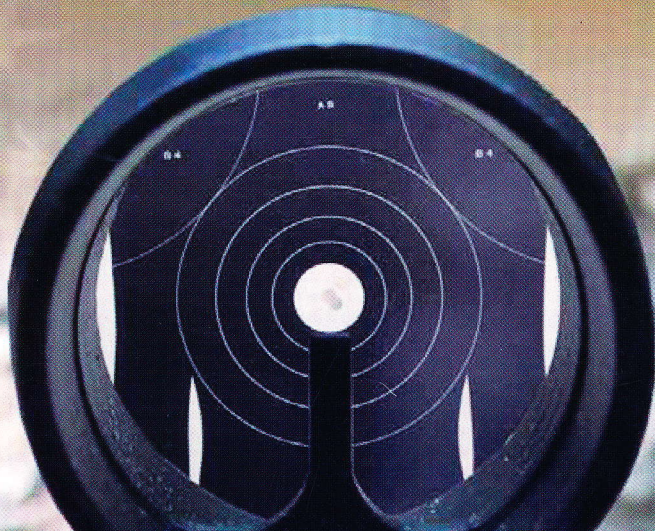


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PTR 91 INC.



**PTR-91 SERIES**  
PRECISION  
TACTICAL RIFLE

Made in the USA

## GENERAL SAFETY GUIDELINES

Firearms can be very dangerous if misused. When purchasing a firearm you assume a great responsibility for its use, storage and transportation. Listed below are guidelines that should be strictly observed..

1. Handle all firearms as if they are loaded.
2. Be thoroughly familiar with the firearm before firing.
3. Keep your fingers off the trigger until you are on target and have decided to fire.
4. Be sure of your target and what is beyond it, including the backstop. Make certain shots fired present no safety hazard for yourself and others.
5. Never allow anyone to use your firearm who is not completely familiar with its operation.
6. When the firearm is not in use or being stored make certain it is unloaded. Secure all firearms and ammunition from access by unauthorized persons, especially children. A locked container and/or trigger lock or like device are recommended to prevent unauthorized use.
7. Always use eye and hearing protection when shooting any firearm or when near operating firearms.
8. In the event of a misfire (hangfire) keep the muzzle pointed in a safe direction. Wait approximately 30 seconds before opening the action. Discard the faulty cartridge and inspect the bolt, chamber, and bore for damage or obstruction before firing is resumed.
9. Clean the area after each shooting session. Do not leave behind spent casings, empty cartridge boxes, or bullet ridden targets.

## WARNING

PTR-91 Rifles are shipped with firearms safety manuals from the NSSF and a trigger lock for your safety and protection. Please read and follow these instruction manuals when using the PTR-91 Rifle.

This firearm is rugged, well constructed and, when properly used, reliable. It is nonetheless a mechanical device and, as such, is subject to all potential problems and errors of any mechanical device. As a firearm, it can be very dangerous if misused or operated improperly. It is wise to exercise due care and caution before placing the firearm into service.

Reading and following the instructions below, and the directions and warnings in this manual are a good first step. Please do not hesitate to seek professional assistance or instruction if you are at all unsure about proper and safe handling of any firearm.

### **Before operation of any firearm, the following steps are good safety measures:**

1. Make certain there are no obstructions in the bore.
2. Be completely familiar with the proper operation of the firearm, especially the safety features.
3. Use only clean ammunition of the correct type, caliber, and load. Do not use hand loaded or re-loaded ammunition.
4. When a firearm is not in service, it should be secure from unauthorized persons (especially children) in a locked container and/or by means of a trigger lock or like device

**PTR 91 Inc.** takes great pride in announcing the introduction of the Precision Target Rifle Model 91 to the American market. This rifle is manufactured in the United States and complies with all 922 regulations. We have gone to great lengths to produce the most up-to-date rifle on the market today!

