Welcome to POF-USA

Congratulations on your new purchase of POF-USA weapons system, featuring our P308 and the P415/P416 gas piston rifle systems and accessories. We are dedicated to providing the highest quality parts and accessories for law enforcement, military and civilian sales at the lowest costs available. Service and support is our number one priority and concern. Whether you are a Soldier, Federal Agent, Police Officer, Contractor, or an American Citizen we guarantee RELENTLESS RELIABILITY.

POF-USA, Inc. is an American owned and operated small business. Our manufacturing and R&D facilities are headquartered in Arizona. We specialize in the design, manufacturing and marketing of AR style rifles, uppers, lowers and miscellaneous gun accessories.

POF-USA, Inc. has engineered, manufactured and tested this system. We are extremely proud of the durability and performance of the P308 and the P415/P416 gas-piston uppers. We have eliminated features of the Gas Operating System such as gas-rings, gas tube, gas key. The P308 and the P415/P416 gas-piston systems also eliminates Heat, Carbon build up and gas leaks which can have an adverse effect on the operating system. The biggest issue being “HEAT”. A weapons first priority, must be “RELIABILITY”.

We have engineered the entire upper receiver system using standard “AR15/M16” style parts such as the flat top receiver and bolt. We add only three additional parts to operate our gas piston uppers (gas plug, gas piston, and push rod). All upper receivers come standard with C.R.O.S™ (Corrosion Resistant Operating System).

Frank DeSomma is President and CEO of POF-USA, Inc. Frank has 28 years experience in an industry most recognized for precision, quality, and reliability, the Aerospace Industry. His success in the manufacturing business is based on his skill and experience in troubleshooting faulty equipment and design engineering. As a sport shooter and lifelong student of quality and precision, Frank decided to embark on a voyage to improve the traditional gas impingement design for the AR-style rifle. In just four short years, Frank has been able to inject his dedication for perfection into the main stream firearms industry.
# Table of Contents

<table>
<thead>
<tr>
<th>Section</th>
<th>Page</th>
</tr>
</thead>
<tbody>
<tr>
<td>Warning</td>
<td>2</td>
</tr>
<tr>
<td>Firearm Safety Rules</td>
<td>3</td>
</tr>
<tr>
<td>General Description</td>
<td>5</td>
</tr>
<tr>
<td>P308 Specifications</td>
<td>6</td>
</tr>
<tr>
<td>P415/P416 Specifications</td>
<td>7</td>
</tr>
<tr>
<td>Gas Piston Operation &amp; Maintenance</td>
<td>8</td>
</tr>
<tr>
<td>Bolt Group Operation &amp; Maintenance</td>
<td>10</td>
</tr>
<tr>
<td>P308, P415/P416 General Operation</td>
<td>12</td>
</tr>
<tr>
<td>P308, P415/P416 Field Stripping</td>
<td>13</td>
</tr>
<tr>
<td>POF-USA .223 Rifle Exploded View</td>
<td>15</td>
</tr>
<tr>
<td>POF-USA .308 Rifle Exploded View</td>
<td>16</td>
</tr>
<tr>
<td>Predator Rail System™</td>
<td>17</td>
</tr>
<tr>
<td>Warranty and Return Policies</td>
<td>20</td>
</tr>
</tbody>
</table>
POF-USA, Inc. recommends that you carefully read this operating manual in its entirety and receive proper training from a certified firearms instructor BEFORE attempting to operate our weapons system.

Please read all the instructions and warnings contained in this operating manual BEFORE attempting to handle, load or utilize the POF-USA P-308, P-415/P-416 weapons system. Even if you are intimately familiar with the standard AR-10, AR-15, M-16, M-4 family of firearms, you need to familiarize yourself with POF-USA weapons system and its accessories before using it in any manner. Failure to do so could result in damage to the firearm, bodily injury to the shooter or bystanders, or even DEATH.

The P-308, P-415/416 weapons system is designed to be used with factory manufactured cartridges only. Using hand-loaded, remanufactured, reloaded or other non-standard ammunition could result in serious malfunction and damage to the firearm or serious bodily injury to the operator or bystanders. POF-USA, Inc. shall not be liable for any bodily injury to the person(s) or damage to any property resulting from the use or misuse of our weapons system firearm. The operating manual should accompany this weapons system at all times. A replacement copy is readily available and can be obtained anytime by visiting the website at www.POF-USA.com.

