



BLACKWATER FIREARMS

IRON HORSE RIFLE

**THUMB OPERATED TACTICAL RIFLE
SAFETY & INSTRUCTION MANUAL**



PRODUCT OF USA
PATENT PENDING



CAREFULLY READ INSTRUCTIONS
BEFORE OPERATING THIS FIREARM
BLACKWATERWORLDWIDE.COM
NORTH SALT LAKE, UTAH
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OWNER INFORMATION



NAME: _____

SERIAL #: _____

PURCHASE DATE: _____

US PATENT PENDING

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STATEMENT OF LIABILITY

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ENSURE YOUR UNDERSTANDING OF THESE INSTRUCTIONS AND WARNINGS BEFORE USE.

This manual must accompany this firearm and be transferred with it upon change of ownership or when presented to another person. Contact Blackwater for extra copies of this safety manual.
www.blackwaterworldwide.com

These warnings are to ensure the safe handling and operation of the firearm. Failure to follow these instructions may result in serious injury or death.

Blackwater Firearms are designed to function properly for knowledgeable users. Do not use your firearm unless you are familiar with these instructions are comfortable with using your firearm safely.

VIOLATION OF THE FOLLOWING RULES CAN CAUSE HARMFUL ACCIDENTS.

Before handling a firearm, understand its operation in its entirety.

Never handle a firearm without checking the magazine and the chamber.

Ensure the muzzle is always pointed in a safe direction.

Do not point a firearm at anything you do not want to fire upon.

Clear the firearm of all ammunition and check the barrel of the unloaded firearm for obstructions.

SAFETY

Never store a loaded firearm in the home or vehicle. Do not store a firearm with the cartridge in the chamber.

Keep firearms and ammunition separately and away from children.

Using, cleaning, or handling firearms in poorly ventilated areas may result in exposure to lead and other substances known to cause birth defects, reproductive harm, and other physical harm. Ensure adequate ventilation. Wash hands after handling firearms and ammunition.

Always use eye and ear protection during firearm operation. Never shoot a surface that has potential for ricochet.

Never discharge the firearm without being sure of your target and what lies beyond.

If the gun doesn't fire when trigger is pulled, maintain the same target for at least 30 seconds before removing the magazine and unfired case.

Be aware of your surroundings and ensure that people cannot accidentally enter the line of fire. Follow all rules and regulations when operating at a target range. Do not cross rivers or similar obstacles while the firearm is loaded.

Ensure that nobody operates the firearm that does not understand gun safety and proper handling.

THE FIREARM CAN REACH TEMPERATURES HIGH ENOUGH TO CAUSE SEVERE BURNS.

When transporting your firearm, be sure your firearm is unloaded with the safety engaged. If you have questions about the safe operation of our products, please contact us at:
www.blackwaterworldwide.com

DO NOT modify any part of the product.

DO NOT handle firearms under the influence of alcohol, drugs, or medications.

DO NOT load the firearm without pointing the firearm in a safe direction.

DO NOT load a firearm unless you expect to immediately shoot.

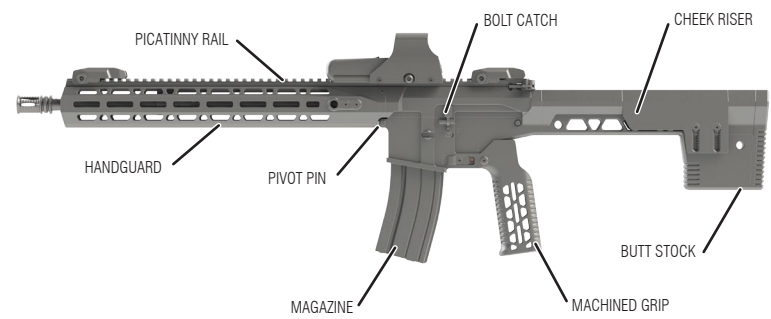
SAFE GUN HANDLING IS YOUR RESPONSIBILITY.

