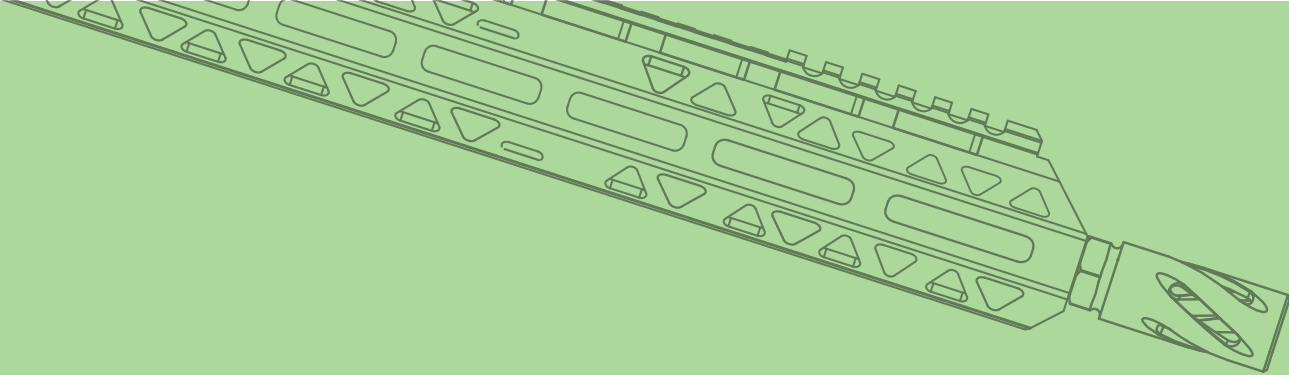




# BEAR CREEK<sup>®</sup> ARSENAL

## **IMPORTANT SAFETY INFORMATION INSIDE**

Read this manual before handling this firearm. Keep this manual with your firearm and review it before each use. Do not allow others to handle or fire your firearm until they have read this manual. Transfer this manual with the firearm upon ownership change. This manual is for Bear Creek Arsenal<sup>®</sup> FIREARMS ONLY. Be a responsible firearm owner. Use it safely, store it securely, and always transfer a firearm responsibly and legally.



