



# UNIVERSAL FIREARMS CORP

PHONE: Area 305/696-0950

3740 EAST 10th COURT / HIALEAH, FLORIDA 33013

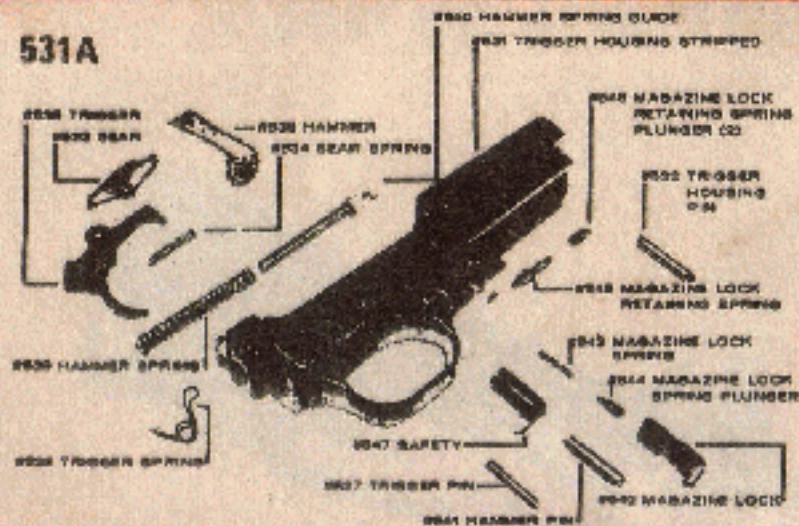


## OPERATION AND MAINTENANCE OF THE UNIVERSAL CARBINE

USED BY THE ARMED FORCES AND SPORTSMEN THE WORLD OVER

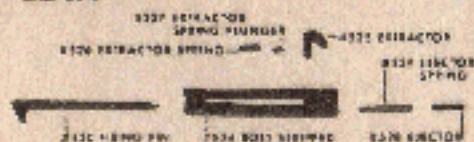


531A



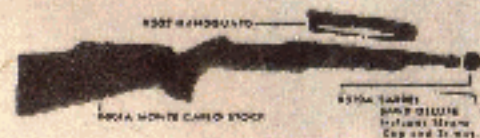
## TRIGGER HOUSING ASSEMBLY

524A



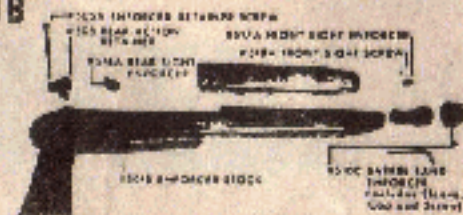
## BOLT ASSEMBLY

501A

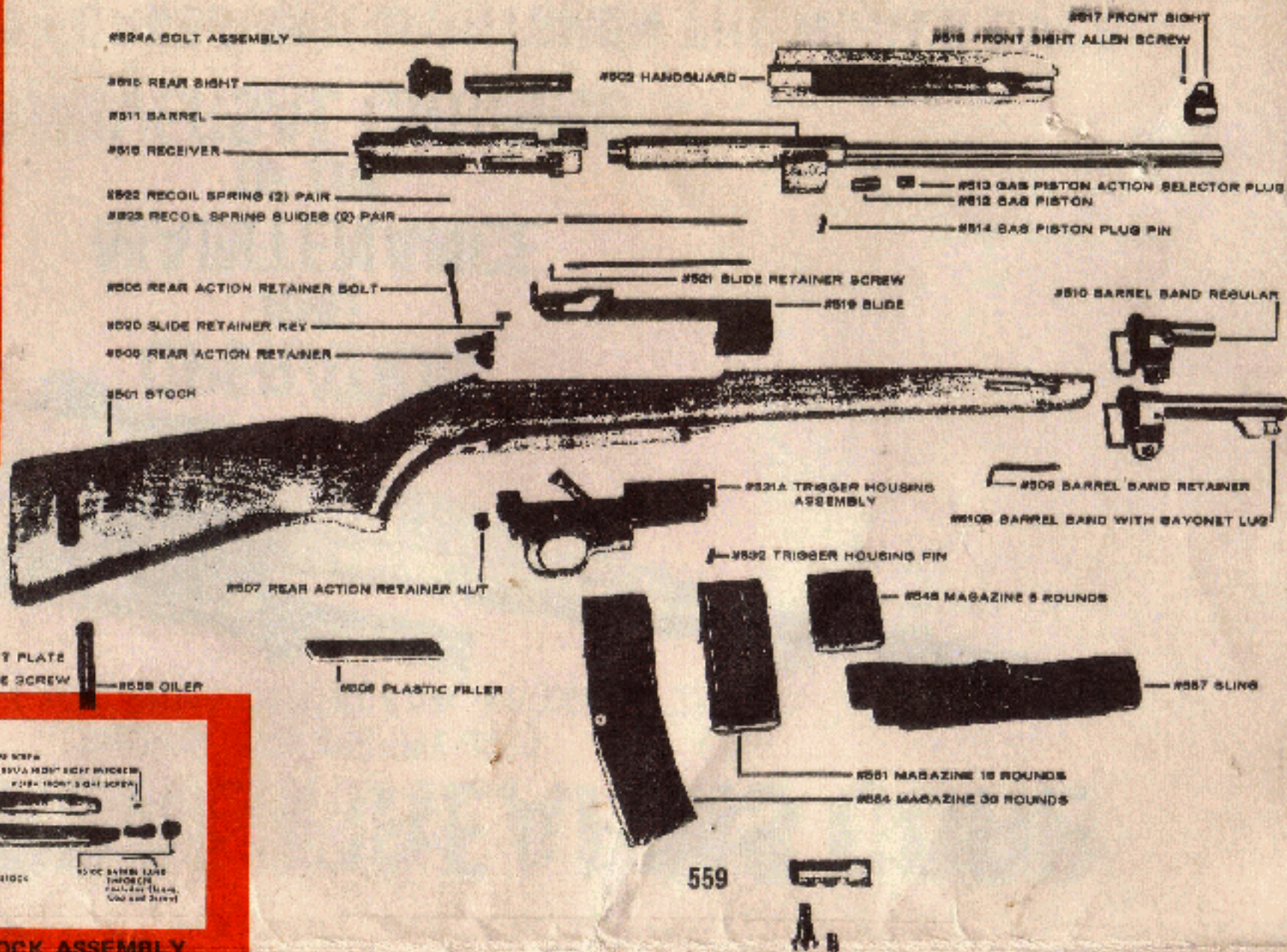


## MONTE CARLO STOCK ASSEMBLY

501B



## ENFORCER STOCK ASSEMBLY





# PARTS LIST WITH PRICES

FOR USE WITH UNIVERSAL CARBINES WITH SERIAL NO.'S OVER 100,000

No. 501	Stock	\$16.50	No. 526	Extractor Spring	\$ .12
501A	Monte Carlo Stock Assembly	27.50	527	Extractor Spring Plunger	.50
501B	Enforcer Stock Assembly	27.50	528	Ejector	1.00
502	Handguard	5.00	529	Ejector Spring	.12
503	Butt Plate	2.50	530	Firing Pin	3.50
504	Butt Plate Screw	.15	531	Trigger Housing Stripped	8.50
505	Rear Action Retainer	3.00	531A	Trigger Housing Assembly	25.00
506	Rear Action Retainer Bolt	.50	532	Trigger Housing Pin	.50
506A	Enforcer Retainer Screw	.50	533	Sear	4.50
507	Rear Action Retainer Nut	1.00	534	Sear Spring	.50
508	Plastic Filler	.50	535	Trigger	5.50
509	Barrel Band Retainer	1.75	536	Trigger Spring	1.00
510	Barrel Band Regular	5.00	537	Trigger Pin	.50
510A	Barrel Band Deluxe	7.50	538	Hammer	5.50
510B	Barrel Band w/Bayonet Lug	7.50	539	Hammer Spring	1.00
510C	Barrel Band for Enforcer	7.50	540	Hammer Spring Guide	2.00
511	Barrel	22.00	541	Hammer Pin	.50
