

# Rifle HK417

Calibre 7.62 mm x 51



Maintenance manual





### 1.4.3 Conventions for illustrations



Illustrations and drawings can vary from your weapon, depending on the model.

The information “right”, “left”, “front” and “back” apply to the weapon as seen in the direction of fire.

Illustrations and their constituent elements support the descriptions in this manual, and are identified as follows:

- The name of an illustration comprises the current page number and a consecutive lower-case letter starting again from “a” on each page, e.g. 6a.
- Calls to perform an action are indicated by upper-case letters enclosed in circles.
- Components relevant to the action are highlighted in blue. Where necessary the components are marked with numbers and identified in a legend.
- Motions are indicated by orange-coloured arrows.

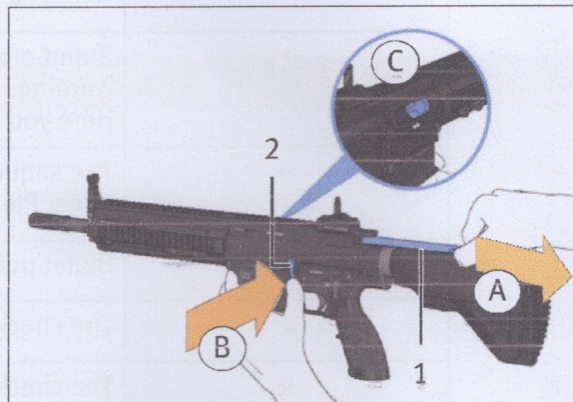


Fig. 6a: Example of an illustration

- 1 Charging handle
- 2 Bolt catch/release

### 1.4.4 Conventions for cross references

Cross references represent relationships between the text and an illustration or an individual section. Cross references are in *italics* and enclosed in (brackets).

- Example of a cross reference between the text and an illustration: (6a-2)  
The cross reference refers to numeral 2 in the illustration numbered 6a on page 6, the bolt catch/release.



The text frequently refers to the front and back fold-out pages, which are identified by the Roman numerals I (front) and II (back)

- Example of a cross reference between sections: (Section 1.4.3)  
The cross reference refers to Section 1.4.3, conventions for illustrations.



## 2 Fundamental safety instructions



The weapon has been designed and manufactured according to the latest technical knowledge and the recognised safety rules. Nevertheless, use of the weapon may result in injury or death of the user and third parties, or damage to the weapon and other material property.

- › Follow all of the instructions in this maintenance manual and the operator's manual for the weapon described here. Non-compliance may result in injury or death.
- › Do not handle the weapon if you are tired, feel unwell, or have consumed alcohol, drugs or medicines.
- › Follow the applicable regulations for the handling of weapons.

### 2.1 Safety instructions for handling the weapon

- › Special care must be taken when handling firearms, because the position and direction of the weapon can be changed very easily.
- › Use the weapon only if it is in perfect technical condition.
- › Treat the weapon as if there were a round in the chamber until you have verified whether or not it is actually loaded.
- › Make sure that the weapon is always unloaded when it is handled for purposes other than loading or firing.
- › Use the weapon only for its intended purpose. Do not use the weapon as a club, hammer, pry bar, etc. Using the weapon for other than its intended purpose may result in accidental discharge of weapon or damage to the weapon.
- › Do not play with the weapon.
- › Never point the weapon at people when handling or practising with it.
- › Do not touch the trigger when loading, unloading, aiming or handling the weapon in any other way. Always place your trigger finger on the outside of the trigger guard.
- › Do not use excessive force when handling, disassembling, cleaning and assembling the weapon.



- › Avoid dry firing of the hammer. Dry firing of the hammer can lead to premature wear.
- › Store weapon and ammunition separately. Be sure to prevent access to the weapon and ammunition by unauthorised persons, especially children.
- › Never give or take the weapon unless it is unloaded and the bolt is in the open position.
- › Immediately rectify any faults that compromise safety.
- › Exposure to exceptional stresses such as when the weapon is banged or dropped can have a negative effect on safety. Inspect the weapon after any excessive stresses.
- › Do not rely on safety features. Safety features are no substitute for careful, correct handling of the weapon.
- › When using accessories and ammunition, follow the instructions provided by their respective manufacturers.

## 2.2 Safety instructions for firing

- › Wear hearing protection when firing.
- › Wear safety goggles when firing.
- › Keep your hands out of the path of the bolt when firing.
- › Keep the muzzle area clear when firing.
- › Do not shoot at doors, panes of glass, walls, concrete, stone, or smooth surfaces (including water). A round can penetrate these objects or be deflected in an unsafe direction.
- › Pull the trigger only if the weapon is pointing at the target and the area behind the target is not endangered.
- › Use only properly loaded, undamaged cartridges of the correct calibre.
- › Wear protective gloves when touching the barrel or the flash hider after firing. The barrel and flash hider heat up during firing.



## 2.3 Exclusion of liability and warranty

Heckler & Koch GmbH accepts no liability and provides no warranty for incidents arising from:

- non-compliance with this manual,
- incorrect handling of the weapon,
- negligence,
- improper use,
- modifications, attachments to or conversion of the weapon without the express written consent of Heckler & Koch GmbH, or
- use of accessories or spare parts from other manufacturers without the express written consent of Heckler & Koch GmbH.



### 3 Auxiliary materials



The specified service life of the weapon can only be ensured if the auxiliary materials listed in this manual are used.



Required auxiliary materials are listed at the beginning of each section.

#### 3.1 Tools, lubricants and other auxiliary materials



Tools, lubricants and other auxiliary materials are available from specialist dealers. Auxiliary materials that have an Ident.-No. can also be ordered from Heckler & Koch.

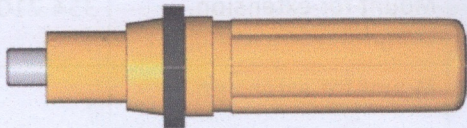

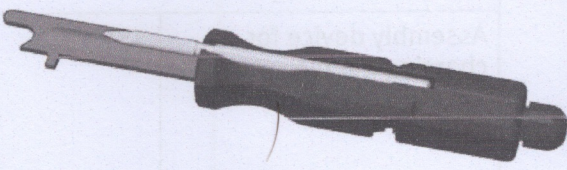
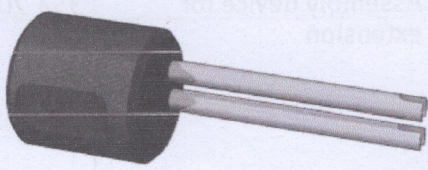
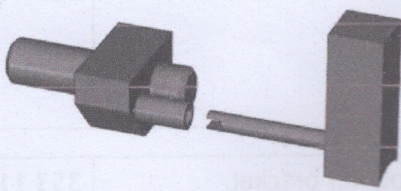
- Ø 0.9 mm pin punch (Ident.-No. 957 308)
- Ø 1.4 mm pin punch (Ident.-No. 957 309)
- Ø 1.8 mm pin punch (Ident.-No. 957 310)
- Ø 2.4 mm pin punch (Ident.-No. 957 311)
- Ø 2.8 mm pin punch (Ident.-No. 957 312)
- Ø 3.4 mm pin punch (Ident.-No. 957 313)
- Ø 5.9 mm pin punch (Ident.-No. 957 322)
- Hammer, 200 g (Ident.-No. 957 416)
- Mounting pin 3.92h8 x 13 mm (Ident.-No. 235 659)
- Mounting pin 3.9 x 8 mm (Ident.-No. 354 626)
- Screwdriver, 7 x 150 mm (Ident.-No. 952 656)
- Screw bit 1.62 x 25 mm (Ident.-No. 973 357)
- Extension for screw bit (Ident.-No. 973 356)
- Pliers (Ident.-No. 997 417)
- Lubricating oil (Ident.-No. 979 341): Arpol Petroleum Company, Arpolube 46000
- Lubricating paste (Ident.-No. 960 930): Castrol, Optimol Paste PL
- Preservative oil (Ident.-No. 985 372): Electrolube, LWP (Light Weapons Preservative)
- "Break Free" oil (Ident.-No. 982 576): CLP Chemicals, CLP-9
- 7.62 mm x 51 training rounds (Ident.-No. 235 897)
- Loctite 242
- Target
- Cleaning rag
- Cleaning kit (Ident.-No. 978 523)
- Vice
- Mat



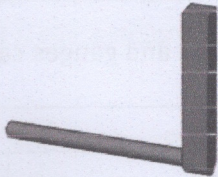



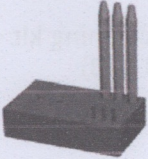
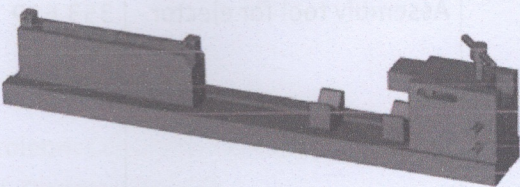
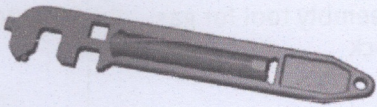

## 3.2 Special tools and gauges




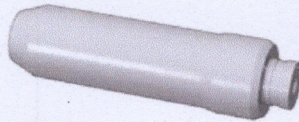
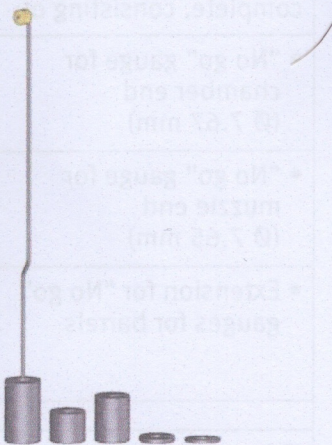
Special tools and gauges can be ordered from Heckler & Koch using the Ident.-No. shown.

Special tool	Ident.-No.	Illustration
Torque wrench 1 - 5 Nm	987 613	
Torque wrench 20 - 200 Nm	968 301	
Assembly and cleaning tool (contained in cleaning kit Ident.-No. 978 523)	235 641	
Assembly tool for ejector	353 619	
Assembly tool for gas block	354 205	

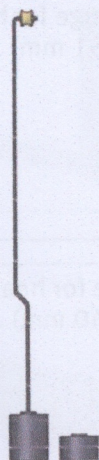






Special tool	Ident.-No.	Illustration
Cleaning tool for gas block	354 259	
Mount for extension, complete, consisting of:	354 210	
Mount for extension		
Caulking tool A		
Caulking tool B		
Assembly device for charging handle	354 262	
Assembly device for extension	354 204	
Assembly wrench	227 468	
Counter bracket	353 111	



Gauge	Ident.-No.	Illustration
"No go" gauge for head-space (41.51 mm)	353 749	
"Go" gauge for head-space (41.40 mm)	353 747	
Test weight for standard trigger pull (20+10+15+2+1 N)	354 222	



Gauge	Ident.-No.	Illustration
Test weight for 2-stage trigger (17+8 N)	354 879	
<b>"No go" gauge for barrels, complete, consisting of:</b>		
• "No go" gauge for chamber end (Ø 7.67 mm)		
• "No go" gauge for muzzle end (Ø 7.65 mm)		
• Extension for "No go" gauges for barrels		
Firing pin protrusion gauge (1.23 mm - 1.40 mm)	353 626	



## Major cleaning

Regular cleaning and care of the windows and glass panes

- maintain functional operation
- increase service life
- prevent accidents and
- save repair costs and time

Major cleaning means cleaning the window and restores the optimal light transmission of the window. Major cleaning should be carried out at the spot time intervals (monthly). In addition, major cleaning can be carried out at the discretion of the manufacturer's experts, for example when a malfunction of the window is suspected.

## Part II

### Maintenance and checks



# Rifle HK417

## Calibre 7.62 mm x 51

HK417 12"

HK417 16"

HK417 20"

### DANGER

**Risk of death from gunshot wounds!**

**Accidental discharge of weapon may occur when loaded weapon is handled.**

- › Carry out a safety check before working on the weapon.
- › Do not perform maintenance work until you have read and understood this manual and the operator's manual for the weapon described here completely.
- › Follow the safety instructions when handling the weapon.





## 4 Major cleaning



Regular cleaning and care of the weapon and accessories

- maintain functional reliability
- increase service life
- prevent accidents, and
- save repair costs and time.

Major cleaning removes fouling on the weapon and restores the optimal lubrication state of the weapon. Major cleaning must be carried out at the specified intervals (*Section 4.1*). In addition, major cleaning can be carried out at the discretion of the firearms technicians, for example when a malfunction of the weapon is suspected.

### 4.1 Intervals for major cleaning

- › Carry out major cleaning at intervals of 10,000 rounds.



The intervals for special cleaning work (*Section 5*) can vary.



## 4.2 Carrying out major cleaning

Required auxiliary materials:

- Lubricating oil
- Lubricating paste
- Preservative oil
- "Break Free" oil
- Cleaning rag
- Cleaning kit

### NOTICE

**Danger of material damage from incorrect cleaning agents and care products!**

**Incorrect cleaning agents and care products can damage the weapon.**

- › When cleaning the weapon, use the specified cleaning agents.
- › Do not use any metallic objects, plastics (nylon, etc.) or chemical cleaning agents (benzine, tetrachlorethylene, trichlor, etc.) to clean the weapon.

1. Disassemble the weapon completely (*Section 9*).
2. Clean the pressure bolt hole (*Section 5.1*).
3. Clean all parts with the cleaning kit and remove lubricant using the cleaning rag.
4. Lubricate all parts according to the lubrication diagram (*Section 4.3*).
5. Assemble the weapon completely (*Section 10*).
6. Carry out function check.



### 4.3 Lubrication diagram



The parts of the weapon must be lubricated using the specified lubricants after major cleaning, when spare parts are used, and when required by the current lubrication state.

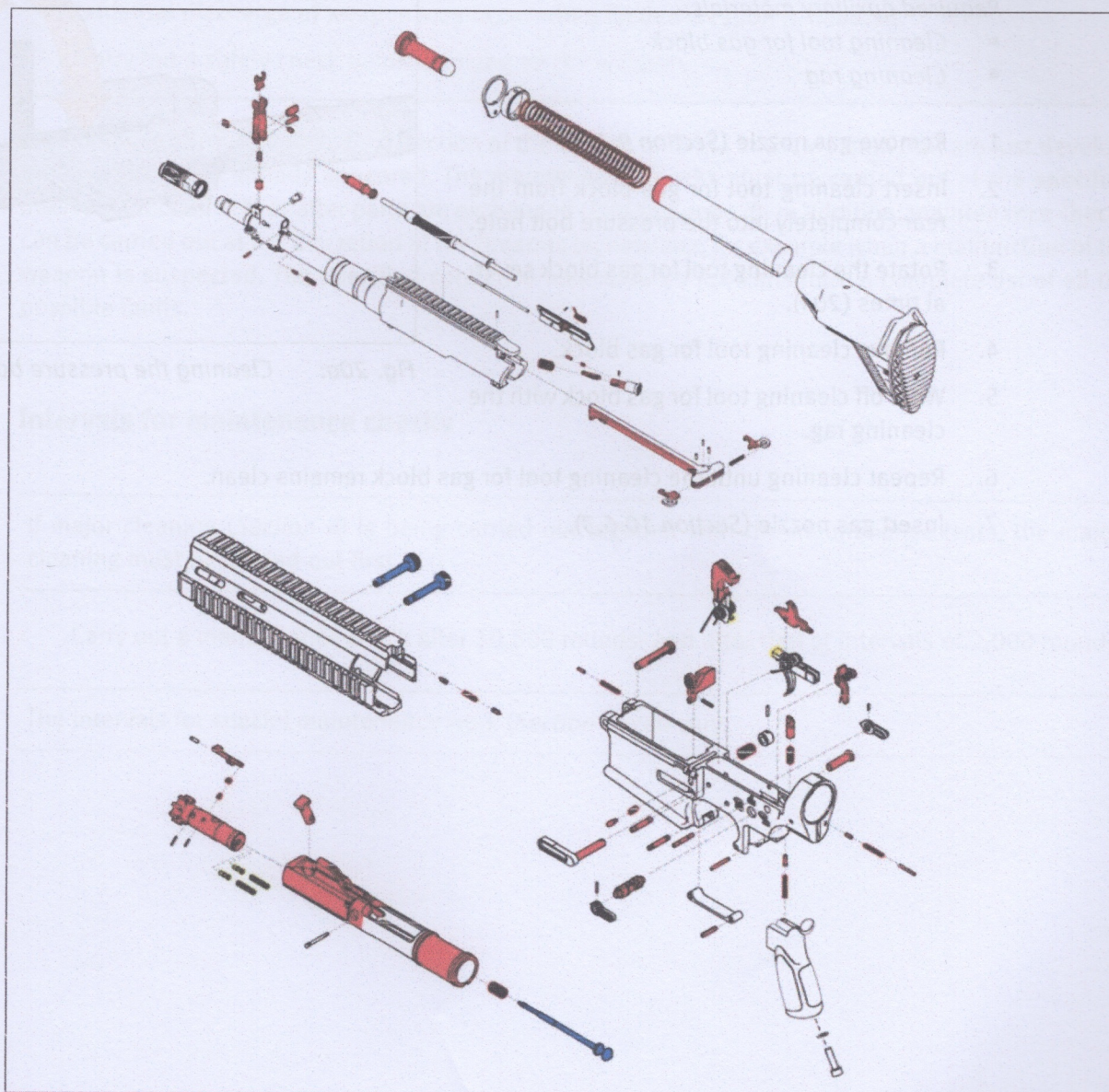


Fig. 19a: Lubrication diagram

Colour	Lubricant
Yellow	Lubricating paste
Red	"Break Free" oil
Blue	Lubricating oil
Green	Preservative oil



## 5 Special cleaning work

### 5.1 Cleaning the pressure bolt hole

*Required auxiliary materials:*

- Cleaning tool for gas block
- Cleaning rag

1. Remove gas nozzle (Section 9.1.3).
2. Insert cleaning tool for gas block from the rear completely into the pressure bolt hole.
3. Rotate the cleaning tool for gas block several times (20a).
4. Remove cleaning tool for gas block.
5. Wipe off cleaning tool for gas block with the cleaning rag.
6. Repeat cleaning until the cleaning tool for gas block remains clean.
7. Insert gas nozzle (Section 10.6.3).

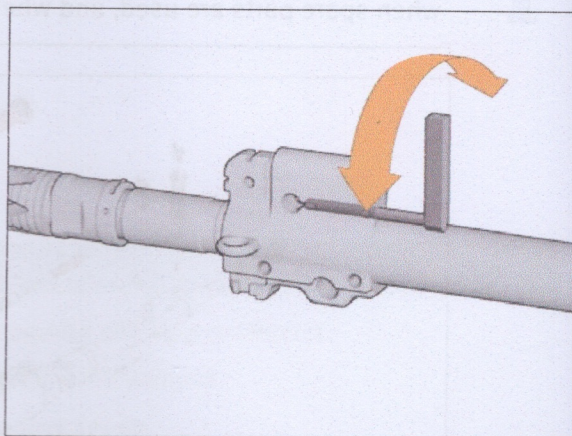


Fig. 20a: Cleaning the pressure bolt hole

Color	Lubricant
Yellow	Lubricating grease
Red	"Break free" oil
Blue	Lubricating oil
Green	Protective oil



## 6 Maintenance checks

### WARNING

**Risk of death from gunshot wounds!**

**Accidental discharge of weapon may occur when loaded weapon is handled.**

- › Carry out a safety check before working on the weapon.

Maintenance checks allow early detection of the causes of faults in the weapon that are just developing or which have already appeared. The maintenance checks must be carried out at the specified intervals (*Section 6.1*) or after parts are exchanged (*fold-out page II*). In addition, maintenance checks can be carried out at the discretion of the firearms technicians, for example when a malfunction of the weapon is suspected. The specified corrective measures do not constitute a complete list of all the possible faults.

### 6.1 Intervals for maintenance checks



If major cleaning (*Section 4*) is being carried out together with the maintenance tests, the major cleaning must be carried out first.

- › Carry out a maintenance check after 10,000 rounds, and after that at intervals of 2,000 rounds.



The intervals for special maintenance work (*Section 7*) can vary.



## 6.2 Checking the loading and unloading procedure



Checking the loading and unloading procedure ensures that the cartridges are fed, extracted and ejected properly. If the check of the loading and unloading procedure is not successful, malfunctions may occur.

*Required auxiliary materials:*

- Training rounds

1. Fill magazine with 5 training rounds.
2. Insert magazine into the weapon until the magazine catch engages.
3. Pull charging handle back all the way and let it snap forwards.
4. Repeat step 3. until all of the training rounds have been ejected. The bolt catch/release holds the bolt in the open position.



The training rounds are fed, extracted and ejected properly.



Malfunctions occur.

1. Rectify fault (Section 8).
2. Repeat test.

## 6.3 Checking the headspace



The headspace ensures that the bolt head can lock in the barrel extension when there is a cartridge in the chamber. If the headspace is too large, malfunctions may occur.

*Required auxiliary materials:*

- "No go" gauge for headspace
- Mat

1. Pull charging handle all the way back and hold it. >>



2. Press bolt catch/release and hold it. The bolt catch/release holds the bolt in the open position.

### ⚠ CAUTION

**Risk of injury when the bolt moves forwards quickly!**

**The bolt snaps forwards when the bolt catch/release is pushed.**

- › Do not touch the bolt catch/release while you are inserting the gauge into the chamber.

3. Insert “no go” gauge for headspace into the chamber with the conical end forwards.

### NOTICE

**Danger of material damage!**

**If the bolt snaps forwards while the gauge is in the chamber, the weapon and the gauge could be damaged.**

- › Guide the bolt forwards slowly.

4. Pull bolt catch/release back and guide the bolt forwards slowly.

✓ The bolt head does not lock in the barrel extension. The bolt is clearly set back (23a).

✗ The bolt head locks in the chamber. The bolt is not set back.

