

# M1600 SEMI-AUTOMATIC RIFLE

## USER'S MANUAL



WARNING: READ THE INSTRUCTIONS AND SAFETY PRECAUTIONS IN THIS MANUAL CAREFULLY BEFORE USING THE FIREARM.



# ROCK ISLAND ARMORY

## USER'S MANUAL M1600 SEMI-AUTOMATIC RIFLE

### SAFETY, INSTRUCTION AND PARTS MANUAL



As a responsible owner of this firearm, you must read the instructions and warnings in this manual carefully. Before using this firearm, make sure you understand thoroughly the contents of this manual.

This manual must always be in the firearm's carrying case whenever the owner/user brings it or when it transfers ownership. A copy of this manual is available upon request from:

*ARMSCOR PRECISION INTERNATIONAL  
150 N Smart Way, Pahrump NV 89060  
E-mail: [support@armscor.com](mailto:support@armscor.com)*

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## MAINTENANCE



## STATEMENT OF LIABILITY

This rifle is classified as a firearm or dangerous weapon. It is expressly understood that we assume no liability for its resale or unsafe handling under local laws and regulations. Armscor assumes no responsibility for physical injury or property damage resulting from either intentional or accidental discharge, or for the function of the firearm subjected to influence beyond their control. Armscor will honor no claims which may result from careless handling, unauthorized adjustments, defective or improper ammunition, corrosion or neglect. Examine your firearm carefully at the time of purchase. It should be forwarded immediately to the factory or its sales agent if any adjustment of any kind of required.

### State-By-State Warnings



#### CALIFORNIA STATE WARNING

*CHILDREN ARE ATTRACTED TO AND CAN OPERATE FIREARMS THAT CAN CAUSE SEVERE INJURIES OR DEATH. PREVENT CHILD ACCESS BY ALWAYS KEEPING FIREARMS LOCKED AWAY AND UNLOADED WHEN NOT IN USE. IF YOU KEEP A LOADED FIREARM WHERE A CHILD OBTAINS AND IMPROPERLY USES IT, YOU MAY BE FINED OR SENT TO PRISON. IT IS UNLAWFUL TO USE A MAGAZINE WITH A CAPACITY OVER 10 ROUNDS.*



#### MASSACHUSETTS STATE WARNING

*IT IS UNLAWFUL TO CARRY ANY MAGAZINE OR BELT WHICH HOLDS MORE THAN TEN ROUNDS, UNLESS AUTHORITY IS GRANTED BY THE BOSTON POLICE COMMISSIONER. IT IS UNLAWFUL TO STORE OR KEEP A FIREARM, RIFLE, SHOTGUN OR MACHINE GUN IN ANY PLACE UNLESS THAT WEAPON IS EQUIPPED WITH A TAMPER RESISTANT SAFETY DEVICE OR IS STORED OR KEPT IN A SECURELY LOCKED CONTAINER.*



#### NEW YORK STATE WARNING

*IT IS UNLAWFUL TO CARRY ANY MAGAZINE OR BELT WHICH HOLDS MORE THAN SEVEN ROUNDS, UNLESS AUTHORITY IS GRANTED BY THE STATE OF NEW YORK. THE USE OF A LOCKING DEVICE OR SAFETY LOCK IS ONLY ONE ASPECT OF RESPONSIBLE FIREARMS STORAGE FOR INCREASED SAFETY, FIREARMS SHOULD BE STORED UNLOADED AND LOCKED IN A LOCATION THAT IS BOTH SEPARATED FROM THEIR AMMUNITION AND INACCESSIBLE TO CHILDREN AND OTHER UNAUTHORIZED PERSONS.*

## 02 | SAFETY PRECAUTIONS

Safety must be the first and constant consideration of every person who handles firearms and ammunition. The person with a firearm in his possession has an important responsibility. He/she must know how to use his/her firearm safely:

