

Figure D-1: CMR-30™ General Disassembly (field stripped)



WARNING If the CMR-30™ has been fired, wait a sufficient amount of time for the components to cool before attempting disassembly, failure to do so may result in burns.

Removal of the grip assembly

1. Cycle the action to verify that the chamber is empty, the hammer is cocked, and the bolt is in the forward position.
2. Engage the safety by raising the safety lever and ensuring that no part of the red oval is visible.
3. Fully extend the stock (pull all the way out).
4. Push out and remove the assembly pin (a small pointed object may be necessary to start the pin out).
5. Remove the grip assembly by sliding the grip straight back at least one inch, and then pull it away from the barrel assembly as shown in *Figure D-2*.



Figure D-2: Slide grip straight back, then pull away

Removal of the bolt assembly and stock assembly

1. Position the upper assembly with the muzzle pointing down and pull up slightly on the operating handle to allow for a finger to get in front of the bolt in order to grip it as shown in *Figure D-3*.



Figure D-3: Grip bolt block as shown, after lifting it with the operating handle

2. While holding onto the rear of the upper, as shown in figure D-3, lift the bolt all the way up until the front of the spring tube clears the rear of the upper. The stock will also be lifted, but should still partially be in its track.
3. Rotate the bolt assembly out, and twist it 90 degrees to unhook the tabs from the stock rods and remove the bolt assembly.
4. Pull out the stock assembly.



Figure D-4: Hold stock rods while lifting bolt and rotate to remove bolt



WARNING Further disassembly should only be performed by a certified gunsmith or Kel-Tec CNC Industries Inc. Attempting further disassembly could void your warranty.

E. ASSEMBLY

WARNING Always wear safety glasses when reassembling the CMR-30™ to protect your eyes from springs.

Inserting the stock assembly and bolt assembly

1. Position the barrel assembly with the muzzle pointing down and grab the stock assembly by the end of the stock rods as shown in *Figure E-1*.
2. Align both stock rods with the corresponding channels in the upper assembly and slide the stock on. Be sure to keep your hand close to the end of the stock rods to help with aligning the tracks. Angling the rods and getting both tops in first before straightening the rods is often helpful.

NOTICE Failure to insert **BOTH** stock rods into **BOTH** appropriate channels of the upper assembly can cause damage to your firearm. Be sure both stock rods are properly aligned before proceeding.

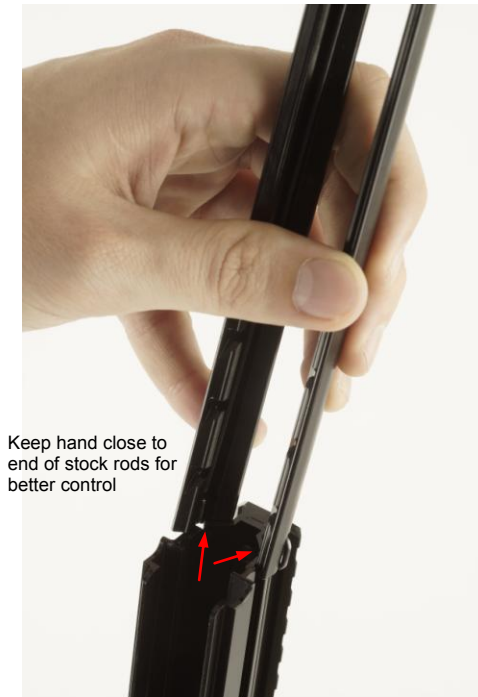


Figure E-1: Align BOTH stock rods onto the upper assembly, and slide them on
Notice the hand placement on the stock rods is close to the ends of the rods

3. Grab the bolt assembly and twist the rear of it 90 degrees after inserting it into the stock rod channels as shown in *Figure E-2*. (The reverse of the disassembly process).



Figure E-2: Insert the rear of the bolt assembly into the stock rod channels

4. Lift the bolt assembly up until the spring tube clears the rear of the upper assembly. The stock will also be lifted, but should still be in its track. Slowly align the bolt assembly with the guide rails in the upper and guide the bolt and the stock assemblies down into the upper assembly together, making sure that the slots in the bolt align with the tabs in the upper assembly.

NOTICE The stock assembly **MUST** move down **WITH** the bolt assembly or it may bind and damage the firearm.

Installing the grip assembly

1. Verify that the hammer is cocked, safety is on SAFE, and that no magazine is present in the grip assembly.
2. Position the grip onto the bottom of the upper assembly, as shown in *Figure E-3*.



Figure E-3: Install grip assembly onto upper assembly

3. Slide the grip forward onto the upper assembly until the assembly pin hole aligns with the hole in the upper assembly.
4. Insert the assembly pin from either side of the grip.

Verifying function

1. Use the operating handle to verify that the bolt cycles smoothly.
2. Pull out the stock and verify that it locks in place and collapses correctly.