## PTR-91 SPECIFICATIONS

**Caliber:** 7.62mm NATO (.308 Win.)

**Operating Principle:** Recoil operated

**Locking System:** Delayed roller-lock

**Action:** Semiautomatic only

**Feeding:** 20-round box magazine

**Construction:** Receiver-stamped; barrel-button rifling

**Overall Length:** 40 inches (Rifle) 38 inches (Carbine)

**Barrel Length:** 18 inch heavy barrel (Rifle) 16 inch heavy barrel (Carbine)

**Sight Radius:** 22.52" (Rifle) 20.52" (Carbine)

**Weight:** Weight without magazine 9.17 lbs. (4.16 kg)

**Sights:** Rotary style sight with 4 adjustments, adjustable for windage and elevation. (100, 200, 300, and 400 yards)

**Front:** Protected post

## RECOMMENDED CLEANING PROCEDURES

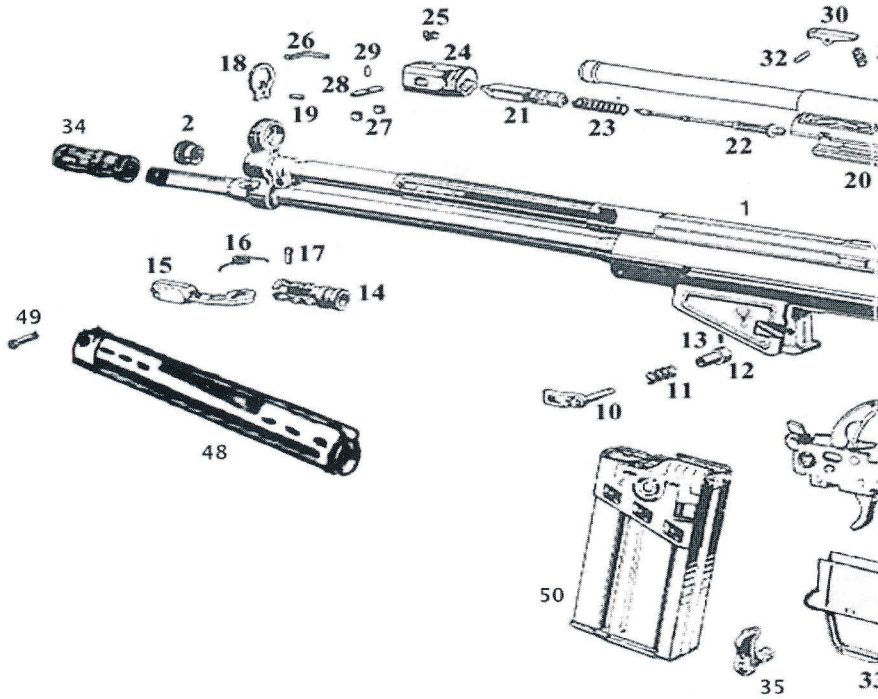
1. Basic cleaning after use (with rifle field stripped):
  - Use the bore brush to clean all residues from the barrel, visually checking the barrel regularly. A lightly oiled cleaning patch or piece of clean flannel cloth might help remove all dirt or grime. If an oiled cleaning patch is used, complete the cleaning process with a clean, dry patch or a dry rag.
  - Follow the above procedure to clean the chamber, using the chamber brush rather than the bore brush.
  - Using a clean, lightly oiled rag, thoroughly clean the bolt assembly, the rear part of the barrel and inside the receiver. Dry them after they are cleaned.
  - Finish the whole cleaning process by lightly oiling all moving parts with a good quality lubricating gun oil.
2. Complete barrel cleaning (the barrel requires special periodic attention):
  - We do not recommend the use of corrosive ammunition with these rifles. But, if you use corrosive ammunition, wash the barrel with soapy water to protect the bore from corrosive powder residue, using a solution of approximately 15% no-acid soap. Bore solvent can also be used. Be sure to keep soapy water out of the mechanism.
  - Dry thoroughly with a clean flannel rag.
  - Dry outside of the barrel with another rag.
  - If the barrel is to be stored for any length of time, barrel grease should be applied to the bore after cleaning.
3. Cleaning before use:

Before firing your rifle, it should be cleaned again to remove excess oil from all parts.