The safety warnings are for the protection of the owner and operator of POF-USA weapons system as well as the safety of others. Disregarding information in this manual or failure to follow the basic rules of safe firearm handling can result in the unnecessary destruction of property or unintentional injury or death of others.

Please handle every firearm as if it were loaded. Always keep the muzzle pointed in a safe direction. Make sure the safety selector on your firearm is fully engaged until ready to fire. Never chamber a round until you are ready to shoot.

Please call your state or local law enforcement agencies or visit the NRA website (www.nra.org), or the AFT website (www.atf.gov) for further information.

**PROTECT OUR CHILDREN. STORE YOUR FIREARMS RESPONSIBLY.**
Firearm Safety Rules

■ **ALWAYS keep the firearm pointed in a safe direction.**
This is the primary rule of firearm safety. A safe direction means that the firearm is pointed so that even if it were to go off, it would not cause injury or damage. The key to this rule is to control where the muzzle or front end of the barrel is pointed at all times. Common sense dictates the safest direction, depending on different circumstances.

■ **ALWAYS keep your finger off the trigger until ready to shoot.**
When holding a firearm, rest your finger on the trigger guard or along the side of the firearm. Until you are actually ready to fire, do not touch the trigger.

■ **ALWAYS keep the firearm unloaded until ready to use.**
Whenever you pick up a firearm, immediately engage the safety device is possible. If the firearm has a magazine, remove it before opening the action and looking into the chamber(s) which should be clear of ammunition. If you do not know how to open the action or inspect the chamber(s), leave the firearm alone and get help from someone who does.

When using or storing a firearm, **ALWAYS follow these rules:**

■ **Know your target and what is beyond.**
Be absolutely sure you have identified your target beyond any doubt. Equally important, be aware of the area beyond your target. This means observing your prospective area of fire before you shoot. Never fire in a direction in which there are people or any other potential for mishap. Think first. Shoot next.

■ **Know how to use the firearm safely.**
Before handling a firearm, learn how it operates. Know its basic parts, how to safely open and close the action and remove any ammunition from the firearm or magazine. Remember, a firearm’s mechanical safety device is never foolproof. Nothing can ever replace safe firearm handling.

■ **Be sure the firearm is safe to operate.**
Just like other tools, firearms need regular maintenance to remain operable. Regular cleaning and proper storage are part of the firearm’s general upkeep. If there is any question concerning the firearm’s ability to function, a knowledgeable gunsmith should look at it.
Use only the correct ammunition for your firearm. Only BBs, pellets, cartridges or shells designed for a particular firearm can be fired safely in that firearm. Most firearms have the ammunition type stamped on the barrel. Ammunition can be identified by information printed on the box and sometimes stamped on the cartridge. Do not shoot the firearm unless you have the proper ammunition.

Wear eye and ear protection as appropriate. Firearms are loud and the noise can cause hearing damage. They can also emit debris and hot gas that could cause eye injury. For these reasons, shooting glasses and hearing protectors should be worn by shooters and spectators.

Never use alcohol or over-the-counter, prescription or other drugs before or while shooting. Alcohol, as well as any other substance likely to impair normal mental or physical body functions, must not be used before or while handling or shooting firearms.

Store firearms so they are not accessible to unauthorized persons. Many factors must be considered when deciding where and how to store firearms. A person’s particular situation will be a major part of the consideration. Dozens of firearm storage devices, as well as locking devices that attach directly to the firearm, are available. However, mechanical locking devices, like the mechanical safeties built into firearms, can fail and should not be used as a substitute for safe firearm handling and the observance of all firearm safety rules.

Be aware that certain types of firearms and many shooting activities require additional safety precautions.

Cleaning
Regular cleaning is important in order for your firearm to operate correctly and safely. Taking proper care of it will also maintain its value and extend its life. Your firearm should be cleaned every time that it is used. A firearm brought out of prolonged storage should also be cleaned before shooting. Accumulated moisture and dirt, or solidified grease and oil, can prevent the firearm from operating properly.

