



Operation and Safety Manual for the Evolution Competition Rifle



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Disclaimer of Liability

360 Precision shall not be responsible for product malfunction or for physical injury, death or damage to property resulting from either intentional or accidental discharge of this firearm, its criminal or negligent use, improper or careless handling, unauthorized modifications or alteration, use of defective, improper or hand-loaded ammunition, or from its use for purposes or subjection to treatment for which it was not designed. For your safety, use only original high quality commercially manufactured ammunition in good condition that matches the caliber of your rifle. 360 Precision shall not be responsible for the product or its result from use of defective, improper or reloaded ammunition.

Safety

Important Notice!

Before your Evolution rifle left our shop, it was inspected, function tested, and test fired. 360 Precision can not control the handling of the rifle after it has left our shop. Therefore, at the time of purchase carefully examine the rifle to be sure it is unloaded and undamaged.

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. If unfamiliar with firearms, seek appropriate firearms instruction through courses run by NRA approved instructors or similar qualified organizations.



WARNING:

ALWAYS HANDLE YOUR FIREARM AS IF IT IS LOADED! NEVER point your firearm at anything you don't intend to shoot. Always be sure of your target and what is behind it before firing.



CAUTION:

USE ONLY CLEAN, DRY, HIGH QUALITY COMMERCIALY MANUFACTURED AMMUNITION IN GOOD CONDITION which matches 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 WEAPON COULD CHAMBER A ROUND if it is dropped or jarred with a loaded magazine in place.



WARNING:

NEVER LEAVE A LOADED FIREARM UNATTENDED! 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.

Safe Handling Procedures

- The Evolution rifle was designed to function properly in its original condition. Do not alter or modify the Evolution rifle.
- Careless and improper handling of the Evolution rifle could result in unintended discharge causing injury, death or property damage. Safety must be the first and a constant consideration when handling a firearm and ammunition.
- The Evolution rifle should always be carried with an empty chamber and with safety selector to the “safe”  position to prevent accidental discharge.
- Always keep the safety selector on “safe”  when the Evolution is loaded and a round is chambered. Only switch the safety selector to “fire”  position when ready to shoot. Never place your fingers inside the trigger guard until ready to fire.
- Always handle and treat the Evolution as if it were loaded. Always make sure the firearm is unloaded before handing it to another person. Never assume the firearm is unloaded when receiving it from another person. Always perform a visual check of the chamber while keeping fingers away from the trigger and the barrel pointed in a safe direction.
- Always make sure the Evolution is not loaded and the bolt is latched open and to the rear before laying it down or handing it to someone else.
- Unload the Evolution when not in use. Never store a loaded firearm. Firearms and ammunition should be stored safely and separately so that they are inaccessible to children or unauthorized users.
- Do not consume alcohol or drugs before or during shooting. Do not indulge in horseplay when handling firearms. Doing so may result in property damage, injury or death
- Always wear and encourage others to wear safety glasses while shooting to prevent eye injury from gas, gun powder, metallic particles, and other debris. Always wear and encourage others to wear ear protection when shooting to prevent hearing injury.
- Obey all applicable local, state and federal laws regarding shooting, transporting and storing the Evolution rifle.

Always Practice Safe Firearms Handling!

Dangerous Procedures

- Do not exchange bolt assemblies from one rifle to another. It could cause harm to you and others and cause severe damage to your rifle.
- If your firearm fails to fire, keep the barrel pointed safely downrange and wait 30 seconds. If the failure to fire was caused by a hangfire, the round will fire within that 30 seconds. If the failure to fire was caused by a misfire, remove the magazine, eject the round and examine the primer. If the firing pin indent on the primer is light or non-existent, have your firearm examined by a qualified gunsmith. If the firing pin indent on the primer appears normal, assume the issue is faulty ammunition and dispose of misfired round.
- If your rifle misfires with a live round in the chamber of a particularly hot barrel, keep the barrel pointed safely downrange and immediately eject the round. If the live round fails to eject, remove the magazine and wait 15 minutes for the barrel to cool. After cooling, try to remove the round. Always keep your face away from the ejection port when clearing a hot chamber.
- Continuous, rapid firing of your rifle can cause the barrel temperature to reach a temperature where a live round to “cook-off” or fire with only brief contact with a hot chamber.
- If the bolt locks in the forward position, it can be freed by banging the stock on the ground (mortaring). Keep the barrel pointed in safe direction and stay clear of the muzzle when performing this procedure.
- Never fire your rifle with water, snow, mud, excessive lubricating oil, or any other material or any other substance in the barrel as this could cause the barrel to explode.
- If you experience a noticeable difference in sound or recoil when firing, STOP FIRING IMMEDIATELY! Either condition could indicate an incomplete powder burn possibly causing a bullet to become stuck in the bore. Immediately clear the rifle and check for unburned powder in the bore and for a bullet stuck in the bore. Remove the unburned powder before firing as firing with unburned powder in the barrel could cause the barrel to explode. If a bullet is stuck in the bore, have your firearm examined by a qualified gunsmith
- Do not shoot at hard surfaces. Doing so may result the bullet traveling in a unpredictable direction that could cause property damage, injury or death.

