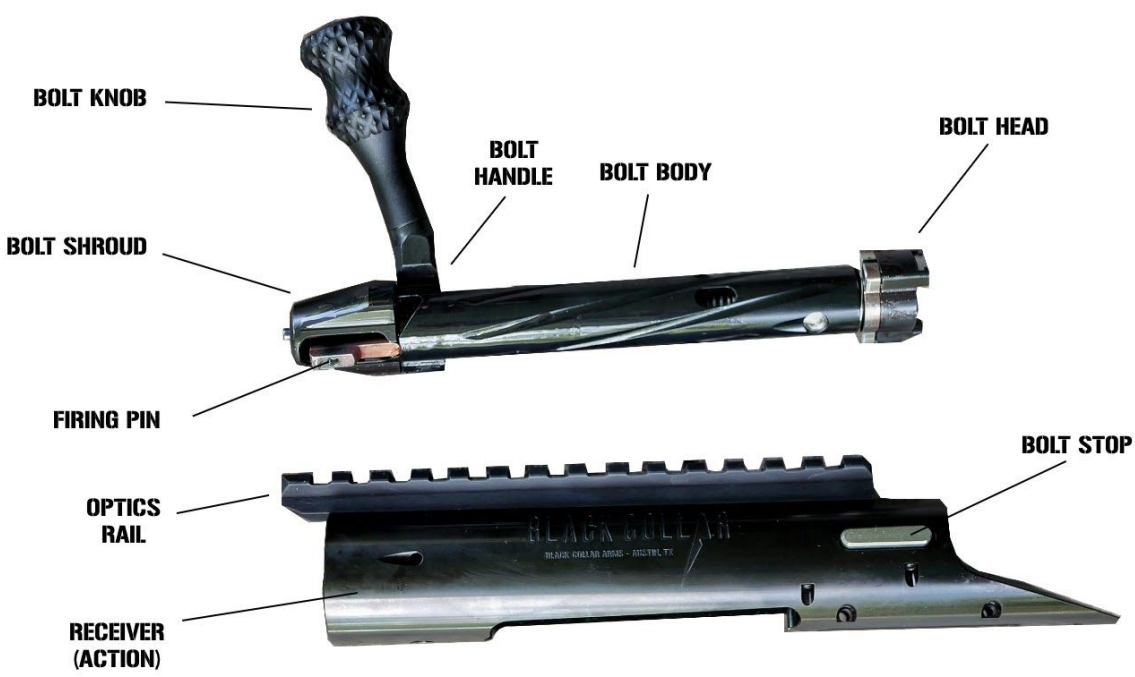


Black Collar Arms Pork Sword Pistol Owner's Manual

WARNINGS:	•	Before using this firearm, ensure you have read and understood the owner's manual. Failure to do so may result in serious injury, property damage, and/or death. Use extreme care when handling, using, and/or storing any firearm and/or ammunition.
	•	Do not place any portion of your body beyond the muzzle of the barrel, regardless of what type and length of handguard accessory you have.
	•	Your Pork Sword barrel is screwed into the action until correct headspace is achieved, then locked in place with a barrel nut torqued to 70 ft-lbs. It is possible to inadvertently unscrew the barrel if a muzzle device is installed with excessive thread locking compound or torqued too tightly and then removal is attempted.
	•	Do not fire any cartridge other than the one marked on the barrel of this firearm.
	•	Only use SAAMI / CIP approved ammunition that matches the chamber of this firearm.

FIREARM SAFETY:	•	Treat every firearm as if it is loaded
	•	Always keep your firearm pointed in a safe direction (zero injury to yourself and others and least amount of property damage possible should the firearm be discharged)
	•	Keep your trigger finger outside of the trigger guard and off the trigger until you are ready to fire
	•	Be certain of your target, what is between you and your target, and what is beyond your target.
	•	Always wear appropriate eye and ear protection
	•	If you are unsure of firearm safety best practices, seek training from a qualified firearms instructor

DIAGRAMS



SAFETY MECHANISM

The safety mechanism provides protection against accidental or unintentional discharge under normal usage when properly engaged and in good working order. The safety mechanism is not a substitute for following the rules of safe gun handling (see "Firearm Safety" on Page 1).



To engage the safety mechanism, put the safety selector into “safe” position by pulling it all the way to the rear. Safety selector should be in the “safe” position except when you are ready to fire. Never pull the trigger when the selector is on “safe.”

To disengage the safety mechanism when ready to fire, put the safety selector into “fire” position by pushing the safety selector all the way forward.

LOCKING DEVICE

A cable lock was included with your Pork Sword Pistol. This does not eliminate the need for safe gun handling and storage.

To use the cable lock:

- Put safety selector in “safe” position (see “Safety Mechanism” Page 2-3)
- Remove magazine (see “Unloading” Page 5)
- Lift bolt handle and pull bolt rearward (see “Unloading” Page 5)
- Ensure firearm is unloaded via visual and physical inspection of chamber, ejection port area, bolt face, and magazine well
- Unlock and open cable lock
- Feed small end through ejection port and down through magazine well
- Insert small end into lock, remove key, and verify that cable is secure in lock

BOLT ASSEMBLY: INSTALLATION AND REMOVAL

Installation:

- With the bolt knob oriented on the correct side for your action, align bolt lugs with slots in action
- Slide bolt assembly into the action

Removal:

- Lift bolt handle
- Depress rear of bolt stop so front of bolt stop lifts out and away from action
- With rear of bolt stop still depressed, slide bolt assembly rearward and out of the action

LOADING AND FIRING

READ AND UNDERSTAND ALL WARNINGS AND SAFETY INSTRUCTIONS ON PAGE 1. SEEK PROFESSIONAL TRAINING OR CONSULTATION IF YOU ARE AT ALL UNSURE ABOUT SAFE USE OF A BOLT-ACTION FIREARM.