Before cleaning your firearm, make absolutely sure that it is unloaded. The firearm’s action should be open during the cleaning process. Also, be sure that no ammunition is present in the cleaning area.
General Description

Our gas piston weapon system operates cooler and does not require oil or lubricant. We are the only AR-15/M-16 manufacturer to offer these features! POF-USA barrel designs reduce heat and weight, and our “Patented” oversized 3.375” oversized heat sink barrel nut design provides strength, rigidity and works as a heat sink to reduce heat. When designing this system, our first priority was to eliminate heat. Our gas piston weapon system design is strong and rigid which helps to eliminate flex in the flat top receiver. As a standard feature on our gas piston weapon system, each part of the operating system is hard chrome plated which makes it easy to clean and maintain. Under rigorous testing, the P-308 and P-415/P-416 rifles incorporates a gas-trap system. The rugged billet look bolt carrier is the heart of the P308 and P415/P416 rifles. No tools are required to disassemble the P-308 and P415/P415 rifles, a simple cartridge is all that needed. Simply turn the gas-plug 90 degrees to remove and clean the gas piston and re-assemble. Remove the bolt carrier assembly, wipe down, put light oil on the carrier, and re-assemble. Our gas piston design also eliminates the chance of losing your optics zero, since we don’t have to remove the hand guard for maintenance of the gas piston. The P308 and P415/P416 recoil is reduced, allowing for smoother and more accurate operation. The P416 system operates at a slower cycle rate of fire in full-auto which makes the weapon more reliable, controllable and accurate.

POF-USA has engineered, manufactured and tested this system. We are extremely proud of the durability and performance of the P-308 and P-415/P-416 gas piston uppers. We have eliminated features of the gas operating system such as gas-rings, gas tube and gas key. The gas piston plug in our weapon system has a 2-position operating mode(s) for (S) Suppressed or (N) Normal. A unique feature in all our POF-USA weapon systems. The P308 and P415/P416 gas piston system also eliminates heat, carbon build-up and gas leaks which can have an adverse effect on the operating system.

All raw materials are manufactured from U.S. steel mills. All heat treats and plating/coatings are completed by U.S. owned and operated manufacturers. All accessory and component parts on weapons systems are from U.S. owned and operated manufacturers. All of our weapon systems are 100% pure American made.
**P308 Specifications**

**Barrel:**
12”, 14.5”, 16.5” and 20” heavy contour, fluted to reduce weight and heat
4150 Mil-B-11595 chrome-moly-vanadium alloy (machine gun rated)
70 Rockwell case hardened heat treated “5R” polygonal barrels are
2 times harder than Mil-Spec & hammer forged barrels
Corrosion resistant and 10 times thicker and harder than Mil-Spec chromed lining
"5R" polygonal right handed 1x10 twist button rifled barrels from Rock Creek Barrels, Inc.
POF-USA muzzle device
Chamber: 7.62 x 51 mm NATO (.308 Win)

**Method of Operation:**
Gas piston operated, rotating bolt (short stroke system)
2-position gas plug for normal (N) or suppressed (S) operating modes
C.R.O.S.™ (Corrosion Resistant Operating System)
Nitrate heat treated: barrel, gas block/tube (billet machined), gas plug
NP3 coated (billet machined), gas piston chromed (billet machined),
bolt carrier assembly NP3 coated (one-piece billet machined),
A3 flattop upper receiver NP3 coated or black anodized and charging handle NP3 coated

**Bolt & Carrier:**
Nickel Teflon plated 8620 integral keyed steel bolt carrier (billet machined),
heat treated/plated per Mil-Spec
Chrome plated bolt, heat treated to Mil-Spec

**Upper Receiver:**
POF-USA M.R.R. Modular Railed Receiver, billet machined 7075-T6 aircraft aluminum alloy,
2-piece upper receiver w/ free floating monolithic top rail, oversized heat sink barrel nut,
A3 flattop: NP3 coated or black anodized, charging handle black anodized