1. Clean and check barrel (1a-2) and bolt head (1a-41).
2. Replace barrel and/or bolt head if necessary.
3. Repeat test.

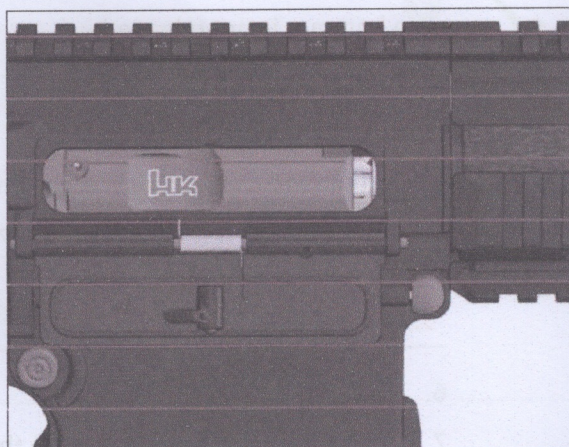


Fig. 23a: Headspace “Go”

5. Pull charging handle and hold it.
6. Hold weapon so that the “go” gauge for headspace falls out of the chamber and onto the mat.



## 6.4 Checking trigger pull



The correct trigger pull prevents a cartridge from being fired unintentionally. If the trigger pull is too light, a round can be discharged unintentionally. If the trigger pull is too heavy, it becomes harder to operate the weapon.

## 6.4.1 Checking standard trigger pull

Required auxiliary materials:

- Test weight for standard trigger pull

1. Put together 22 N test weight.
2. Pull charging handle back all the way and let it snap forwards.
3. Click safety lever to the “single fire” position.
4. Hold weapon vertically with the muzzle pointing up.
5. Lift test weight with the trigger (24a).



The hammer is not released.



The hammer is released.

1. Clean and check trigger and hammer.
2. If necessary, replace trigger (1a-70) and/or hammer (1a-67).
3. Repeat test.

6. Put together 46 N test weight.
7. Pull charging handle back all the way and let it snap forwards.
8. Hold weapon vertically with the muzzle pointing up.
9. Lift test weight with the trigger (24a).



The hammer is released.



The hammer is not released.

1. Lubricate weapon according to lubrication diagram (Section 4.3).
2. Repeat test.

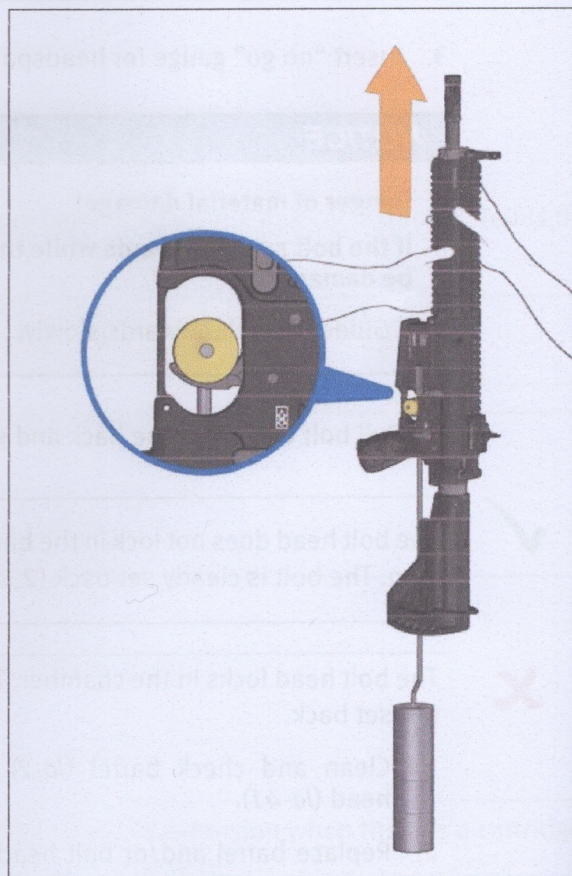


Fig. 24a: Lifting a test weight



## 4.2 Checking 2-stage trigger

Required auxiliary materials:

- 2-stage trigger test weight

1. Put together 17 N test weight.
2. Pull charging handle back all the way and let it snap forwards.
3. Click safety lever to the "single fire" position.
4. Hold weapon vertically with the muzzle pointing up.
5. Lift test weight with the trigger (25a).



The hammer is not released.



The hammer is released.

1. Clean and check trigger (1a-70) and hammer (1a-67).
2. Replace trigger and/or hammer if necessary.
3. Repeat test.

6. Put together 25 N test weight.
7. Pull charging handle back all the way and let it snap forwards.
8. Hold weapon vertically with the muzzle pointing up.
9. Lift test weight with the trigger (25a).



The hammer is released.



The hammer is not released.

1. Lubricate weapon according to lubrication diagram (Section 4.3).
2. Repeat test.

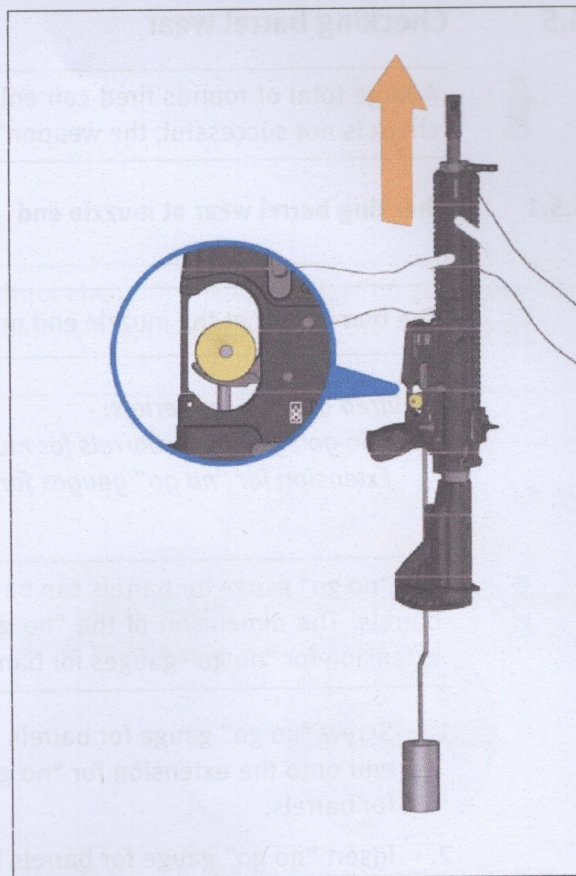


Fig. 25a: Lifting a test weight



## 6.5 Checking barrel wear

**i** A large total of rounds fired can enlarge the inner diameter of the barrel (la-2). If the barrel wear check is not successful, the weapon's shooting performance is no longer adequate.

### 6.5.1 Checking barrel wear at muzzle end

**i** The barrel wear at the muzzle end may only be checked with the factory-installed flash hider.

*Required auxiliary materials:*

- "No go" gauge for barrels for muzzle end
- Extension for "no go" gauges for barrels

**i** The "no go" gauge for barrels can be mounted on either end of the extension for "no go" gauges for barrels. The dimension of the "no go" gauge for barrels must correspond to the marking on the extension for "no go" gauges for barrels.

1. Screw "no go" gauge for barrels for muzzle end onto the extension for "no go" gauges for barrels.
2. Insert "no go" gauge for barrels for muzzle end into the barrel from the front (26a).

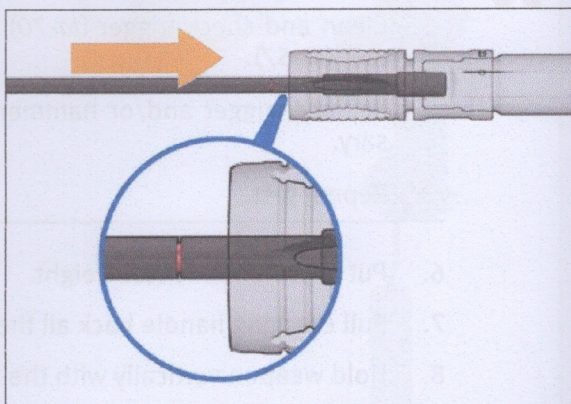


Fig. 26a: Inserting "no go" gauge for barrels into the barrel from the front

**✓** The red marking is located outside of the flash hider (la-1).

**✗** The red marking is located inside of the flash hider.

1. Tighten the flash hider (la-1) (Section 10.6.5).
2. Replace barrel (la-2) if necessary.
3. Repeat test.



## Illustration of individual components

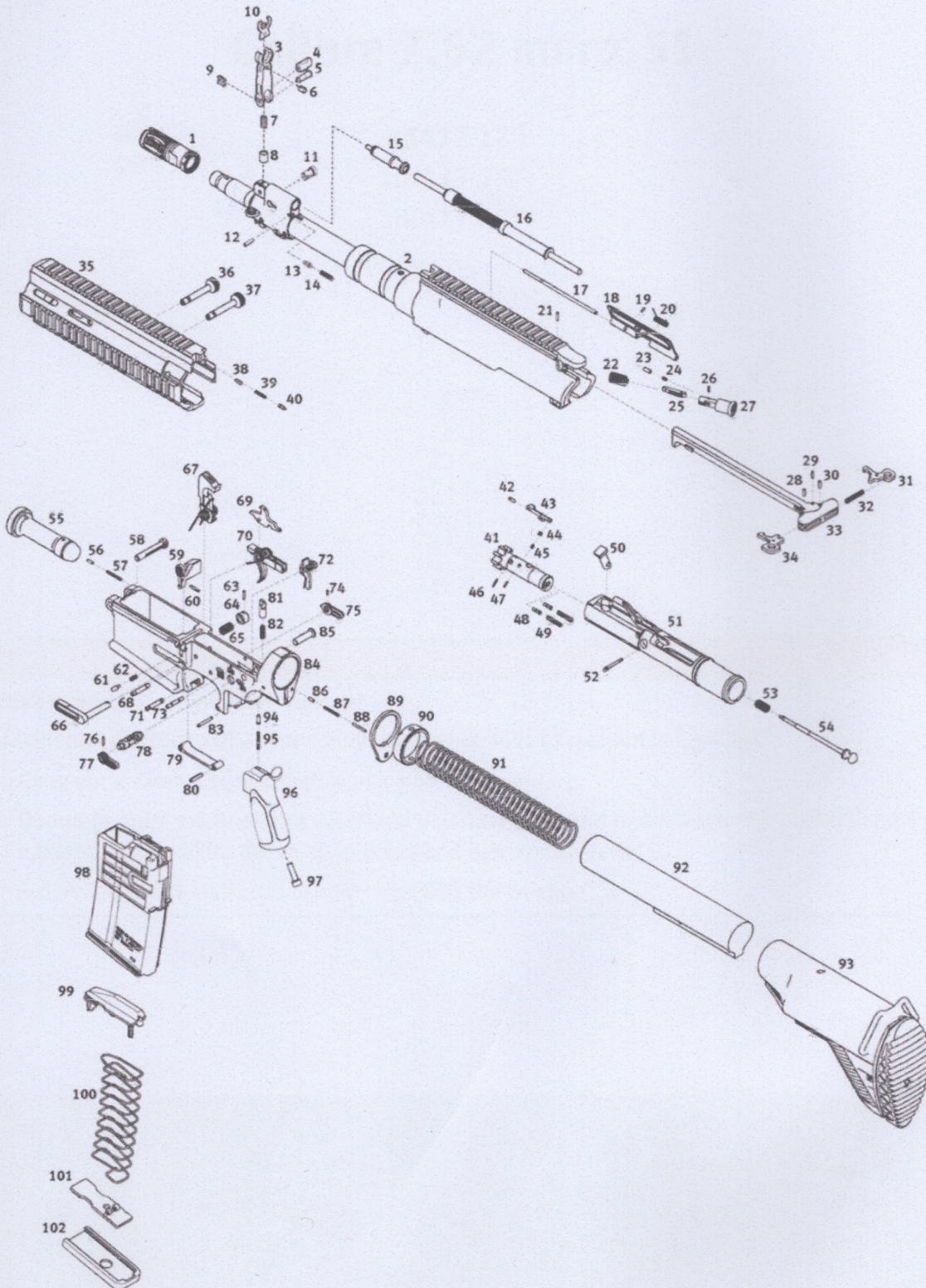


Fig. 1a: Illustration of individual components



## 5.2 Checking barrel wear at chamber end

Required auxiliary materials:

- “No go” gauge for barrels for chamber end
- Extension for “no go” gauges for barrels

1. Disassemble the weapon into assembly groups.

i

The “no go” gauge for barrels can be mounted on either end of the extension for “no go” gauges for barrels. The dimension of the “no go” gauge for barrels must correspond to the marking on the extension for “no go” gauges for barrels.

2. Screw “no go” gauge for barrels for chamber end (27a-1) onto the extension for “no go” gauges for barrels (27a-3).
3. Insert “no go” gauge for barrels for chamber end into the barrel from the rear (27a).
4. Look into the weapon from below.

✓

The red marking is located outside of the barrel extension (27a-2).

✗

The red marking is located inside of the barrel extension.

1. Replace barrel (1a-2).
2. Repeat test.

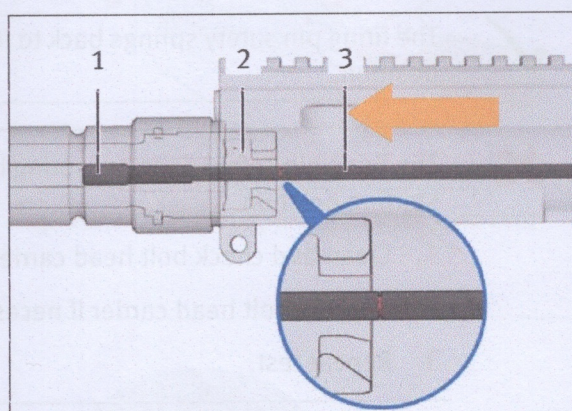


Fig. 27a: Inserting “no go” gauge for barrels into the barrel from the rear

- |   |   |
|---|---|
| 1 | “No go” gauge for barrels for chamber end |
| 2 | Barrel extension                          |
| 3 | Extension for “no go” gauges for barrels  |



## 6.6 Checking function of the firing pin safety



The firing pin safety prevents accidental operation of the firing pin, for example if the weapon is dropped. If the firing pin safety is not functional, a round can be discharged unintentionally or ignition faults may occur.

1. Disassemble the weapon into assembly groups.
2. Raise firing pin safety (28a-A).
3. Release firing pin safety.



The firing pin safety springs back to its starting position.



The firing pin safety does not spring back to its starting position.

1. Clean and check bolt head carrier (1a-41).
2. Replace bolt head carrier if necessary.
3. Repeat test.

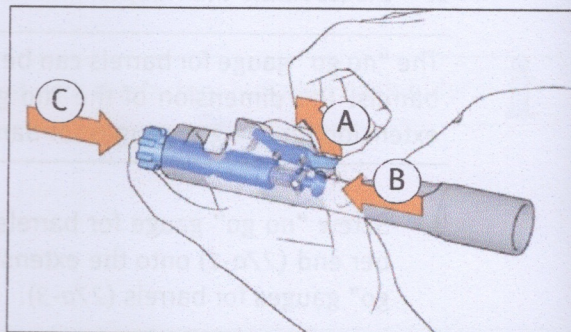


Fig. 28a: Pushing firing pin into the bolt

4. Raise firing pin safety and hold it (28a-A).
5. Press firing pin safety into the bolt from the rear (28a-B).
6. Push bolt head to the rear as far as it will go and hold it there (28a-C).



The firing pin projects visibly from the bolt head and springs back to its starting position.



The firing pin does not project from the bolt head or does not spring back to its starting position.

1. Clean bolt head.
2. Clean and check components of the bolt group (1a-41 to 1a-54).
3. Replace components of the bolt group if necessary.
4. Repeat test.



## 6.7 Checking firing pin protrusion



The correct firing pin protrusion ensures that the firing pin projects far enough out of the bolt head to ignite a cartridge that has been loaded into the chamber. If the firing pin protrusion is too small, the functional reliability of the weapon is endangered. If the firing pin protrusion is too large, the firing pin may become damaged.

*Required auxiliary materials:*

- Firing pin protrusion gauge

1. Disassemble the weapon into assembly groups.
2. Raise bolt catch/release and hold it (29a-A).
3. Push firing pin into the bolt from the rear (29a-B).
4. Push bolt head to the rear as far as it will go and hold it there (29a-C). The firing pin projects out of the bolt head.
5. Place firing pin protrusion gauge onto the tip of the firing pin from the front.
6. Push firing pin protrusion gauge against the bolt head (29b-A).

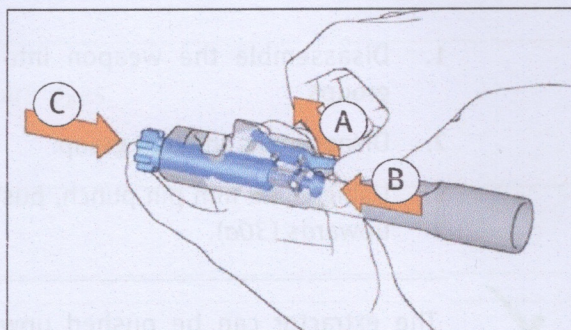


Fig. 29a: Pushing firing pin into the bolt



The tip of the firing pin protrusion gauge is located between the two measurement surfaces (29b-B).



The tip of the firing pin protrusion gauge is not located between the two measurement surfaces.

1. Clean bolt head.
2. Clean and check components of the bolt group (Ia-41 to Ia-54).
3. Replace components of the bolt group if necessary.
4. Repeat test.

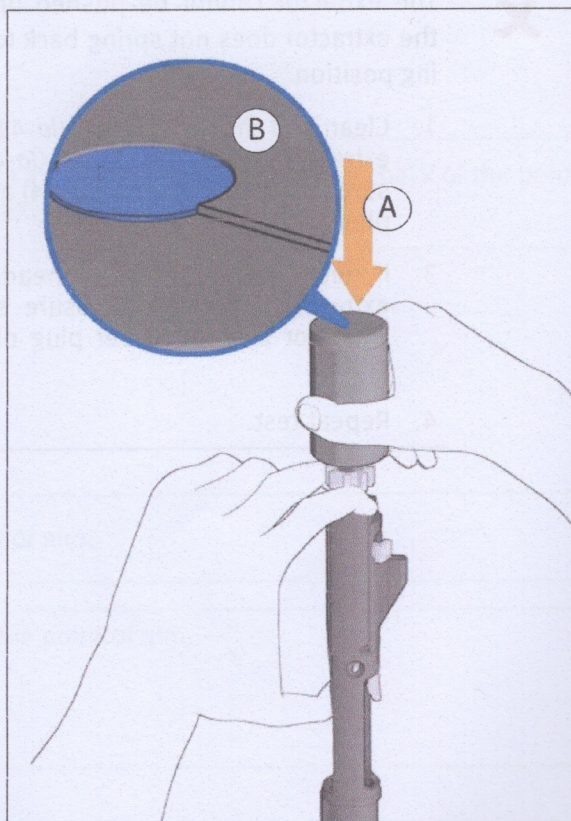


Fig. 29b: Checking firing pin protrusion



## 6.8 Checking function of the extractor



The extractor pulls the cartridge case out of the chamber. If the check of the function of the extractor is not successful, malfunctions may occur.

*Required auxiliary materials:*

- Ø 2.8 mm pin punch

1. Disassemble the weapon into assembly groups.
2. Disassemble the bolt group.
3. Using Ø 2.8 mm pin punch, push extractor upwards (30a).

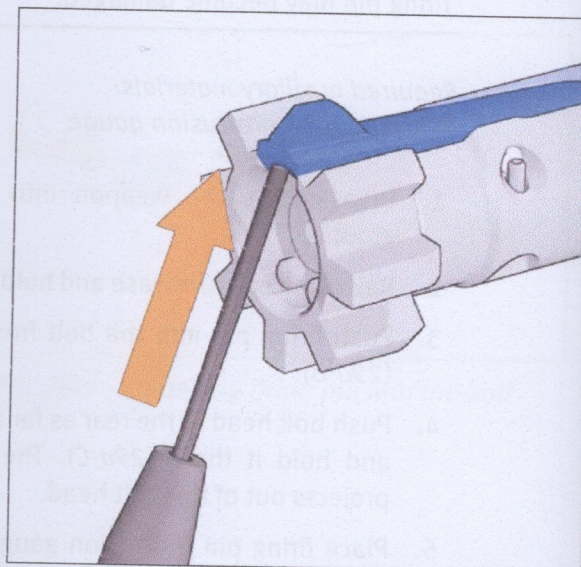


Fig. 30a: Checking function of the extractor

✓ The extractor can be pushed upwards. The extractor springs back to its starting position.

✗ The extractor cannot be pushed upwards or the extractor does not spring back to its starting position.

1. Clean and check bolt head (la-41), axle for extractor (la-42), extractor (la-43), pressure spring for extractor (la-44) and rubber plug (la-45).
3. If necessary replace bolt head, axle for extractor, extractor, pressure spring for extractor and/or rubber plug of the bolt group.
4. Repeat test.



## 6.9 Checking firing function



Checking the firing function ensures that the weapon fires without faults.



Follow safety instructions for firing (*Section 2.2*).

1. Fill a magazine with the maximum number of cartridges.
2. Shoot magazine empty.



No fault occurred during firing.



A fault occurred during firing.

1. Rectify fault (*Section 8*).
2. Repeat test.

## 6.10 Checking point of impact



Checking the point of impact ensures that the sights are correctly adjusted. If the check of the point of impact is not successful, the point of impact is different from the point of aim.

*Required auxiliary materials:*

- Target

1. Fire 5 rounds at a target at a range of 100 m.
2. Determine mean point of impact (*Section 7.2*).



The mean point of impact corresponds to the point of aim.



The mean point of impact does not correspond to the point of aim.

