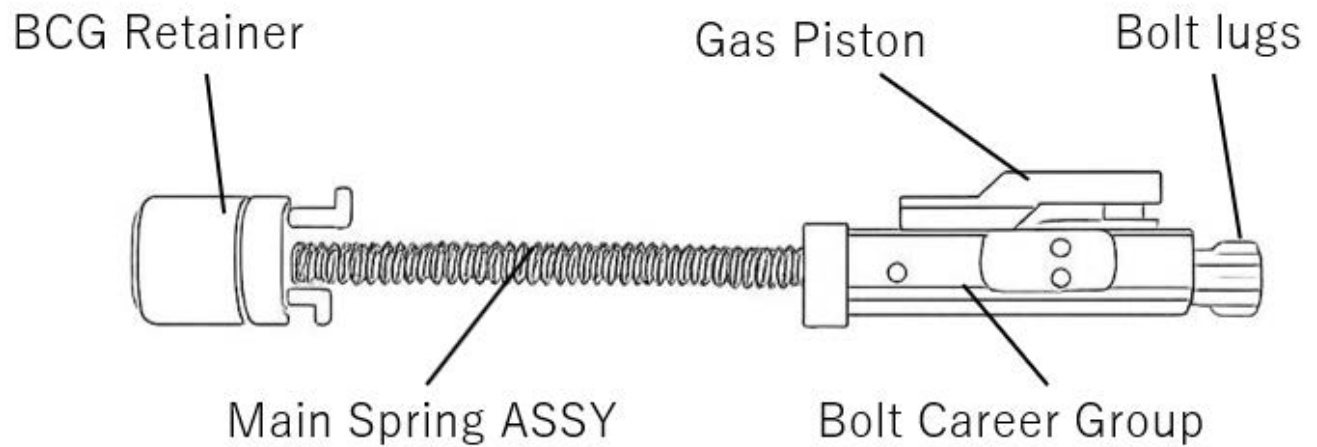
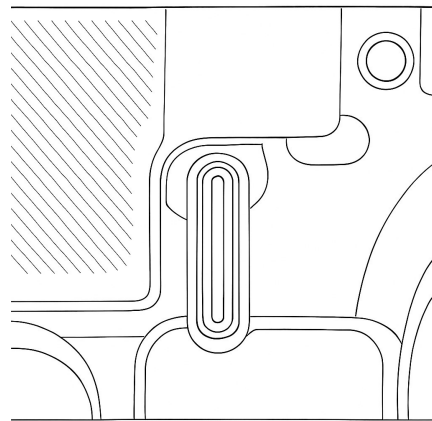
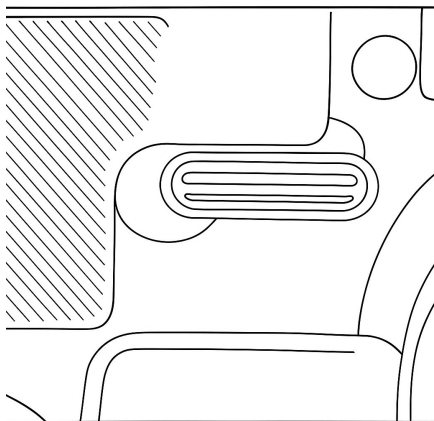


Figure 4

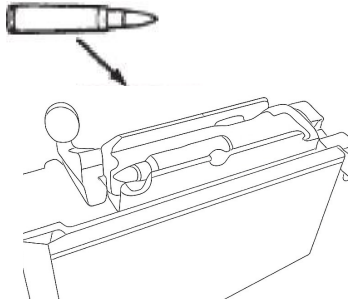
Operating your LW Model Firearm

Safety Selector



The safety selector lever, located on the left of lower receiver, has two positions, "FIRE" and "SAFE". When set to "FIRE" (Vertical) the firearm will fire a single shot each time the trigger is pulled. When set to "SAFE" a cam bears upon the rear of the trigger, blocking trigger movement and preventing the hammer from being released.