OVERVIEW

DESCRIPTION

The TOR model has several advantages over traditional trigger implementations, allowing shooters maximum control by employing the strongest digit on the hand. Force applied to the trigger is in line with the shooters center of aim, opposed to traditional left or right error common with a traditional trigger pull. The TOR model offers a shorter learning curve for new shooters, increased dexterity in cold weather, and safer transport. The TOR also enables disabled shooters to operate a firearm.

COMPONENTS



DIMENSIONS AND WEIGHT

| | | |
|-----------------|------------|--------------|
| Total Length | 38.34" | (973.84 mm) |
| Total Width | 01.92" | (048.88 mm) |
| Total Height | 08.42" | (213.95 mm) |
| Width of Grip | 01.13" | (028.58 mm) |
| Width of Forend | 01.55" | (039.31 mm) |
| Width of Stock | 01.39" | (035.31 mm) |
| Weight | 09.00 lbs. | (004.08 kg.) |

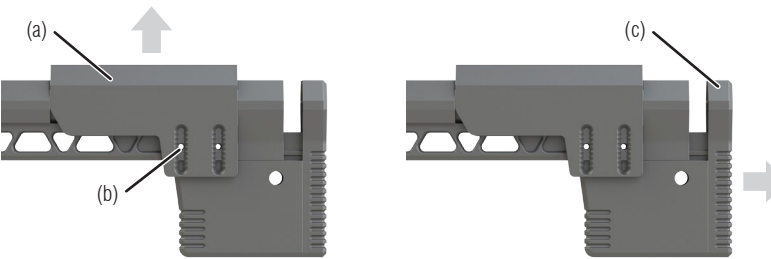
*All specifications subject to change.

ACCESSORIES & ADJUSTMENTS

CHEEK RISER & TAILSTOCK ADJUSTMENTS

Upon receiving your TOR Rifle, calibrate the adjustments to your shooting style. The tailstock (c) and cheek riser (a) will adjust to your desired posture. Remove the four screws (b) in the cheek riser. Adjust riser to desired position. Before replacing the screws, pull buttpad rearwards to adjust the tailstock to your desired length. When both components are adjusted and resting in position, replace the four cheek riser screws to lock in your custom firing position.