512	Gas Piston	1.50	542	Magazine Lock	3.50
513	Gas Piston Action Selector Plug	2.00	543	Magazine Lock Spring	.50
514	Gas Piston Plug Pin	.50	544	Magazine Lock Spring Plunger	.50
515	Receiver	25.00	545	Magazine Lock Retaining Spring	.25
516	Rear Sight	5.00	546	Magazine Lock Retaining Spring Plunger (2) pair	1.00
516A	Rear Sight Enforcer	2.50	547	Safety	3.50
517	Front Sight	4.50	548	Magazine 5 rounds Blue	4.50
517A	Front Sight Enforcer	2.50	549	Magazine 5 rounds Nickel	6.50
518	Front Sight Allen Screw	.40	550	Magazine 5 rounds Gold	6.50
518A	Front Sight Allen Screw Enforcer	.40	551	Magazine 15 rounds Blue	4.50
519	Slide	9.00	552	Magazine 15 rounds Nickel	7.50
520	Slide Retainer Key	1.00	553	Magazine 15 rounds Gold	7.50
521	Slide Retainer Screw	.50	554	Magazine 30 rounds Blue	8.00
522	Recoil Spring (2) pair	1.50	555	Magazine 30 rounds Nickel	10.00
523	Recoil Spring Guides (2) pair	1.50	556	Magazine 30 rounds Gold	10.00
524	Bolt Stripped	9.50	557	Sling	2.50
524A	Bolt Assembly	18.50	558	Oiler	1.50
525	Extractor	4.50	559	Slide Lock Assembly	1.50

SPECIFICATIONS SUBJECT TO CHANGE AT OUR DISCRETION WITHOUT NOTICE  
PAYMENT IN FULL, PLUS POSTAGE, MUST ACCOMPANY ALL ORDERS

## SERVICE

Every Carbine is proof-tested and function-fired in order to prove that it is in perfect condition and conforms fully to our specifications and standards before shipment.

If there is any question with regard to the performance of the gun, please write to our Service Department, fully describing all circumstances and conditions involved.