Loading:

- Place safety selector in “safe” position and follow all Firearm Safety instructions on Page 1.
- Lift bolt handle upward until it stops, then slide bolt fully rearward until it stops.
- Inspect chamber, magazine well, bolt face, and barrel for any potential obstructions or foreign matter.
- Load a magazine by inserting cartridges of the correct caliber and type until desired capacity or full magazine is achieved.
 - With the rear of the cartridge just in front of the magazine feed lips, press downward on the cartridge with your thumb, then slide the cartridge rearward under the magazine feed lips until the cartridge is fully to the rear. Repeat procedure to load subsequent rounds.
- Insert loaded magazine into magazine well until fully seated. It should “click” past the magazine release. A downward pull on the magazine can be used to ensure it has locked in place.
- Grab bolt knob and push bolt handle forward to strip top cartridge from magazine and into chamber.
 - With some cartridge and magazine combinations, doing this too slowly and gently may not provide full feeding reliability. Do not hesitate to run the bolt firmly and confidently.
- When bolt is all the way forward, rotate bolt knob all the way down until it stops. There is approximately 90 degrees of bolt handle rotation between unlocked and locked.
- **WARNING: FIREARM IS NOW LOADED!**

Firing:

- Identify appropriate target, taking careful note of what lies in front of and behind target.
- Use firing hand thumb to push safety selector to “fire” position.
- Smoothly and slowly apply pressure to trigger while keeping sights/optic on target until cartridge is fired.
- To cycle the action and continue firing, lift bolt knob until it stops, pull bolt rearward until it stops and ejects empty case, push bolt forward (to strip and chamber next cartridge) until it stops, lower bolt knob until it stops.
 - For best function, do these steps firmly and confidently.
 - Control empty case ejection distance by moderating rearward bolt speed.
- If pausing between shots, put safety selector back on “safe” or fully unload firearm.

Unloading:

- Move safety selector to “safe” position
- Press forward on magazine release and remove magazine (WARNING: GUN WILL FIRE WITHOUT A MAGAZINE INSERTED)
- Rotate bolt knob up until it stops.
- Pull bolt rearward until it stops, ejecting spent case or unfired, live round.
- Ensure firearm is unloaded by visually and physically inspecting chamber, bolt face, ejection port, and magazine well.

Pro Tips:

- The firing pin can be cocked without cycling the action by simply lifting the bolt knob all the way up and then lowering it all the way back down. This is handy for dry fire (BE SAFE) or for re-cocking the firing pin should a primer fail to fire (WAIT 30 SECONDS after any failures to fire before unlocking the bolt handle).
- The firing pin can be de-cocked without dry firing. With the bolt knob all the way up, depress the trigger and keep it depressed while lowering the bolt knob all the way down. DO NOT DO THIS WITH A ROUND IN THE CHAMBER unless you are sighted in on target and safe to fire.
- Firearm can be single-round fed, with the bolt fully to the rear, either by placing a cartridge in through the ejection port and on top of an empty, inserted magazine or by hand feeding the cartridge through the ejection port and into the chamber (with or without a magazine installed).

Folding The Pistol Brace

Your Pork Sword Pistol is likely (but not necessarily) equipped with an SB Tactical FS1913 pistol stabilizing brace. To fold and unfold the brace:

- Place your strong hand thumb on top of the rearmost part of the Pork Sword Chassis, just in front of the rear picatinny rail (see Page 2 diagram).
- Grip the pistol brace strut by wrapping your other fingers around and under it.
- Push down with your thumb while pulling up with your fingers. Chassis down, strut up.
- When the hinge unlocks, the pistol brace will fold to the left side of the gun and will snap into the fully folded position.
- Simply pull the brace rearward to deploy it. Pulling slightly upward at the same time may help.

Maintenance and Cleaning

Standard firearm cleaning and maintenance procedures and supplies (solvents, lubes, bore brushes, etc.) apply to the Pork Sword Pistol. No special caveats or unique requirements exist.

Keep your Pork Sword Pistol clean and dry other than your lube/protectant/CLP of choice. Clean and protect the chamber and bore with your swap/patch/nylon brush and solvent/lube/CLP/etc of choice. Lubricate the bolt body and bolt head with your lube/CLP/grease of choice.

General maintenance does not involve disassembly beyond removing the bolt from the action.

For instructional videos and documents on detail stripping the bolt, swapping bolt heads, or performing other procedures more in-depth than the scope of this owner's manual, visit <https://blackcollararms.com/Pork-Sword-Manual/>

Disassembly / Assembly

Disassembly:

- ENSURE FIREARM IS UNLOADED
- Remove bolt (see "Removal" Page 4). At this point the gun is "field stripped."
- For instructional videos and documents covering more in-depth disassembly, visit <https://blackcollararms.com/Pork-Sword-Manual/>

Assembly:

- Insert bolt (see "Installation" Page 3)

Tools and torque specifications list:

- Action screws: 3/16" hex: 55-65 in-lbs
- Grip screw: 3/16" hex: 25-35 in-lbs
- Forward Accessory screw: 5/32" hex: 30 in-lbs (do not exceed 60 in-lbs).
- Pistol brace screw: 1/8" hex (no torque spec provided)
- Magazine release screw: 5/64" hex: only gently finger tight
- Optics rail screws: T-15 Torx: 25-30 in-lbs
- Barrel nut: 1.25" wrench flats: 70 ft-lbs

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