**Lower Receiver:**
P308, GEN III billet machined 7075-T6 aircraft aluminum alloy with integral oversized
trigger guard, ambidextrous bolt release lever machined into the lower receiver
T.I.T.S. (Tactical Integrated Trigger System) 4-5 lb. non-adjustable single stage competition
trigger group
ERGO pistol grip
VLTOR, 6-position retractable buttstock with Mil-Spec tube
NP3 coated or black anodized

**Handguards:**
Ergo ladder rail covers, sling/bi-pod mount
POF-USA M.R.R. Modular Railed Receiver, free floating monolithic top rail, tactical rail
system

**Magazines:**
POF-USA, Bushmaster, C-Products, DPMS, Fulton, JP Rifles, Knights, Remington R-25 and
the original AR-10 waffle magazines

**Sights:**
Fixed removable FTA-2005 hooded, snag free front site assemble and TROY flip up
rear site (both optional)

**Weight:** 8.25 - 9.2 lbs. (Empty)
P415/416 Specifications

**Barrel:**
7.25”, 9.25”, 11.5”, 14.5”, 16”, 16.5”, 18” heavy contour, fluted to reduce weight and heat 4150 Mil-B-11595 chrome-moly-vanadium alloy (machine gun rated)
70 Rockwell case hardened heat treated “5R” polygonal barrels are 2 times harder than Mil-Spec & hammer forged barrels
Corrosion resistant and 10 times thicker and hardness than Mil-Spec chromed lining Chamber: 5.56 mm NATO (.223 Cal.) - “5R” polygonal right handed 1x8 twist button rifled barrels and 6.8 SPC Spec II - “4R” polygonal right handed 1x11.3 twist button rifled barrels from Rock Creek Barrels, Inc.
POF-USA muzzle device for .223 Cal. and FMC-A3 muzzle device for 6.8 SPC II

**Method of Operation:**
Gas piston operated, rotating bolt (short stroke system)
2-position gas plug for normal (N) or suppressed (S) operating modes
C.R.O.S.™ (Corrosion Resistant Operating System)
Nitrate heat treated: barrel, gas block/tube (billet machined), gas plug
NP3 coated (billet machined), gas piston chromed (billet machined),
bolt carrier assembly NP3 coated (one-piece billet machined),
A3 flattop upper receiver NP3 coated or black anodized and charging handle NP3 coated

**Bolt & Carrier:**
Nickel Teflon plated 8620 integral keyed steel bolt carrier (billet machined), heat treated/plated per Mil-Spec, .223 bolt: chrome plated bolt heat treated to Mil-Spec
6.8 SPC bolt: phosphate heat treated to Mil-Spec

**Upper Receiver:**
POF-USA M.R.R. Modular Railed Receiver, billet machined 7075-T6 aircraft aluminum alloy,
2-piece upper receiver w/ free floating monolithic top rail, oversized heat sink barrel nut,
A3 flattop: NP3 coated or black anodized, charging handle black anodized

**Lower Receiver:**
P415, billet machined 7075-T6 aircraft aluminum alloy with integral oversized trigger guard
Ambidextrous bolt release lever machined into the lower receiver
T.I.T.S. (Tactical Integrated Trigger System) 4-5 lb. non-adjustable single stage competition trigger group
ERGO pistol grip
VLTOR, 6-position retractable buttstock with Mil-Spec tube
M4 Plastic hand guard (BP model only)
NP3 coated or black anodized

**Handguards:**
Ergo ladder rail covers,
Sling/bi-pod mount
POF-USA M.R.R. Modular Railed Receiver, free floating monolithic top rail, tactical rail system

**Sights:**
Fixed removable FTA-2005 hooded, snag free front site assemble and TROY flip up rear site (both optional)

**Weight:** 6.4 - 8.2 lbs. (Empty)
Gas Piston Operation & Maintenance

The POF-USA gas piston weapon system with C.R.O.S.™ (Corrosion Resistant Operating System) is available in many configurations. The barrel lengths vary from 7.25 inches to 20 inches and are available with the M.R.R.™ Modular Railed System™, M4-Black Plastic handguards and Modular Railed Receiver for the P-308 rifles. Individual, complete upper receivers are available for use with your semi-automatic AR-15 variant or your registered full automatic M16/M4 variant as a simple drop-on item similar to any other upper receiver. POF-USA gas piston weapon systems are also available as complete weapons including the lower receiver, utilizing our stylish and functional pictogram markings. Complete firearms may only be shipped to those with a current Federal Firearms License (FFL). Upper receivers may only be shipped directly to the individual in most circumstances.