1. Always keep the firearm holstered except when drawn for a definite purpose.
2. Always check the firearm for live ammunition when picked up, drawn from the holster, handed to, or received from another person.
3. Never point the firearm at anything you do not intend to shoot.
4. Never cock the hammer of the firearm unless you are ready to immediately shoot it. Do not even insert your finger in the trigger guard until you are ready to shoot.
5. Avoid dry firing even with dummy cartridges, unless the same is performed on a regular target range or at a known inanimate target.
6. When holding the firearm that is ready to fire, be absolutely certain that it is not pointed at any part of your body or at any person within your immediate vicinity.
7. Beware of obstructions in barrel. If, when firing, a weak or peculiar report is heard, cease firing and inspect the barrel for an obstruction. Remove magazine then check to insure there is no obstruction in barrel or chamber.
8. When a misfire or a "dud" is experienced keep the rifle pointed at the target for at least ten seconds before inspecting the firearm. A delayed firing may occur.
9. Remove magazine and ensure chamber and barrel are free of foreign objects.
10. When possible, wear shooting glasses and hearing protectors when firing.
11. Do not shoot at a hard surface, or water for the bullet can glance off and travel in unpredictable directions with considerable velocity.
12. Avoid drinking alcoholic beverages when handling the firearm.

### **WARNING:**

*DO NOT ATTEMPT TO USE ANY FIREARM WITHOUT HAVING A COMPLETE UNDERSTANDING OF ITS PARTICULAR CHARACTERISTICS AND SAFE USE.*

### **WARNING:**

*YOU SHOULD NEVER DEPEND ON A SAFETY MECHANISM OR ANY OTHER MECHANICAL DEVICE TO JUSTIFY CARELESS AND IMPROPER HANDLING.*

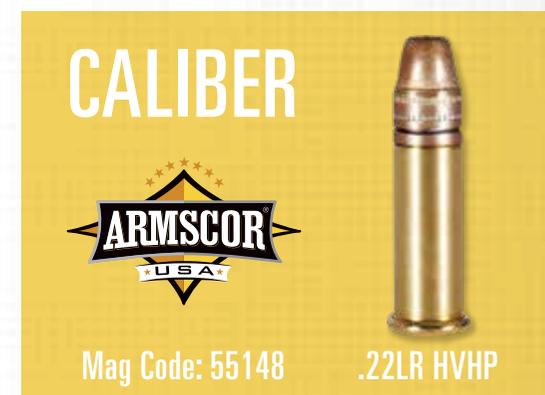
### **WARNING:**

*THIS FIREARM WAS MANUFACTURED TO PERFORM PROPERLY WITH THE ORIGINAL PARTS AS DESIGNED. PLEASE MAKE SURE ANY PARTS YOU BUY ARE INSTALLED CORRECTLY AND THAT NEITHER REPLACEMENTS NOR ORIGINALS ARE ALTERED OR CHANGED. PUTTING A FIREARM TOGETHER INCORRECTLY OR WITH MODIFIED PARTS CAN RESULT IN DAMAGED FIREARM, DANGER, AND INJURY OR DEATH. ANY MODIFICATIONS TO FIREARM WILL VOID FACTORY WARRANTY.*

# 03 | TECH SPECS

The M1600 Semi-Automatic rifle is an AR15 style 22LR tactical rifle. Built suppressor-ready including rear peep sight, A2 style front sight and pistol grip. Comes with a 10-round capacity magazine with optional factory 15-round magazine.

Model	M1600
Caliber	.22 LR
Action	Semi-Auto, Recoil Operated
Magazine Capacity	10 / 15 Rounds
Overall Width	57mm / 2.24in
Overall Length	991mm / 39in
Overall Height	197mm / 2.25in
Weight Empty	2.95kgs / 6.5lbs
Trigger Pull	1.81kgs - 2.72kgs ( 4.0lbs - 6.0lbs)
Barrel	Straight Tapered
Barrel Length	464mm / 18.25in
Front Sight	Post
Rear Sight	Peep
Rifling Twist	Right hand, 1 turn in 400mm
No. Of Grooves	6
Finish	Parkerized
Stock	Black finish Philippine wood M16 style stock with plastic buttpad and plastic pistol grip
Safety	Positive Thumb Operated