**Suggestions:** We recommend the use of only high quality bore solvent, lubricants, and other cleaning aids.

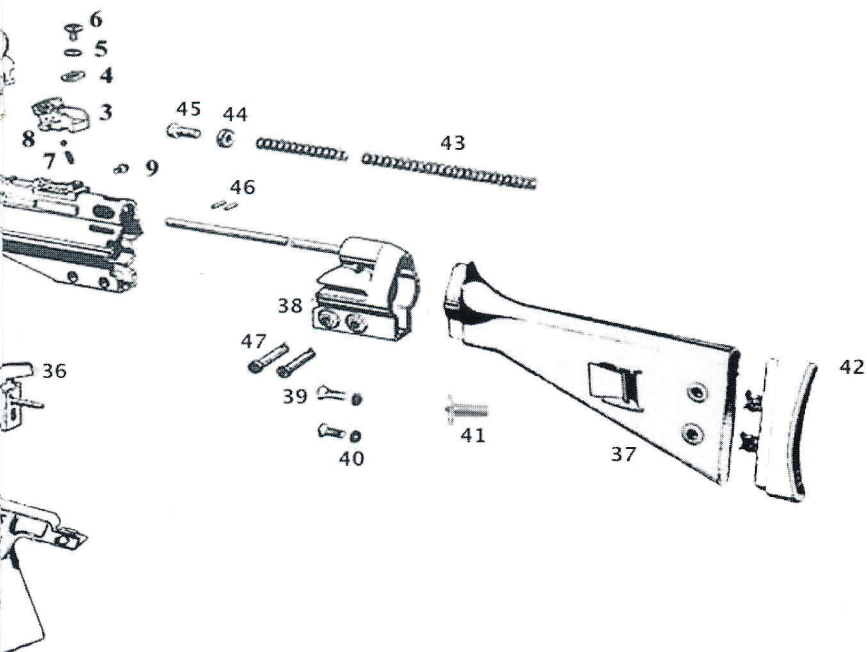
**NOTE:** The magazine should not be stripped or cleaned unless it has been subjected to excessive amounts of sand, grit or dampness.

# PTR-91 RIFLE EXPLODED VIEW AND PARTS LIST



1. Receiver with barrel and cocking lever housing
2. Cap complete
3. Rotary rear sight
4. Washer
5. Toothed lock washer
6. Clamping screw
7. 2 Compression springs for ball catch
8. 2 Balls
9. Windage adjusting screw
10. Magazine catch complete
11. Compression spring for magazine catch
12. Push button for magazine catch
13. Clamping sleeve
14. Support for cocking lever
15. Cocking lever

16. Elbow spring for cocking lever
17. Cocking lever axle
18. Front sight
19. Clamping sleeve
20. Bolt head carrier
21. Locking piece
22. Firing pin
23. Firing pin spring
24. Bolt head, complete
25. Extractor
26. Extractor spring
27. Locking roller
28. Holder for cocking rollers
29. Clamping sleeve 2 x 6.9
30. Bolt head locking lever
31. Compression spring for bolt head locking lever



- 32. Cylindrical pin
- 33. Pistol grip
- 34. Flash hider
- 35. Safety, complete
- 36. Trigger housing, complete
- 37. Butt stock
- 38. Back plate, complete
- 39. Countersunk screw for buffer
- 40. Lock washer
- 41. Recoil Buffer
- 42. Butt plate
- 43. Recoil spring
- 44. Recoil spring guide ring
- 45. Recoil spring stop pin
- 46. 2 riveted pins
- 47. Butt stock locking pin

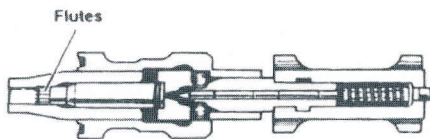
- 48. Handguard
- 49. Handguard locking pin
- 50. Magazine 20 rounds



# GENERAL OPERATION

The PTR-91 rifle operates on a delayed blow back principle, one of the safest and most reliable semiautomatic actions currently in use.