1. Adjust the sights.
2. Repeat test.



## 7 Special maintenance work

### 7.1 Checking minimum dimension of the headspace



The minimum dimension of the headspace is checked by the manufacturer before the weapon is shipped. The headspace cannot decrease through the use of the weapon. Therefore the minimum dimension of the headspace only has to be checked if a new bolt head and/or a new barrel has been introduced into the weapon.



The headspace ensures that the bolt head can lock in the barrel extension when there is a cartridge in the chamber. If the headspace is too small, malfunctions may occur.

*Required auxiliary materials:*

- "Go" gauge for headspace
- Mat

1. Pull charging handle all the way back and hold it.
2. Press bolt catch/release and hold it. The bolt catch/release holds the bolt in the open position.

#### **⚠ CAUTION**

**Risk of injury when the bolt moves forwards quickly!**

**The bolt snaps forwards when the bolt catch/release is pushed.**

- › Do not touch the bolt catch/release while you are inserting the gauge into the chamber.

3. Insert "go" gauge for headspace into the chamber with the conical end forwards. »



## NOTICE

### Danger of material damage!

If the bolt snaps forwards while the gauge is in the chamber, the weapon and the gauge could be damaged.

- Guide the bolt forwards slowly.

4. Pull bolt catch/release back and guide the bolt forwards slowly.



The bolt head locks in the chamber. The bolt is not set back (33a).



The bolt head does not lock in the barrel extension. The bolt is set back.

1. Clean and check barrel (1a-2) and bolt head (1a-41).
2. Replace barrel and/or bolt head if necessary.
3. Repeat test.

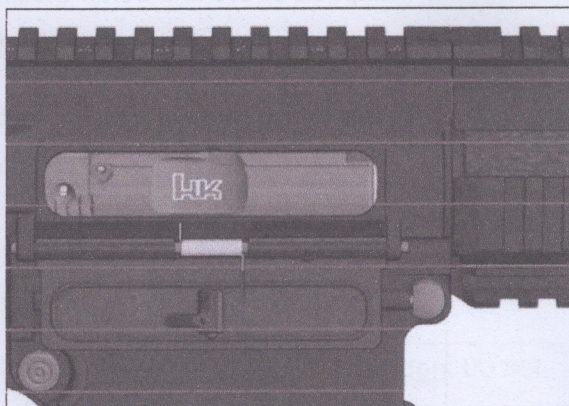


Fig. 33a: Headspace "Go"

5. Pull bolt back and hold it.
6. Hold weapon so that the "go" gauge for headspace falls out of the chamber and onto the mat.



**7.2 Determining mean point of impact****i**

The mean point of impact is the point lying at the centre of a certain number of impacts. The mean point of impact serves as the basis for adjusting the sights.

1. Draw a horizontal line through the grouping so that there is the same number of impacts above and below the line (34b-A).
2. Draw a vertical line through the grouping so that there is the same number of impacts to the right and left of the line (34b-B).
3. The intersection of the two lines is the mean point of impact (34b-C).

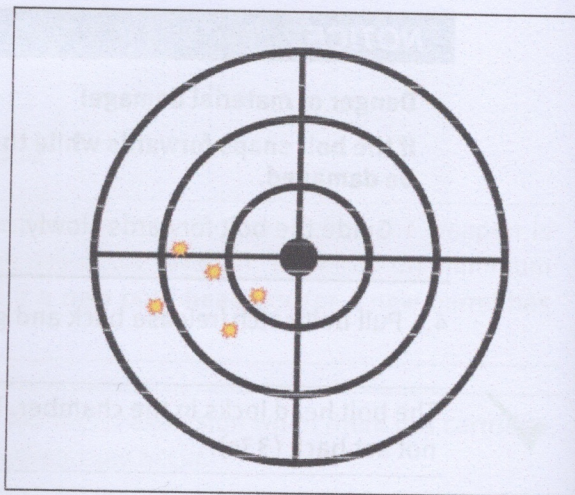


Fig. 34a: Grouping

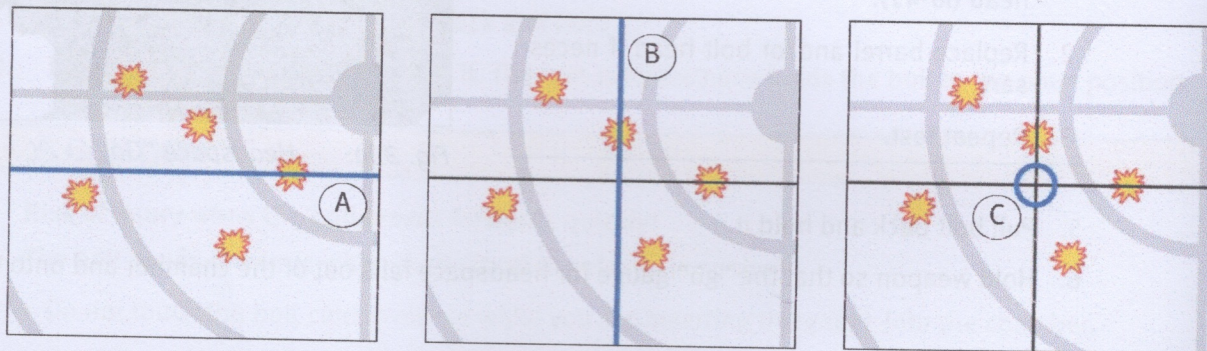


Fig. 34b: Determining mean point of impact



## 8 Faults: Causes and remedies

### WARNING

**Safety risk from not knowing whether or not the weapon is loaded!**

**In the event of a fault, the weapon may be loaded even if you expect that it is unloaded.**

- › In the event of a fault, treat the weapon as if there were a round in the chamber.
- › In the event of a fault, verify whether the weapon is actually loaded.
- › Follow the fundamental safety instructions (*Section 2*) for rectifying faults.

The following points do not constitute a complete list of all the possible faults. Causes other than those named here are also possible.

Fault	Cause	Remedy
Round is stuck in the barrel.	Improperly loaded ammunition.	Extract bullet from barrel from the front to the rear using brass mandrel. Check barrel for damage. Replace barrel if necessary.
Cartridge has not fired.	Defective ammunition.	Wait at least one minute. Unload weapon. Do not re-use cartridges that have failed to fire.
	Firing pin sluggish, damaged or broken.	Clean bolt head. Check firing pin for damage. Replace firing pin if necessary.
	Hammer defective.	Clean hammer. Check hammer for damage. Replace hammer if necessary.
Bolt does not open after firing.	Defective ammunition.	Unload weapon. Clean chamber if necessary.
	Gas drive fouled or defective.	Clean gas nozzle. Check gas nozzle for damage. Replace gas nozzle if necessary.



Fault	Cause	Remedy
Cartridge or cartridge case is not ejected.	Cartridge rim ripped off.	Unload weapon. Extract cartridge from barrel from the front to the rear using brass mandrel.
	Chamber is fouled.	Clean chamber.
	Rearward movement of bolt too short.	Unload weapon. Carry out function check. Check position of the gas port. Clean chamber if necessary. Replace buffer if necessary.
	Ammunition incorrectly loaded.	Use different ammunition.
	Extractor, pressure spring for extractor, ejector or pressure spring for ejector damaged.	Clean extractor, pressure spring for extractor, ejector or pressure spring for ejector. Check extractor, pressure spring for extractor, ejector and pressure spring for ejector for damage. f necessary replace extractor, pressure spring for extractor, ejector and/or pressure spring for ejector.
Cartridge is not loaded into the chamber.	Chamber is fouled.	Unload weapon. Clean the weapon.
	Cartridge deformed.	Use different cartridge.
	Recoil spring defective.	Clean the recoil spring. Check recoil spring. Replace recoil spring if necessary.
Cartridge does not feed.	Magazine not correctly inserted.	Insert magazine correctly.
	Magazine spring defective.	Clean the magazine. Check magazine spring. Replace magazine spring if necessary.
	Magazine or magazine lips damaged.	Use different magazine.
	Rearward movement of bolt too short.	Unload weapon. Carry out function check. Check position of the gas port. Clean chamber if necessary. Replace buffer if necessary.
	Rearward movement of bolt too long.	Check position of the gas port.





After assembly of spare parts the specified checks must be carried out. A function check must be carried out after every assembly operation.

	Check
A	Check loading and unloading procedure (Section 6.2)
B	Check headspace (Section 6.3)
C	Check trigger pull (Section 6.4)
D	Check barrel wear (Section 6.5)
E	Check function of firing pin safety (Section 6.6)

	Check
F	Check firing pin protrusion (Section 6.7)
G	Check function of extractor (Section 6.8)
H	Check firing function (Section 6.9)
I	Check point of impact (Section 6.10)
J	Check minimum dimension of headspace (Section 7.1)

Item	Designation	Check
1	Flash hider	
2	Upper receiver with barrel	B,D,H,I,J
3	Front sight holder	I
4	Front sight locking device	I
5	Axle for front sight	I
6	Clamping sleeve	
7	Pressure spring	
8	Sleeve for pressure spring	
9	SL retainer	
10	Front sight	I
11	Gas nozzle	H
12	Clamping sleeve	
13	Pressure bolt for gas nozzle	
14	Pressure spring for pressure bolt	
15	Gas piston	H
16	Rod	H
17	Axle for cover	A
18	Ejection port cover	A
19	Clamping sleeve	
20	Elbow spring	
21	Clamping sleeve for forward assist	
22	Pressure spring for forward assist	
23	Pressure bolt for forward assist	
24	Pressure spring for pressure bolt	
25	Locking piece for forward assist	
26	Pressure bolt for locking piece	
27	Retainer	
28	Clamping sleeve for pawl	
29	Clamping sleeve for pawl	
30	Clamping sleeve for pawl	
31	Pawl 2	
32	Pressure spring for pawl 2	
33	Charging handle	
34	Pawl 1	
35	Handguard	
36	Locking screw for handguard, front	
37	Locking screw for handguard, rear	
38	Grooved bolt, front	
39	Pressure spring	
40	Grooved bolt, rear	
41	Bolt head	B,E,F,G,H,I
42	Axle for extractor	A,G
43	Extractor	G,H
44	Pressure spring for extractor	A,G
45	Rubber plug	A,G
46	Clamping sleeve	
47	Clamping sleeve	
48	Ejector	A
49	Pressure springs for ejector	A
50	Control bolt	F
51	Bolt head carrier	E

Item	Designation	Check
52	Locking pin	
53	Pressure spring for firing pin	E
54	Firing pin	E,F
55	Buffer	
56	Stop pin for locking pin	
57	Pressure spring for stop pin	
58	Locking pin, front	
59	Bolt catch/release	A
60	Clamping sleeve for bolt catch/release	A
61	Pressure pin	
62	Pressure spring for pressure pin	
63	Clamping sleeve for retainer	
64	Retainer for magazine catch	
65	Pressure spring for retainer	
66	Magazine catch	
67	Hammer	C,H
68	Axle for hammer	
69	Disconnecter	
70	Trigger	C
71	Axle for trigger	
72	Sear release catch	
73	Axle for sear release catch	
74	Clamping sleeve for safety lever, right	
75	Safety lever, right	
76	Clamping sleeve for safety lever, left	
77	Safety lever, left	
78	Safety roller	
79	Trigger guard	
80	Clamping sleeve for trigger guard	
81	Locking pin for buffer	
82	Pressure spring for locking pin	
83	Clamping sleeve for locking pin	
84	Lower receiver	
85	Locking pin, rear	
86	Stop pin for locking pin	
87	Pressure spring for stop pin	
88	Cylindrical pin for stop pin	
89	Plate	
90	Nut for extension	
91	Recoil spring	H
92	Extension	
93	Buttstock	
94	Stop pin	
95	Pressure spring for stop pin	
96	Pistol grip	
97	Cylindrical screw	
98	Magazine housing	H
99	Follower	H
100	Magazine spring	H
101	Locking plate	
102	Magazine floor plate	



Fault	Cause	Remedy
Bolt does not stay in open position after last round.	Magazine spring defective.	Clean the magazine. Check magazine spring. Replace magazine spring if necessary.
	Rearward movement of bolt too short.	Unload weapon. Carry out function check. Check position of the gas port. Clean chamber if necessary. Replace buffer if necessary.
	Rearward movement of bolt too long.	Check position of the gas nozzle.
	Bolt catch/release damaged.	Replace bolt catch/release.
	Ammunition incorrectly loaded.	Use different ammunition.
Magazine sticks in magazine well.	Magazine damaged.	Exchange magazine. Clean and check components of the damaged magazine. Replace components of the damaged magazine if necessary.
	Magazine catch defective.	Replace magazine catch.
Weapon fires with a significantly higher rate of fire.	Gas piston defective.	Replace gas piston.
Weapon does not function when shooting with blank firing attachment.	Blank firing attachment is not fully screwed on.	Tighten blank firing attachment.
	Inner wall of barrel is damp and/or unburnt powder in barrel.	Stop firing immediately. Clean barrel and blank firing attachment.
Windage or elevation of point of impact changed.	Sights misaligned.	Adjust the sights.
	Other type of ammunition.	Use another type of ammunition or adjust sights.
	Sights damaged.	Replace sights.



9. Disassemble the weapon completely.

10. Store the weapon in the storage container.

## Disassembling the weapon completely

1. Disassemble the weapon into assembly groups.

## Disassembling the upper receiver

### Removing the flash hider

Required auxiliary materials:

- Counter bracket
- Assembly wrench
- Key

## Part III

3. Place upper receiver on the counter.

## Disassembly and assembly

4. Remove flash hider.

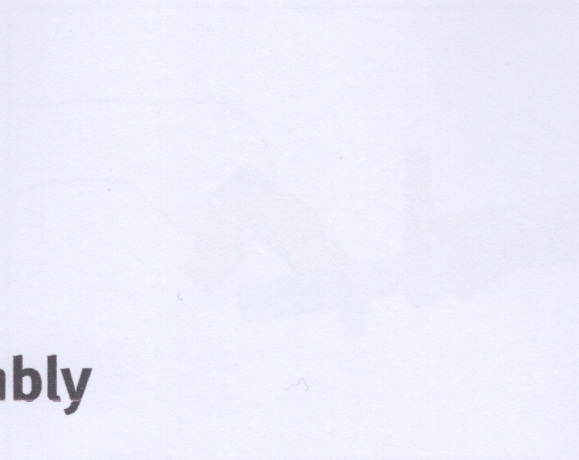


Fig. 3.10. Removing the flash hider

### Removing the front sight

Required auxiliary materials:

- 2 x 4 mm pin punch
- Hammer
- 7 x 150 mm screwdriver

1. Remove "S" retainer (6-9) using 7 x 150 mm screwdriver.

2. Remove side for front sight (6-10).

3. Remove front sight holder (6-11).

4. Using 7 x 150 mm screwdriver, push front sight locking device in and push it to the side (4-12).

5. Remove front sight locking device.



Fig. 4.12. Pushing the front sight locking device to the side



## Disassembling the weapon completely

- › Disassembling the weapon into assembly groups.

### 1.1 Disassembling the upper receiver

#### 1.1.1 Removing the flash hider

*Required auxiliary materials:*

- Counter bracket
- Assembly wrench
- Vice

1. Clamp counter bracket in the vice.
2. Place upper receiver on the counter bracket.
3. Loosen flash hider using assembly wrench (41a).
4. Remove flash hider.

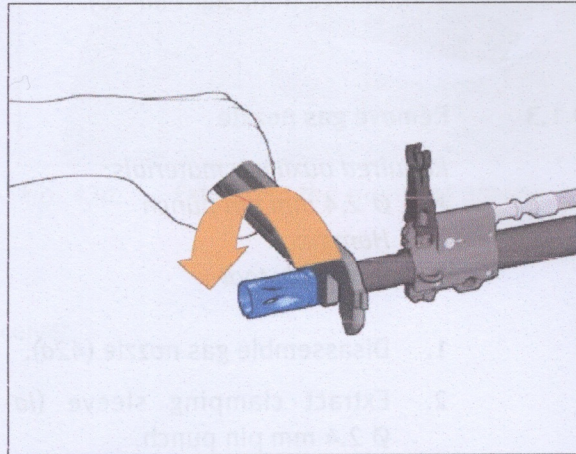


Fig. 41a: Loosening the flash hider

#### 1.1.2 Removing the front sight

*Required auxiliary materials:*

- Ø 3.4 mm pin punch
- Hammer
- 7 x 150 mm screwdriver

1. Remove SL retainer (1a-9) using 7 x 150 mm screwdriver.
2. Remove axle for front sight (1a-5).
3. Remove front sight holder (1a-3).
4. Using 7 x 150 mm screwdriver, press front sight locking device in and push it to the side (41b).
5. Remove front sight locking device. »

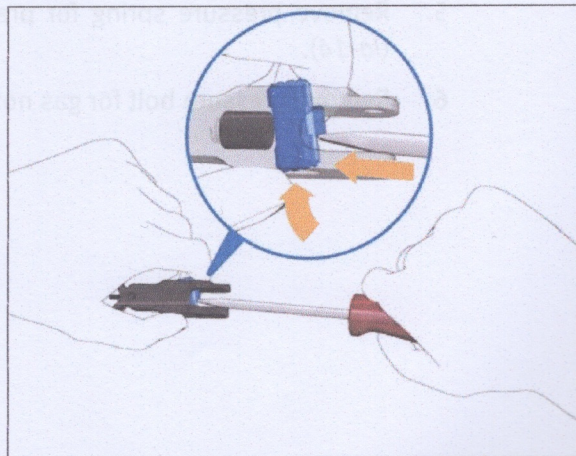


Fig. 41b: Pushing the front sight locking device to the side



6. Remove sleeve for pressure spring (1a-8).
7. Remove pressure spring (1a-7).



The hole in the front sight holder (1a-3) has a shoulder. The clamping sleeve (1a-6) can only be driven out to the rear.

8. Extract clamping sleeve (1a-6) using Ø 3.4 mm pin punch.
9. Remove front sight (1a-10).

### 9.1.3 Remove gas nozzle

*Required auxiliary materials:*

- Ø 2.4 mm pin punch
- Hammer
- Assembly tool

1. Disassemble gas nozzle (42a).
2. Extract clamping sleeve (1a-12) using Ø 2.4 mm pin punch.
3. Secure pressure bolt hole with your finger.
4. Remove Ø 2.4 mm pin punch.
5. Remove pressure spring for pressure bolt (1a-14).
6. Remove pressure bolt for gas nozzle (1a-13).

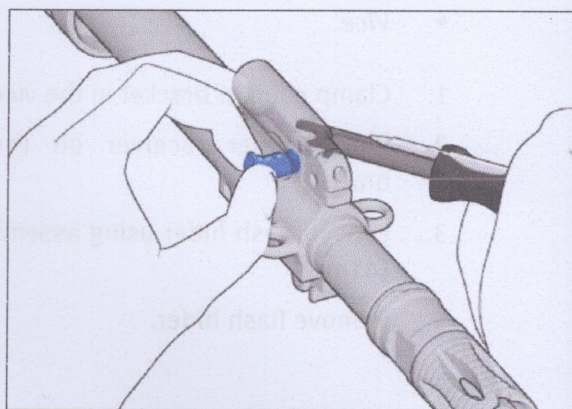


Fig. 42a: Removing the gas nozzle



## 9.1.4 Removing the ejection port cover

Required auxiliary materials:

- Ø 0.9 mm pin punch
- Ø 2.4 mm pin punch
- Hammer

1. Extract clamping sleeve using Ø 0.9 mm pin punch (43a).



The elbow spring (1a-20) is spring-loaded. Secure the elbow spring with your finger during disassembly of the axle for cover.

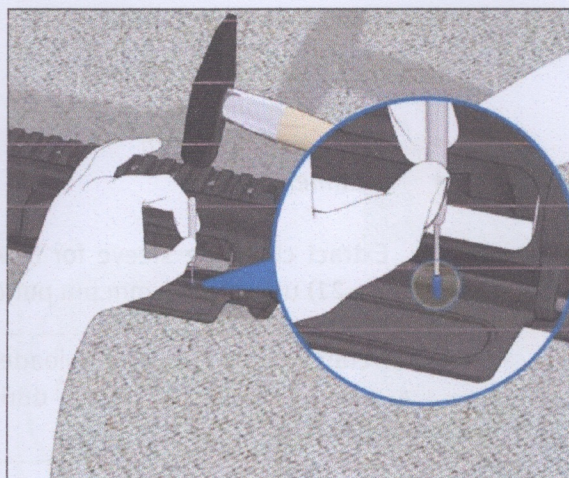


Fig. 43a: Extracting the clamping sleeve

2. Push axle for cover (1a-17) forwards out of the upper receiver using Ø 2.4 mm pin punch.
3. Pull axle for cover forwards out of the upper receiver.
4. Remove elbow spring (1a-20).
5. Remove ejection port cover (1a-18).



#### 9.1.5 Removing the forward assist

*Required auxiliary materials:*

- Ø 1.4 mm pin punch
- Ø 2.4 mm pin punch
- Hammer

1. Extract clamping sleeve for forward assist (la-21) using Ø 2.4 mm pin punch.



The retainer (la-27) is spring-loaded. Secure the retainer with your finger during disassembly (44a).

2. Remove Ø 2.4 mm pin punch (44a-B).
3. Remove retainer (la-27).
4. Remove pressure spring for forward assist (la-22).
5. Extract pressure bolt for locking piece (la-26) using Ø 1.4 mm pin punch.



The pressure bolt for forward assist (la-23) is spring-loaded. Secure the locking piece for forward assist with your finger during disassembly (44b).

6. Remove Ø 1.4 mm pin punch (44b-B).
7. Remove locking piece for forward assist (la-25).
8. Remove pressure bolt for forward assist (la-23).
9. Remove pressure spring for pressure bolt (la-24).