COMPONENTS



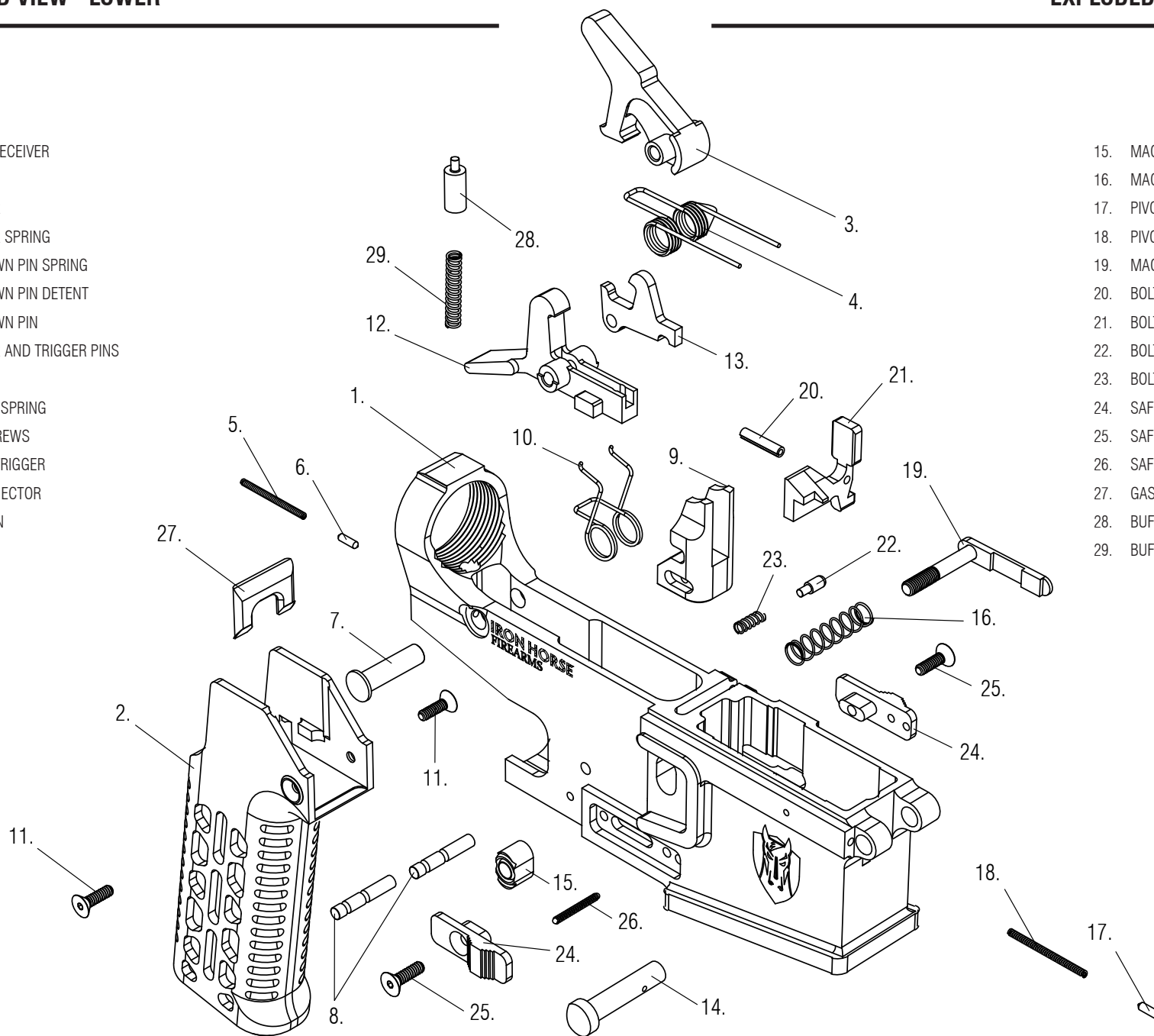
QUICK DISCONNECT SLING MOUNTS

The TOR Rifle features two quick disconnect sling mounting locations (d,e) as shown below. Mounting location is dependent on shooter preference



EXPLODED VIEW - LOWER

1. LOWER RECEIVER
2. GRIP
3. HAMMER
4. HAMMER SPRING
5. TAKEDOWN PIN SPRING
6. TAKEDOWN PIN DETENT
7. TAKEDOWN PIN
8. HAMMER AND TRIGGER PINS
9. SAFETY
10. TRIGGER SPRING
11. GRIP SCREWS
12. THUMB TRIGGER
13. DISCONNECTOR
14. PIVOT PIN



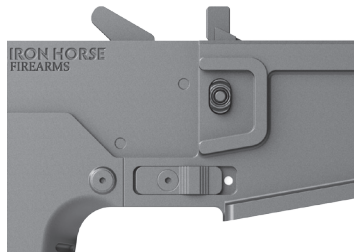
EXPLODED VIEW - LOWER

15. MAGAZINE RELEASE BUTTON
16. MAGAZINE CATCH SPRING
17. PIVOT PIN DETENT
18. PIVOT PIN SPRING
19. MAGAZINE CATCH
20. BOLT CATCH ROLLER PIN
21. BOLT CATCH
22. BOLT CATCH PLUNGER
23. BOLT CATCH SPRING
24. SAFETY SELECTOR
25. SAFETY SCREWS
26. SAFETY SELECTOR SPRING
27. GAS SHIELD
28. BUFFER RETAINER
29. BUFFER RETAINER SPRING

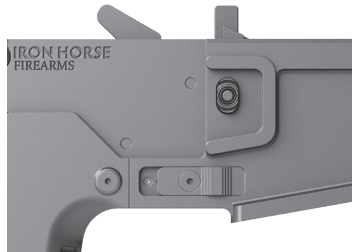
OPERATING INSTRUCTIONS

SAFETY

The TOR features a sliding manual safety located on the grip assembly. When the safety is activated, it prevents the thumb trigger from being depressed. The safety selector slide is generally engaged with either index finger.