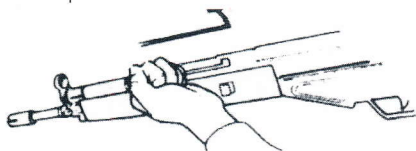
When the cartridge is fired, the thrust of the cartridge case drives the bolt backwards, but the backwards movement is delayed by the mechanical arrangement of the bolt until the pressure has dropped to a safe limit. However, there is a slight rear movement of the fired cartridge case. To minimize this movement and to prevent ruptured cartridge cases, the front of the chamber is fluted (see illustration) to allow propellant gases to leak rearward along the cartridge case to aid in the extraction of the fired case. Cartridge cases fired from these rifles are readily identifiable by the well-defined gas marks or slight grooves that extend about halfway down the case.



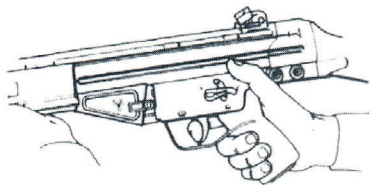
## DISASSEMBLY PROCEDURES

### (Field Stripping)

1. Before beginning disassembly, remove all slings, scopes and scope mounts.

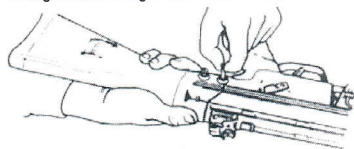


2. Remove the magazines and set the selector lever on "S" or "Safe"; then check the rifle to make sure it is unloaded. To inspect the rifle, unfold the cocking handle located on the left side of the rifle at the front of the handguard and pull the cocking handle towards you (rearward); then rotate the handle upward in to the retaining notch located near the back of the bolt. When inspection is completed, pull the cocking handle slightly rearward and rotate it downward out of the retaining notch; then release the

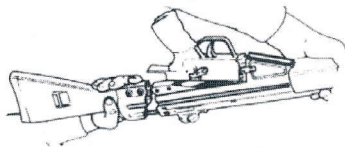


handle to allow it to return to forward position. Then point the muzzle in a safe direction, rotate the selector lever to "F" or "Fire" and depress the trigger to allow the bolt to return to its closed or fired position. Rotate the selector back to "Safe" before proceeding.

3. Remove the two takedown pins located just forward of the stock. No tools should be required to push the pins through from the right side to the left side of the rifle.



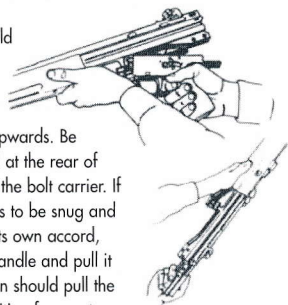
4. The butt stock and driving spring should now remove easily by pulling the butt stock straight back to the rear; the entire butt stock assembly will come out as a unit.



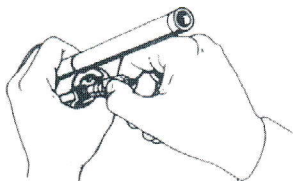
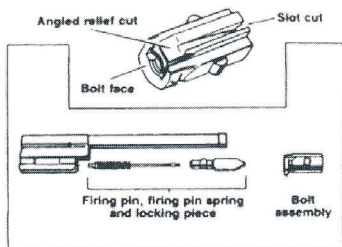
5. With the butt stock assembly removed, you can remove the entire trigger group by pulling downward on the pistol grip.