Loading the Magazine



- Pull the rear Reload pin to reload your firearm.
- With the magazine facing forward as shown, place a round between the lips of the magazine with the bullet tip forward. Push the round down until it is held by the magazine lips.
- If necessary, slightly push the round backward to seat it against the back edge of the magazine lips. Place the next round on top of the previous round and repeat steps until the desired number of rounds are achieved.

Loading your Rifle



WARNING:

MAKE SURE THE RIFLE IS POINTED IN A SAFE DIRECTION AND THE SAFETY IS ENGAGED AT ALL TIMES WHILE LOADING THE RIFLE. NEVER ALLOW YOUR FINGERS OR OTHER OBJECTS TO CONTACT THE TRIGGER WHILE LOADING OR UNLOADING YOUR RIFLE. DO NOT DISENGAGE THE SAFETY UNTIL YOU ARE READY TO FIRE AND HAVE THE RIFLE POINTED SAFELY DOWNRANGE

- Press in on the bottom of the Bolt Catch while pulling back the Charging Handle. This will cock the hammer and lock the Bolt Carrier to the rear.
- Return the Charging Handle fully forward until it locks in place and remove your finger from the Bolt Latch.
- Set the Selector to the "SAFE" position.
- With the bullets pointing forward, insert the loaded magazine into the Magazine Well and push it up until it stops and is retained by the magazine catch.
- With the rifle pointed in a safe direction, press in on the top of the Bolt Catch. This will release the Bolt Carrier and move a round into the chamber. The rifle is now loaded with a round in the chamber and the hammer cocked.
- Do not disengage the safety until the rifle is pointed in a safe direction and you are ready to fire.

Firing your Rifle

- Always wear ear and eye protection when firing your firearm.
- Load firearm as previously described.

- Before firing your rifle, practice your stance, aim, rhythm and breathing for steady aim with your firearm unloaded. Practice firing on a range before going hunting or using your firearm for any other type of shooting.
- Grasp firearm with one hand on the Handguard and other hand on Grip with trigger finger resting alongside of trigger guard. Raise firearm and pull Buttstock firmly into shoulder.
- Keeping steady aim, place trigger finger on the Trigger and squeeze gently until the Trigger releases the hammer. Do not jerk the Trigger as you will disturb your aim and ruin your accuracy.
- To fire the next round and subsequent rounds, all that is necessary is to release the Trigger and squeeze it again after every shot until the magazine is emptied.
- This is a semi-automatic firearm and is immediately loaded and ready to fire after each shot until magazine is empty.
- Once the magazine is emptied, release the Trigger, remove finger from Trigger, and set Selector lever to "SAFE". If you have fired the last round from magazine, the Bolt Carrier will be held open to the rear so that the chamber can be checked to ensure it is empty.

Clearing the Chamber (Unloading)



WARNING:

MAKE SURE THE RIFLE IS POINTED IN A SAFE DIRECTION AND THE SAFETY IS ENGAGED AT ALL TIMES WHILE LOADING THE RIFLE. NEVER ALLOW YOUR FINGERS OR OTHER OBJECTS TO CONTACT THE TRIGGER WHILE LOADING OR UNLOADING YOUR RIFLE.

- Press in on the bottom of the Bolt Catch while pulling back the Charging Handle. This will cock the hammer and lock the Bolt Carrier to the rear.
- If there is a round or a spent cartridge in the chamber, it will be ejected.
- Return the Charging Handle fully forward until it locks in place and remove your finger from the Bolt Catch.
- Set the Selector to the "SAFE" position.
- Inspect the chamber making sure it is empty.
- With the rifle pointed in a safe direction, press in on the top of the Bolt Catch. This will release the Bolt Carrier.