SAFE (above)



FIRE (above)

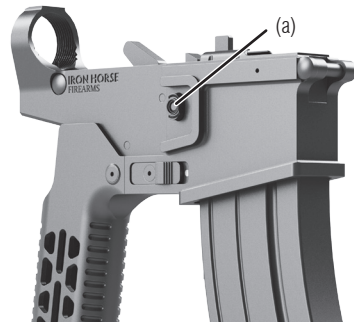


FIGURE 1

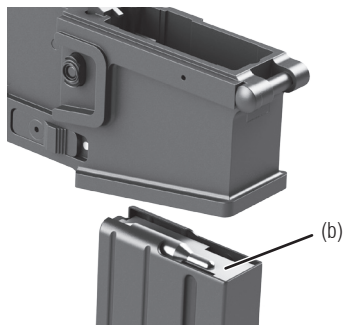


FIGURE 2

LOADING

Do not load the firearm before reading and understanding this manual in its entirety.

Press the magazine release (a) and remove the magazine from the firearm. (Fig. 1)

Load one round at a time.

Feed each round into the magazine (b) from the top. (Fig. 2)

Place the next round on top of the previous round and repeat until loaded.

Do not load the magazine beyond its capacity. Pull the charging handle back and press the bottom of the bolt catch (c) down and release the pressure on the charging handle. This will keep the bolt in the open position. (Fig. 3)

OPERATING INSTRUCTIONS

Return charging handle fully forward until it locks and release bolt catch.

Set safety selector (d) to SAFE. (Fig. 4)

With the bullets oriented correctly, insert the loaded magazine (e) into magazine until it is securely locked in. Check that it is locked by pulling down on the magazine. (Fig. 5)

Always point the muzzle in a safe direction when you release the bolt.

Press the top of the bolt catch (f) in order to release the bolt. This allows it to move forward and feed a round in the chamber. (Fig. 6)

The firearm is now loaded. If the safety is set to 'FIRE', the firearm will discharge when thumb trigger is suppressed.

If the round is not properly chambered, the bolt must be opened and properly cleared.

Always load a round by feeding it through the magazine, not directly into the ejection port. Failure to follow these instructions can result in serious injury or death.

This product will fire with the magazine removed. Keep your thumb away from the trigger until you have made the decision to fire.

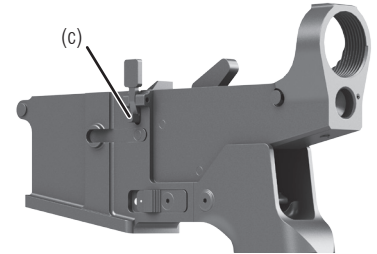


FIGURE 3

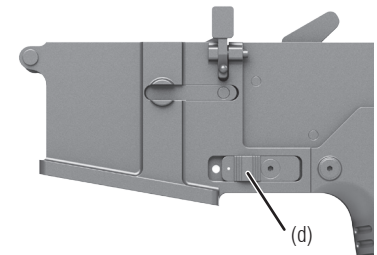


FIGURE 4

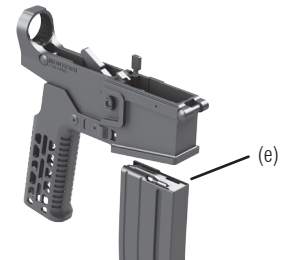


FIGURE 5

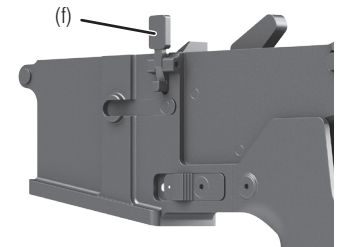


FIGURE 6

OPERATING INSTRUCTIONS

FIRING

Always keep muzzle pointed in a safe direction. Wear firearm specific eye and ear protection every time you operate your firearm.

Grasp firearm with one hand on the hand guard and other hand on the firearm grip. Rest your thumb outside of the trigger enclosure. Raise the firearm and pull the stock to your shoulder.

Move the safety selector (g) to 'FIRE'. (Fig. 7)

Keeping steady aim, place your thumb on the trigger (h) and compress lightly until the rifle fires. Your firearm reloads immediately after firing. (Fig. 8)

You may continue to fire by compressing and fully releasing the trigger until the magazine is empty.