Always Practice Safe Firearms Handling!

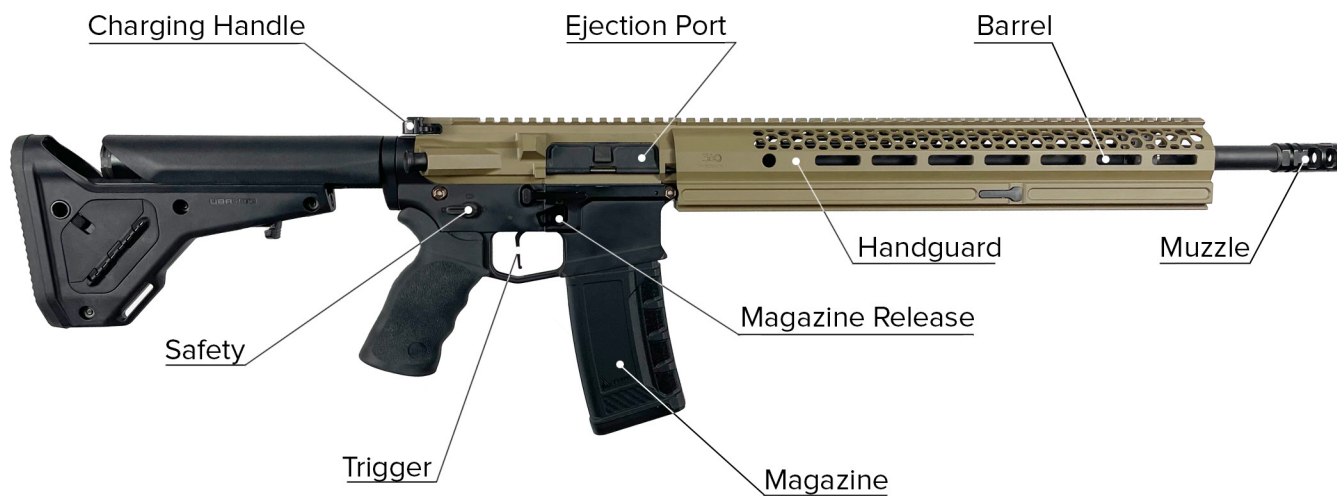
About the Evolution Competition Rifle

Description

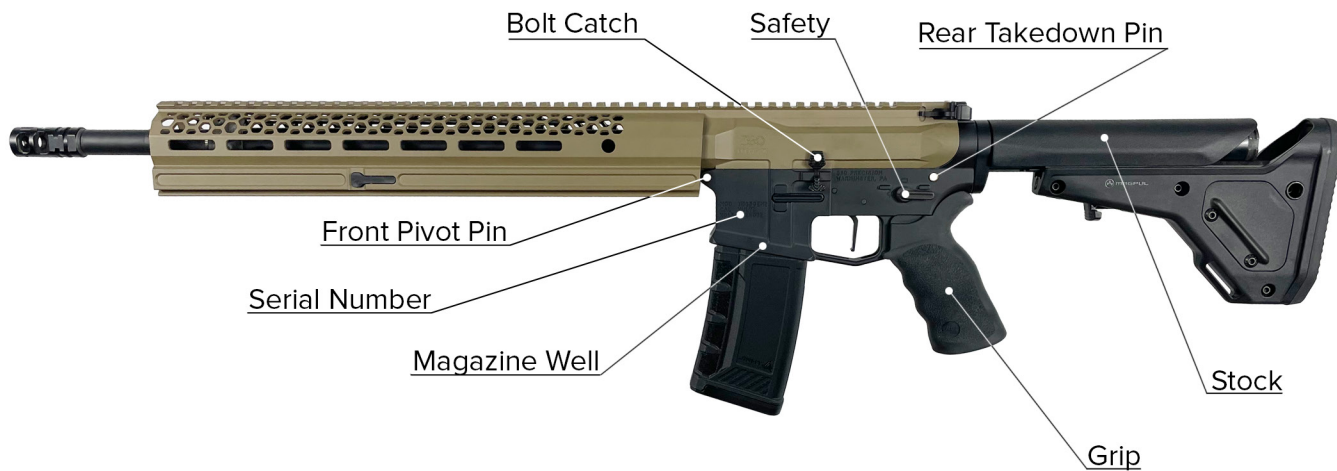
The Evolution rifle is a gas-operated, magazine-fed, shoulder-fired, semi-automatic rifle. A round is fired when the trigger is pulled releasing the hammer that drives the firing pin into the primer of a chambered round. The primer ignites the gun powder in the round and the gas pressure from the burning gun powder propels the bullet down the barrel of the rifle. Rifling in the barrel causes the bullet to spin resulting in stable flight to the target. As the bullet nears the end of the barrel, the gas from the burning gun powder travels back through the gas tube along the barrel and into the gas key on the bolt carrier group forcing the bolt carrier group rearward. This action ejects the spent round and chambers the new round.