If you should return your Carbine for repair or if you order component parts, please comply with the following suggestions for prompt service:

1. Please enclose remittance with order.
2. Guns shipped to the factory should be sent prepaid. We will not accept collect shipments.
3. If no work is required on the stock, the complete barrel, receiver and mechanism may be sent alone.
4. Always give serial number and model of firearm. Give detailed information covering difficulty or work desired. Give name of shipper, if other than correspondent. Be sure to order parts by name and number.

### RETURNING GUNS TO FACTORY:

After 90 days all guns require a \$2.50 service and handling charge. Please include sufficient postage for return of gun. This also applies to the three year warranty and lifetime warranty.

**NOTE: Please be sure gun is UNLOADED!**  
Open action to be sure cartridge is not in chamber.



# WARRANTIES

## FOR THE FIRST TIME ... YOUR CHOICE OF TWO WARRANTIES OUR FAMOUS THREE YEAR WARRANTY OR UNIVERSAL'S NEW LIFETIME WARRANTY!

THREE YEARS COVERING DEFECTS\* IN MANUFACTURING OR UNIVERSAL'S NEW WARRANTY\*  
THAT COVERS EVEN NORMAL USAGE FOR THE LIFE OF THE ORIGINAL OWNER.  
CHECK THE WARRANTY CARDS ENCLOSED WITH YOUR NEW UNIVERSAL FIREARM  
FOR THE WARRANTY OF YOUR CHOICE!

### THREE YEAR WARRANTY

UNIVERSAL FIREARMS CORPORATION HEREBY WARRANTS YOUR NEW UNIVERSAL FIREARM AGAINST ALL DEFECTS ARISING FROM FAULTY WORKMANSHIP OR MATERIALS FOR THE PERIOD OF THREE YEARS FROM DATE OF PURCHASE. DURING THIS THREE YEAR PERIOD, WE WILL REPAIR OR REPLACE WITHOUT CHARGE (AT OUR OPTION) ANY PART PROVED DEFECTIVE, WOOD EXCEPTED. THIS WARRANTY DOES NOT COVER NEGLIGENCE, NEGLECT OR MISUSE OF THIS FIREARM BY THE ORIGINAL PURCHASER, NOR DOES IT COVER COST OF REPAIRS OR EFFECT OF SUCH REPAIRS MADE OUTSIDE OUR FACTORY FACILITIES.

IF REPAIR IS NECESSARY, PLEASE FORWARD GUN, PREPAID, WITH A LETTER INDICATING THE DIFFICULTY TO UNIVERSAL FIREARMS CORPORATION.

*19. Fontaine*

President



UNIVERSAL  
FIREARMS  
CORPORATION  
3740 EAST 10TH COURT  
HIALEAH, FLORIDA 33013

USED BY THE ARMED FORCES AND SPORTSMEN THE WORLD OVER.

### LIFETIME WARRANTY

IN CONSIDERATION OF \$5.00

UNIVERSAL FIREARMS CORPORATION HEREBY WARRANTS YOUR NEW UNIVERSAL FIREARM AGAINST DEFECTS ARISING FROM FAULTY WORKMANSHIP OR MATERIAL OR FROM NORMAL USAGE AND WEAR (BUT NOT INCLUDING STOCK) FOR THE LIFETIME OF THE ORIGINAL PURCHASER. AT THEIR OPTION, UNIVERSAL FIREARMS CORPORATION WILL REPAIR OR REPLACE ANY PART FOUND DEFECTIVE UNDER THE TERMS OF THIS WARRANTY. ONLY DAMAGE DUE TO NEGLIGENCE, NEGLECT OR MISUSE IS EXCEPTED.

ALL FIREARMS FOUND DEFECTIVE UNDER THIS LIFETIME WARRANTY SHOULD BE RETURNED TO UNIVERSAL FIREARMS CORPORATION PREPAID WITH A STATEMENT COVERING THE REASON FOR RETURN.

*19. Fontaine*

President



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\*Wood excepted

Make a permanent record of your serial number. Our Warranty files are maintained by number and not by name.

Serial Number \_\_\_\_\_

AFTER 90 DAYS ALL GUNS REQUIRE A \$2.50 SERVICE AND HANDLING CHARGE. PLEASE INCLUDE SUFFICIENT POSTAGE FOR RETURN OF GUN. THIS ALSO APPLIES TO THE THREE YEAR WARRANTY AND LIFETIME WARRANTY.

KEEP THIS

KEEP THIS



## SEND THIS

TO VALIDATE, PLEASE FILL OUT CARD BELOW  
AND RETURN IT WITHIN 10 DAYS TO  
UNIVERSAL FIREARMS CORP.  
WITH YOUR CHECK OR  
MONEY ORDER  
FOR \$5.00

## SEND THIS

TO VALIDATE, PLEASE FILL OUT CARD BELOW  
AND RETURN WITHIN 10 DAYS TO  
UNIVERSAL FIREARMS  
CORP.

FILL IN EITHER WARRANTY, FOLD AND MAIL

SERIAL NUMBER WILL BE FOUND ON RECEIVER BEHIND REAR SIGHT.