.22LR HVHP BALLISTICS				
CALIBER	BULLET		VELOCITY, fps	ENERGY, ft-lbs
	Weight, grains	Style	Muzzle	Muzzle
.22LR HVHP	36	HOLLOW	1,247	130

# 04 | BASIC PARTS

## M1600 SEMI-AUTOMATIC RIFLE BASIC PARTS

A. BARREL-RECEIVER ASSEMBLY	
PART NAME	PART NUMBER
Barrel Reciever Cross Pin	1601
Barrel	1602
Ejector	1603
Front Sight	1606
Front Sight Stud	1607
Front Sight Stud Lock Screw	1608
Front Sight Set Screw	1609
Rear Sight Carrying Handle	1610
Rear Sight Carrying Handle Screw	1611
Rear Sight Carrying Handle Lock Screw	1612
Rear Sight Leaf	1613
Rear Sight Leaf Screw(2pcs)	1614
Flash Deflector	1615
Receiver	1616
Receiver Cap	1617
Receiver Cap Lock Screw	1618

B. BOLT ASSEMBLY	
PART NAME	PART NUMBER
Bolt	1619
Bolt Operating Handle	1620
Bolt Operating Stud	1621
Bolt Handle Locating Bearing	1622
Bolt Handle Locating Spring	1623
Extractor	1624
Extractor Plunger	1625
Extractor Spring	1626
Firing Pin	1627
Firing Pin Spring	1628
Firing Pin Spring Guide Head & Stem	1629
Firing Pin Spring Guide Head Insert	1629A
Recoil Spring	1630
Recoil Spring Guide Sleeve	1631
Recoil Spring Retainer Sleeve	1632

C. TRIGGER HOUSING ASSEMBLY	
PART NAME	PART NUMBER
Magazine Catch	1633
Magazine Catch Button	1634
Magazine Catch Pivot Pin	1635
Magazine Catch Stop Pin	1635A
Magazine Catch Spring	1635B
Safety Latch	1636
Safety Latch Button	1637
Safety Latch Bearing	1638
Safety Latch Spring	1639
Safety Latch Screw	1640
Sear	1641
Sear Pivot Pin	1642
Sear Stop Pin	1643
Sear Spring	1644
Sear Spring Pin	1645
Trigger	1646
Trigger Pivot Pin	1647
Trigger Stop Pin	1648
Trigger Spring	1649
Trigger Spring Follower	1650
Rebound Lever	1651
Rebound Lever Pivot Pin	1652
Rebound Lever Safety Pin	1653
Rebound Lever Spring	1654
Rebound Lever Spring Bearing	1655
Trigger Housing	1656
T. H. Hold Down Screw (Front)	1657
T. H. Hold Down Screw (Front)	1657A
T. H. Hold Down Screw (Rear)	1658
T. H. Hold Down Screw Washer (Rear)	1658A