Parts of Your Rifle

Right Side View



Left Side View



Operating Your Evolution Competition Rifle

Safety



Safety selector in “safe” position



Safety selector in “fire” position

The safety selector lever has two positions, “fire”  and “safe” . When set to “fire”  the fire-arm will fire a single shot each time the trigger is pulled. When set too “safe” a cam bears upon the rear of the trigger, blocking trigger movement and preventing the hammer from being released.

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.

- 1 Press the magazine release to remove the magazine from the rifle.
- 2 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.
- 3 If there is a round in the chamber, it will be ejected.
- 4 Return the charging handle fully forward until it locks in place and remove your finger from the bolt catch.
- 5 Set the safety to the “safe”  position.
- 6 Inspect the chamber making sure it is empty.
- 7 With the rifle pointed in a safe direction, press in on the top of the bolt catch. This will release the bolt carrier group.
- 8 Close the ejection port cover

Loading the Magazine



- Use only quality ammunition suitable for 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 Evolution 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.
- The Ejection Port Cover (dust cover) can be closed and will open automatically when the first round is fired.
- Do not disengage the safety until the rifle is pointed in a safe direction and you are ready to fire.

Firing Your Evolution Rifle

- Always wear ear and eye protection.
 - Before firing, practice grip, stance, and aim with the Evolution unloaded.
- 1 Load the Evolution as previously described.
 - 2 Grasp the Evolution with firing hand on the handguard and other hand on the grip with trigger finger indexed alongside the trigger guard. Raise the Evolution and place the stock firmly into shoulder.
 - 3 Move the safety to the “fire”  position, place trigger finger on the trigger and pull gently until the trigger breaks and releases the hammer.
 - 4 To fire the next and subsequent rounds, release the trigger to reset it and pull it again after every round until the magazine is empty. The Evolution is a semi-automatic rifle and automatically chambers the next round.
 - 5 Once the magazine is empty, remove trigger finger from trigger and set safety to “safe” . If the magazine is empty, the bolt carrier group will lock to the rear so the chamber can be checked to ensure it is clear.