If you wish to stop shooting, release the trigger, remove your thumb from trigger enclosure, and set the safety (i) to 'SAFE'. (Fig. 9)

If you have fired the last round from the magazine, the bolt will be held to the rear so the firearm can quickly be reloaded by replacing the magazine. Now the chamber can be inspected to ensure that it's empty.

CLEARING A JAM

Be certain the muzzle is pointed in a safe direction and remove the magazine.

Pull the charging handle back and lock the bolt open with the bolt stop (j) before attempting to clear the jam. Drawing the bolt fully to the rear may bring the jammed cartridge along. (Fig. 10)

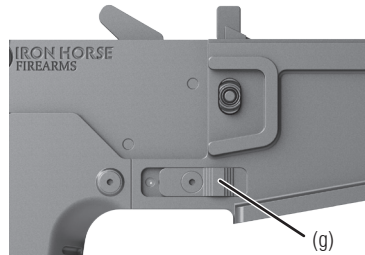


FIGURE 7

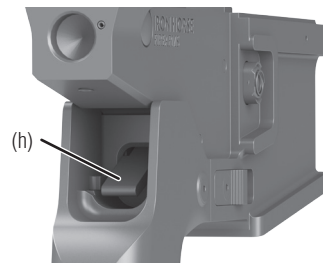


FIGURE 8

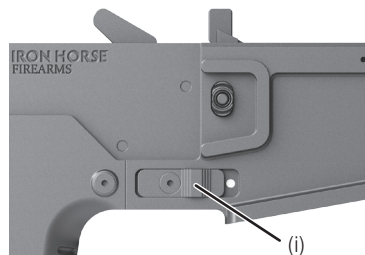


FIGURE 9

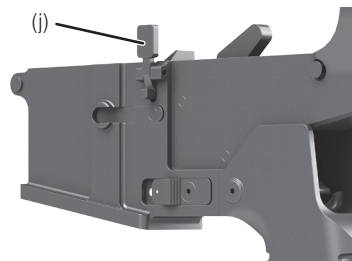


FIGURE 10

CLEARING A JAM CONTINUED

Put the safety (k) in the safe position. (Fig. 11)

Keep your face away from the ejection port. A cartridge may ignite if the rim/primer of the cartridge is struck. If a cartridge ignites while being cleared, it could result in serious injury or death.

Only use wood tools such as a pointed dowel to remove a jam. Use extreme caution to avoid striking the rim/primer of the cartridge.

Check to make certain all cartridges have been removed from the firearm. Dispose of any cartridges involved in a jam. Never use damaged ammunition in any firearm.

Once the cause for the mis-feed is cleared, load the firearm normally.

UNLOADING

Press the magazine release (l) to remove the magazine. (Fig. 12)

When the last round has been fired, the bolt will be held open if the magazine is empty.

Pull charging handle to rear and push in bolt catch to remove any round from chamber.

Set the safety selector (m) to 'SAFE'. (Fig. 13)

Look in the chamber through ejection port to ensure it's empty.

Remove remaining live rounds (n) from the magazine by sliding them forward and out of the magazine. (Fig. 14)

