

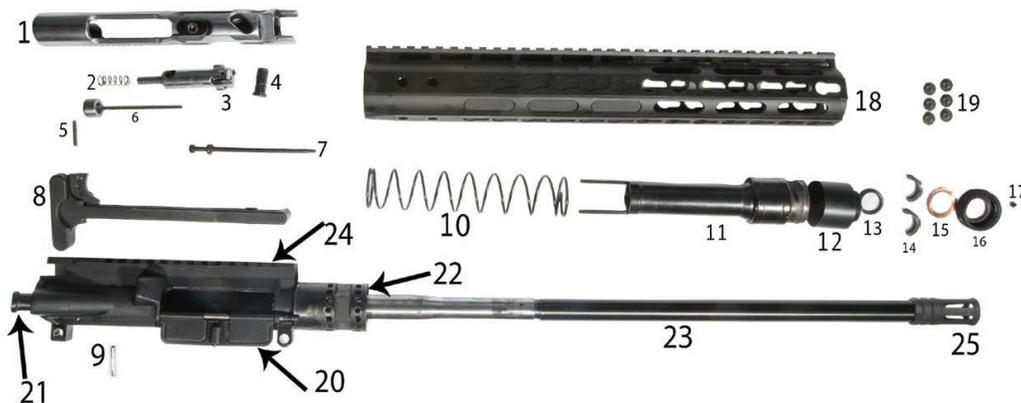
BG.410 Semi-automatic Owner's Manual



**DO NOT ATTEMPT TO FIRE .45 LONG COLT or
45-70 GOVERNMENT OUT OF THIS UPPER!**

Parts Diagram

- 1: Bolt Carrier 2: Ejector Spring 3: Bolt 4: Cam Pin 5: Firing Pin Retainer**
6: Ejector 7: Firing Pin 8: Charging Handle 9: Ejector Arm Retaining Groove Pin
10: Piston Spring 11: Piston 12: Gas Bonnet 13: Gas O-Ring 14: C-Clips
15: Copper Gas Washer 16: Gas Bonnet Cap 17: Gas Bonnet Cap Set Screw
18: Handguard 19: Handguard Screws 20: Dust Cover Kit 21: Forward Assist
22: Barrel Nut 23: Barrel 24: Upper Receiver 25: Flash Hider



Disassembly

-To remove the .410 upper, simply remove the rear and front take down pin on the lower receiver. Pull the upper off the lower receiver.

To remove the bolt carrier group, punch out the ejector arm retaining groove pin from the left (port side), towards the right side (starboard side) (Fig. 1). Lift the ejector arm to allow the bolt carrier group to slide to the rear of the receiver (Fig. 2).



Figure 1



Figure 2

To disassemble the gas piston system, start by removing the flash hider with an AR-15 armorers tool and using a 3mm allen head wrench to remove 6 screws from the hand guard (Fig. 3). Remove the handguard by sliding forward towards the muzzle. Next, use a 1.5mm allen wrench to remove the indexed set screw from the gas bonnet cap (Fig. 4). Take note of the position of the set screw area marked on the gas bonnet. Use locktite #243 while replacing the handguard screws.



Figure 3



Figure 4

Remove the gas bonnet cap and copper gas washer (Fig. 5). Grasp the gas bonnet firmly and apply downward pressure towards the receiver until the C-clips are exposed and can be removed by hand (Fig. 6) and remove the Gas O-ring (Fig. 7)



Figure 5



Figure 6



Figure 7

After removing C-clips and O-ring, slowly release the pressure previously applied to the gas bonnet and slide the gas system and spring forward, removing it from the barrel (Fig. 8). When removing the gas system take note of the position of the piston drive rods underneath the barrel extension. When reassembling, the drive rods must return to this position.



Caution: Spring under pressure!



Figure 8

Bolt Carrier Group Disassembly

Punch out firing pin retaining pin (Fig. 9) and remove the firing pin (Fig. 10). Remove the cam pin (Fig. 11) and the bolt will slide out (Fig. 12). Remove the ejector rod and spring (Fig. 13).



Figure 9



Figure 10



Figure 11



Figure 12



Figure 13



Figure 14

Reassembly

Follow all steps in reverse taking into account the noted positions of the guides for the piston system and the set screw for the piston end cap. When placing the bolt carrier group (BCG) back into the upper receiver, you must lift the ejector arm so it does not catch on the BCG. See Figure 14 on previous page. Replace the ejector arm retaining grooved pin back through the right side of the receiver so the smooth end of the pin can be seen on the left side of the receiver.

Cleaning

-American Tactical recommends a minimum of 1000 rounds shot before a thorough cleaning of the gas system, chamber, and bolt assembly.
-American Tactical also recommends the use of all Lucas Oil Outdoor Line of products in cleaning and lubricating your .410 upper and all its parts.