### THREE YEAR WARRANTY PLEASE PRINT

SERIAL NO.	MODEL NO.	CALIBER	
DEALER'S NAME	DATE PURCHASED		
DEALER'S ADDRESS	CITY	STATE	
PURCHASER'S NAME			
PURCHASER'S ADDRESS	CITY	STATE	ZIP CODE
SIGNATURE OF PRUCHASER			

SERIAL NUMBER WILL BE FOUND ON RECEIVER BEHIND REAR SIGHT.

### LIFETIME WARRANTY PLEASE PRINT

SERIAL NO.	MODEL NO.	CALIBER	
DEALER'S NAME	DATE PURCHASED		
DEALER'S ADDRESS	CITY	STATE	
PURCHASER'S NAME	AGE	SEX	
USE OF FIREARM			
PURCHASER'S ADDRESS	CITY	STATE	ZIP CODE
<input type="checkbox"/> CHECK <input type="checkbox"/> MONEY ORDER	SIGNATURE OF PURCHASER		



# DISASSEMBLY FIELD STRIPPING

FIG. 1

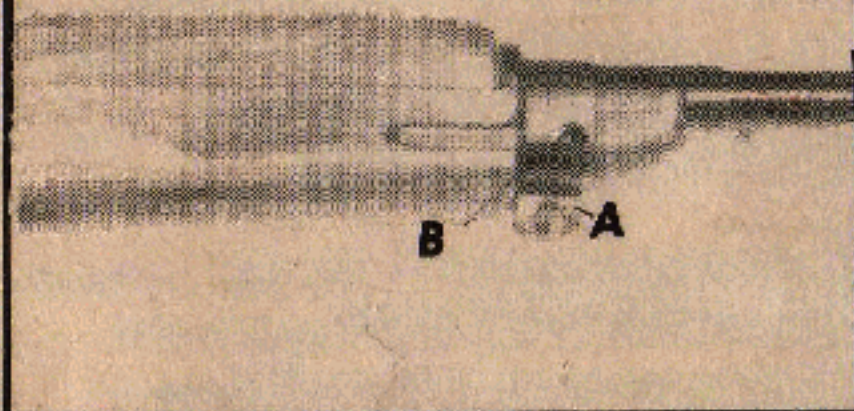


FIG. 2



FIG. 3

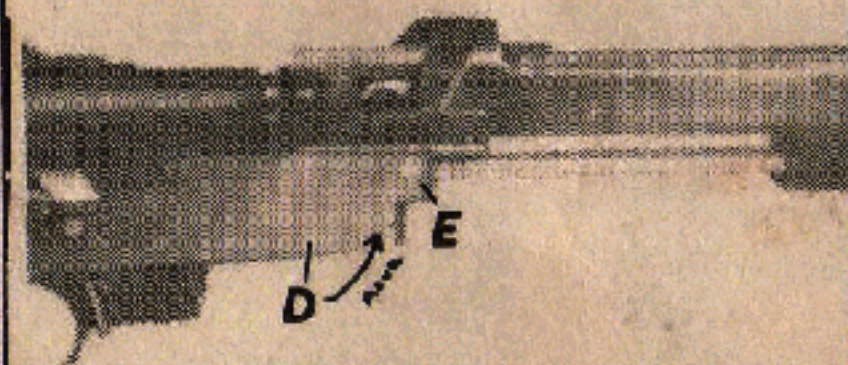


FIG. 4

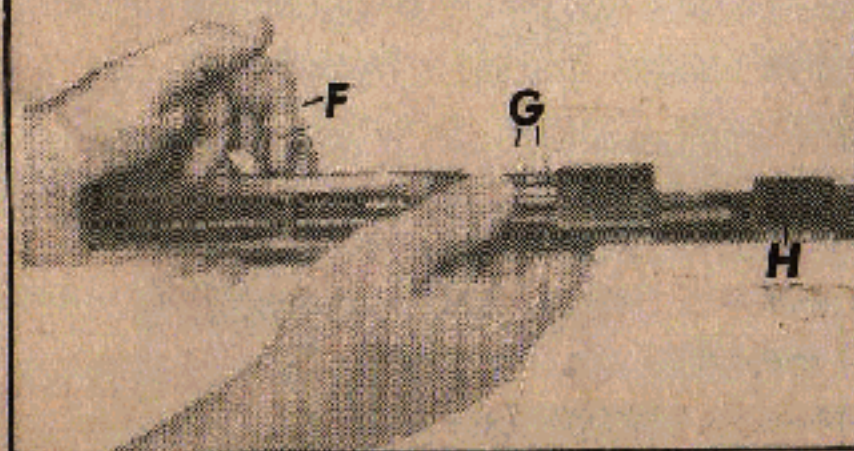


FIG. 5

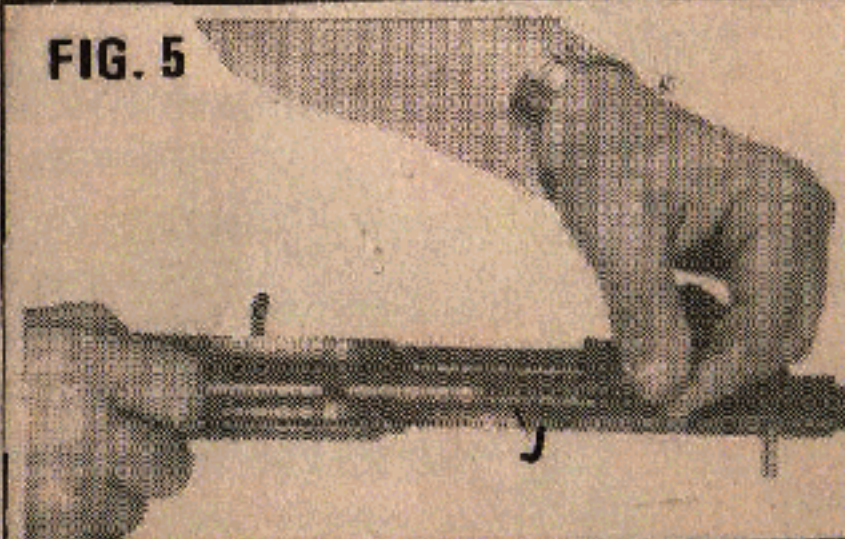


FIG. 6

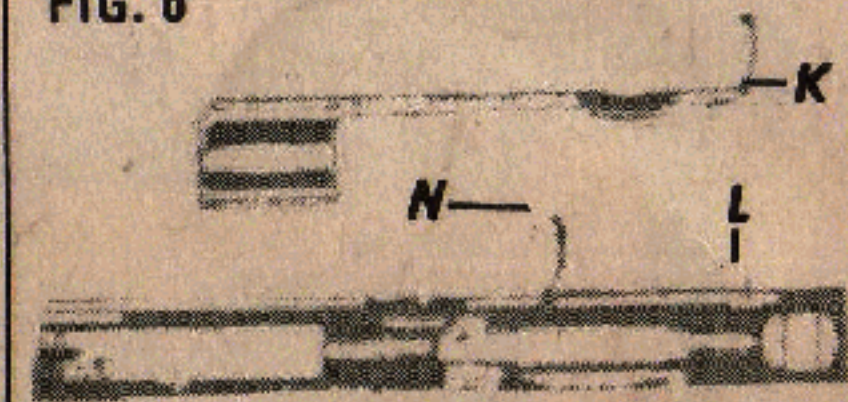


FIG. 7

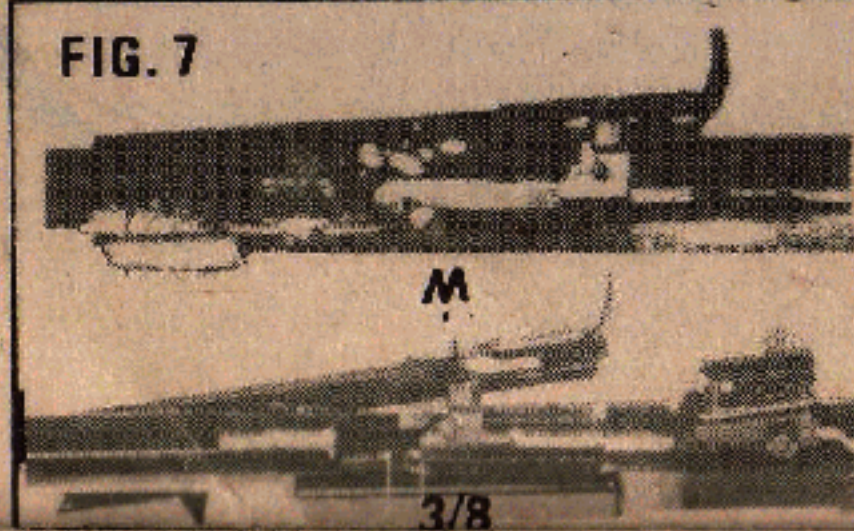


FIG. 8

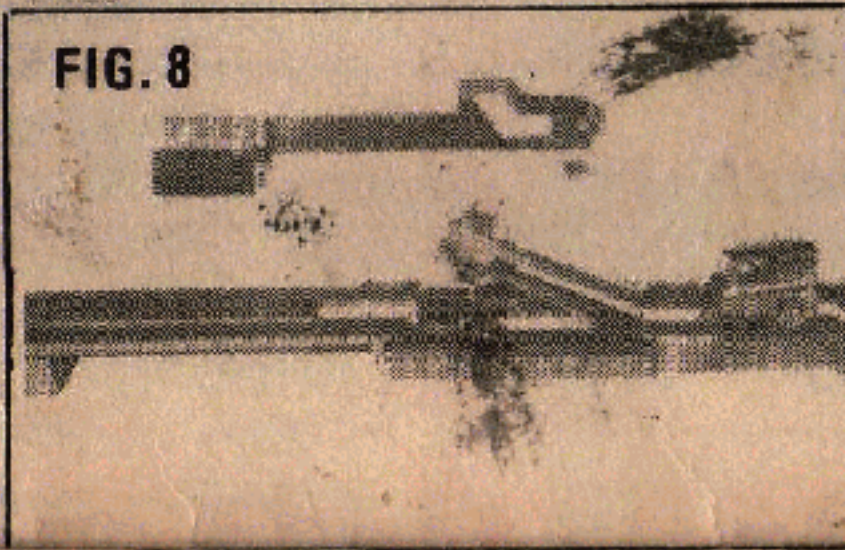
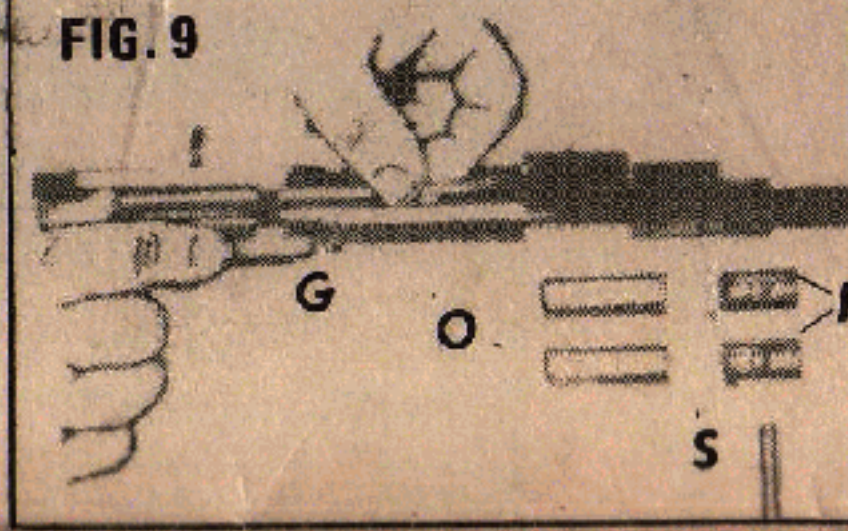


FIG. 9





Remove magazine from trigger guard. Loosen Barrel Band Screw (A) Fig. 1. Do not remove. Depress Barrel Band Retainer (B) with narrow screwdriver to disengage notch from Barrel Band and slide Barrel Band forward by tapping lightly with hammer until Barrel Band clears Hand Guard (C). Grasp Barrel at forward end and pull from Stock. See Fig. 2.