## Table of Contents:

Know Your Upper Assembly

How To Break In Your Bolt Action

What to Expect

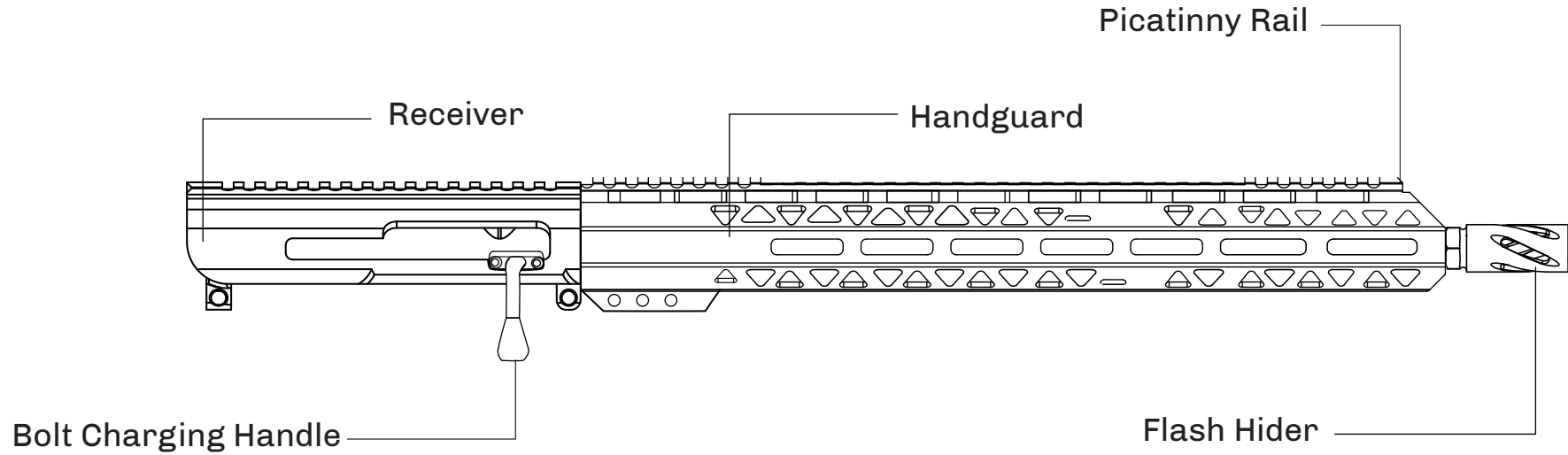
Mounting Procedure On Lower Assemblies

Limited Lifetime Warranty



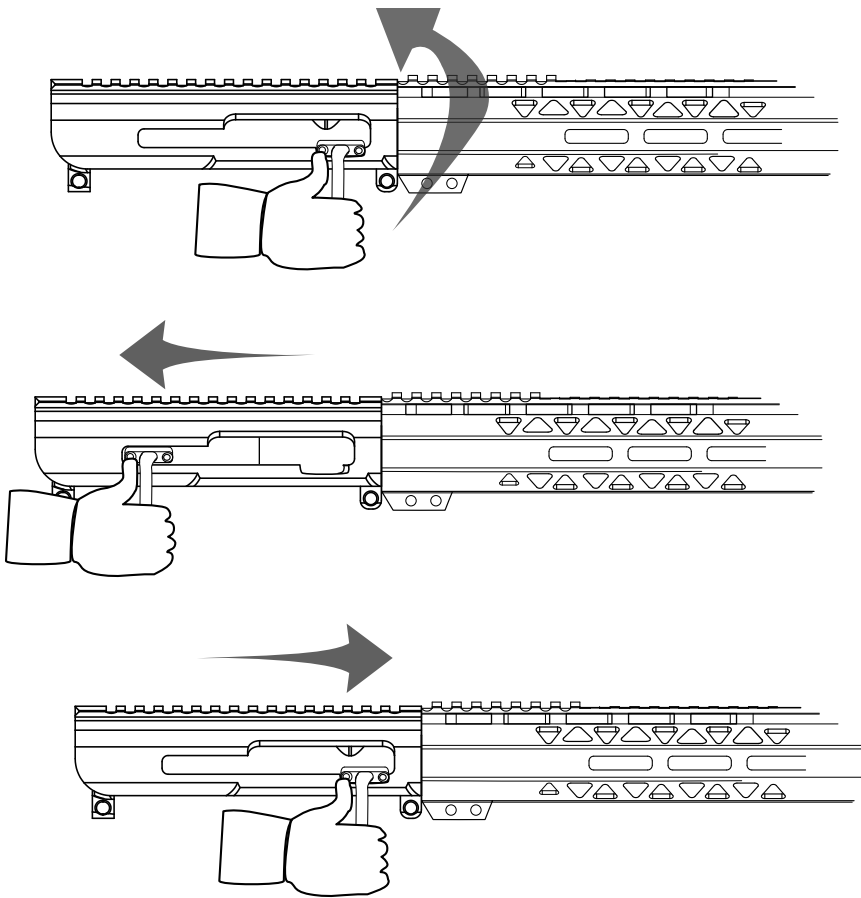
# Know Your Upper Assembly

---



## How To Break In Your Bolt Action

- Clean and inspect all parts
- Lubricate the bolt carrier as well as the receiver where the carrier makes contact
- Run the action 25-50 times to smooth out the finish



Running your bolt action style

## What To Expect

This is not a traditional bolt action rifle, you will feel **slight resistance** in the action due to the function of the AR15 fire control group, requiring a manual reset that takes place by **pulling the bolt carrier group to the rear**.

The throw of your bolt lever will only be a **23-degree throw**, so it will feel short compared to traditional bolt actions. There is no gas blowback on this rifle, the barrel does include a gas port but has been covered with a collar to ensure no gas blowback during operation.

The rifle comes with a complete lower assembly including the buffer and buffer spring, while recommended, these parts are non essential to function of the platform due to the manual action, however you do still need the buffer tube, removal of the buffer tube will impede function.