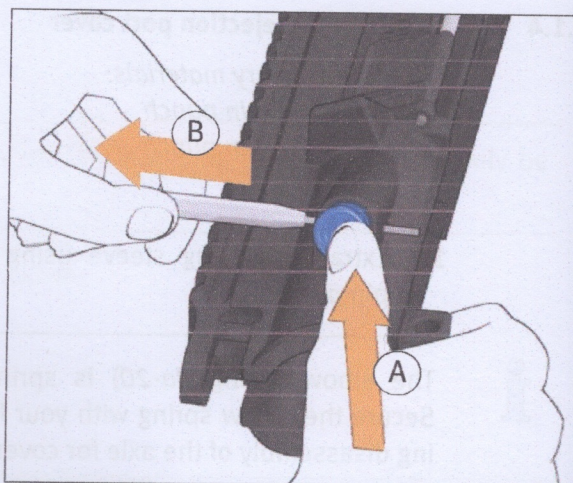


Fig. 44a: Securing the retainer

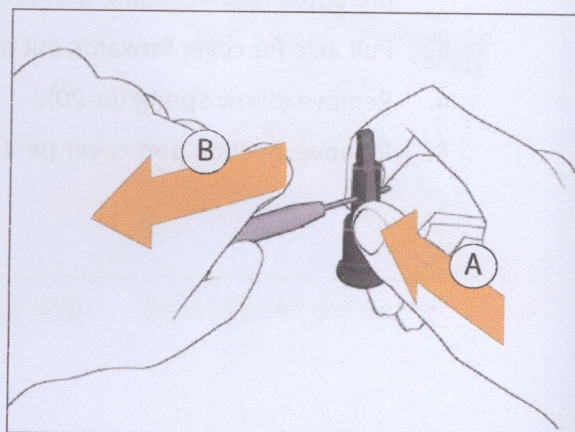


Fig. 44b: Securing the locking piece for forward assist



## 9.2 Disassembling the handguard

### 9.2.1 Disassembling the standard handguard

Required auxiliary materials:

- Ø 0.9 mm pin punch

1. Extract retaining screws for handguard (1a-36, 1a-37) as far as disassembly position.
2. Push rear grooved bolt (45a-40) forwards using Ø 0.9 mm pin punch and hold it there.
3. Extract rear retaining screw for handguard (1a-37) from the handguard (1a-35).
4. Secure grooved bolt hole with your finger (45a-A).
5. Remove Ø 0.9 mm pin punch from the handguard (45a-B).
6. Remove rear grooved bolt.
7. Remove pressure spring (45a-39).
8. Remove front grooved bolt (45a-38).
9. Extract front retaining screw for handguard (45a-36) from the handguard.

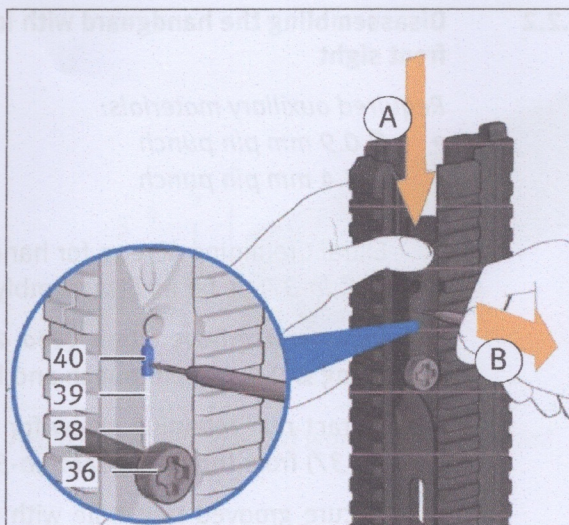


Fig. 45a: Securing pressure bolt hole with your finger

- |    |                                    |
|----|------------------------------------|
| 36 | Locking screw for handguard, front |
| 38 | Grooved bolt, front                |
| 39 | Pressure spring                    |
| 40 | Grooved bolt, rear                 |



### 9.2.2 Disassembling the handguard with integrated front sight

*Required auxiliary materials:*

- Ø 0.9 mm pin punch
- Ø 3.4 mm pin punch

1. Extract retaining screws for handguard (46a-1, 1a-37) as far as disassembly position.
2. Push rear grooved bolt (46a-4) forwards using Ø 0.9 mm pin punch and hold it.
3. Extract rear retaining screw for handguard (1a-37) from the handguard (1a-35).
4. Secure grooved bolt hole with your finger (46a-A).
5. Remove Ø 0.9 mm pin punch from the handguard (46a-B).
6. Remove rear grooved bolt.
7. Remove pressure spring (46a-3).
8. Remove front grooved bolt (46a-2). »

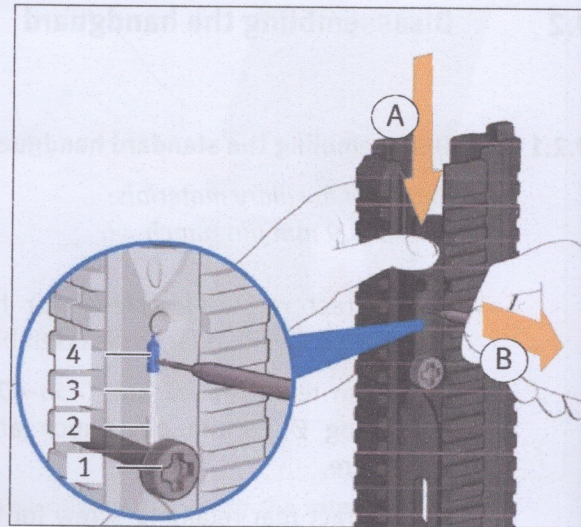


Fig. 46a: Securing hole for grooved bolt with your finger

- 1 Retaining screw for handguard, front
- 2 Grooved bolt, front
- 3 Pressure spring
- 4 Grooved bolt, rear



9. Extract front retaining screw for handguard (45b-1) from the handguard.
10. Extract axle for front sight (47a-1) using  $\varnothing 3.4$  mm pin punch (47b).
11. Remove front sight (47a-2).
12. Remove indexing pin (47a-4).
13. Remove pressure spring for indexing pin (46a-3).
14. Remove locking bolt (47a-5).
15. Remove pressure spring for locking bolt (47a-6).

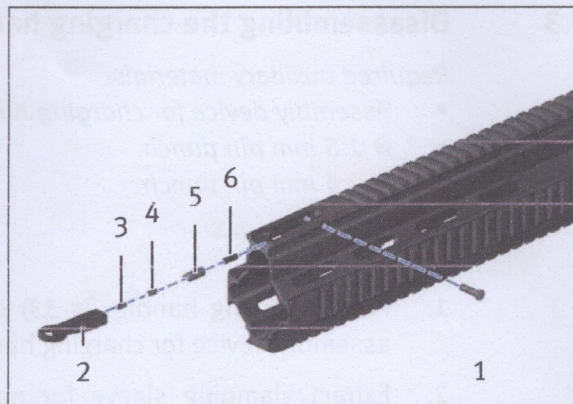


Fig. 47a: Handguard with integrated front sight

- 1 Axle for front sight
- 2 Front sight
- 3 Pressure spring for indexing pin
- 4 Indexing pin
- 5 Locking bolt
- 6 Pressure spring for locking bolt

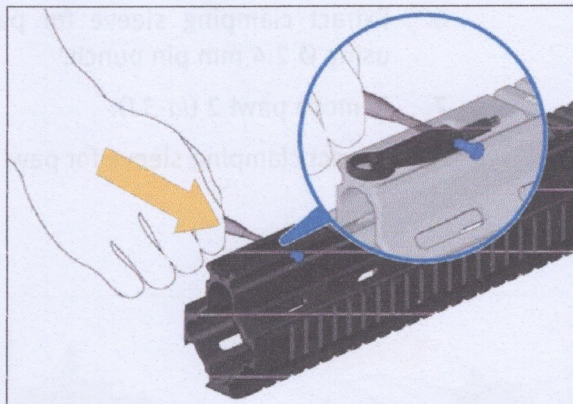


Fig. 47b: Extracting axle for front sight



## 9.3 Disassembling the charging handle

*Required auxiliary materials:*

- Assembly device for charging handle
- Ø 1.8 mm pin punch
- Ø 2.4 mm pin punch
- Hammer

1. Place charging handle (la-33) on the the assembly device for charging handle.
2. Extract clamping sleeve for pawl (la-28) using Ø 2.4 mm pin punch (48a).



Pawl 1 (la-34) is spring-loaded. Secure pawl 1 with your finger during disassembly.

3. Pull Ø 2.4 mm pin punch out of the charging handle.
4. Remove pawl 1.
5. Remove pressure spring for pawl 2 (la-32).
6. Extract clamping sleeve for pawl (la-30) using Ø 2.4 mm pin punch.
7. Remove pawl 2 (la-31).
8. Extract clamping sleeve for pawl (la-29) using Ø 1.8 mm pin punch.

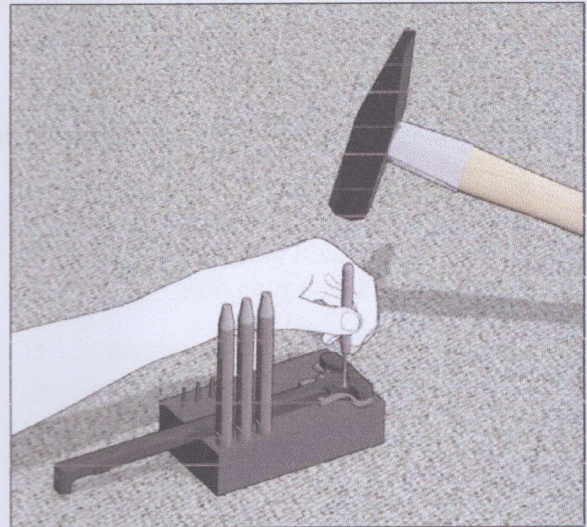


Fig. 48a: Extracting clamping sleeve for pawl



## Table of contents

### Part I General principles

<b>1</b>	<b>Using this manual</b> .....	<b>3</b>
1.1	Purpose of this manual .....	3
1.2	Target audience for this manual .....	3
1.3	Requirements for performing the activities in this manual .....	3
1.4	Warnings, notes and information .....	4
<b>2</b>	<b>Fundamental safety instructions</b> .....	<b>7</b>
2.1	Safety instructions for handling the weapon .....	7
2.2	Safety instructions for firing .....	8
2.3	Exclusion of liability and warranty .....	9
<b>3</b>	<b>Auxiliary materials</b> .....	<b>10</b>
3.1	Tools, lubricants and other auxiliary materials .....	10
3.2	Special tools and gauges .....	11

### Part II Maintenance and checks

<b>4</b>	<b>Major cleaning</b> .....	<b>17</b>
4.1	Intervals for major cleaning .....	17
4.2	Carrying out major cleaning .....	18
4.3	Lubrication diagram .....	19
<b>5</b>	<b>Special cleaning work</b> .....	<b>20</b>
5.1	Cleaning the pressure bolt hole .....	20
<b>6</b>	<b>Maintenance checks</b> .....	<b>21</b>
6.1	Intervals for maintenance checks .....	21
6.2	Checking the loading and unloading procedure .....	22
6.3	Checking the headspace .....	22
6.4	Checking trigger pull .....	24
6.5	Checking barrel wear .....	26
6.6	Checking function of the firing pin safety .....	28
6.7	Checking firing pin protrusion .....	29
6.8	Checking function of the extractor .....	30
6.9	Checking firing function .....	31
6.10	Checking point of impact .....	31



## 9.4 Disassembling the bolt head

Required auxiliary materials:

- Assembly tool for ejector
- Ø 1.4 mm pin punch
- Ø 1.8 mm pin punch
- Hammer

1. Disassemble the bolt group.
2. Extract clamping sleeve (1a-46) using Ø 1.4 mm pin punch.
3. Extract axle for extractor (1a-42) using Ø 1.8 mm pin punch.
4. Remove extractor (1a-43).
5. Remove pressure spring for extractor (1a-44) and rubber plug (1a-45).
6. Insert assembly tool for ejector from the rear into the holes for ejector (49a-A).
7. Extract clamping sleeve using Ø 1.4 mm pin punch (49a-B).
8. Remove Ø 1.4 mm pin punch.
9. Remove assembly tool for ejector.
10. Remove pressure springs for ejector (1a-49).
11. Remove ejector (1a-48).

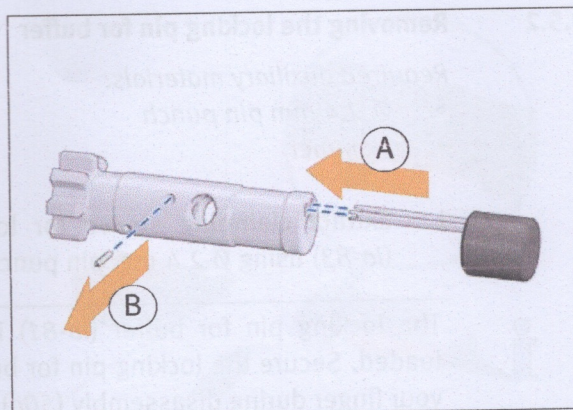


Fig. 49a: Inserting the assembly tool

## 9.5 Disassembling the lower receiver

## 9.5.1 Removing the buttstock

1. Pull buttstock release lever all the way down and hold it (49b-A).
2. Pull buttstock rearwards out of the extension (49b-B).

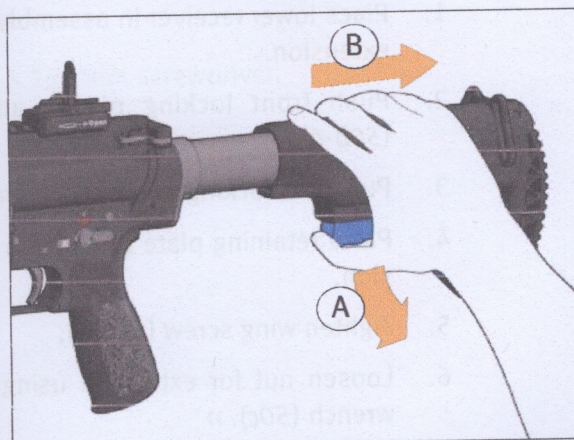


Fig. 49b: Removing the buttstock



## 9.5.2 Removing the locking pin for buffer

Required auxiliary materials:

- Ø 2.4 mm pin punch
- Hammer

1. Extract clamping sleeve for locking pin (la-83) using Ø 2.4 mm pin punch.



The locking pin for buffer (la-81) is spring-loaded. Secure the locking pin for buffer with your finger during disassembly (50a).

2. Remove Ø 2.4 mm pin punch.
3. Remove locking pin for buffer (la-81).
4. Remove pressure spring for locking pin (la-82).

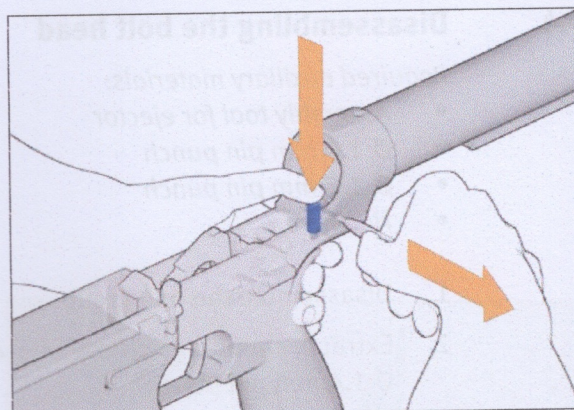


Fig. 50a: Removing the locking pin for buffer

## 9.5.3 Removing the extension

Required auxiliary materials:

- Assembly wrench
- Assembly device for extension



The plate (la-89) will become damaged when the extension is removed.

1. Place lower receiver in assembly device for extension.
2. Push front locking pin in all the way (50b-A).
3. Push rear locking pin in all the way (50b-B).
4. Place retaining plate (50b-2) on the extension.
5. Tighten wing screw (50b-C).
6. Loosen nut for extension using assembly wrench (50c). »

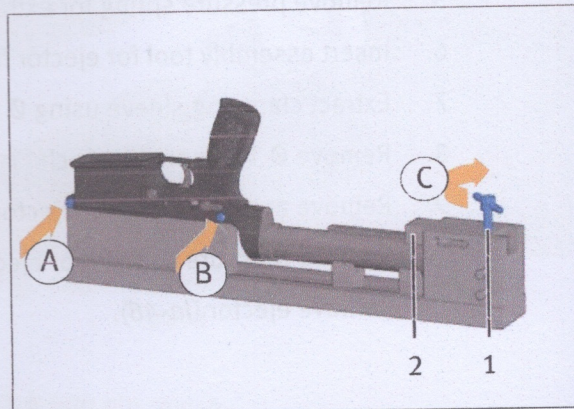


Fig. 50b: Placing lower receiver in assembly device for extension.

- 1 Wing screw
- 2 Retaining plate

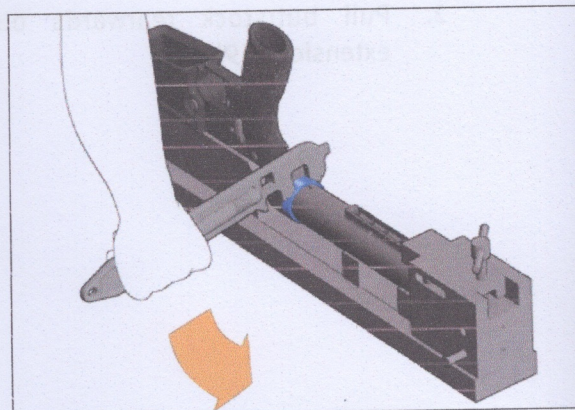


Fig. 50c: Loosening the nut for extension



7. Loosen wing screw.
8. Push retaining plate back.
9. Remove lower receiver from assembly device for extension.

**i** The cylindrical pin for stop pin (la-88) is spring-loaded. Secure the hole for cylindrical pin with your finger during disassembly (51a).

10. Unscrew extension (la-92) from the lower receiver.
11. Remove plate (la-89).
12. Remove nut for extension (la-90).



Fig. 51a: Securing hole for cylindrical pin with your finger

#### 9.5.4 Removing the rear locking pin

1. Remove extension (Section 9.5.3).
2. Remove cylindrical pin for stop pin (la-88).
3. Remove pressure spring for stop pin (la-87).
4. Remove stop pin for locking pin (la-86).
5. Remove rear locking pin (la-85).

#### 9.5.5 Remove pistol grip

Required auxiliary materials:

- 7 x 150 mm screwdriver

1. Loosen cylinder head screw pin (la-97) using 7 x 150 mm screwdriver.
2. Remove cylinder head screw.
3. Remove pistol grip (la-96).
4. Remove pressure spring for stop pin (la-95).
5. Remove stop pin (la-94).



### 9.5.6 Removing the sear release catch

*Required auxiliary materials:*

- Ø 2.8 mm pin punch
- Hammer

1. Extract axle for sear release catch (la-73) using Ø 2.8 mm pin punch.



The sear release catch (la-72) is spring-loaded. Secure the sear release catch with your finger during disassembly (52a).

2. Remove Ø 2.8 mm pin punch.
3. Remove release catch (la-72).

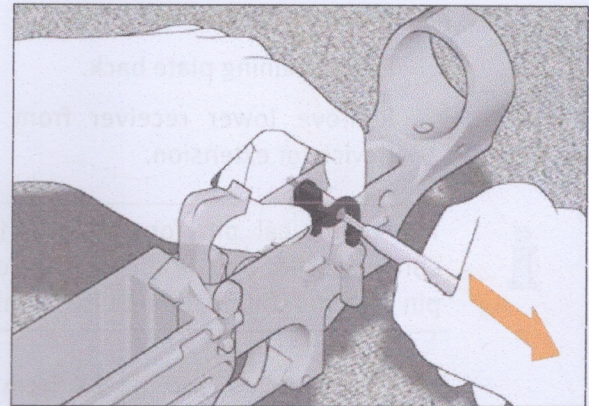


Fig. 52a: Removing the sear release catch

### 9.5.7 Remove safety lever

*Required auxiliary materials:*

- Ø 1.4 mm pin punch

1. Remove pistol grip (Section 9.5.5).
2. Remove sear release catch (Section 9.5.6).
3. Extract clamping sleeve for right-hand safety lever using Ø 1.4 mm pin punch (52b).
4. Remove right-hand safety lever (la-75).
5. Extract clamping sleeve for left-hand safety lever (la-76) using Ø 1.4 mm pin punch.
6. Remove left-hand safety lever (la-77).
7. Cock hammer.
8. Remove safety roller (la-78)
9. Pull the trigger. The hammer is released.

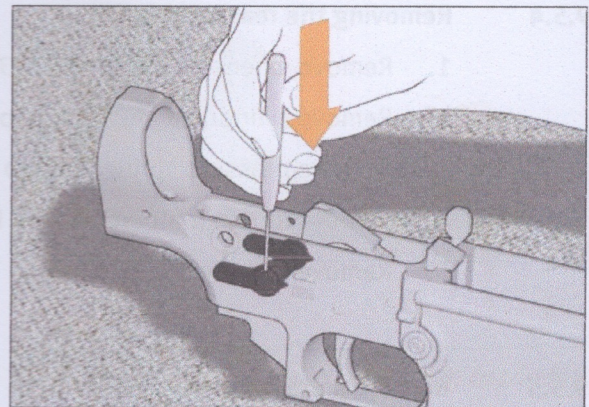


Fig. 52b: Extracting the clamping sleeve for the right-hand safety lever.