6. The bolt carrier should slide out of the rear of the receiver easily by merely tipping the muzzle upwards. Be

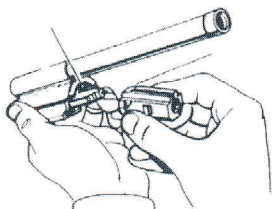
sure to place a hand at the rear of the receiver to catch the bolt carrier. If the bolt carrier seems to be snug and will not slide out of its own accord, unfold the cocking handle and pull it rearward. That action should pull the bolt carrier into position for you to grasp it and remove it from the receiver. An excessively dirty rifle might also necessitate this action to remove the bolt carrier.



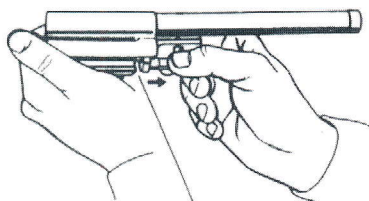
7. To disassemble the bolt assembly, first turn the bolt head one half turn counterclockwise and pull it forward out of the carrier. Then slowly rotate the locking piece counter clockwise until its lug clears the carrier. You can now remove the locking piece, firing pin, and spring as a unit. No further disassembly of the rifle is either necessary or recommended beyond this point. Any repair or maintenance procedure that requires further disassembly of the rifle should be referred to a qualified gunsmith.



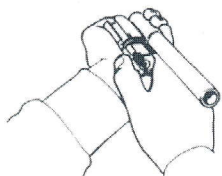
1. Insert the firing pin, firing pin spring, and locking piece into the bolt head carrier. Depress the locking piece into the carrier, and turn it one-quarter turn clockwise.



Insert the bolt head onto the locking piece, making sure the slot cut on the bolt head is at the top. Turn the bolt head slightly clockwise until the angled relief cut at the base of the bolt head is aligned with the bolt head-locking piece.



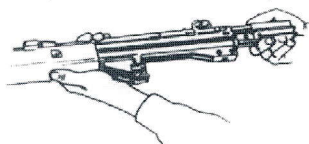
Push the bolt against the locking lever until the base of the bolt is touching the bolt carrier with the thumb and the index finger, squeeze the bolt rollers into each other, this will move the bolt assembly forward.



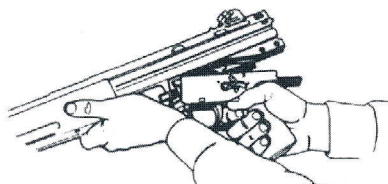
## ASSEMBLY PROCEDURE

Grasping the carrier and bolt assembly firmly, turn the bolt clockwise until the slotted relief on the bolt is at the bottom position. Once again squeeze the bolt rollers to be sure they are in the fully depressed position. The bolt carrier and the bolt assembly may now be inserted into the receiver.

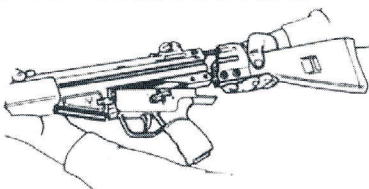
2. Check to be certain the operating handle is in the forward position. Then insert the complete bolt carrier assembly into the receiver as far as possible.



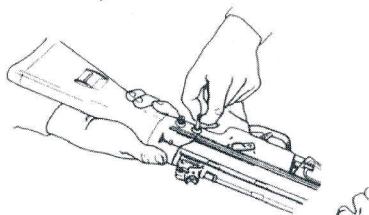
3. Reinstall the trigger group by first inserting the front of the trigger group, then rolling the rear end with the pistol grip into position.



4. Slide the butt stock back into place over the rear of the receiver, with the driving spring properly positioned in its recess in the bolt carrier.



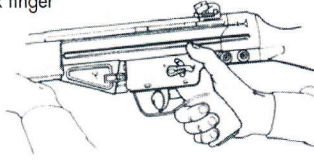
5. Insert the two takedown pins in their proper holes from left to right at the rear of the receiver. The rifle is now fully assembled.