The POF-USA gas piston weapon system is compatible with all standard AR-15/M16/M4 lower receivers. Our system works without the gas tube utilized in the traditional systems, and eliminates the carbon buildup that can be problematic in the area of the bolt, bolt carrier, and trigger group. The gas tube is replaced with a gas piston and an op-rod which contacts our newly designed bolt carrier. In this process, very little gas, heat, carbon and other debris are transferred to the lower receiver meaning a cleaner and cooler running system. The major components of the POF-USA gas piston upper receiver has been coated with an electroless Nickel finish which creates an extremely smooth and slick surface, and requires little or no lubrication for normal operation. This coating, combined with the cleaner and cooler running internal parts allows this weapon system to perform in elements never before thought possible.

The bolt carrier of the POF-USA gas piston upper receiver has been machined specifically for this system and is not simply an adaptation or conversion from a standard bolt carrier. Our proprietary bolt carrier provides an element of strength and reliability not found in other weapon systems. The bolt is a standard M16 bolt without the traditional gas rings as they are no longer necessary. It is, however, coated with our electroless Nickel finish to match the remaining components. The POF-USA gas piston weapon systems is shipped fully assembled and after a brief inspection it is ready to fire. After making certain the firearm is unloaded and no magazine or ammunition is present, check the bore for obstruction before firing any gun for the first time. To inspect, clean and maintain the gas piston and op-rod depress the release button on the left side of the gas block (fig. 1). With the button depressed, rotate the gas plug 90 degrees, clockwise and pull straight out removing the gas plug completely (fig. 2). With the gas plug removed, tip the rifle with the muzzle down and the gas piston will slide out freely (fig. 3). With the gas plug and gas piston removed the op-rod may then be removed. Again, slightly tilt the firearm towards muzzle end and the op-rod will slide out freely (fig. 4). Completely remove the op-rod and the gas system is now disassembled. Simply reassemble in the reverse order.
Gas Piston Operation & Maintenance

If disassembling the gas system after heavy shooting or after a long period of inattention, light carbon deposits may create a situation where the gas plug may be difficult to turn after depressing the button. If this is the case, press the release button and insert the rim of a standard 5.56x45mm (.223 Cal.) and 7.62mm (.308 Win.) NATO round into the slot in the plug and turn clockwise as usual. This will assist you with additional leverage make it a simple task (Fig. 5a and 5b). You can utilize the strength of the recoil buffer spring to assist you in removing the plug. Making sure the firearm is unloaded and there is no ammunition present, place your left hand on the gas plug and with your right hand, pull the charging handle to the rear and release it as though charging the firearm. After a few returns of the recoil spring, the gas plug will slide out and the system may be maintained as usual.
Bolt Group Operation & Maintenance

The bolt carrier group is very similar to a standard M16 bolt carrier but THE POF CARRIER IS NOT INTERCHANGEABLE. On the POF-USA gas piston weapon, the surface area on the bolt carrier that impacts the op-rod is machined from the same material as the bolt carrier and is not an “add-on” component (fig. 6). This has been done for strength and to ensure maximum reliability with a minimal amount of ware. To disassemble the bolt group, first remove the firing pin retaining pin by pulling through the left side of the carrier (fig. 7). Next, remove the firing pin from the rear of the bolt and carrier by tipping the carrier rearward (fig. 8). The pin should slide out the back of the bolt carrier. After removing the firing pin, the bolt cam pin can be removed from the top of the bolt carrier (fig. 9). Next, remove the bolt by pulling straight out the end of the bolt carrier (fig. 10). (The field stripped bolt carrier group can be seen in fig. 11). A-Bolt Carrier * B-Bolt * C-Bolt Cam Pin * D-Firing Pin Retaining Pin * E-Firing Pin).