Maintaining your Evolution Competition Rifle

Rifle Disassembly

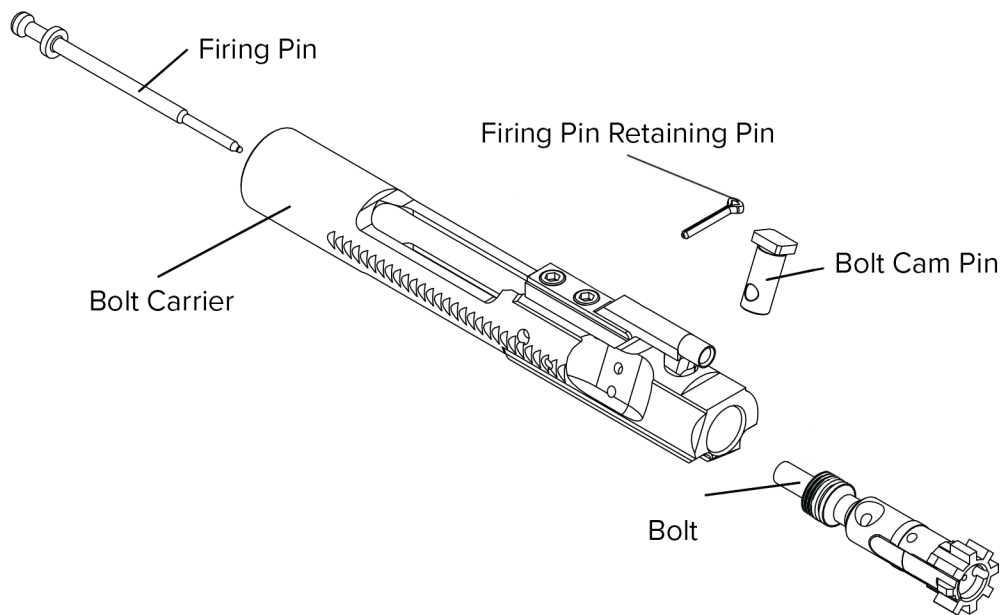


WARNING:

BEFORE DISASSEMBLY, REMOVE THE MAGAZINE, CLEAR THE CHAMBER AND MAKE SURE THE FIREARM IS IN THE “SAFE”  POSITION.

- Make sure the bolt carrier group is in the forward (battery) position.
- Slide the rear take down pin out, the Evolution’s upper receiver will now pivot forward.
- To completely separate the lower receiver from the upper receiver, slide the front pivot pin out.
- To disengage and remove the bolt carrier group, pull the charging handle back and remove the bolt carrier group and the charging handle.

Disassembling the Bolt Assembly



- 1 Remove the firing pin retainer pin.
- 2 Remove the firing pin.
- 3 To remove the bolt cam pin, extend the bolt completely, rotate the bolt cam pin 90°, push the bolt back into the bolt carrier so that bolt cam pin clears the bolt carrier gas key, then slide the bolt cam pin up and out.
- 4 Inspect the bolt cam pin for wear.
- 5 Note the orientation of the extractor and ejector before removing the bolt from the bolt carrier.
- 6 Inspect the lugs and the gas rings on the bolt for wear.



WARNING:
FURTHER DISASSEMBLY IS NOT RECOMMENDED.

Cleaning Your Evolution Competition Rifle



WARNING:

BEFORE CLEANING, REMOVE THE MAGAZINE, CLEAR THE CHAMBER AND MAKE SURE THE FIREARM IS IN THE “SAFE”  POSITION.

Cleaning the Barrel Bore

- 1 Make sure the bolt carrier group is in the forward (battery) position. Slide the rear take down pin out allowing the Evolution's upper receiver to pivot forward. Pull the charging handle back and remove the bolt carrier group and the charging handle.
- 2 Always clean from the chamber toward the muzzle.
- 3 Wet a cotton patch with cleaning solution, attach it to the cleaning rod with a patch holder, then insert it into the chamber and pass it through the bore. Be sure to go all the way through the barrel and out the muzzle.
- 4 Wet a cotton patch with cleaning solution, attach it to the cleaning rod with a patch holder, then insert it into the chamber and pass it through the bore. Be sure to go all the way through the barrel and out the muzzle. Continue this procedure until the patch comes out clean. Complete this process by passing an oiled patch through the bore.
- 5 If more substantial cleaning is required, attach a nylon bristle bore brush to a cleaning rod, dip the brush in cleaning solution then insert it in the chamber and pass it through the bore. Be sure to go all the way through the barrel and out the muzzle before reversing direction. Always have the bore wet with cleaner before using a nylon bristle brush. Never reverse the direction of the bore brush while it is in the bore.

Cleaning the Upper and Lower Receiver

- 1 Use a cleaning solution and a nylon bristle brush to clean the aluminum upper and lower receiver. A wire brush may damage the finish of the aluminum.
- 2 Use a cleaning solution and a nylon bristle brush to clean the firing chamber and the area around the gas tube in the upper receiver. Use a pipe cleaner to clean out the gas tube.
- 3 Wipe all components clean and dry, and inspect for excessive wear, corrosion or mechanical damage.
- 4 Use a cleaning solution and a nylon bristle brush to wipe any dirt from the trigger mechanism. Carefully clean the magazine release and the magazine catch on the left side of the lower receiver. Clean the bolt catch and the front pivot pin and rear takedown pin.