Fig. 3. Lay gun on flat surface supporting back side of trigger guard (D) to prevent damage. Drive Trigger Guard Housing Pin (E) out with a drift punch. When pin is removed, trigger guard may be tapped lightly towards the front sight. This will remove it from the Dove Tail so it can be withdrawn from the receiver.

Turn receiver over and place on back as in Fig. 4. Pull Slide (F) to rear. At the same time bring both the Recoil Spring Guides (G) back. Hold Guides at rear with thumb and let Slide return forward. This disengages Guides from Gas Piston Block (H) and will enable you to remove Recoil Spring Guides. First Right Guide, then Left Guide. Hold Recoil Springs (J) as in Fig. 5 to prevent them from flying loose.

Fig. 6. Move slide (N) and bolt assembly to rear until key (K) on slide is in line with key slot (L) in receiver. Move slide outward and upward so key passes into slot as far as it will go. With slide in this position, move bolt completely to rear of receiver to allow key on slide to clear slot, Fig. 7. Move bolt and slide forward together until face of bolt is  $\frac{3}{8}$ " from left locking lug (M), Fig. 7. Raise slide and move forward to completely disengage slide from bolt and receiver, Fig. 7. Rotate bolt to left one-quarter turn while moving bolt upward to release bolt from receiver, Fig. 8.