9.5.8

### Removing the hammer

Required auxiliary materials:

- Ø 2.8 mm pin punch
- Hammer

1. Extract axle for hammer (1a-68) using Ø 2.8 mm pin punch.

**i** The hammer (1a-67) is spring-loaded. Secure the hammer with your finger during disassembly (53a).

2. Remove Ø 2.8 mm pin punch.
3. Remove hammer (1a-67).

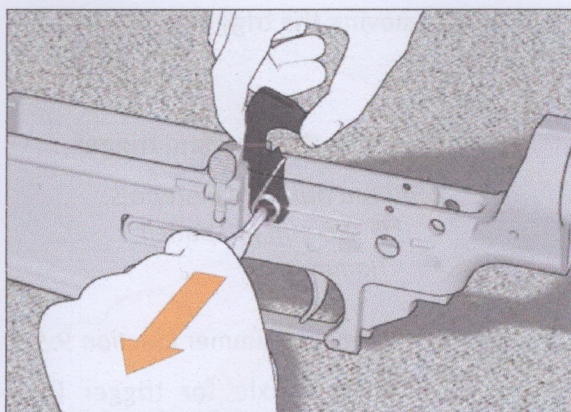


Fig. 53a: Removing the hammer

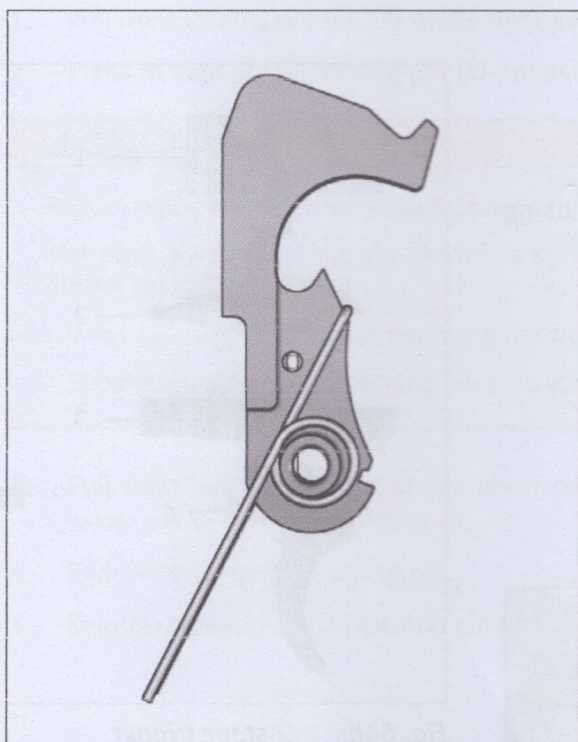


Fig. 53b: Hammer for standard trigger

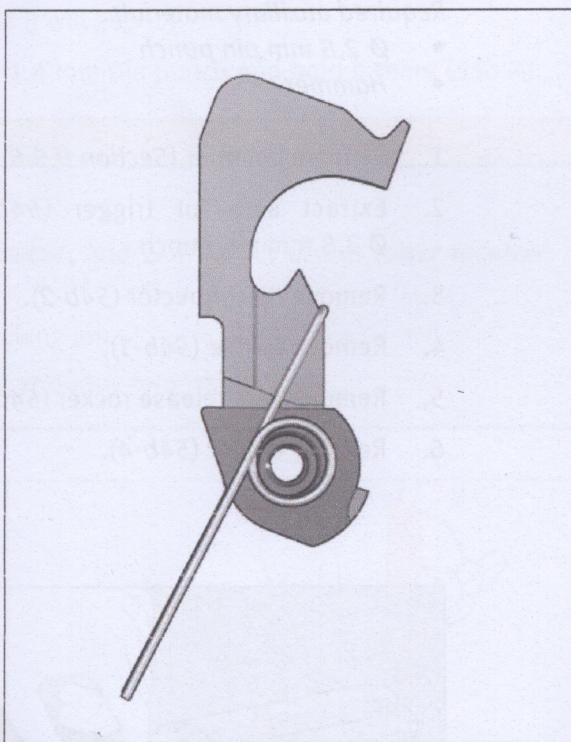


Fig. 53c: Hammer for 2-stage trigger



## 9.5.9 Removing the trigger

### Removing the standard trigger

Required auxiliary materials:

- Ø 2.8 mm pin punch
- Hammer

1. Remove hammer (Section 9.5.8).
2. Extract axle for trigger (54a-71) using Ø 2.8 mm pin punch.
3. Remove disconnecter (54a-69).
4. Remove trigger (54a-70).

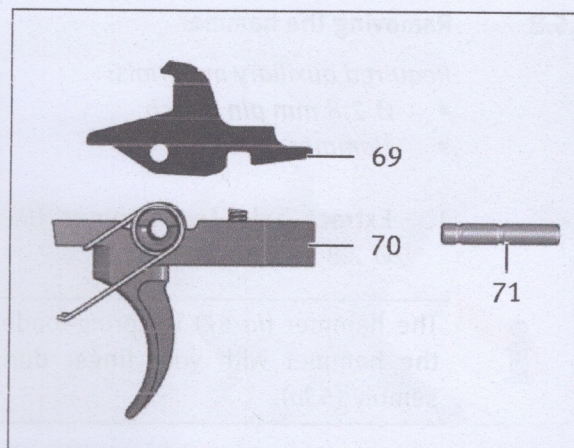


Fig. 54a: Standard trigger

- 69 Disconnecter  
70 Trigger  
71 Axle for trigger

### Removing the 2-stage trigger

Required auxiliary materials:

- Ø 2.8 mm pin punch
- Hammer

1. Remove hammer (Section 9.5.8).
2. Extract axle for trigger (54b-5) using Ø 2.8 mm pin punch.
3. Remove disconnecter (54b-2).
4. Remove bridge (54b-1).
5. Remove sear release rocker (54b-3).
6. Remove trigger (54b-4).

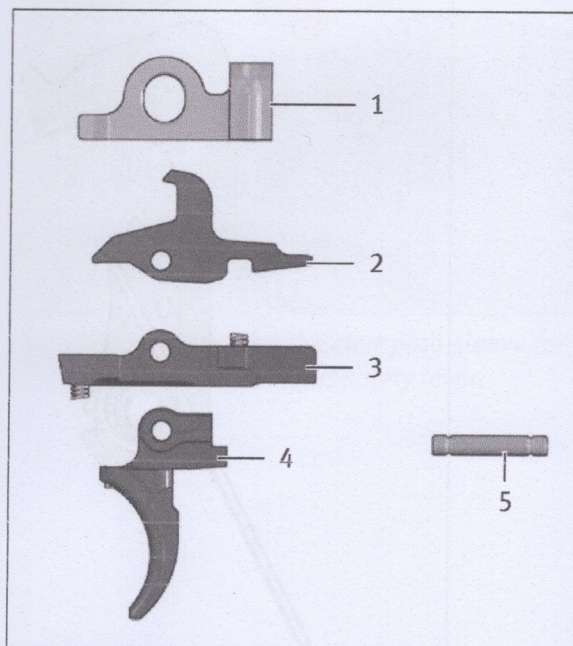


Fig. 54b: 2-stage trigger

- 1 Bridge  
2 Disconnecter  
3 Sear release rocker  
4 Trigger  
5 Axle for trigger

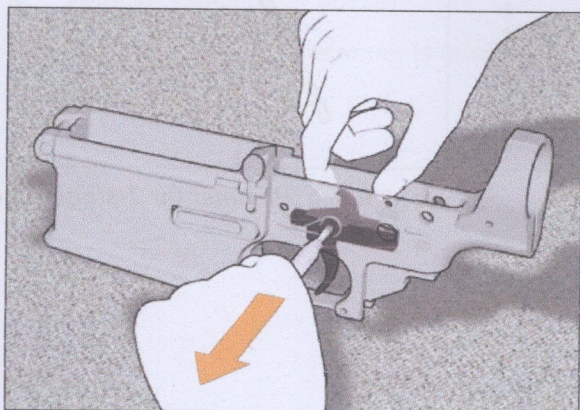


Fig. 54c: Removing the trigger



### 5.10 Removing the trigger guard

Required auxiliary materials:

- Ø 2.8 mm pin punch
- Hammer

1. Extract clamping sleeve for trigger guard (1a-80) using Ø 2.8 mm pin punch (55a).
2. Push in trigger guard release mechanism using Ø 2.8 mm pin punch.
3. Remove trigger guard (1a-79).

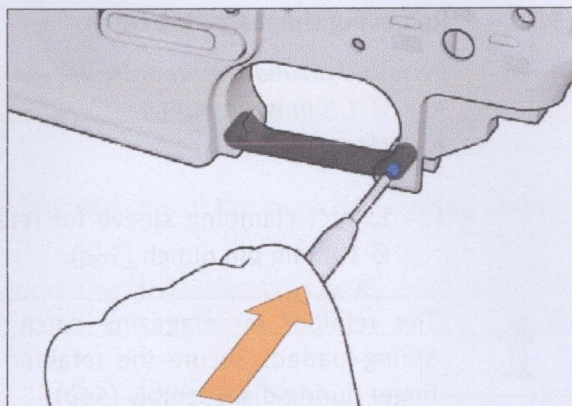


Fig. 55a: Removing the trigger guard

### 5.11 Removing the front locking pin

Required auxiliary materials:

- Ø 1.4 mm pin punch
- Hammer

1. Pull front locking pin (1a-58) to the right as far as it will go.
2. Press in stop pin for locking pin (1a-56) using Ø 1.4 mm pin punch and hold it there (55b-A).

#### ⚠ CAUTION

**Risk of injury from spring-loaded parts!**

**The stop pin for locking pin (1a-48) is spring-loaded, and can fly out of the lower receiver during removal.**

- › Wear safety goggles when removing the front locking pin.
- › Secure the stop pin for locking pin with your finger during removal (55b-B).

3. Pull front locking pin out of the lower receiver to the right (1a-84) (55b-C).
4. Remove stop pin for locking pin.
5. Remove pressure spring for stop pin (1a-57).

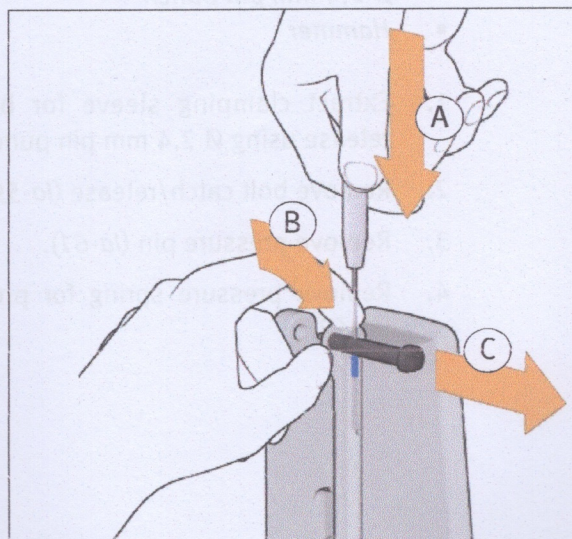


Fig. 55b: Removing the stop pin



## 9.5.12 Removing the magazine catch

*Required auxiliary materials:*

- Ø 1.8 mm pin punch
- Hammer

1. Extract clamping sleeve for retainer using Ø 1.8 mm pin punch (56a).



The retainer for magazine catch (la-64) is spring-loaded. Secure the retainer with your finger during disassembly (56b).

2. Remove Ø 1.8 mm pin punch.
3. Remove retainer for magazine catch (la-64).
4. Remove pressure spring for retainer (la-65).
5. Remove magazine catch (la-66).

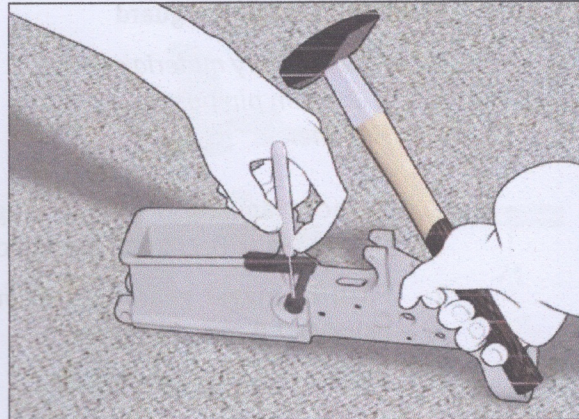


Fig. 56a: Extracting the clamping sleeve for retainer

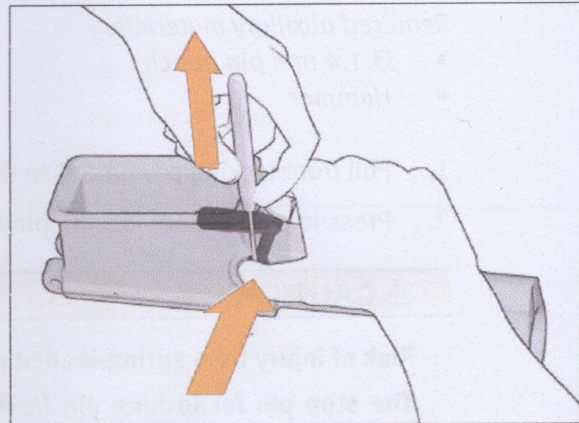


Fig. 56b: Securing the retainer

## 9.5.13 Removing the bolt catch/release

*Required auxiliary materials:*

- Ø 2.4 mm pin punch
- Hammer

1. Extract clamping sleeve for bolt catch/release using Ø 2.4 mm pin punch (56c).
2. Remove bolt catch/release (la-59).
3. Remove pressure pin (la-61).
4. Remove pressure spring for pressure pin (la-62).

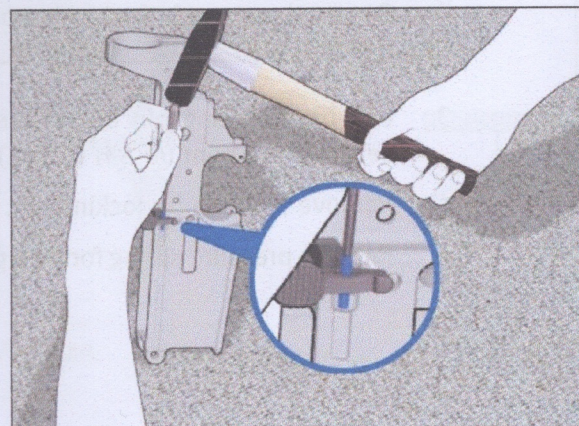


Fig. 56c: Extracting the clamping sleeve



- 9 Disassembling the weapon completely
- 9.6 Disassembling the magazine



## 9.6 Disassembling the magazine

### ⚠ CAUTION

**Risk of injury from spring-loaded parts!**

**The magazine locking plate (la-101) will fly out of the magazine if the magazine locking plate is not secured.**

- › Secure the magazine locking plate with your finger during disassembly (57a-A).

1. Press in magazine locking plate (la-101) and slide magazine floor plate (la-102) backwards slightly.
2. Pull magazine floor plate off of magazine housing (57a-B).
3. Remove magazine floor plate and magazine spring (la-100).
4. Pull magazine spring off of magazine floor plate.
5. Remove follower (la-99).

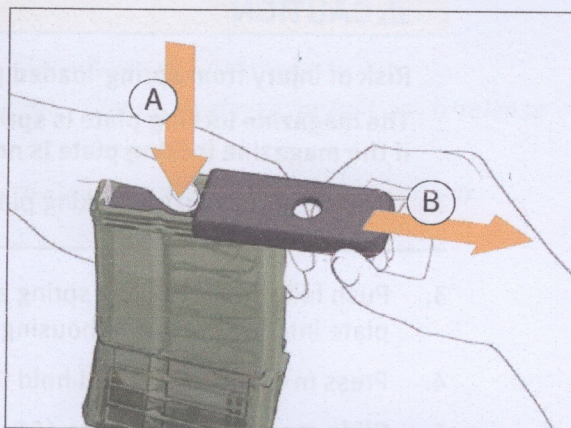


Fig. 57a: Disassembling the magazine



## 10 Assembling the weapon completely



Clamping sleeves that have been removed may not be re-used during assembly. Replace removed clamping sleeves with new clamping sleeves.

### 10.1 Assembling the magazine

1. Place follower (58a-99) on magazine spring (58a-100).
2. Hook magazine spring onto magazine locking plate (58a-101).

#### **⚠ CAUTION**

**Risk of injury from spring-loaded parts!**

**The magazine locking plate is spring-loaded during assembly, and can fly out of the magazine if the magazine locking plate is not secured.**

➤ Secure the magazine locking plate with your finger during assembly (57a-A).

3. Push follower, magazine spring and locking plate into the magazine housing (58a-98).
4. Press in locking plate and hold it.
5. Slide magazine floor plate (58a-102) onto magazine housing from the rear until the magazine locking plate engages in the magazine floor plate.

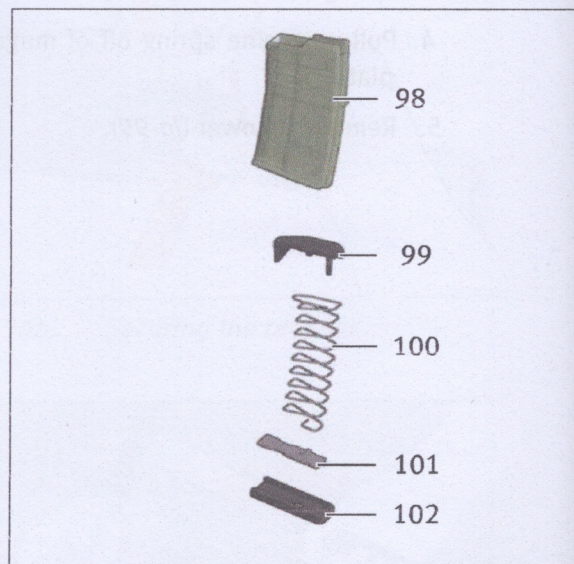


Fig. 58a: Magazine

98 Magazine housing

99 Follower

100 Magazine spring

101 Locking plate

102 Magazine floor plate





<b>7</b>	<b>Special maintenance work</b>	<b>32</b>
7.1	Checking minimum dimension of the headspace	32
7.2	Determining mean point of impact	34
<b>8</b>	<b>Faults: Causes and remedies</b>	<b>35</b>
<b>Part III Disassembly and assembly</b>		
<b>9</b>	<b>Disassembling the weapon completely</b>	<b>41</b>
9.1	Disassembling the upper receiver	41
9.2	Disassembling the handguard	45
9.3	Disassembling the charging handle	48
9.4	Disassembling the bolt head	49
9.5	Disassembling the lower receiver	49
9.6	Disassembling the magazine	57
<b>10</b>	<b>Assembling the weapon completely</b>	<b>58</b>
10.1	Assembling the magazine	58
10.2	Assembling the lower receiver	59
10.3	Assembling the bolt head	72
10.4	Assembling the charging handle	73
10.5	Assembling the handguard	75
10.6	Assembling the upper receiver	77



## 0.2 Assembling the lower receiver

### 0.2.1 Inserting the bolt catch/release

Required auxiliary materials:

- Ø 2.4 mm pin punch
- Hammer

1. Insert pressure spring for pressure pin (59b-62) into lower receiver.
2. Insert pressure pin (59b-61) into the lower receiver.
3. Insert bolt catch/release (59b-59) into lower receiver.
4. Drive in clamping sleeve for bolt catch/release (59b-60) using Ø 2.4 mm pin punch.

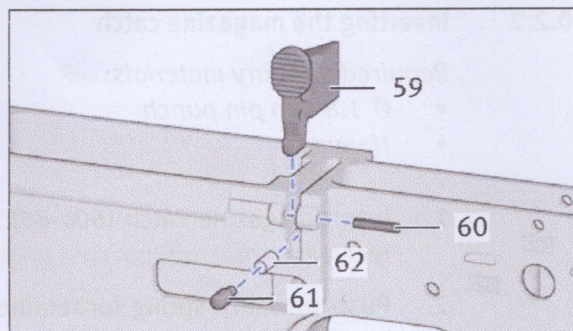


Fig. 59b: Bolt catch/release

59 Bolt catch/release

60 Clamping sleeve for bolt catch/release

61 Pressure pin

62 Pressure spring for pressure pin



### 10.2.2 Inserting the magazine catch

*Required auxiliary materials:*

- Ø 1.8 mm pin punch
- Hammer

1. Insert magazine catch (60a-66) into lower receiver.
2. Push pressure spring for retainer (60a-65) onto the magazine catch.
3. Push retainer for magazine catch (60a-64) onto the magazine catch and hold it there.
4. Drive in clamping sleeve for retainer (60a-63) using Ø 1.8 mm pin punch.

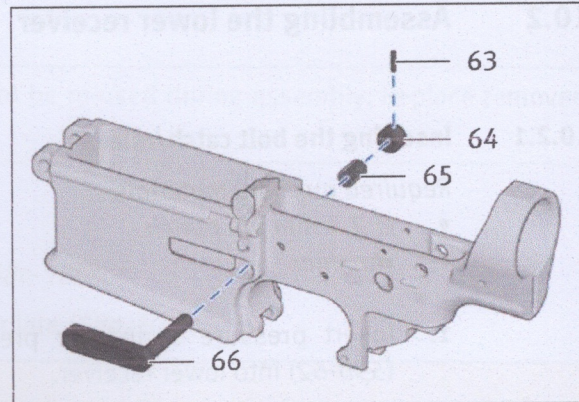


Fig. 60a: Magazine catch

- 63 Clamping sleeve for retainer
- 64 Retainer for magazine catch
- 65 Pressure spring for retainer
- 66 Magazine catch



### 0.2.3 Inserting the front locking pin

Required auxiliary materials:

- Ø 1.4 mm pin punch
- Ø 5.9 mm pin punch
- Pliers

1. Insert Ø 5.9 mm pin punch into the hole for locking pin from the left.
2. Insert pressure spring for stop pin (61a-57) into the lower receiver.

#### **CAUTION**

**Risk of injury from spring-loaded parts!**

**The stop pin for locking pin (61a-56) is spring-loaded when it is inserted, and can fly out of the lower receiver.**

› Wear safety goggles when inserting the front locking pin.