The bolt is similar to a standard M16 bolt with the exception of the gas rings that are not necessary in the POF-USA gas piston weapon system (fig. 12). The bolt is disassembled and maintained in the same manner as a standard bolt. To remove the extractor for cleaning and inspection, push the extractor-retaining pin with the tip of the firing pin while lightly depressing the extractor spring from the bolt. This area should be clean and free of debris. If extraction is a problem, a new extractor spring (fig. 14) may be necessary. A D-Fender D-Ring from MGI military may also solve any potential extraction problems and is available at www.mgi-military.com (The disassembled bolt including the extractor, extractor spring and extractor retaining pin can be seen in fig. 15). A-Bolt * B-Extractor Retaining Pin * C-Extractor * D-Extractor Spring). Reassemble the bolt and the bolt carrier in the reverse order.
The P308 and P415 are gas operated semi-automatic firearm. The P-416 is a full automatic variant available to military, law enforcement and Class III dealers only. Unlike other similar rifles, the POF-USA weapon system uses a gas piston and op-rod to operate the action. Because residual gasses and debris are expelled at the front of the firearm and not in the bolt carrier and trigger group, this provides a cleaner and cooler action, resulting in less fouling and more reliability with less maintenance.

To begin the firing sequence, a loaded magazine is placed into the magazine well (fig. 16). Utilizing the charging handle (fig. 17), the bolt carrier is pulled rearward and allowed to slam forward stripping a round from the magazine and loading it in the chamber. When the firearm is placed on “FIRE” and the trigger is squeezed, the hammer drops striking the firing pin. As the round is fired, the bullet passes down the barrel at a high rate of speed. The residual gasses behind the bullet are chambered into the gas trap as the bullet passes by and start the gas piston traveling rearward. The gas piston pushes the op-rod which in turn pushes the bolt carrier rearward. As the bolt carrier travels rearward, the fired casing is extracted from the chamber and ejected out the ejection port. The ejection port has a dust cover that can remain closed until firing and will automatically open either when the gun is charged or fired. The hammer is again cocked during this rearward travel of the bolt carrier. As the bolt carrier returns forward, a new round is stripped from the magazine and chambered, and the op-rod and gas piston returned to their starting position, beginning the firing process all over again.

The lower receiver of the P415/P416 and P308 firearms function identically to the standard AR-15/M16/M4 firearms are are utilized and maintained in the same way. The P415/P416 is chambered in .223 Remington (5.56 x 45 mm) and utilize standard AR-15/M16/M4 style magazines. The P415 6.8 (semi-automatic) upper receiver is chambered in 6.8 SPC Spec II. The upper receiver of the P308 (semi-automatic) firearms function identical to AR-15 rifle platform. It is chambered in .308 Win (7.62 x 51 mm) and utilize standard POF-USA, Bushmaster, C-Products, DPMS, Fulton, JP Rifles, Knights, and the original AR-10 waffle magazines.
Very little maintenance is required when utilizing the POF-USA gas piston weapon system to the unique method of operation and construction. When general maintenance and cleaning is necessary it is an easy task requiring no tools. Field stripping your P308, P415/P416 begins with making certain the firearm is unloaded and no live ammunition is present. Remove the magazine and re-check the chamber to be certain it is unloaded. Return

the bolt carrier to its forward position. Using the tip of your finger, depress the rear takedown pin located above the pistol grip on the left side of the receiver (fig 19). After pushing through far enough to field-strip the firearm, it will be held captive on the right side and will not slide all the way out. Next, push the front takedown pin in the same manner located above the magazine-well and also on the left side of the firearm (fig. 20). At that point, the upper receiver can be separated from the lower receiver. Slowly pull the charging handle to the rear and remove the bolt carrier sliding straight out from the upper receiver (fig 21). The charging handle can also be removed after the bolt carrier is removed by placing a downward pressure on it as it is pulled rearward. The buffer and buffer spring may be removed from the lower receiver by depressing the buffer retaining pin (fig 22) and allowing the buffer and spring to ride over it while depressed. This is easiest to accomplish while the hammer is in “cocked” position (fig. 23). The hammer may be placed in a relaxed “fired” position after removing the buffer and buffer spring by holding it down at the same time the trigger is squeezed and allowed to slowly move forward. The rifle can now be cleaned and lubricated and resassembled in the reverse order. (The field stripped rifle can be seen in fig. 24).
P308, P415/P416 Field Stripping