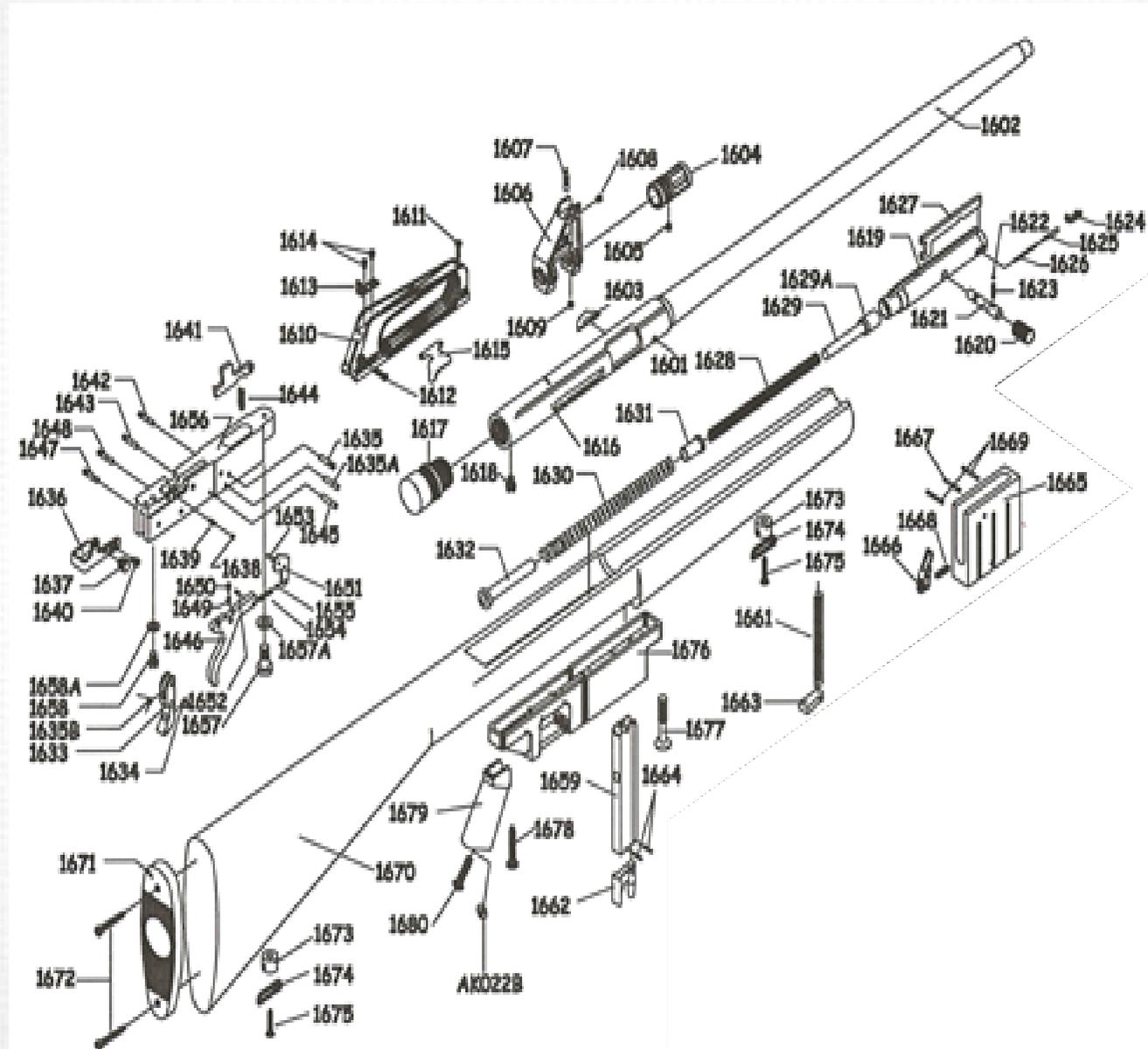
# 05 | BASIC PARTS

D. MAGAZINE BOX ASSEMBLY	
PART NAME	PART NUMBER
Magazine Box	(15/10 Rounds) 1659/1659A
Magazine Box Inner Strip (not shown)	(15/10 Rounds) 1660/1660A
Magazine Spring	(15/10 Rounds) 1661/1661A
Magazine Spring Follower	1662
Magazine Spring Retainer	1663
Magazine Spring Retainer Pin	1664
Magazine Cover	1665
Magazine Cover Plug (not shown)	1665A
Magazine Release	1666
Magazine Release Pivot Pin	1667
Magazine Release Spring	1668
Magazine Box Retainer Pin (2pcs)	1669

E. GUNSTOCK ASSEMBLY	
PART NAME	PART NUMBER
Gunstock	1670
Butt Pad (Plastic)	1671
Butt Pad Retainer Screw (2pcs)	1672
Swivel Head (2pcs)	1673
Swivel Ring (2pcs)	1674
Swivel Screw (2pcs)	1675
Gunslings (not shown)	1675A
Trigger Guard Housing	1676
Trigger Guard Screw (Front)	1677
Trigger Guard Screw (Rear)	1678
Grip (Plastic)	1678
Grip Screw	1680
Grip Screw Washer	AK022B