3. Using the pliers, set stop pin for locking pin on the pressure spring for stop pin and hold it there (61b-A).
4. Press stop pin for locking pin into the lower receiver using Ø 1.4 mm pin punch and hold it there (61b-B). »

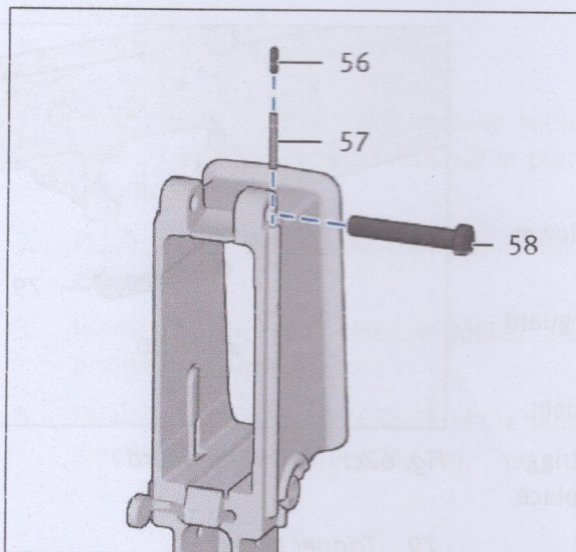


Fig. 61a: Front locking pin

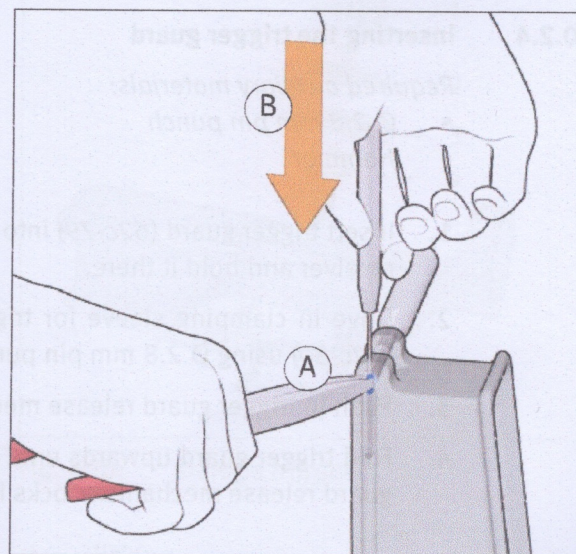


Fig. 61b: Inserting stop pin for locking pin

- 56 Stop pin for locking pin  
57 Pressure spring for stop pin  
58 Locking pin, front



5. Push  $\varnothing$  5.9 mm pin punch in front of the stop pin for locking pin and hold it there (62a).
6. Push locking pin from the right in front of the stop pin for locking pin, thus extracting  $\varnothing$  5.9 mm pin punch (62b).

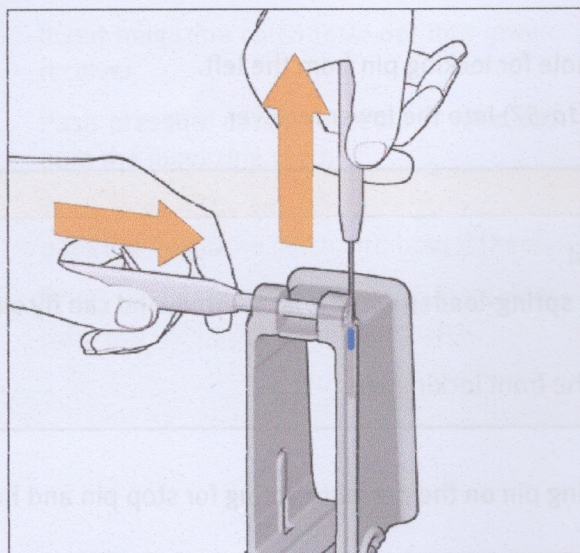


Fig. 62a: Pushing pin punch in front of the stop pin for locking pin

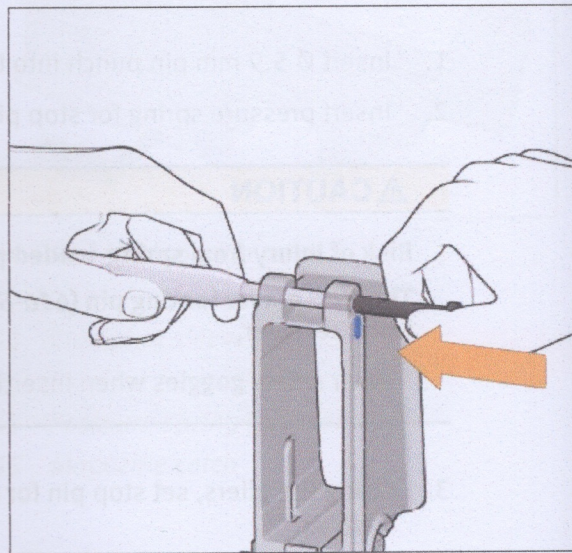


Fig. 62b: Pushing locking pin before the stop pin for locking pin

#### 10.2.4 Inserting the trigger guard

Required auxiliary materials:

- $\varnothing$  2.8 mm pin punch
- Hammer

1. Insert trigger guard (62c-79) into the lower receiver and hold it there.
2. Drive in clamping sleeve for trigger guard (62c-80) using  $\varnothing$  2.8 mm pin punch.
3. Push in trigger guard release mechanism.
4. Fold trigger guard upwards until the trigger guard release mechanism locks into place.

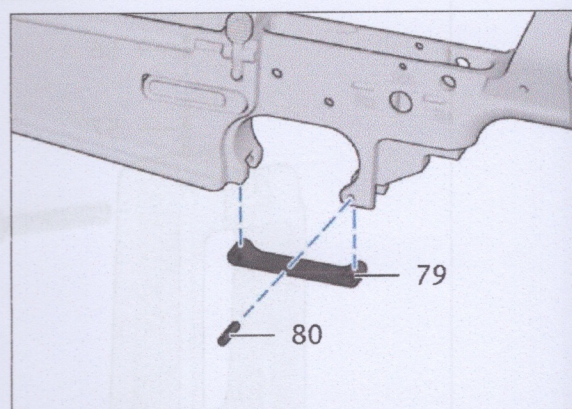


Fig. 62c: Trigger guard

79 Trigger guard

80 Clamping sleeve for trigger guard



### 10.2.5 Inserting the trigger

#### Inserting the standard trigger

Required auxiliary materials:

- Hammer
- Mounting pin

1. Hold trigger (63a-70) and disconnecter (63a-69) in place with mounting pin.
2. Insert trigger and disconnecter into the lower receiver.
3. Drive in axle for trigger (63a-71), at the same time extracting the mounting pin.

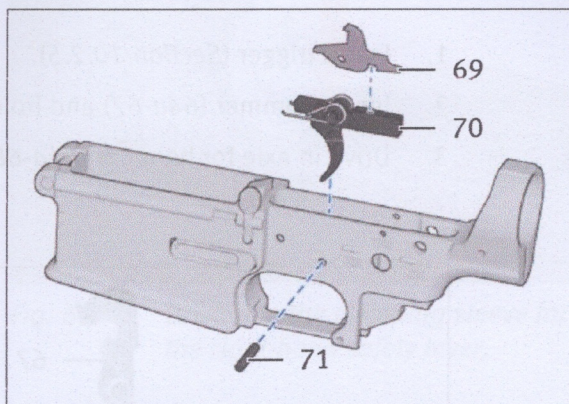


Fig. 63a: Standard trigger

- 69 Disconnecter
- 70 Trigger
- 71 Axle for trigger

#### Inserting the 2-stage trigger

Required auxiliary materials:

- Hammer
- Mounting pin 3,92h8 x 13 mm

1. Hold trigger (63b-4), sear release rocker (63b-3) and disconnecter (63b-2) in place with mounting pin.
2. Place bridge (63b-1) on the sear release rocker.
3. Insert trigger, sear release rocker and bridge into the receiver.
4. Drive in axle for trigger (63b-5), at the same time extracting the mounting pin.

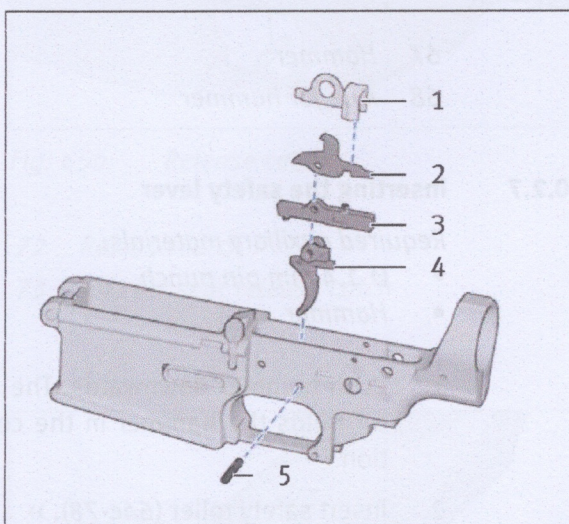


Fig. 63b: 2-stage trigger

- 1 Bridge
- 2 Disconnecter
- 3 Sear release rocker
- 4 Trigger
- 5 Axle for trigger



### 10.2.6 Inserting the hammer

Required auxiliary materials:

- Hammer

1. Insert trigger (Section 10.2.5).
2. Insert hammer (64a-67) and hold it. Observe position of the spring (64b).
3. Drive in axle for hammer (64a-68).

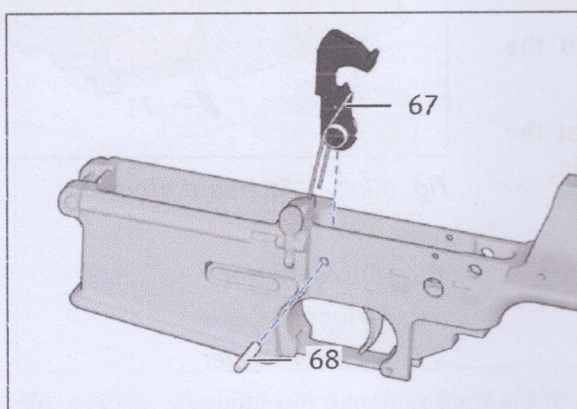


Fig. 64a: Hammer

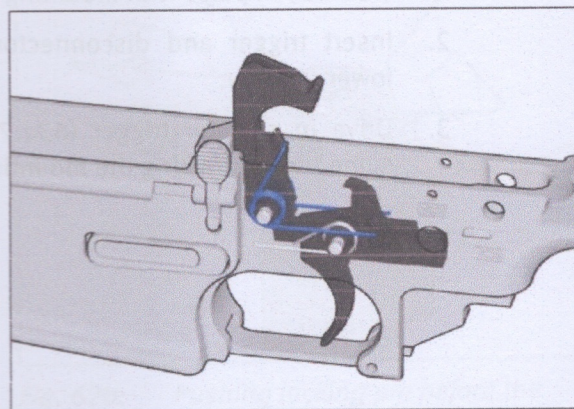


Fig. 64b: Position of the spring

67 Hammer

68 Axle for hammer

### 10.2.7 Inserting the safety lever

Required auxiliary materials:

- Ø 1.4 mm pin punch
- Hammer

1. Push hammer downwards. The disconnecter holds the hammer in the cocked position.
2. Insert safety roller (64c-78). »

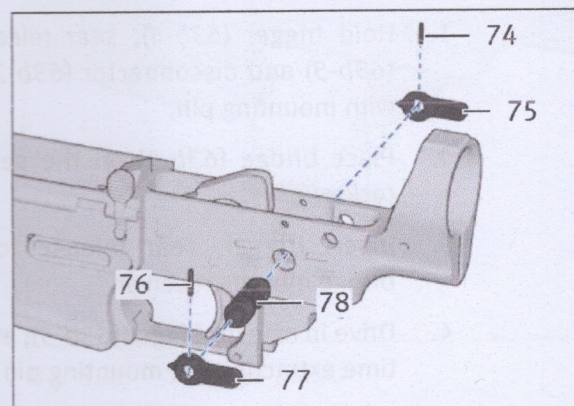


Fig. 64c: Safety lever

74 Clamping sleeve for safety lever, right

75 Safety lever, right

76 Clamping sleeve for safety lever, left

77 Safety lever, left

78 Safety roller



3. Place left-hand safety lever (64c-77) on the safety roller.
4. Drive in clamping sleeve for left-hand safety lever (64c-76) using  $\varnothing$  1.4 mm pin punch.
5. Place right-hand safety lever (64c-75) on the safety roller.
6. Drive in clamping sleeve for right-hand safety lever using  $\varnothing$  1.4 mm pin punch (65 a).
7. Pull the trigger. The hammer is released.

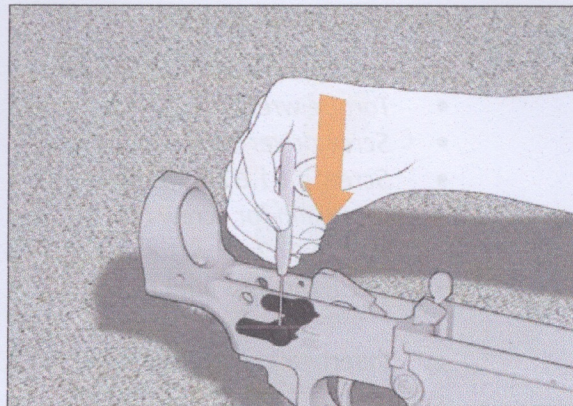


Fig. 65a: Driving in the clamping sleeve for the right-hand safety lever.

### 10.2.8 Inserting the sear release catch

Required auxiliary materials:

- Hammer

1. Insert safety lever (Section 10.2.7).
2. Click safety lever to the "sustained fire" position.
3. Push elbow spring into assembly position (65c).
4. Insert sear release catch (65b-72). Observe position of the elbow spring (65d).
5. Drive in axle for sear release catch (65b-73) (65d).

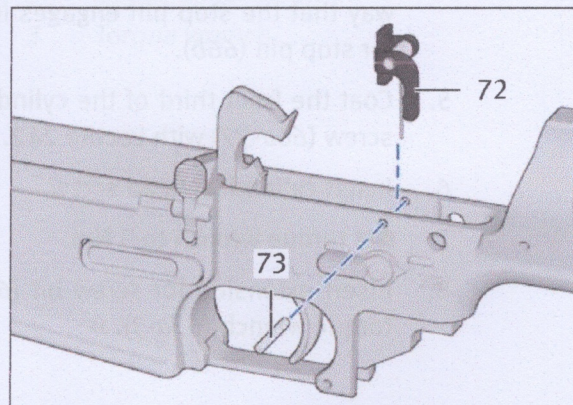


Fig. 65b: Release catch

72 Release catch

73 Axle for sear release catch

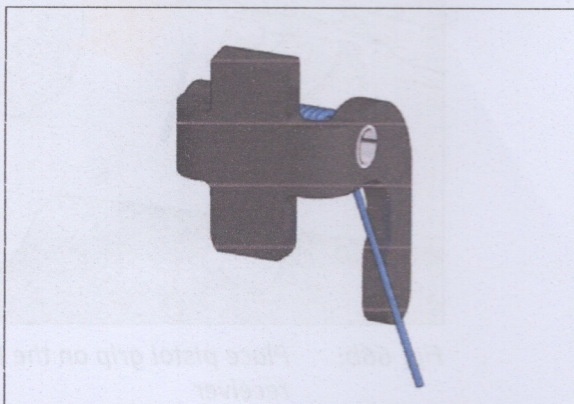


Fig. 65c: Assembly position of the elbow spring

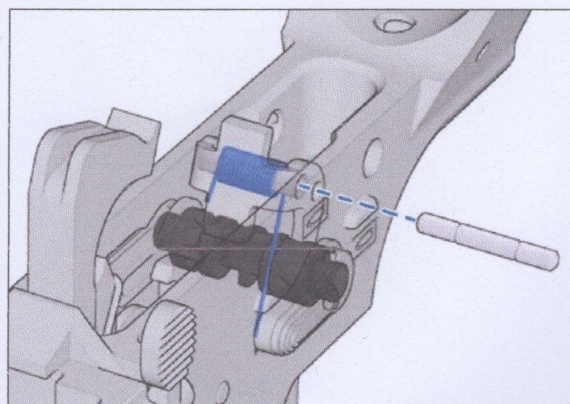


Fig. 65d: Driving in axle for sear release catch



## 10.2.9 Inserting the pistol grip

required auxiliary materials:

- Torque wrench 1 - 5 Nm
- Screwdriver 7 x 150 mm
- Screw bit 1.62 x 25 mm
- Extension for screw bit
- Loctite 242
- Ø 1.8 mm pin punch

1. Insert safety lever (Section 10.2.7).
2. Insert stop pin (66a-94) into lower receiver.
3. Insert pressure spring for stop pin (66a-95) into pistol grip (66a-96).
4. Set pistol grip on lower receiver in such a way that the stop pin engages in the hole for stop pin (66b).
5. Coat the front third of the cylindrical head screw (66a-97) with Loctite 242.
6. Insert cylindrical head screw.
7. Set torque wrench to 3 Nm.
8. Insert extension for screw bit (67a-2) into torque wrench (67a-3). »

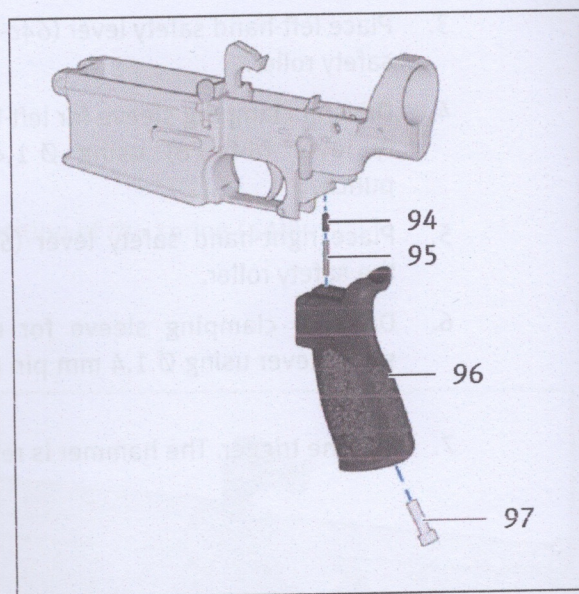


Fig. 66a: Pistol grip

- 94 Stop pin
- 95 Pressure spring for stop pin
- 96 Pistol grip
- 97 Cylinder head screw

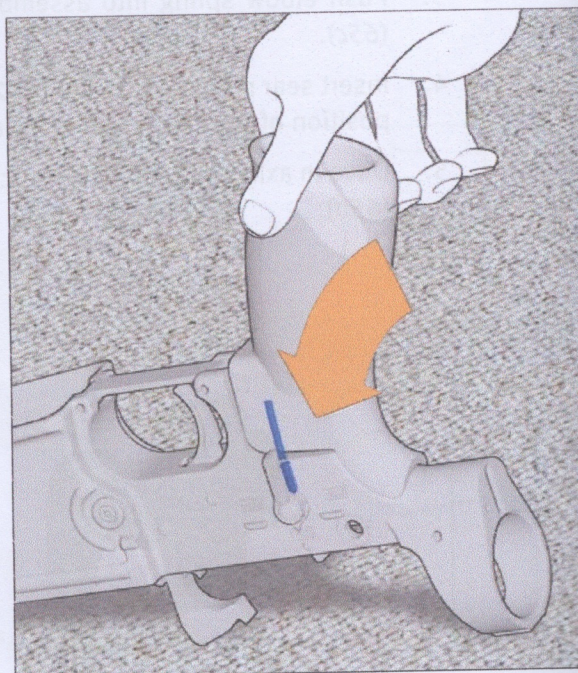


Fig. 66b: Place pistol grip on the lower receiver



## 10 Assembling the weapon completely

### 10.2 Assembling the lower receiver



9. Insert screw bit (67a-1) into extension for screw bit.
10. Tighten cylinder head screw using screw bit until the torque is reached (67a).

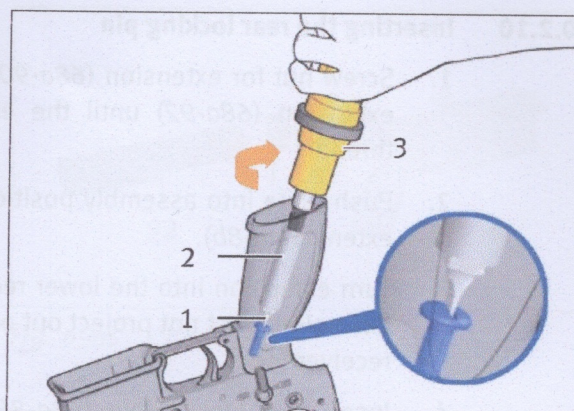


Fig. 67a: Tightening the cylinder head screw

- 1 Screw bit
- 2 Extension for screw bit
- 3 Torque wrench



### 10.2.10 Inserting the rear locking pin

1. Screw nut for extension (68a-90) onto the extension (68a-92) until the end of the thread.
2. Push plate into assembly positions on the extension (68b).
3. Turn extension into the lower receiver. The extension must not project out of the lower receiver (68c).
4. Insert rear locking pin (68a-85) into the lower receiver from the right side.
5. Insert pin punch for locking pin (68a-86) into lower receiver.
6. Insert pressure spring for stop pin (68a-87) into lower receiver.
7. Insert cylindrical pin for stop pin (68a-88) into the lower receiver.
8. Push cylindrical pin for stop pin with plate (68a-89) into the lower receiver and hold it there.
9. Screw nut for extension all the way forwards.

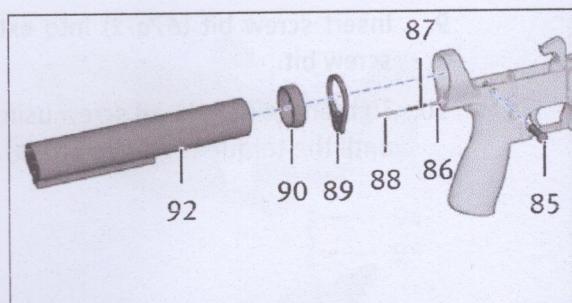


Fig. 68a: Locking pin, rear

- |    |                              |
|----|------------------------------|
| 85 | Locking pin, rear            |
| 86 | Stop pin for locking pin     |
| 87 | Pressure spring for stop pin |
| 88 | Cylindrical pin for stop pin |
| 89 | Plate                        |
| 90 | Nut for extension            |
| 92 | Extension                    |



The stop pin for locking pin (68a-86) must engage with the recess in the rear locking pin (68a-85). If necessary turn the rear locking pin until the stop pin for locking pin engages in the recess.