Cleaning the Bolt Carrier Group

- 1 Begin cleaning the bolt carrier group by applying a thin coating of cleaning solution to each of the bolt carrier group parts allowing time for the cleaning solution to break down the carbon.
- 2 Use a nylon bristle brush, cotton swabs, and cotton patches to clean the bolt carrier group parts.
- 3 After cleaning the bolt carrier group, make sure to rub down each part, including the firing pin, firing pin retaining pin, and cam pin to remove any remaining carbon build up.

Lubricating the Bolt Carrier Group

- 1 Lubricate the firing pin and the firing pin recess in the bolt.
- 2 Lubricate the inner and outer surfaces of the bolt carrier. Lightly lubricate the cam pin area and the slide rail areas of the bolt carrier where they contact the inside of the upper receiver.
- 3 Lightly lubricate the bolt, the cam pin area, the gas rings. Lightly lubricate the extractor and the extractor pin. Be sure to lubricate in and around all the locking lugs on the bolt.
- 4 Lubricate the charging handle including the latch and the spring.
- 5 Dry the inside of the gas key on the bolt carrier with a pipe cleaner, then lightly lubricate the inside of the gas key.

Lubricating the Upper and Lower Receivers:

- 1 Lightly lubricate the inside of upper receiver, the chamber, and the outer surfaces of the upper receiver and the barrel.
- 2 Generously lubricate all moving parts inside the lower receiver including the trigger, hammer, safety, bolt catch, and magazine release.
- 3 Lubricate the front pivot pin and rear takedown pin and their detents.
- 4 Lightly lubricate the inside of the buffer tube, the buffer and the buffer spring. Also lightly lubricate the latch of the telescoping stock.
- 5 Wipe all exterior surfaces to remove any fingerprints on the exterior surfaces as their oils can start the corrosion process.

Reassembling the Bolt Assembly:

- 1 Reinsert the bolt into the bolt carrier, matching the orientation of the ejector and extractor when removed.
- 2 Reinsert the cam pin and rotate 90°.
- 3 Reinsert the firing pin making sure it is seated completely forward towards the bolt face.
- 4 Reinsert the firing pin retaining pin.
- 5 After assembly, make sure the bolt moves freely in the bolt carrier and that the firing pin is secured in place.

Rifle Assembly

- Reinsert the charging handle into the upper receiver by aligning the ears of the charging handle with the corresponding notch in the upper receiver. The charging handle must be seated at the bottom of the slot in the upper receiver. Slide the charging handle slightly forward.
- With the bolt fully extended from the bolt carrier, install the bolt carrier group into the upper receiver using the slot in the charging handle as a guide.
- Slide the bolt carrier group into the forward (battery) position.
- Line up the upper and lower receiver pivot pin holes and slide the front pivot pin into the locked position.
- Pivot the receivers together and slide the take down pin into the locked position.
- The firearm is now assembled.

Function Test:



WARNING:

BEFORE PERFORMING A FUNCTION TEST, REMOVE THE MAGAZINE AND CLEAR THE CHAMBER AND KEEP THE FIREARM POINTED IN A SAFE DIRECTION.

- Pull the charging handle fully to the rear and release. Make sure the bolt carrier group returns to the forward (battery) position.
- Move the safety selector to the “safe”  position.
- Pull the trigger to check that the safety is working correctly.
- Move the Selector to the “fire”  position.
- Pull the trigger to check that the hammer is falling properly. Dry firing the Evolution will not damage it in any way.

Storing your Rifle:



WARNING:

BEFORE STORING, REMOVE THE MAGAZINE AND CLEAR THE CHAMBER.

- 1 After clearing the chamber, check that the bolt carrier group is in the forward (battery) position.
- 2 Point the gun in a safe direction and pull the trigger so the hammer is in a fired state.
- 3 Close the dust cover
- 4 Store the rifle in a locked case in a safe area.
- 5 If storing your rifle for an extended period of time, use a lite coat of oil in the barrel and chamber to prevent corrosion.

Warranty and Guarantee Information

Warranty

We warranty any original 360 Precision products from manufacturing defects for the lifetime of the product. Normal wear and tear (e.g., barrel rifling) is not covered in this warranty.

Guarantee

Our goal is customer satisfaction through our products and services. If any of our products or services fall short in performance or function, please contact us and we will work with you to ensure you are satisfied with your 360 Precision products and services.