# 06 | EXPLODED VIEWS

## M1600 SEMI-AUTOMATIC RIFLE



# 07 | OPERATING INSTRUCTIONS

## OPERATING INSTRUCTIONS

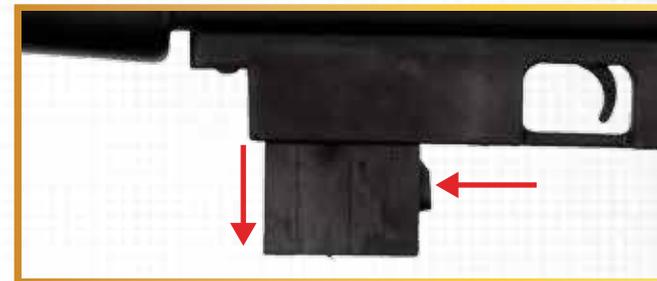
This rifle is packed and shipped from the factory fully assembled, with detached magazine assembly.

### TO LOAD MAGAZINE BOX



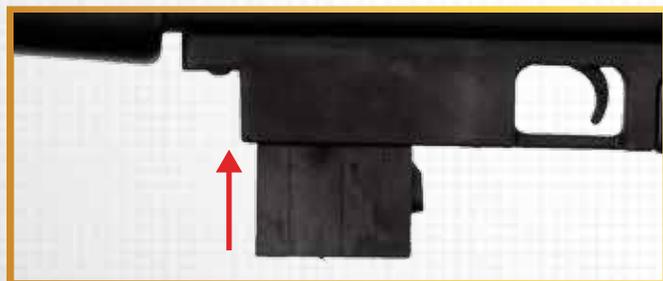
Hold the magazine box firmly with in one hand. With the other hand, position cartridge over magazine lip just forward of notch. Insert cartridge head under ears at rear of magazine. Repeat this procedure as derived or until the magazine is fully loaded to its capacity.

### TO REMOVE MAGAZINE BOX



To disengage magazine, press magazine catch rearward, hold on lock and pull box downward and out.

### TO ATTACH MAGAZINE BOX



Position magazine open end up and ears rearward. Insert magazine into the opening of the trigger guard housing. Push magazine inward until it engages with the magazine catch.

### TO MAKE GUN SAFE



Safely lever is at right side of the receiver and rearward of the bolt operating handle. Pull safety latch towards the "S" mark engraved on the receiver. Trigger is locked up in the process and gun can no longer be fired.

# 08 | OPERATING INSTRUCTIONS

## TO LOAD CHAMBER



Draw safety on and insert a loaded magazine into the rifle. Retract bolt handle fully to the rear of the receiver slot and release. Allow the bolt to be snapped back under the full force of the operating springs. Bolt automatically picks up a cartridge from the magazine and feeds it into the chamber. Do not ease bolt forward.

## TO FIRE



**BE SURE THAT RIFLE IS POINTED AT TARGET!** With action closed, move safety to "F" position. Pull trigger. To repeat, open and close action. The discharged shell will be ejected and a new cartridge will be fed into the chamber. Pull trigger. Repeat process as desired until magazine is empty.

## TO UNLOAD WITHOUT FIRING



Draw safety on and release the magazine from guard. Work action several times to remove any cartridge left inside the chamber. Slide bolt handle rearward and lock piece. Inspect the chamber to make sure no cartridge is left. Empty magazine can be placed back if desired.

## FOR SHORT STORAGE



After firing, swab bore with clean cloth patch wet with approved cleaning solvent. Wipe dry. Apply light coat of oil on barrel bore, bolt and other metal surfaces to keep free of rust.

## FOR LONG STORAGE



After firing, swab bore with clean cloth patch wet with approved cleaning solvent. Wipe dry. Apply a good grade of gun grease or gun oil on the bore and other outside metal surfaces.

Before firing after storage, remove all traces of gun grease or gun oil from barrel bore. Check that bore is free of any obstruction. Obstruction will block passage of bullet & may cause injury to barrel or person.

# 09 | MAINTENANCE

## DISASSEMBLY

### STOCK TRIGGER GUARD HOUSING

1. Remove the magazine by depressing the magazine catch.
2. Remove front screw of trigger guard housing and detach the barrel-receiver assembly from the stock.