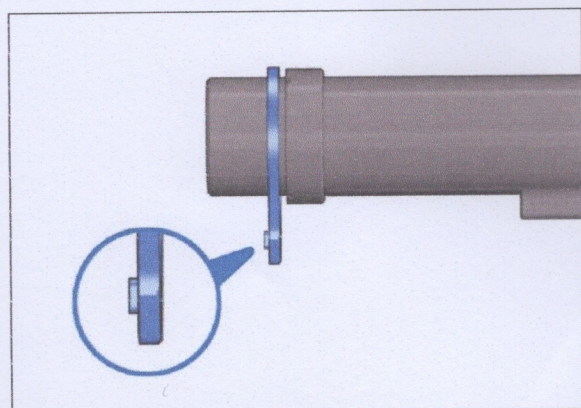


Fig. 68b: Pushing the plate onto the extension



Fig. 68c: Position of the extension



## Part I

### General principles

- you have successfully completed a relevant qualification for the position described here.
- you have read and understood the information on general conditions.
- you have accepted the conditions described in the advertisement for this.
- you have read and understood the company's policy on the use of personal data.
- you have read and understood the company's policy on the use of personal data.



### 10.2.11 Inserting the extension

Required auxiliary materials:

- Mount for extension
- Torque wrench 20 - 200 Nm
- Assembly device for extension
- Assembly wrench
- Vice
- Caulking tool

1. Insert front locking pin (Section 10.2.3).
2. Insert rear locking pin (Section 10.2.10).
3. Place lower receiver in assembly device for extension.
4. Push front locking pin in all the way (69b-A).
5. Push rear locking pin in all the way (69b-B).
6. Place retaining plate (69b-2) on the extension (69a-92).
7. Tighten wing screw (69b-C).
8. Set torque wrench to 60 Nm.
9. Insert assembly wrench in torque wrench.
10. Tighten nut for extension using assembly wrench until the torque is reached (69c).
11. Loosen wing screw.
12. Push retaining plate back.
13. Remove lower receiver from assembly device for extension. »

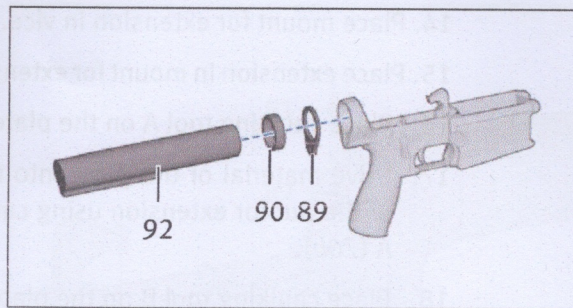


Fig. 69a: Extension

- 89 Plate  
90 Nut for extension  
92 Extension

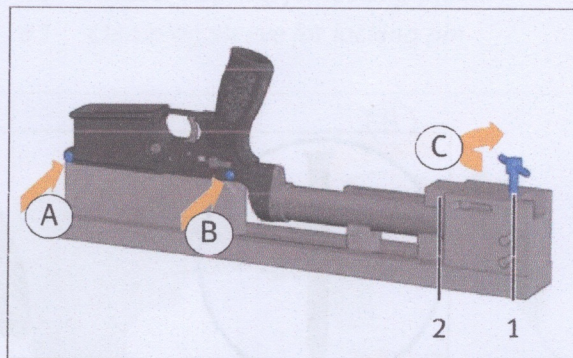


Fig. 69b: Placing lower receiver in assembly device for extension

- 1 Wing screw  
2 Retaining plate

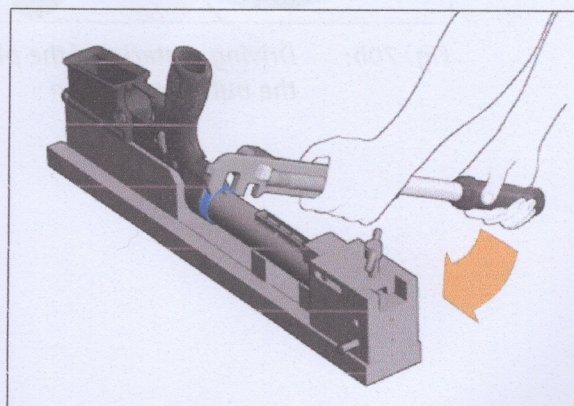


Fig. 69c: Tightening nut for extension



14. Place mount for extension in vice.
15. Place extension in mount for extension (70a).
16. Place caulking tool A on the plate.
17. Drive material of the plate into the groove of the nut for extension using caulking tool A (70b).
18. Place caulking tool B on the plate.
19. Caulk driven-in material and nut for extension using caulking tool B (71c).

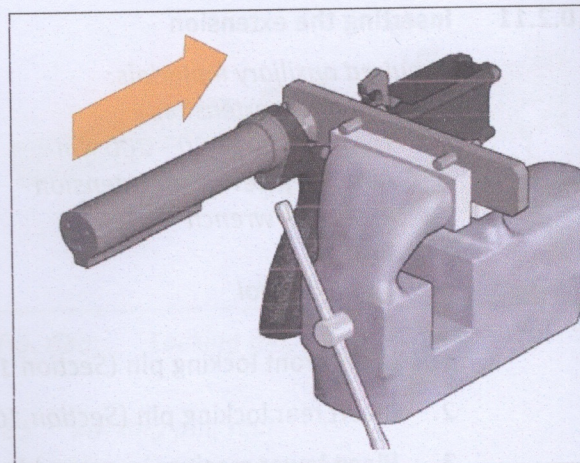


Fig. 70a: Inserting the extension

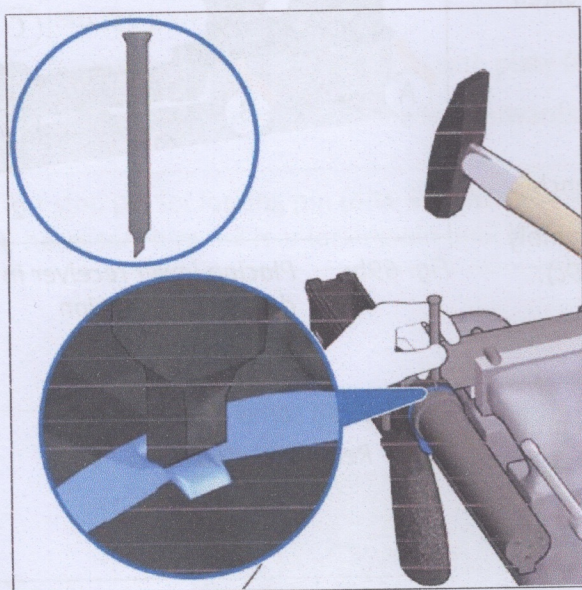


Fig. 70b: Driving material of the plate into the nut for extension

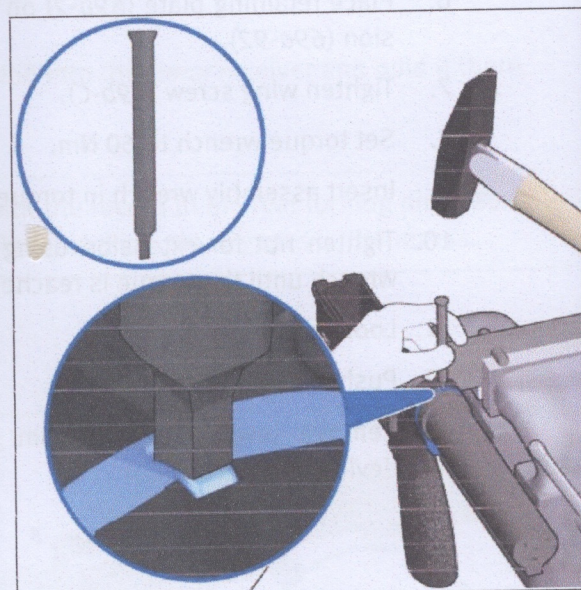


Fig. 70c: Caulking the plate using caulking tool B



**10.2.12 Inserting locking pin for buffer**

Required auxiliary materials:

- Ø 2.4 mm pin punch
- Hammer

1. Insert pressure spring for locking pin (71a-82) into lower receiver.
2. Push locking pin for buffer (71a-81) into lower receiver all the way and hold it there.
3. Hold locking pin for buffer in place with Ø 2.4 mm pin punch.
4. Drive in clamping sleeve for locking pin (71a-83), at the same time extracting Ø 2.4 mm pin punch.

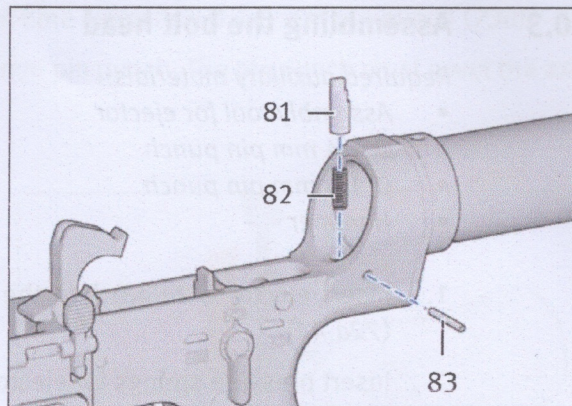


Fig. 71a: Locking pin for buffer

81 Locking pin for buffer

82 Pressure spring for locking pin

83 Clamping sleeve for locking pin

**10.2.13 Inserting the buttstock**

1. Insert the extension (Section 10.2.11).
2. Pull buttstock release lever all the way down and hold it (71b-A).
3. Push buttstock onto extension from the rear (71b-B).

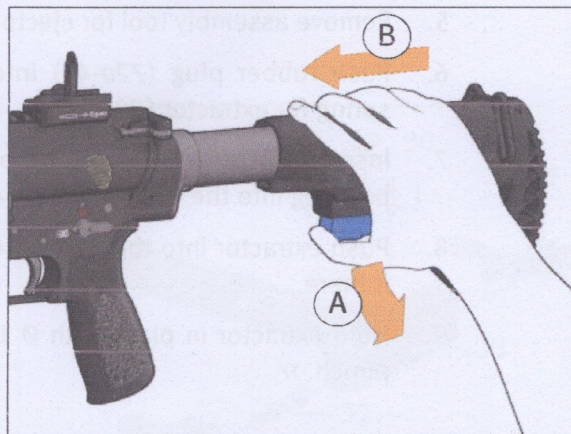


Fig. 71b: Removing the buttstock



### 10.3 Assembling the bolt head

*Required auxiliary materials:*

- Assembly tool for ejector
- Ø 1.4 mm pin punch
- Ø 1.8 mm pin punch
- Hammer

1. Insert ejector (72a-48) into the bolt head (72a-41).
2. Insert pressure springs for ejector (72a-49) into the bolt head.
3. Push assembly tool for ejector into the bolt head as far as it will go and hold it there (72b-A).
4. Drive in clamping sleeve (72a-47) using Ø 1.4 mm pin punch (72b-B).
5. Remove assembly tool for ejector.
6. Push rubber plug (72a-45) into pressure spring for extractor (72a-44).
7. Insert pressure spring for ejector with rubber plug into the extractor (72a-43).
8. Push extractor into the bolt head and hold it there.
9. Hold extractor in place with Ø 1.8 mm pin punch. »

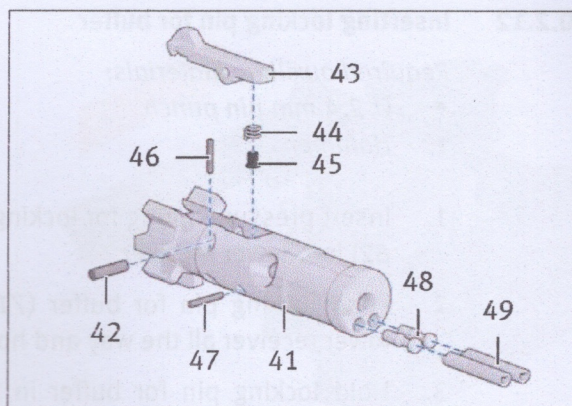


Fig. 72a: Bolt head

- |    |                               |
|----|-------------------------------|
| 41 | Bolt head                     |
| 42 | Axle for extractor            |
| 43 | Extractor                     |
| 44 | Pressure spring for extractor |
| 45 | Rubber plug                   |
| 46 | Clamping sleeve               |
| 47 | Clamping sleeve               |
| 48 | Ejector                       |
| 49 | Pressure springs for ejector  |

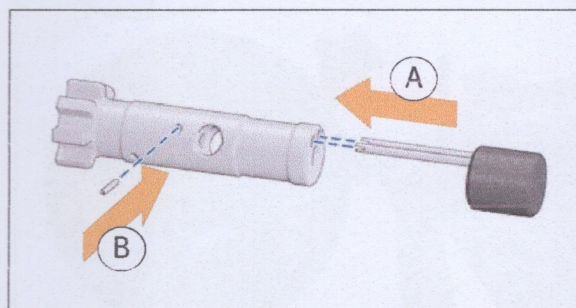


Fig. 72b: Pushing assembly tool for extractor into the bolt head



10. Drive in axle for extractor (72a-42), at the same time extracting  $\varnothing 1.8$  mm pin punch (73a).
11. Drive in clamping sleeve (72a-46) using  $\varnothing 1.4$  mm pin punch. The pin punch must cover the axle for extractor (73b).

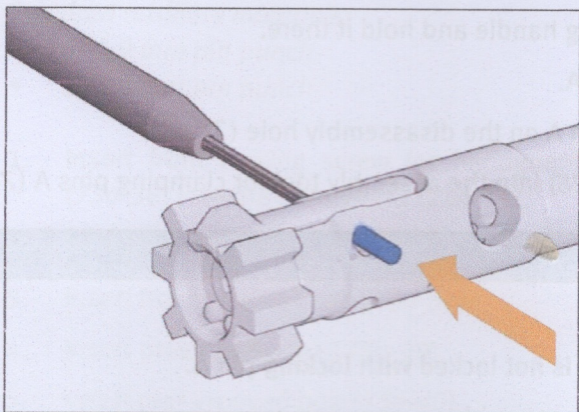


Fig. 73a: Driving in axle for extractor

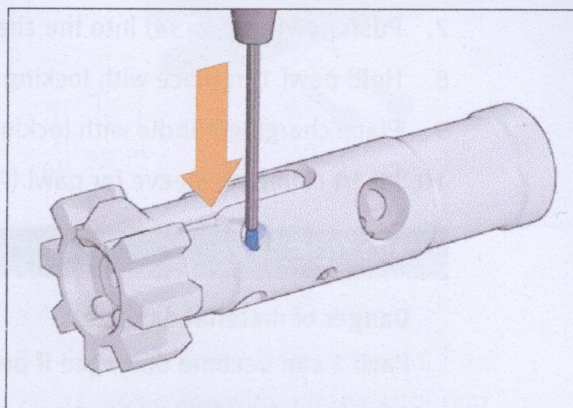


Fig. 73b: Driving in clamping sleeve

## 0.4 Assembling the charging handle

### Required auxiliary materials:

- Assembly device for charging handle
- $\varnothing 1.8$  mm pin punch
- $\varnothing 2.4$  mm pin punch
- Hammer

1. Place charging handle on the the assembly device for charging handle.
2. Drive in clamping sleeve for pawl (73c-29) into charging handle (73c-33) using  $\varnothing 1.8$  mm pin punch.
3. Insert pawl 2 (73c-31) into the charging handle.
4. Drive clamping sleeve for pawl (73c-30) into the charging handle.
5. Insert pressure spring for pawl 2 (73c-32) into the the charging handle. »

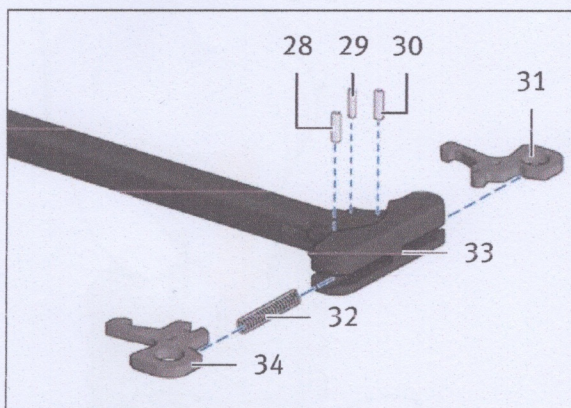


Fig. 73c: Charging handle

- 28 Clamping sleeve for pawl
- 29 Clamping sleeve for pawl
- 30 Clamping sleeve for pawl
- 31 Pawl 2
- 32 Pressure spring for pawl 2
- 33 Charging handle
- 34 Pawl 1





The assembly device for charging handle also contains tools for the HK416. Not all of the tools are needed for assembly of the HK417.

6. Insert locking pin A (74a-4) into the mounting position (74a-2).
7. Push pawl 1 (73c-34) into the charging handle and hold it there.
8. Hold pawl 1 in place with locking pin A.
9. Place charging handle with locking pin A on the disassembly hole (74a-1).
10. Insert clamping sleeve for pawl (73c-28) into the assembly tool for clamping pins A (74a-3).

### NOTICE

#### **Danger of material damage!**

**Pawl 1 can become damaged if pawl 1 is not locked with locking pin A.**

- › Lock pawl 1 with locking pin A during assembly.

11. Drive clamping sleeve for pawl into the charging handle.

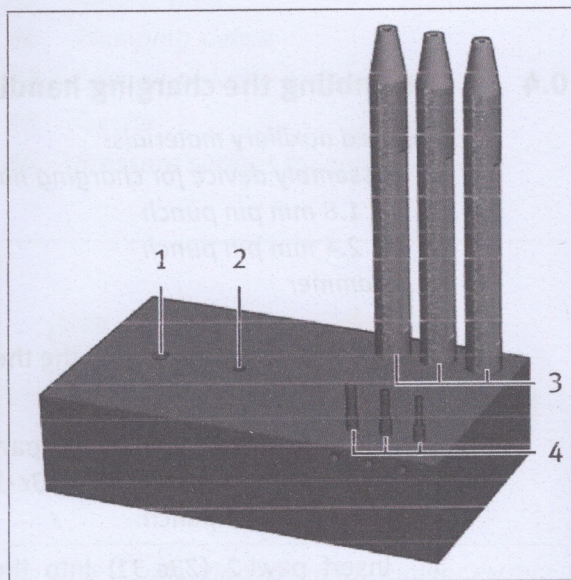


Fig. 74a: Assembly device for charging lever

- 1 Disassembly hole
- 2 Mounting position
- 3 Assembly tools for clamping pins A, B and C
- 4 Locking pins A, B and C



## 5.5 Assembling the handguard

### 5.1 Assembling the standard handguard

Required auxiliary materials:

- Ø 0.9 mm pin punch
- Ø 2.4 mm pin punch

1. Insert front locking screw for handguard (75a-36) into the handguard (75a-35).
2. Stand handguard up vertically.
3. Insert front grooved bolt (75a-38).
4. Insert pressure spring (75a-39).
5. Insert rear grooved bolt (75a-40).
6. Extract front retaining screw as far as the disassembly position.
7. Push in rear grooved bolt using Ø 2.4 mm pin punch and hold it there (75b-A).
8. Secure rear grooved bolt using Ø 0.9 mm pin punch (75b-B).
9. Insert rear retaining screw for handguard (75a-37) into the handguard.
10. Remove Ø 0.9 mm pin punch.

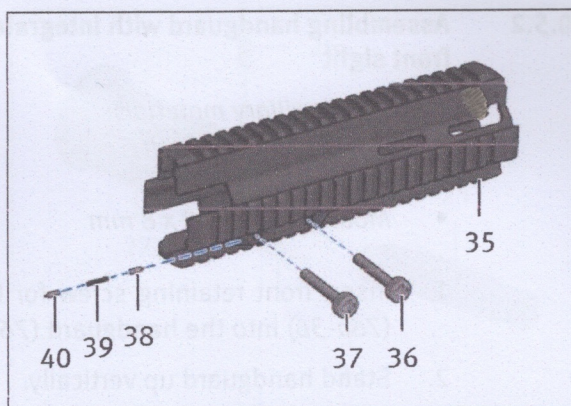


Fig. 75a: Handguard

- 35 Handguard
- 36 Locking screw for handguard, front
- 37 Locking screw for handguard, rear
- 38 Grooved bolt, front
- 39 Pressure spring
- 40 Grooved bolt, rear

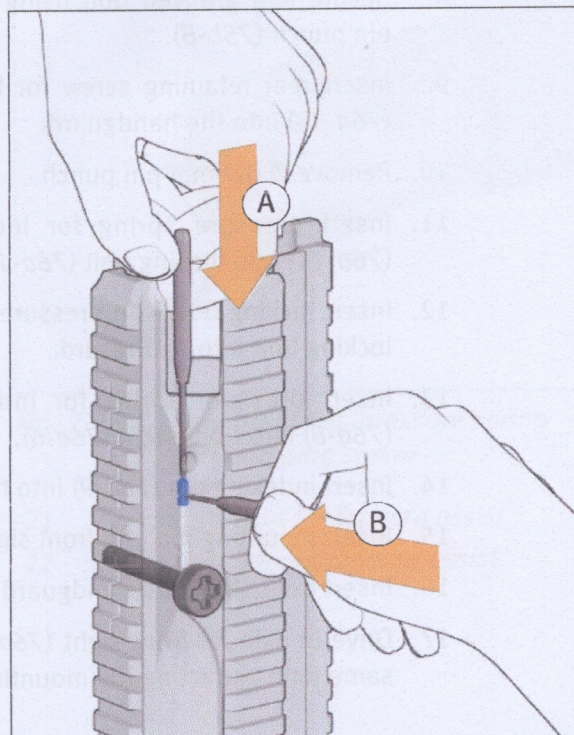


Fig. 75b: Assembling the handguard



## 10.5.2 Assembling handguard with integrated front sight

*Required auxiliary materials:*

- Ø 0.9 mm pin punch
- Ø 2.4 mm pin punch
- Mounting pin 3.9 x 8 mm

1. Insert front retaining screw for handguard (76a-36) into the handguard (76a-35).
2. Stand handguard up vertically.
3. Insert front grooved bolt (76a-38).
4. Insert pressure spring (76a-39).
5. Insert rear grooved bolt (76a-40).
6. Extract front retaining screw as far as the disassembly position.
7. Push in rear grooved bolt using Ø 2.4 mm pin punch and hold it there (75b-A).
8. Secure rear grooved bolt using Ø 0.9 mm pin punch (75b-B).
9. Insert rear retaining screw for handguard (76a-37) into the handguard.
10. Remove Ø 0.9 mm pin punch.
11. Insert pressure spring for locking bolt (76a-11) into locking bolt (76a-10).
12. Insert locking bolt with pressure spring for locking bolt into handguard.
13. Insert pressure spring for indexing pin (76a-8) into front sight (76a-6).
14. Insert indexing pin (76a-9) into front sight.
15. Insert mounting pin into front sight.
16. Insert front sight into handguard.
17. Drive in axle for front sight (76a-7), at the same time extracting the mounting pin.