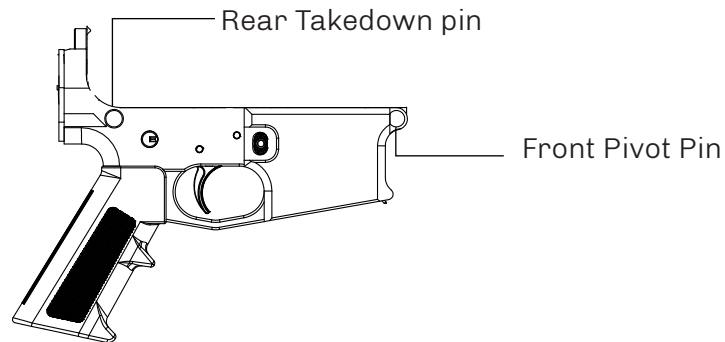


*Only shoot rounds of caliber of the purchased Upper assembly. Shooting rounds of other calibers could lead to serious damage to product or in extreme cases injury to operator.*

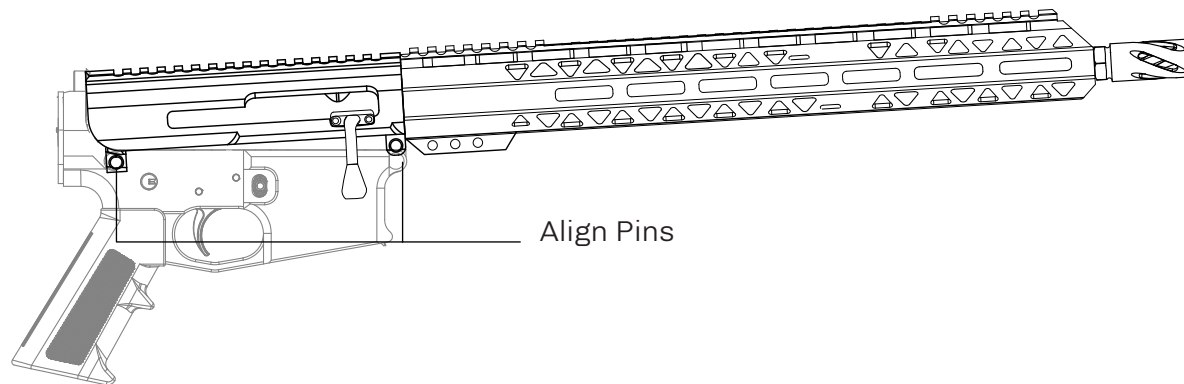
# Mounting Procedure On Lower Assemblies

*BCA complete upper assemblies are only compatible with mil-spec lowers.*

- Locate the rear takedown pin and the front pivot pin on your milspec lower receiver



- Push out both pins all the way
- Align the pins with the takedown and pivot slots on the bottom of the upper receiver



- Push both pins into place, locking the receivers together
- Perform a functions check to ensure operability

# LIMITED LIFETIME WARRANTY

## 30-Day Return Policy

All of our products have a money back guaranteed for thirty (30) days from date of purchase (herein defined as the date a product is ordered and payment is submitted through the Site) no questions asked! Any returns after the 30 day time period will be re-imbursed in the form of a store credit coupon. Any returns 6 months or more after purchase date will be refunded in the form of a store credit and will have a 15% restocking fee.

## How to Return a Product:

- 1) To initiate a warranty claim, please submit an RMA request from the website directly. Here is a how-to video on the procedure to submit an RMA. Our video can be found at [How-to submit a Warranty Request](#) If you require additional help processing your warranty, please reach out to our customer service desk at [customerservice@bearcreekarsenal.com](mailto:customerservice@bearcreekarsenal.com) and they can help guide you further.
- 2) Once an RMA has been received our team will be in contact with you and provide you with a return number and shipping label. We will also provide you with an estimated timeline so you can stay aware of the process.
- 3) Please remove all accessories/attachments before returning item. Extra fees may be charged if accessories are not removed. Then package your item and drop off at the shipping carrier.
- 4) If you contact us with questions or to inquire about the status of your return, we may request that you provide the return number indicated before.



**LIFETIME  
GUARANTEE**

## Term and Limitations:

- We reserve the right to reject any returned product and to decline to issue **any reimbursement if in our sole judgment the returned product has been damaged by you or otherwise while in your custody or care.**
- We reserve the right to repair, replace, or issue credit for the returned product regardless of the requested outcome.
- No return payment will issue to you until we have received, processed, and accepted your returned product, packaging, proof of purchase, and return tag.
- Typical processing time is 1-14 business days from the date we receive your return.

## What is NOT covered by our Bear Den Guarantee?

- Normal wear and tear.
- Products that have been modified/serviced by another manufacturer or gunsmith.
- Damage caused in whole or part by failure to perform proper care and maintenance.
- Damage caused in whole or part by the use of nonstandard ammunition, including without limitation high velocity or high pressure ammunition, tracer ammunition, or hand-loaded ammunition.
- Damage caused in whole or part by unauthorized modification or alteration, unauthorized repair, misuse, or abuse.