### TRIGGER GROUP

1. Remove the trigger by punching out trigger stop pin and pivot pin.
2. Remove the trigger springs and spring follower at the rear end of the housing.
3. Loosen the rear and front trigger housing hold down screws to disengage the housing from the receiver.



#### CAUTION

*STEP NO. #3 IS NOT RECOMMENDED UNLESS NECESSARY. IF IT COULD NOT BE AVOIDED, MAKE SURE TO APPLY LOCTITE OR EPOXY GLUE ON REAR SCREW THREADS WHEN REATTACHING THE HOUSING TO THE RECEIVER.*

### BOLT DISASSEMBLY

1. Loosen the receiver cap lock screw and unscrew the receiver cap. Be careful as spring inside are under compression.
2. Pull out the unit assembly (recoil spring, recoil spring retainer and guide sleeve, firing pin spring & firing pin spring guide head and stem). Keep all of this in order together with the receiver cap to avoid confusion in reassembly.
3. With muzzle pointing in an upward direction retract bolt handle fully to the rear end of the receiver slot.
4. Push firing pin forward so as to align its tail end approximately even with the receiver cap lock screw. (Firing pin is visible and is even with the rear of the bolt).
5. Pull out bolt handle and operating stud and remove bolt from the receiver.

### BOLT ASSEMBLY

1. Place firing pin at the rear end of firing pin slot of the bolt.
2. Push bolt and firing pin into the receiver and align them with respect to the receiver slot so that the bolt handle can be inserted through it past the bolt and firing pin stud clearance. Slide bolt forward with bolt handle and stud already inserted into it until it stops against the rebound lever.
3. While holding the trigger back with one hand, use a nail or any pointed object to trip the rebound lever by moving it to the rear away from the sear in the direction indicated by an arrow on the rebound lever. (See small sketch engraved on the trigger housing).
4. Push bolt handle forward sliding the bolt over the rebound lever. Release the trigger.
5. Insert recoil spring guide sleeve and retainer sleeve in opposite ends of the recoil spring.  
NOTE: Step nos. 5, 6, & 7 can be by passed as long as you followed the instruction in step C-2 for bolt disassembly keeping the components together and in order.
6. Insert firing pin spring guide into the firing pin spring.
7. Insert assembly no. 6, spring end first, into the recoil spring through the guide sleeve (shorter sleeve).
8. Insert the entire unit inside the receiver, shorter sleeve resting against the bolt. Place the receiver cap at the rear end of the unit assembly and compress the springs carefully to return receiver cap into its original position. Tighten the receiver cap lock screw.  
Pull bolt handle back and forth several times to check the action of bolt and trigger assembly.

### TRIGGER ASSEMBLY

1. With gun in an upside down position, insert trigger spring follower into the trigger spring and mount it into the spring hole.
2. Insert the trigger, locating the catch of the rebound lever with the rear catch.
3. Insert the trigger stop pin and pivot pin into their respective holes.
4. Squeeze trigger several times to check the action of the trigger spring. (Pull bolt handle back and forth several times to check if trigger will release cocked firing pin spring).



#### CAUTION

*THE SAFETY IN YOUR SEMI-AUTO RIFLE IS CORRECTLY DESIGNED, FITTED AND TESTED. HOWEVER, ANY MECHANICAL DEVICE CAN FAIL. NEVER POINT AT ANYTHING BUT A SAFE TARGET AND NEVER RELY UPON THE SAFETY TO JUSTIFY CARELESS HANDLING. USE HIGH VELOCITY .22 CALIBER LONG RIFLE CARTRIDGES ONLY. WHEN LOADING, PULL BOLT HANDLE REARWARD AND ALLOW IT TO SNAP FORWARD SHARPLY. BREECH AREA AND MAGAZINE SHOULD BE CLEANED THOROUGHLY.*



SCAN QR

[SEE FULL VIDEO TUTORIALS ON OUR WEBSITE](#)

## STORAGE AND TRANSPORTATION

When storing the firearm and ammunition, store in separate locations, store ammo in a cool, dry location.