## LOADING

Press cartridge down with thumb until caught under magazine lips. Repeat until full. Turn safety, Fig. 2 (H) down to SAFE (green exposed). Push magazine up into receiver until a click indicates the magazine lock has snapped into place. Pull operating slide handle (J) back and release it — thereby chambering first cartridge. It is a good habit to make sure the bolt and slide are completely closed before firing gun. Turn safety back to FIRE (red exposed). **WARNING:** Make sure slide and bolt is completely locked forward before firing.



## UNLOADING

Turn safety down to SAFE (green exposed).

Press magazine lock (M) in Fig. 10.

Slide magazine down and out.

Pull operating slide back to eject remaining cartridge.

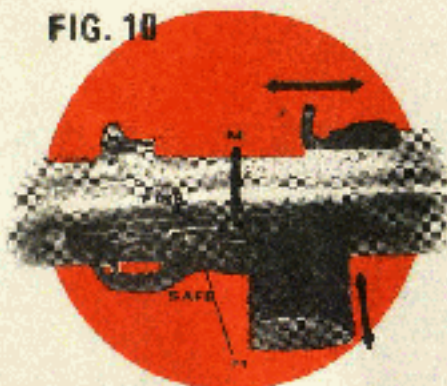
Magazine is unloaded by sliding cartridges forward and out, one at a time.

### NOTE:

To withdraw 5 shot slip/clip when bolt is in open position, draw slide back and hold it firmly while depressing magazine follower through top of gun with left thumb. Allow bolt to move forward slowly over magazine follower. When magazine follower is under bolt, withdraw left thumb and let bolt close all the way.