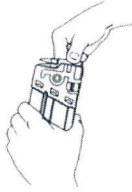
6. Reattach all slings, scopes and scope mounts.

## USE OF THE PTR-911

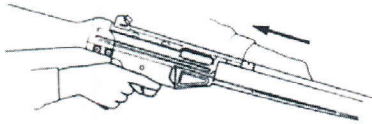
1. Before preparing to use the rifle, first make sure the selector lever on the left side of the receiver is in "S" or "Safe" position. While using the rifle, the selector lever can be easily manipulated with the thumb of your right hand if you are right-handed or the index finger of your left hand if you are left handed.



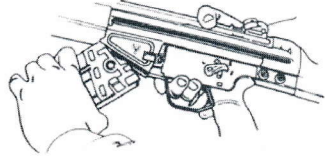
2. To load the magazine, hold the magazine in either hand and use the other hand to place the first round on top of the magazine follower. Make sure the bullet end faces towards the front of the magazine. Then apply pressure with the thumb to fully seat the round in the magazine. Place additional rounds in the magazine up to twenty rounds following the same procedure as the first round.



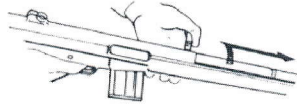
3. Check again to make sure the safety lever is on "S" or "Safe" position, and then point the rifle in a safe direction. You may now cock the rifle by pulling the cocking lever rearward with your hand and engaging it in the cocking lever notch.



4. Insert the magazine into the magazine well. The magazine should be inserted, front end first with a slight bottom-forward cant, then rolling the rear of the magazine back into place. When the distinctive "click" of the magazine catch is heard, the magazine is engaged.



5. When the magazine is properly inserted in the magazine well, press the cocking lever with the thumb of your left hand to disengage it from the retaining notch. The bolt carrier will now travel into battery with its own spring tension. Do not touch the cocking handle as it travels forward into battery. The rifle is now cocked, and the first round is loaded in the chamber. Keep the safety lever on "S" or "Safe" until you are ready to fire.



6. Adjust the rear sight for windage as described in this manual.
7. Raise the rifle to the shooting position. Then choose your sight picture, move the selector lever to "F" or "Fire" position, and squeeze the trigger. Successive shots do not require recocking the rifle; they will cycle semi automatically. **CAUTION**, never point or aim the rifle in a direction that is unsafe to shoot, or at an object or surface that might cause the bullet to ricochet. Always wear proper eye and ear protection.

**NOTE:** When the last round has been fired, the bolt will remain in battery (closed) instead of returning to an open bolt position.

**NOTE:** When you are finished shooting: always engage the safety, remove the magazine by using the magazine release located on the right side of the receiver, and clear the rifle by pulling back on the cocking lever then releasing it quickly to allow it to return to its normal forward position.



## USE THE THE REAR SIGHT

### 1. Windage adjustment:

Using a Phillips head screwdriver, loosen the rear clamping screw.

Fig. 1

If the bullet's point of impact is too far left, turn the adjusting screw counterclockwise with your fingers.

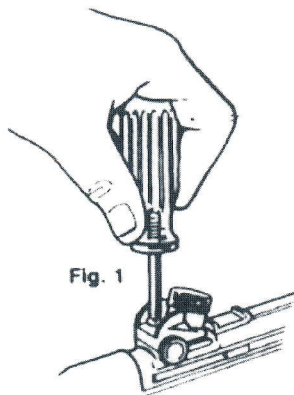
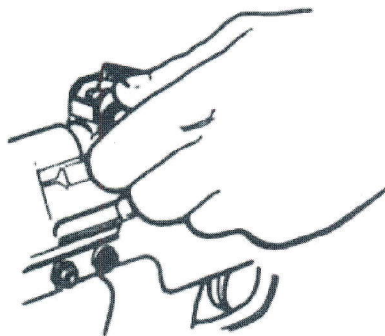
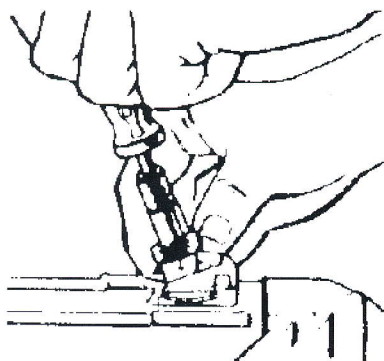