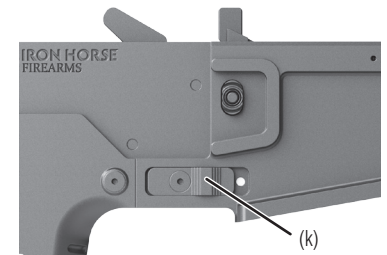


FIGURE 11

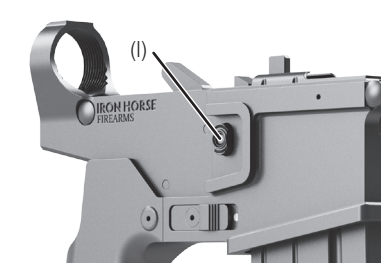


FIGURE 12

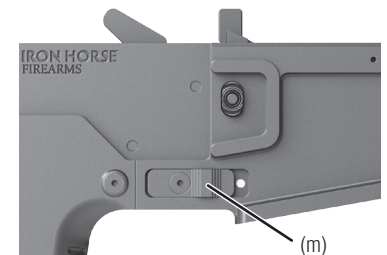


FIGURE 13

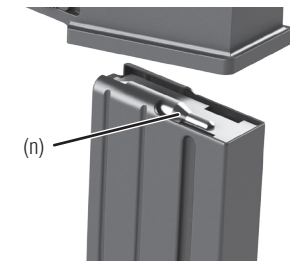


FIGURE 14

DISASSEMBLY/ASSEMBLY

Ensure that the magazine is removed and that the firearm is not loaded.

Push the top of the bolt release (o) to ensure that the bolt is in the forward position. (Fig. 15)

Push in the take down pin (p) from the left of lower receiver and pull the pin out until it comes to a positive stop. (Fig. 16)

Pivot the lower receiver down and away. (Fig. 17)

Push the pivot pin (q) for a full disassembly. (Fig. 16,18)

Pull the charging handle to the rear and remove the bolt assembly and the charging handle.

Assemble your firearm in the reverse order.

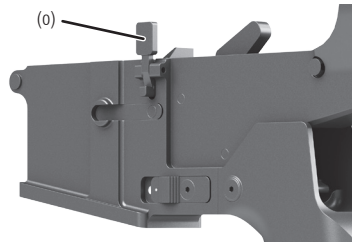


FIGURE 15

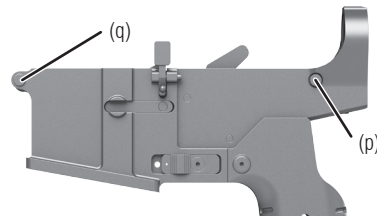


FIGURE 16



FIGURE 17



FIGURE 18

WARRANTY INFORMATION

SCOPE OF WARRANTY

Blackwater Firearms products are warranted to be free from defective materials and workmanship for the life of the original purchaser. Blackwater Firearms obligation under this warranty shall be limited to (1) repairing or (2) replacing any product upon inspection at Blackwater Firearms and based on its discretion, is found to defective in material or in workmanship. This warranty is limited and does not extend to: careless handling, abuse and misuse, unauthorized adjustments or modifications, use of improper ammunition, excessive or unreasonable use, ordinary wear & tear, rust or corrosion, and barrel obstruction. Repairs are warranted for the duration of the original warranty and applies only to factory built products.

EXCLUSIVE REMEDY

The remedies in this section and in the warranty agreement constitute the sole and exclusive remedies of any authorized customer, as well as its successors and assigns, for any defect in the product.

DISCLAIMER

The warranty stated in this agreement is the sole and exclusive warranty pertaining to the product. Blackwater Firearms disclaims any warranty express or implied, including, without limitation, any warranty of merchantability or fitness for a particular purpose. In no event shall Blackwater Firearms be responsible for any indirect, incidental or consequential damages including, without limitations, lost profits, costs of delay, with respect to economic loss or injury to property or to third parties, whether as a result of breach of express or implied warranty, negligence or otherwise. Prior to returning any Blackwater Firearms product for warranty work, you must receive return material authorization (RMA) from our customer service department. The contact information is shown below. Items must be returned prepaid to Blackwater. Blackwater Firearms accepts no responsibility for items lost or damaged in shipping. Items that are returned and found to be Out-of-Warranty will be repaired at the customer's expense; however, no work will be performed without the customer's written authorization.

E-mail intel@blackwaterworldwide.com for shipping authorization.



CUSTOMER WARRANTY CARD

THIS SLIP TO BE MAILED WITH UNLOADED FIREARM FOR WARRANTY & SERVICE

Do not ship with ammunition. Blackwater recommends shipment to be insured by owner.

NAME: _____

SERIAL #: _____ PURCHASED: ____/____/____

ADDRESS: _____

PHONE: _____ E-MAIL: _____



CAREFULLY READ INSTRUCTIONS & WARNINGS

BEFORE OPERATING THIS FIREARM

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