**CAUTION: DO NOT RELEASE BOLT AS FINGER MAY BE CAUGHT BETWEEN BOLT AND BARREL.** Clip may then be withdrawn from gun by depressing magazine release button marked (M) in Fig. 10.

FIG. 10



## SEMI-AUTOMATIC TO SINGLE SHOT BOLT ACTION

To change this gun from Semi-Automatic to Single Shot Bolt Action follow this procedure. Field Strip gun. (See disassembly instructions). Place gun on firm surface and drive gas piston plug pin (S), Fig. 9, from chamber with 3/16" punch. After Pin has been removed, tap Gas Piston (O) towards front sight with large punch to remove Gas Piston Plug (P). Note gas control channel at top of plug. By turning this plug over 180°, channel will be away from the barrel and gas flow will be cut off from the piston. Insert plug and align hole. Drive Gas Piston Plug Pin back through holes in chamber and Plug. Note: This is a special heat treated pin. Do not replace with substitute. The Gas Piston assembly requires no cleaning.

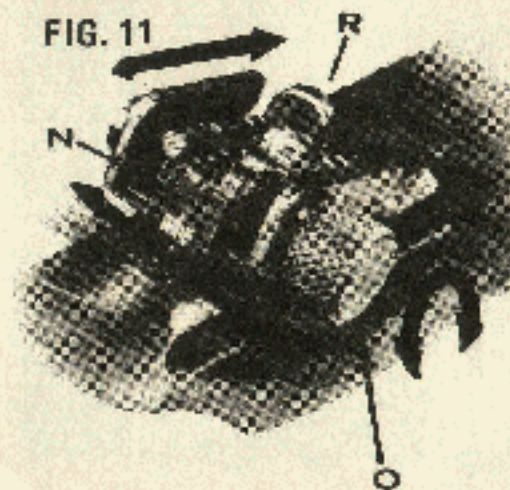
## ASSEMBLY

For assembly, reverse Field Stripping procedure. Slip bolt firing pin through opening in receiver. When face of bolt is approximately 3/8" behind face of left locking lug, turn bolt approximately one-quarter turn to left to allow left lug of bolt to fit into receiver. Turn bolt back to right to seat bolt in receiver. Make sure bolt slides freely back and forth. With face of bolt 3/8" from left locking lug, put slide into place so right lug on bolt will fit through opening on slide. Move slide and bolt together to rear until key on slide lines up with key slot in receiver. Drop slide key through slot. Bolt and slide are now properly aligned and should move smoothly back and forth. Feed Right Recoil Spring (J) onto Recoil Spring Guide (G) as illustrated in Fig. 9. With right thumb push Guide forward until it engages Recoil Slide Hole. Note Springs are flared at both ends to enable you to thread over Guides easily. Repeat for left spring and guide. Make sure Guides are firmly engaged in holes at forward end, and rear ends of Guides clear hole for Trigger Guard Housing Pin. Place rear of Trigger Guard Housing in Dove Tail and tap lightly at forward end of Trigger Guard until holes are properly aligned. Replace Trigger Guard Housing Pin by driving from same side as Slide Handle. Make sure back side of trigger guard is supported to eliminate possibility of breaking Trigger Guard. Replace entire barrel assembly in stock and reset Barrel Band over notch. Tighten Barrel Band Screw.



## SIGHTING

FIG. 11



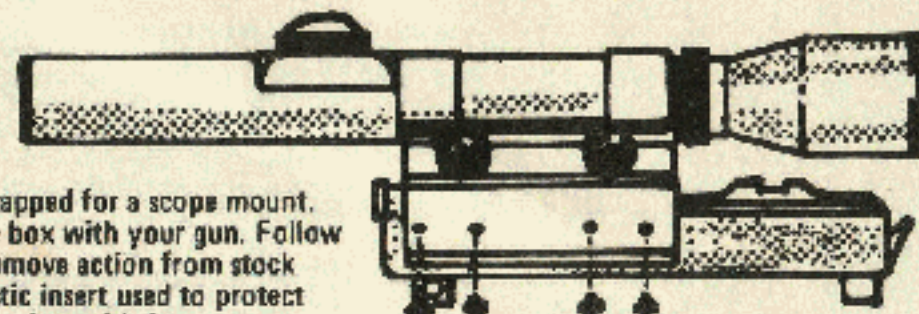
Front sight is of the fixed blade type. Rear sight is of the "peep" or aperture type and is adjustable as follows: Aperture, Fig. 11 (R) slides forward and rearward according to distance to target, and snaps into indents corresponding to 100, 200, 250, and 300 yds. Ramp (N) moves left and right, by turning knob (O) to correct for windage, or lead on moving target. Each click corresponds to 1" at 100 yds. (2" at 200 yds., etc.)