When storing the gun for a prolonged period of time, It is necessary to oil it heavily with an acid-free lubricant. The external parts must be coated with an anti-rust oil or grease to prevent moisture causing the parts to rust and malfunction. Before usage, the rifle must be cleaned and wiped dry again as discussed previously.

### **WARNING:**

*CHILDREN ARE ATTRACTED TO AND CAN OPERATE FIREARMS THAT CAN CAUSE SEVERE INJURIES OR DEATH. PREVENT CHILD ACCESS BY ALWAYS KEEPING FIREARMS LOCKED AWAY AND UNLOADED WHEN NOT IN USE. IF YOU KEEP A LOADED FIREARM WHERE A CHILD OBTAINS AND IMPROPERLY USES IT, YOU MAY BE FINED OR SENT TO PRISON.*

### **WARNING:**

*THE FIREARM SHOULD BE RE-STORED IN ROOMS WITH A DRY ATMOSPHERE AND WITH THE LEAST HUMIDITY. IT SHOULD NOT BE STORED ENCASED IN LEATHER OR ANYTHING THAT WILL ATTRACT AND HOLD MOISTURE, CAUSING IT TO RUST.*

## ORDERING PARTS

Visit RIA website to browse, learn more about and purchase parts and ammunition for all of your Rock Island Armory products.

 [www.advancedtactical.com](http://www.advancedtactical.com)



## WARRANTY REGISTRATION

Armcor's warranty covers its firearms and parts. We offer limited lifetime warranty on our products for their intended purpose. As with any product, abuse, gunsmithing by an unqualified person and normal wear and tear are excluded. Additionally, if the firearm was modified and/or repaired by an unqualified gunsmith without permission from Armcor, then the warranty will be void. If warranty work should be required, return the firearm to the address listed below. There is no refund for the shipping cost. Gunsmithing services are available by registered Armcor Gunsmithers. Please email the address below.

To register your firearm, please go to [www.rockislandarmory.com/support-center/warranty/](http://www.rockislandarmory.com/support-center/warranty/) and complete online warranty form. In comments section, write warranty registration and press submit. You can also go to [www.rockislandarmory.com](http://www.rockislandarmory.com) and press warranty section at the bottom.

For more information on warranty, visit [www.rockislandarmory.com](http://www.rockislandarmory.com), or email [support@armcor.com](mailto:support@armcor.com)

Armcor Precision International  
150 North Smart Way  
Pahrump, NV 89060  
Email: [support@armcor.com](mailto:support@armcor.com)

## IMPORTANT WARRANTY INFORMATION

Our Rock Island Armory rifles are warranted to function only with Factory Brass Cased Ammo and the Original Factory Magazine. Use of Handloads is not covered in Warranty of Repair for the function of the Firearm.

DUE TO THE FIT AND TIGHTNESS OF FIREARM, RIA RECOMMENDS A BREAK-IN PERIOD OF 500 ROUNDS.

### THIS IS HOW YOU VOID YOUR WARRANTY

- \* Refinishing your RIA firearm
- \* Misuse, Mishandling, Dropping your RIA Firearm
- \* Firing Remanufactured or Reloaded Ammunition
- \* Not properly reassembling your RIA Firearm resulting in damage, ie reverse plugs!
- \* Any addition of after market parts
- \* Unauthorized repairs done by any other than Rock Island Armory

### LIMITS ON WARRANTY (will not cover)

- \* Finish, Holster wear, Scratches, Chemical damage
- \* After Market Magazines
- \* Damage to Factory Magazines
- \* Sights not installed by Rock Island Armory
- \* Recoil Springs

WE RESERVE THE RIGHT TO CHARGE FOR LABOR, PARTS AND SHIPPING TO RETURN YOUR RIA FIREARM BACK TO FACTORY SPECIFICATIONS IF IT HAS BEEN ALTERED.

## NOTES



[WWW.ROCKISLANDARMORY.COM](http://WWW.ROCKISLANDARMORY.COM)