Part Number	Part Name Diagram (#)
SPAR41BC	Bolt Carrier (1)
SPAR41EJSPRING	Ejector Spring (2)
SPAR41BOLT	Bolt (3)
SPAR41CAMPIN	Cam Pin (4)
SPAR41FPR	Firing Pin Retainer (5)
SPAR41EJROD	Ejector (6)
SPAR41FP	Firing Pin (7)
SPAR41CH	Charging Handle (8)
SPAR41EJARG-PIN	Ejector Arm Retaining Groove Pin (9)

Part Number	Part Name Diagram (#)
SPAR41PSPRNG	Piston Spring (10)
SPAR41PISTON	Piston (11)
SPAR41GB	Gas Bonnet (12)
SPAR41GSORNG	Gas O-Ring (13)
SPAR41CCLIP	C-Clips (14)
SPAR41CGW	Copper Gas Washer (15)
SPAR41GBC	Gas Bonnet Cap (16)
SPAR41GBCSS	Gas Bonnet Cap Set Screw (17)
SPAR41-UPK-RAIL13KM41	Handguard (18)

Part Number	Part Name Diagram (#)
SPAR-41SCREWKM	Handguard Screws (19)
J&TDUSTKIT	Dust Cover Kit (20)
J&TFWDASSIST	Forward Assist (21)
SPAR41BBLNUT	Barrel Nut (22)
ATTIBAR410	Barrel (23)
SPAR41UPPER	Upper Receiver (24)
SPAR41FH	Flash Hider (25)
SPAR41RBUFKIT	Rifle Buffer Kit
SPAR41BUFKIT	Carbine Buffer Kit

TROUBLESHOOTING TIPS

PROBLEM	CAUSE	SOLUTION
Last Round Bolt Stop Failure	<p>Bolt travel not sufficient</p> <p>Too high velocity in recoil</p> <p>Dirt / Debris in Action</p>	<p>Use ammunition slightly faster, remember the gun is tuned to shoot ammo 325 m/sec</p> <p>Use ammunition slightly less powerful, too much velocity may compromise the correct functioning of the bolt stop</p> <p>If you have been shooting for a while or using ammunition with excessive fouling, it may be necessary to clean the firearm.</p>
The bolt doesn't cycle correctly or is stuck	<p>Not enough pressure to cycle</p> <p>Dirt / Debris in Action – in breech cycle</p> <p>Ammunition too short or too long for chamber.</p>	<p>Use Higher Velocity Ammo, remember the gun is tuned to shoot ammo 1050 fps (325 m/sec) or greater.</p> <p>Disassemble, clean carefully and oil the upper</p> <p>Check the ammunition / Consider different types of ammunition</p>
Fail to Fire (DNF)	<p>Bolt not completely closed</p> <p>Ammunition with rim out of tolerance</p> <p>Weak hammer spring</p> <p>Firing pin damaged or broken</p>	<p>Carefully clean the breech bolt and barrel & chamber area</p> <p>Change type or brand of ammunition</p> <p>Contact our service center</p> <p>Contact our service center to obtain a new firing pin</p>
Failure to Extract Empty Shell	<p>Dirty chamber</p> <p>Damaged Chamber</p> <p>Damaged Extractor</p> <p>Weak Extractor Spring</p>	<p>Clean cartridge chamber with cleaning brush</p> <p>Contact a professional gunsmith to polish the chamber</p> <p>Contact our service center to obtain a new extractor</p> <p>Contact our service center to obtain a new extractor spring</p>
The empty shell does not eject (stove pipe)	<p>Ammunition with rim out of tolerance</p> <p>Not enough pressure to cycle</p>	<p>Change type or brand of ammunition</p> <p>Use Higher Velocity Ammo, remember the gun is tuned to shoot ammo 1050 fps (325 m/sec) or greater.</p>

<p>The bolt stays completely open</p>	<p>Damaged ejector Dirty chamber Damaged chamber Damaged extractor Weak extractor spring Dirt / Debris in Action Weak recoil spring</p>	<p>Replace magazine Clean cartridge chamber with cleaning brush Contact a professional gunsmith to polish the chamber Contact our service center to obtain a new extractor Contact our service center to obtain a new extractor spring Disassemble and carefully clean the gun Contact our service center to obtain a new spring.</p>
<p>Ammunition does not chamber</p>	<p>Incorrect Ammunition</p>	<p>Check the ammunition and change type if necessary</p>
<p>Magazine is stuck</p>	<p>Dirt / Debris in action or chamber Magazine not properly seated Bullet crimp / design Dirt / Debris buildup Ammunition is too long</p>	<p>Disassemble and carefully clean the gun Check the magazine for correct fit and operation. Check the ammunition and change type if necessary Clean the magazine thoroughly Change type of ammunition</p>
<p>The gun fires with safety "On"</p>	<p>Mechanical Issue</p>	<p>Do not attempt to use the gun, contact our service center immediately to arrange shipment of the gun</p>
<p>The gun shoots low</p>	<p>Rear sight needs adjustment</p>	<p>Lift the rear sight to raise the point of impact or vice versa to lower it.</p>
<p>Shooting left or right (Windage)</p>	<p>Rear sight needs adjustment</p>	<p>Move the rear sight the opposite direction of error (If POI "Point of Impact" is left of center, move the rear sight to the right)</p>