**CAUTION:**  
If Misfire Occurs,  
Wait One Full Minute  
Before Ejecting  
Faulty Round.

## CLEANING

The carbine bore can be cleaned only from the muzzle. Pull operating slide to rear and push bolt lock forward to hold action open in a locked position for cleaning. Inspect chamber to make sure it is not loaded. Use cleaning rod, which is available from arms dealers, and guide rod with thumb and finger to prevent damaging rifling at muzzle. Inspect bore with aid of bore reflector, small mirror or piece of white cloth or paper placed in breach opening at an angle to reflect light. With bore reflector or mirror, bore can be inspected from both ends. Carbine cartridges have non-corrosive primers and therefore it is not necessary to use water in cleaning the bore. However, nitro-solvent or bore cleaner should be used to dissolve powder fouling. Dry bore with clean patches after use of nitro-solvent or bore cleaner, and oil bore with patch soaked in preservative oil. Be sure to remove grease or any obstructions from bore prior to firing.

## SCOPE MOUNTING INSTRUCTIONS

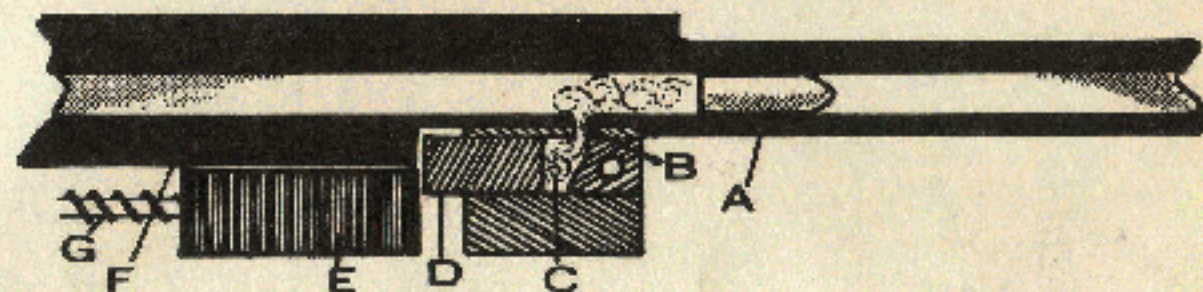


Your new Universal Gun has been drilled and tapped for a scope mount. The base mount and screws are enclosed in the box with your gun. Follow the simple directions to insure best results: Remove action from stock (see Field Stripping instructions). Remove plastic insert used to protect screw holes and inletted area. Fasten base to receiver with four screws extremely tight. Gunsmiths often apply a bonding cement (available at hardware stores) to the screws and under the base for greater security. Tighten each of the four base cap screws a little at a time until they are very tight so there can be no slippage. The rifle is then ready for sighting in.

Before attaching scope, windage and elevation adjustments should be zeroed or centered. (See your Scope instructions). The scope turret must be forward of the mount. Slip the mount caps over the tube. Don't remove the scope turret or eye-piece.

Fasten the mount in position on the base. Place the gun in a vice or some fixed position with the bore or regular sights precisely aligned on a target about 40 feet distant. To boresight rifles, look through the barrel by means of a small mirror held at an angle in the breach. Without moving the rifle from its boresighted position, the scope should be adjusted to the boresight mark. **IMPORTANT:** All screws are specially hardened. Turn them as tightly as possible to eliminate possibility of loosening from recoil or rough handling.

## OPERATION



The carbine is gas-operated and has a short stroke action. As soon as bullet (A) is forward of gas port (B) in barrel, gas from the burning powder expands through gas port into gas cylinder (C) and thrusts the piston (D) rearward. The piston strikes the operating slide (E), starting it into motion, and the piston is stopped after about 3/16" of travel by the barrel (F). As the operating slide starts to the rear, the recoil spring (G) begins to be compressed. The operating slide moves rearward about 5/16" before its cam contacts operating lug of bolt. This allows operating slide to gain speed to overcome inertia of the locked bolt, and also gives time for bullet to clear muzzle, allowing pressure in barrel to be reduced to outside pressure before bolt begins to unlock. As operating slide continues to the rear, it compresses the recoil spring and cams the bolt counterclockwise to unlocked position. Extraction and ejection of fired cartridge case, withdrawal of firing pin to safe position inside bolt, and cocking of hammer occurs as bolt moves rearward. When operating slide and bolt move forward, pushed by the compressed recoil spring, the bolt strips top round from magazine and shoves it into chamber. When bolt reaches forward position, cam in operating slide rotates bolt clockwise so locking lugs on either side of bolt head engage locking shoulders in receiver.



Please be sure to return this card  
with your check or money order  
for \$5.00.



**NIVERSAL FIREARMS CORP.**

3740 EAST 10TH COURT  
HIALEAH, FLORIDA 33013

PLACE  
STAMP  
HERE



**NIVERSAL FIREARMS CORP.**

3740 EAST 10TH COURT  
HIALEAH, FLORIDA 33013



# **WARNING**

## **DO NOT USE**

- Corrosive primer ammunition — can cause rust damage to bolt face and bore.
- Improper size reloads
- Corroded cartridge cases
- Over-sensitive primer
- Any faulty or unsuitable ammunition

## **FOR SAFER OPERATION**

- Use only new commercially manufactured or clean, non-corrosive military ammunition.
- If misfire occurs - wait one full minute before ejecting faulty round
- Make sure bolt is fully closed before firing.
- Make sure barrel is clear before firing
- Before firing carefully read Operating Manual