Fig. 2

If the point of impact is too far right, rotate the screw clockwise. Upon completing the desired adjustment, tighten the clamping screw.



**NOTE:** One revolution of the adjusting screw moves the point of impact 5.14 inches at 100 meters.



**Elevation adjustment:** Insert elevation adjustment tool into the rear sight cylinder so that the wedges of the tool engage the two slots in the cylinder which contain the catch bolts. Press Phillips-head screwdriver downward into the adjustment tool and hold firm. Turn rear sight cylinder manually in the desired direction. Turning clockwise lowers the point of impact 3.3 cm (1.29 in.) per clicks 100 m (1009 yards), turning counter-clockwise raises is correspondingly. After correction withdraw Phillips-head screwdriver and remove elevation adjustment tool. The catch will re-engage in the slots. After performing elevation set the desired aperture again.

# PRECISION TARGET RIFLE, MODEL 91 IMPROVEMENTS

All parts are manufactured to original German military specifications.

Receivers are manufactured from (.059) steel. Original Military bases, mounts and scopes will fit this rifle.

Fitted with a high quality, heat treated steel, heavy barrel.

A brand new laser-cut and heat-treated front sight. There is also a brand new, high quality knurled aluminum end cap.

Sold with a 20 round magazine, the rifle will also accept a 5 and 10 round box magazine.

Manufactured from high quality polymer, the sturdy, attractive furniture consists of a pistol grip and stock.

Handguard is hard anodized aluminum.

The finish on this rifle is a two-step process; parkerized and powder coated with a scratch resistant black matte finish that gives excellent protection from abrasion in the field.

PTR 91 Inc. provides a full year warranty on this rifle, the rifle comes in a hard case, trigger lock included.

We are very confident that all discriminating shooters and collectors will find this rifle a highly desirable addition to their collection, proving itself on the range and in the field, time after time. You will be as proud as your PTR-91 as we are.

MADE IN THE USA

## TROUBLE SHOOTING GUIDE

Problem	Possible Cause	Suggested Action
1) Bolt moves but does not load a cartridge	a) Magazine loose or not properly inserted B) Magazine dirty or deformed	a) Reinsert magazine and check magazine catch b) Insert different magazine
2) Empty cartridge case not extracted or ejected	a) Dirty chamber b) Broken extractor or ejector spring or defective ejector	a) Clean the chamber b) Repair required by PTR 91 Inc. or by qualified gunsmith
3) Cartridge will not ignite	a) Bad cartridge primer b) Broken or shortened firing pin	a) Cock and chamber new cartridge b) Repair required by PTR 91 Inc. or by qualified gunsmith
4) Bolt will not close completely	a) Dirty chamber b) Dirty barrel extension c) Deformed cartridge d) Defective recoil spring	a) Clean the chamber b) Clean the barrel extension c) Cock and chamber new cartridge d) Repair required by PTR 91 Inc. or by qualified gunsmith
5) Rifle fires irregularly or misfires sporadically	a) Defective ammunition b) Magazine loose or improperly inserted c) Magazine dirty or deformed d) Dirty chamber	a) Use different ammunition b) Reinsert magazine and check magazine catch c) Insert different magazine d) Clean the chamber





## **PTR 91 Inc.**

*formerly known as JLD Enterprises*

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