Troubleshooting

PROBLEM	POSSIBLE CAUSE	SOLUTION
Won't Fire	Selector Lever on "SAFE"	Select "FIRE"
	Improper Assembly of the Firing Pin.	Assemble Correctly
	Defective Ammunition	Remove and Discard
	Too much carbon on Firing Pin or in the Firing Pin recess	Clean
Bolt Won't Unlock	Dirty or Burred Bolt	Clean or see a Certified Armorer
Won't Extract	Broken Extractor Spring	See a Certified Armorer
	Dirty or Corroded Ammunition	Remove Stuck Round
	Carbon in the Chamber	Clean the Chamber
	Fouling or carbon in the Extractor recess tip	Clean the Extractor
Won't Feed	Dirty or Corroded Ammunition	Clean
	Dirty Magazine	Clean
	Defective Magazine	Replace
	Too Many Rounds in Magazine	Take out Excess
	Magazine Not Fully seated	Adjust Magazine Catch
Double Feed	Defective Magazine	Replace
Won't Chamber	Dirty or Corroded Ammunition	Clean
	Damaged Ammunition	Replace
Won't Lock	Dirt, Corrosion or carbon Buildup in the Barrel Locking Lugs	Clean Lugs
Won't Extract	Frozen Extractor	Remove and Clean
	Restricted Movement of the Bolt Carrier	Remove and Clean
	Restricted Buffer Assembly	Remove and Clean

PROBLEM	POSSIBLE CAUSE	SOLUTION
Short Recoil	Alignment of gaps of the Bolt Gas Rings	See a Certified Armorer
	Carbon or Dirt in the Bolt Key or on the Outside of the Gas Tube	Clean the Bolt Key and the Area Around the Gas Tube
	Foreign Object Stuck in the Bolt Key	Clean if Possible or see a Certified Armorer
	Poor ammo	Use Factory New Ammo
Bolt Fails to Lock After the Last Round	Dirty or Corroded Bolt Latch	Clean the Bolt Latch, Check for Buffer Endcap Obstruction and Check for Full Travel of the Bolt Carrier
	Poor ammo	Use Factory New Ammo
Selector Lever Binds	Dirt or Sand Under the Trigger	Clean
Bolt Carrier is Hung Up	Round is Jammed Between the Bolt and Charging Handle and/or Double Feed	Remove the Magazine, push in on the bottom of the Bolt Latch. While pulling down on the Charging Handle, bang the Rifle Butt on the Ground. The Bolt should lock to the rear. While the Bolt is held to the rear, the round should fall through the Magazine Well. WARNING! KEEP CLEAR OF THE MUZZLE. AFTER THE ROUND IS REMOVED, THE BOLT IS UNDER TENSION

Warranty and Records Information

Limited Lifetime Warranty

LIMITED LIFETIME WARRANTY: James Precision warrants to the original purchaser of its products that its products are free from defects in materials and workmanship for the entire time that the product is owned by the original purchaser. The original purchase must be in the United States. The sole and exclusive remedy is limited to repairing or replacing, at our option, any product manufactured by James Precision that is determined to be defective. Any defective product will be remedied by James Precision or its authorized representative without charge, other than freight and insurance charges for return of the product. If we send you a new product, we will keep the defective one.

James Precision will not be responsible for defects, malfunctions or required repairs resulting from:

- Improperly assembling of a firearm using James Precision LLC., parts, using parts not manufactured by James Precision LLC., or using incorrect components
- Damage or breakage to James Precision LLC., parts during assembly by the purchaser, such as stripping threads, cracking parts due to overtightening or snapping trigger guard ears due to improper installation
- Unauthorized or improper modification or alteration
- Improper repair or disassembly
- Careless handling, abuse, neglect, criminal misuse, negligence or use under the influence of drugs or alcohol

- Unreasonable use, i.e., use of the products under conditions more severe than those for which they were designed and intended
- Normal wear, tear and/or corrosion
- Use of defective or improper ammunition including remanufactured ammunition

Note: All liability is excluded if the instructions in the James Precision Operation and Safety Manual are not observed.

Limitation of Liability:

IN NO EVENT WILL JAMES PRECISION BE LIABLE FOR ANY INCIDENTAL, INDIRECT, PUNITIVE, SPECIAL OR CONSEQUENTIAL DAMAGES, INCLUDING LOSS OF USE, LOST PROFITS, INJURY, DEATH OR PROPERTY DAMAGE.

