

## Assembly Instructions SaBer Two-22 Gatling Gun

1. Secure two Ruger 10-22 rifles. Remove magazine and ensure the chamber is empty.
2. Remove the stocks by loosening the two screws:
  - A. Main receiver, underneath and in front of the trigger guard
  - B. Barrel clamp, at the end of the stock.
3. Carefully tap the front and rear sights out of the dovetails with a small punch and hammer.
4. Position both rifles side by side, with the ejections port of one rifle facing up, and one facing down. (Keep the rifles in this configuration throughout the rest of the assembly operation).
5. Replace the two medium dowel pins that retain the trigger assembly in the receiver, with the headed pins supplied. Simply push the two new pins down forcing the old pins out. Do this to both rifles.
6. Replace the two small pins that retain the magazine release and the trigger, with the small headed pins provided. Do this to both rifles. You may also replace the Large recoil buffer pins at the rear of the receiver, at this time.
7. Erect the tripod, and put a small amount of grease in the hole and spread some around on the top of the yoke base. Insert the pinde pin located on the bottom of the main frame into the tripod yoke.
8. Install the crank handle & knob assembly on the cam bar. Be sure the set screw locks onto the FLAT side of the cam bar.
9. Remove the two screws that hold the top half of the barrel clamp in place, set the clamp aside and install the two rifles with the thickest part of the barrel down into the half round grooves. Set the guns in and loosely reinstall the barrel clamp. YOU WILL WANT TO REFER TO THE SUPPLEMENT PAGES AT THIS TIME FOR PROPER TIMING OF THE GUNS.
10. Secure the front right blade, the upper and lower clamp and the long screw. Place the clamps around the barrels with the slotted clamp on top. Run the screw up from the bottom and into the right blade. Using an allen wrench draw the blade down into the slot by tightening the screw. Do not over tighten.
11. Slip the front right assembly over the small end of the barrel shrouds and push it ALL the way forward, against the muzzle brakes. Slide the barrel tubes over the barrels. Be sure to put the small end on first (towards the receiver). Align the set screws in a fashion of an 'X' pattern, thus enabling all 8 of the screws to be reached. Looking down the barrels select

a tube and center the tube over the barrel by tightening the set screws individually until centered. Only center one tube at this time! The second tube will automatically be centered during the next operation. Tighten the front right clamp, keeping the front sight straight up. Looking down the other barrel center the barrel in the \_\_\_\_\_ by tightening the set screws individually until centered. These screws can also be used to adjust the front sight.

12. Place the rear sight into the aluminum sight block mounted on the receiver cover and tighten the set screw. Position receiver cover over receivers and align the bolt notch with the bolt on the right hand receiver. Gently tighten the two set screws on the rear of the main frame. This holds the cover in place as well as acts as a stop, keeping the receivers from sliding back during firing.

13. At this point, you are ready for a proportional inspections. Look the setup over and ensure all fasteners are tight. Dry fire (with no ammo) system by cocking both bolts followed by squeezing the trigger and at the same time rotating the crank handle. Both receivers should fire. If both actions fire, you are ready to lock and load. Remember to always be safe.

14. If one or both guns failed to fire (again, with no ammo), remove the cover by loosening the two set screws, and perform the dry fire sequence again. Observe which action fires or fails to fire. Loosen barrel clamps and adjust corresponding receiver forwards of backwards pending observation. Retighten clamp screws and retest. Continue until both fire consistently.

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