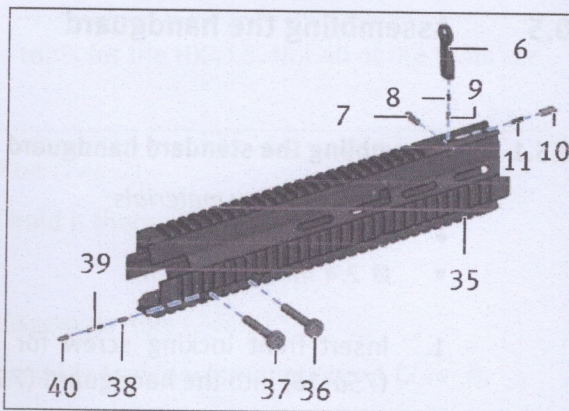


Fig. 76a: Handguard with integrated front sight

- |    |                                      |
|----|--------------------------------------|
| 35 | Handguard                            |
| 36 | Retaining screw for handguard, front |
| 37 | Retaining screw for handguard, rear  |
| 38 | Grooved bolt, front                  |
| 39 | Pressure spring                      |
| 40 | Grooved bolt, rear                   |
| 6  | Front sight                          |
| 7  | Axle for front sight                 |
| 8  | Pressure spring for indexing pin     |
| 9  | Indexing pin                         |
| 10 | Locking bolt                         |
| 11 | Pressure spring for locking bolt     |

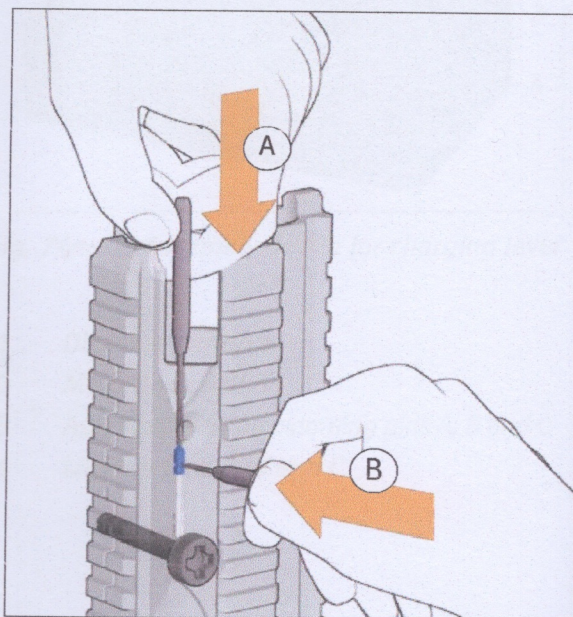


Fig. 76b: Assembling the handguard



## 10.6 Assembling the upper receiver

### 10.6.1 Inserting the forward assist

Required auxiliary materials:

- Ø 1.4 mm pin punch
- Ø 2.4 mm pin punch
- Hammer

1. Insert pressure spring for pressure bolt (77a-24) into the retainer (77a-27).
2. Insert pressure bolt for forward assist (77a-23) into the retainer.
3. Insert locking piece for forward assist (77a-25) into the retainer and hold in place with Ø 1.4 mm pin punch.
4. Drive in pressure bolt for locking piece (77a-26), at the same time extracting Ø 1.4 mm pin punch.
5. Place pressure spring for forward assist (77b-22) on the retainer.
6. Insert retainer with pressure spring for forward assist into the upper receiver.
7. Hold retainer in place with Ø 2.4 mm pin punch.
8. Drive in clamping sleeve for forward assist (77b-21), at the same time extracting Ø 2.4 mm pin punch.

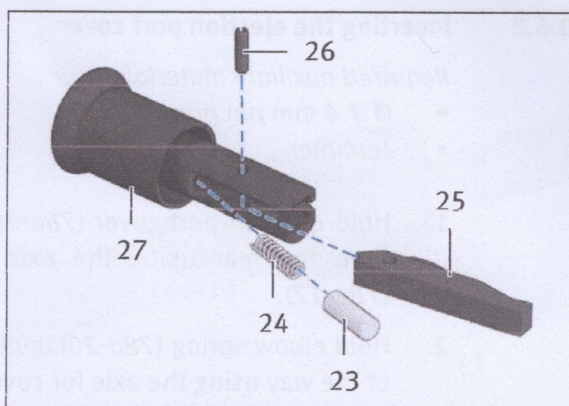


Fig. 77a: Forward assist

- 23 Pressure bolt for forward assist
- 24 Pressure spring for pressure bolt
- 25 Locking piece for forward assist
- 26 Pressure bolt for locking piece
- 27 Retainer

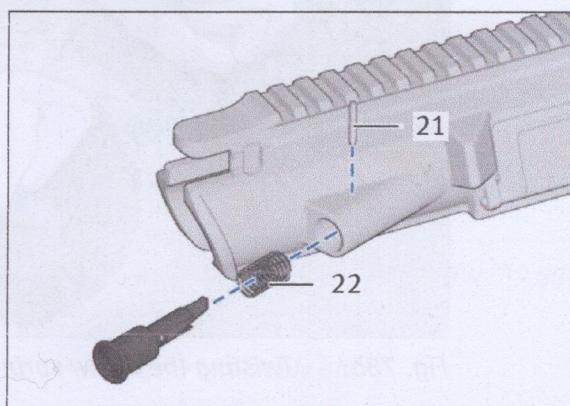


Fig. 77b: Forward assist, pressure spring and clamping sleeve

- 21 Clamping sleeve for forward assist
- 22 Pressure spring for forward assist



### 10.6.2 Inserting the ejection port cover

Required auxiliary materials:

- Ø 1.4 mm pin punch
- Hammer

1. Hold ejection port cover (78a-18) in place from the rear using the axle for cover (78a-17).
2. Hold elbow spring (78a-20) in place a third of the way using the axle for cover.
3. Twist front arm of the elbow spring into the recess in the ejection port cover (78b).
4. Push axle for cover forwards into the assembly position (78c).
5. Drive in clamping sleeve using Ø 1.4 mm pin punch (78d).

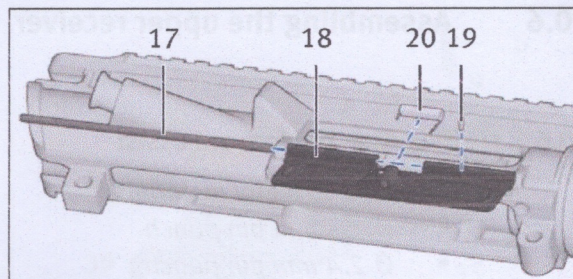


Fig. 78a: Ejection port cover

- 17 Axle for cover
- 18 Ejection port cover
- 19 Clamping sleeve
- 20 Elbow spring

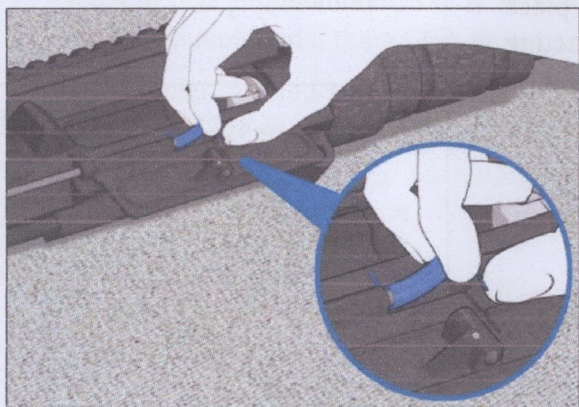


Fig. 78b: Twisting the elbow spring

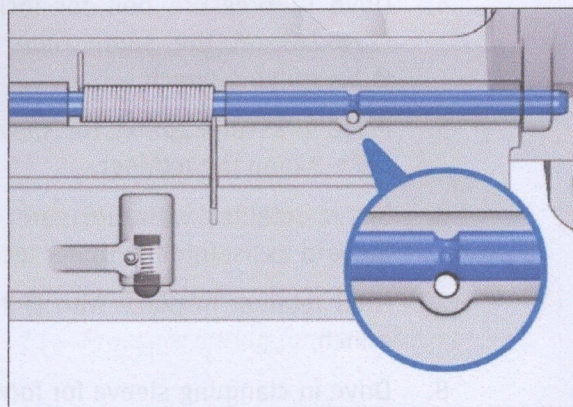


Fig. 78c: Assembly position of the axle for cover

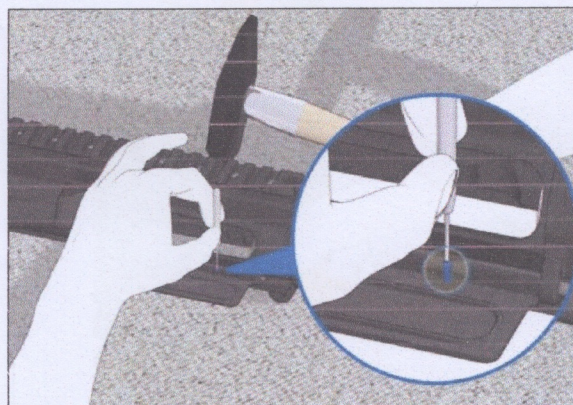


Fig. 78d: Driving in clamping sleeve





## 1 Using this manual

### 1.1 Purpose of this manual

The first part of this manual ("General principles") describes the fundamental principles for using this manual. The second part ("Maintenance and checks") describes maintenance and inspection work on the weapon. The third part ("Disassembly and assembly") describes the complete disassembly and assembly of the weapon.

### 1.2 Target audience for this manual

This manual is intended for trained firearms technicians. This manual assumes good mechanical knowledge and knowledge of firearms.

### 1.3 Requirements for performing the activities in this manual

You may perform the activities described in this manual only if you meet the following requirements:

- you have successfully completed a technician training course for the weapon described here,
- you have read and understood this maintenance manual completely,
- you have mastered the activities described in this maintenance manual,
- you have read and understood the operator's manual for the weapon described here completely,
- and you have mastered the activities described in the operator's manual.



### 6.3 Inserting the gas nozzle

Required auxiliary materials:

- Ø 1.4 mm pin punch
- Hammer
- Assembly tool for gas block

1. Insert pressure bolt for gas nozzle (79a-13) into the gas block.
2. Insert pressure spring for pressure bolt (79a-14) into the gas block.
3. Insert guide for assembly aid into hole for gas piston (79b-A).
4. Push assembly aid through the guide for assembly aid and into the gas block and hold it there (79b-B).
5. Drive in clamping sleeve from the left using Ø 1.4 mm pin punch (79b-C).
6. Assembly gas nozzle (79a-11).

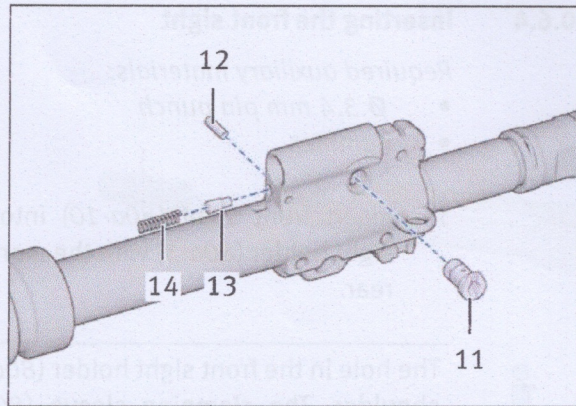


Fig. 79a: Gas nozzle

- 11 Gas nozzle
- 12 Clamping sleeve
- 13 Pressure bolt for gas nozzle
- 14 Pressure spring for pressure bolt

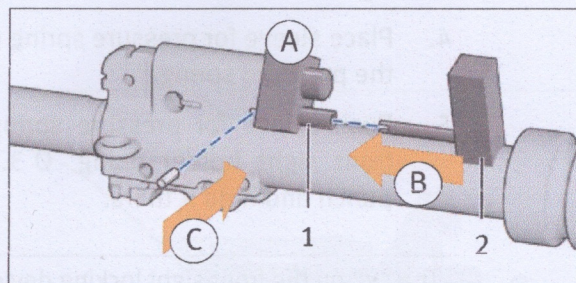


Fig. 79b: Pushing assembly aid into the gas block

- 1 Guide for assembly aid
- 2 Assembly aid



### 10.6.4 Inserting the front sight

*Required auxiliary materials:*

- Ø 3.4 mm pin punch
- Hammer

1. Insert front sight (80a-10) into the front sight holder (80a-3) with the marking to the rear.



The hole in the front sight holder (80a-3) has a shoulder. The clamping sleeve (80a-6) can only be driven in from the rear. The flat side of the front sight holder is to the front.

2. Drive in clamping sleeve (80a-6) using Ø 3.4 mm pin punch.
3. Insert pressure spring (80a-7) into the front sight holder.
4. Place sleeve for pressure spring (80a-8) on the pressure spring.
5. Push sleeve for pressure spring into the front sight holder using Ø 3.4 mm pin punch and hold it there.



The "V" on the front sight locking device (80a-4) must face forwards during assembly. The flat side of the front sight holder is to the front.

6. Insert front sight locking device (80a-4) into the front sight holder.
7. Place front sight holder on the gas port.
8. Insert axle for front sight (80a-5).
9. Push SL retainer (80a-9) onto the axle for front sight.

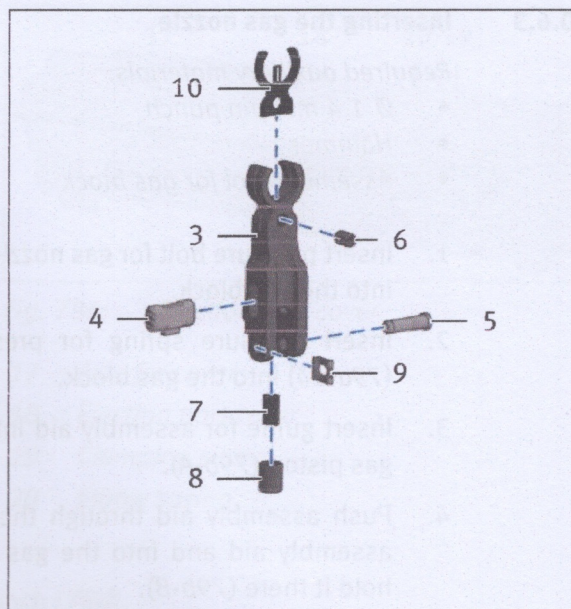


Fig. 80a: Front sight

- |    |                            |
|----|----------------------------|
| 3  | Front sight holder         |
| 4  | Front sight locking device |
| 5  | Axle for front sight       |
| 6  | Clamping sleeve            |
| 7  | Pressure spring            |
| 8  | Sleeve for pressure spring |
| 9  | SL retainer                |
| 10 | Front sight                |



### 10.6.5 Inserting the flash hider

Required auxiliary materials:

- Torque wrench 20 - 200 Nm
- Counter bracket
- Assembly wrench
- Vice

1. Screw flash hider (81a-1) onto the barrel (81a-2) by hand.
2. Clamp counter bracket in vice.
3. Place upper receiver on the counter bracket.
4. Set torque wrench to 45 Nm.
5. Insert torque wrench into assembly wrench (81b).
6. Tighten flash hider using assembly wrench until the torque is reached (81c).

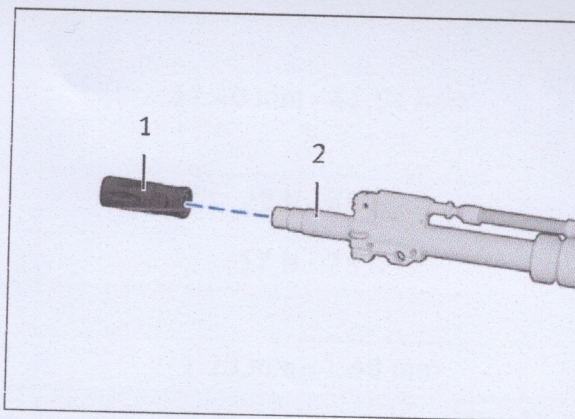


Fig. 81a: Flash hider

- 1 Flash hider
- 2 Barrel

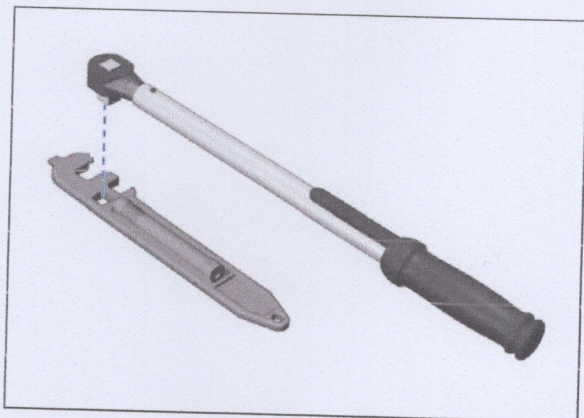


Fig. 81b: Inserting the torque wrench

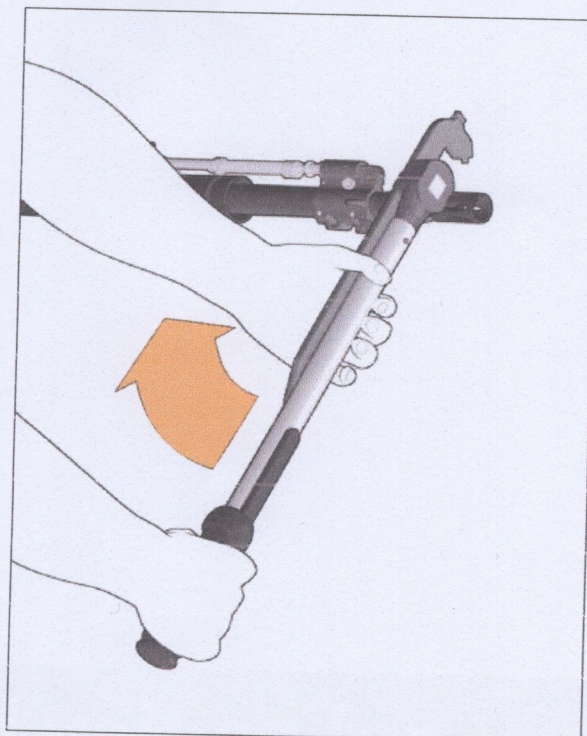


Fig. 81c: Tightening the flash hider



<b>Check headspace</b>	
Headspace	
<b>Check trigger pull</b>	41.40 mm - 41.51 mm
Trigger pull of standard trigger	
Trigger pull of 2-stage trigger	22 N - 46 N
<b>Check firing pin protrusion</b>	17 N - 25 N
Firing pin protrusion	
<b>Check barrel wear</b>	1.23 mm - 1.40 mm
Inner diameter of the barrel, chamber end	
Inner diameter of the barrel, muzzle end	< 7.67 mm
<b>Check point of impact</b>	< 7.65 mm
Point-blank shot at a range of	
	100 m

**Dimensions and values for  
maintenance checks**



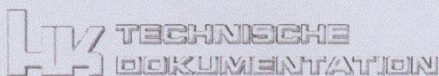


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# No Compromise

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Quality . Innovation . Service . Safety



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## 1.4 Warnings, notes and information

In order to ensure the greatest possible degree of safety during operation, important information and technical notes are specially highlighted.

### 1.4.1 Warnings and warning levels

Warnings are depicted as follows (example):

**⚠ DANGER**

**Risk of death from gunshot wounds!**

**Accidental discharge of weapon may occur when loaded weapon is handled.**





- › Carry out a safety check before working on the weapon.
- › Do not perform maintenance work until you have read and understood this manual and the operator's manual for the weapon described here completely.
- › Follow the safety instructions when handling the weapon.

The following colours and signal words are used in the warnings to indicate various danger levels:

Colour / signal word	Meaning
<b>⚠ DANGER</b>	Direct, imminent danger! Non-compliance will lead to death or extremely serious injury.
<b>⚠ WARNING</b>	Possible imminent danger! Non-compliance could lead to death or serious injury.
<b>⚠ CAUTION</b>	Dangerous situation! Non-compliance could lead to minor injuries.
<b>NOTICE</b>	Non-compliance could lead to material damage.



### 1.4.2 Symbols used

Symbol	Meaning
	Supplementary information on the weapon, on practical handling of the weapon or on using this manual.
1. / 1.	Call to perform an action in a sequence of actions: Here you have to do something!
	Stand-alone call to perform an action or call to perform an action in a warning: Here you have to do something!
»	The sequence of actions is not complete, and is continued on the next page: Please turn the page!
•	Bullet point
	The check was successful.
	The check was not successful: Follow the specified call to perform an action!