FIG. 22

FIG. 23

FIG. 24
The P415/P416 rifles and upper receivers are available with the Predator™ Tactical Rail System. The P308 rifles and upper receivers are available in Modular Railed Receiver (MRR). This unique system is machined from a solid piece of aluminum and provides an unparalleled platform for mounting optics, grips, lights, bi-pods and any of numerous other accessories available today. The barrel remains completely free-floating and our proprietary barrel nut even works as a heat-sink to keep chamber and barrel temperatures cooler than with standard upper receivers. To disassemble the Predator™ Rail System X Series, you must remove the two allen-head screws located on the sides of the system parallel with the barrel nut located at the 3-o’clock and 9-o’clock positions (fig. 25a and 25b). The SX rail series allen-head screw is located at the bottom of the rail in 6-o’clock position (fig. 25c). Next, remove the two Allen-head screws located on the top of the system at the 12-o’clock position directly above the barrel nut (Fig. 26). After removing those top screws, you will notice there are two more screws unders the first ones. The second set of screws are holding the barrel nut spacer in place and must also be removed as well (fig. 27).
Predator Rail System™

Removed the allen-head screw at the top rear of the system immediately above the charging handle (fig. 28). At this point, grasp the upper receiver in the forward assist area and slide the Predator™ Rail System to the front (fig. 29). The upper receiver will now be separated from the Predator™ Rail System (fig. 30). To reassemble the Predator™ Rail System, replace the barrel nut wedge to barrel nut (fig. 31). Slide the rail back over the upper receiver (fig. 32). Install the tapered allen-head screw on (fig. 33) to the rear of the rail but do not tighten all the way. Add the allen screw to the barrel nut wedge until it touches the ball bearing (fig. 35). Next, torque the Tapered Allen-head screws to 25-inch lbs. (fig. 36 and fig. 37). Add the two top cap screws to the barrel nut wedge and tighten to 25-inch lbs. (fig. 38 and fig. 39). Finally, tighten bottom allen screws until flush with the rail (fig. 40).
WARRANTY POLICY:
■ POF-USA firearms have a 3-year limited warranty.

■ POF-USA firearm is warranted to the original retail customer for 3 years from the date of purchase against defects in material and workmanship. All parts and labor or replacement at our option are covered.

■ Shipping to and from our repair facilities, government fees, damage caused by failure to perform normal maintenance, sales outside the United States, damage due to high velocity, high pressure, reloaded, or other non-standard ammunition, or any unauthorized repair, modification, misuse, abuse, or alteration of the product is not covered by this limited warranty.

■ Any implied warranties, including the implied warranties of merchantability and fitness for a particular purpose, are limited to 1 year from date of purchase. Consequential or incidental damages and/or expenses, or any other expenses are not covered by this warranty.

■ To obtain warranty performance, please call 623-561-9572 or email sales@pof-usa.com.

RETURN POLICY:
■ POF-USA Patriot Ordnance Factories, INC. offers a 30-day Return Policy. If your are not satisfied with the product, simply return it for a full refund (less shipping cost). You will need to fill-out and submit an RMA (Return Merchandise Authorization) form and include in the package prior to returning the product.

■ You will need to email sales@pof-usa.com or call us at 623-561-9572 to obtain an RMA number prior to returning the product. You can also download the RMA form at www.pof-usa.com. Complete the form and include it with your shipment. There is a 15% restocking fee will be charged on all returned merchandise.

ALTERATION & MODIFICATION WARNINGS:
■ Altering or modifying parts is dangerous and will void the warranty. This POF-USA rifle was manufactured to perform properly with the original parts as designed. It is your duty to make sure any parts you buy are made for this rifle and are installed correctly and that neither the originals nor the replacements are altered or changed. Your POF-USA rifle is a complex precision tool with many parts that must relate correctly with other parts in order for proper and safe operation. Putting a rifle together wrong or with incorrect or modified parts can result in a damaged rifle, serious personal injury or death to you and others through malfunction. Always have a qualified gunsmith work on your rifle or at least check any work not performed by a gunsmith.
P308, P415/416
WEAPONS SYSTEM
OWNERS MANUAL