Return Instructions:

James Precision will accept the return of new unused products and damaged products under the following circumstances:

It is not unlawful for a customer to ship a registered firearm, nor is it unlawful for any person or company to ship the registered firearm directly back to the owner.

1. Damaged Products

If the product is damaged when you receive it, you must report the damaged item to us within **3 business days** of receiving your order. If you receive your item on a Friday, you must contact us by **4:30 P.M. EST/EDT** the following Wednesday. All returns of damaged items require a **Return Merchandise Authorization Number (RMA)**.

How to contact us:

- Fill out the **Repair and Return Form** on our website with all required information. You can email the Repair and Return Form to James Precision directly from our website to returns@andersonmanufacturing.com. You may also print out the Repair and Return Form, fill it out and fax or mail it to James Precision at the address below.
- When we receive the Repair and Return Form we will send you an RMA Number by email (or by phone, fax or mail if you did not provide an email address). After you receive the RMA Number, you ship the product back to us.
- We must receive your damaged product back within **14 days** of your receipt of the product.
- You must follow the **Return Instructions Applicable to All Approved Returns** set forth below.

2. Fees:

If firearms or parts are returned to James Precision as “damaged” but we determine that they are not damaged, we may charge you a fee to cover the cost of the evaluation, shipping and other labor involved in examining the item returned to us. We will notify you by email or phone of the fee to be charged. You must provide a credit card number (together with the name on the card, the expiration date, the CVV and the billing zip code) to cover the fee. The following charges may apply to services provided for firearms or part that are not “damaged”:

Evaluation \$30

Cleaning \$50

Labor \$50

Replacement parts: Cost of parts

Shipping: UPS shipping charges

3. New Unused Products.

James Precision will accept the return of new unused products under the following circumstances:

- All returns require a **Return Merchandise Authorization Number (RMA)**.
- You must contact us to obtain an RMA Number within **30 days** of delivery.
- **How to Contact us:**

Fill out the **Unused Product Form** on our website with all required information. You can email the Unused Product Form to James Precision LLC., directly from our website to james-precision.com. You may also print out the Unused Product Form, fill it out and fax or mail it to AJames Precision at the address below.

When we receive the Unused Product Form, we will send you an RMA Number by email (or by phone, fax or mail if you did not provide an email address). After you receive the RMA Number, you ship the product back to us.

- We must receive your new unused product back within **37 days** of delivery.
- You must return items in new and unused condition (unfired) with all original packaging, manuals and accessories.
- Custom products are non-refundable.
- Make sure any firearm is not loaded.

4. Return Instructions Applicable To All Approved Returns:

- The product must be shipped in a protective box. The product should be wrapped in bubble wrap or other similar packaging material to prevent movement and damage in the box while in transit. Pack your return in the original shipping package, if possible.
- You are responsible for proper return packing. James Precision LLC., is not responsible for damage caused in transit. We recommend you insure the package.
- All returns may be subject to up to a 25% restocking fee.
- However, if the return is a result of a damaged item or our shipping or packing error, we will refund the full price of the product and shipping charges once the product is returned to us.
- Your refund will be issued in the same form of payment used for purchase.
- Please allow at least 7-10 days for your refund to be posted back to your credit card account. Please wait to see your next credit card statement before contacting us about your credit.

- **It is not unlawful for a customer to ship a registered firearm**, nor is it unlawful for any person or company to ship the registered firearm directly back to the owner.

Send your return via USPS or UPS to:

James Precision LLC.,
Service and Warranty
761A Miami Cir NE
Atlanta , GA 30324

Cancellation Policy:

If you have placed an order with James Precision that you wish to change or cancel, please contact Customer Service at james-precision.com prior to our shipment of your order.

Firearm Record

Make a copy of this operations manual and proof of purchase/sales record. Maintain these items in a secure safe or fireproof container. These materials will be necessary if the firearm is damaged, stolen or returned to James Precision for warranty or repair.

Model : _____

Serial Number : _____

Purchased From : _____

Purchase Date : _____

You may attach the Proof of Purchase or Receipt, or a copy of, to this page.

Keep this Operation and Safety Manual, or a copy of this manual, with your rifle at all times.