

BFG-50A RIFLE OPERATOR'S MANUAL

**WARNING! READ THIS MANUAL CAREFULLY
BEFORE USING THIS FIREARM**



SERBU
FIREARMS, INC



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SAFETY

You must read, understand, and follow all instructions in this manual before loading, firing or disassembling this firearm.

If you do not understand any part of this manual or you are unsure about the operation of your firearm, contact Serbu Firearms at (813) 243-8899 before proceeding.

This manual provides instructions on operation and maintenance of the BFG-50A made by Serbu Firearms. The safety of yourself and those around you depends on your knowledge of the firearm and safety guidelines common to all firearms.

SAFETY ALERT SYMBOL AND SIGNAL WORDS

The safety information in this manual is denoted by the safety alert symbol: . The level of risk is indicated by the following signal words:

DANGER

DANGER - Indicates a hazardous situation, which, if not avoided, WILL result in death or serious injury.

WARNING




WARNING - Indicates a hazardous situation, which, if not avoided, could result in death or serious injury.

CAUTION

CAUTION - Indicates a hazardous situation, which, if not avoided, could result in minor or moderate injury.

NOTICE

NOTICE - Indicates a situation that could result in damage to the equipment or other property.

-  The safe use of a firearm is your responsibility. You must protect yourself and others against injury or death from misuse of a firearm.
-  Always treat every firearm as if it were loaded.
-  Do not drop a firearm. It may discharge on impact.

SAFETY

- ⚠ Always point firearm in a safe direction.
- ⚠ Keep finger off trigger until ready to fire.
- ⚠ Firearm must be unloaded when not in use. Unload firearm before storing it, traveling, laying it down or entering a vehicle or building. Load firearm only when ready to fire. Unload firearm as soon as you are finished shooting.
- ⚠ Never climb a tree or cross obstacles such as streams, creeks or fences with a loaded firearm.

Always verify that a firearm is unloaded. Do not take anyone's word that a firearm is unloaded. Never pass your firearm to another person until you have visually checked that it is unloaded. Keep your firearm unloaded and safely stored when not in use.

- ⚠ Never rely on a firearms' mechanical features alone. Only your safe handling will ensure the safe use of a firearm. A mechanical safety is not a substitute for common sense.
- ⚠ Before using a stored firearm, verify firearm is completely unloaded, and check barrel for obstructions, debris, or excess oil. Never allow water, snow, mud or other materials to enter barrel. Excess lubricants or grease can dangerously increase pressure and may cause barrel to burst when firing. If barrel is obstructed, remove ammunition and clean barrel immediately.
- ⚠ Use only the correct caliber and cartridge for your firearm. Never use incorrect ammunition. Never use remanufactured or reloaded ammunition. Use only quality undamaged ammunition in your firearm. Always read and follow instructions on ammunition box. Do not use firearm if you have any doubt as to the caliber or cartridge firearm is designed to use.
- ⚠ Safely store and secure firearm and ammunition separately.
- ⚠ Be sure of target and surrounding area. Never fire unless you know exactly where your shot is going and what it will strike. Make sure shot has a safe back stop, such as a hillside or sand. Bullets can ricochet on surfaces such as water. Do not fire into the sky.
- ⚠ Always wear appropriate eye and ear protection while firing a firearm. Be sure others in vicinity have protection. Persons without eye and hearing protection must be beyond a 10-yard radius of muzzle when firearm is fired.
- ⚠ Obey all laws regarding the storage, security, transportation and carrying of firearms. You must be familiar with all local, state, and federal laws regarding the safe use, storage and/or transportation of your firearm.

SAFETY

- ⚠ Discharging firearms in poorly ventilated areas, cleaning firearm and handling ammunition may result in exposure to lead and other substances known to cause birth defects, reproductive harm, cancer, and other serious physical injury. Wash hands thoroughly after exposure. Read warnings and labels of all ammunition and cleaning products carefully.
- ⚠ Be sure all accessories are compatible with your firearm. Accessories must not interfere with the safe operation of a firearm.
- ⚠ This manual must accompany this firearm and be transferred with it upon change of ownership or when presented to another person.
- ⚠ Never use drugs or alcohol before or during use of a firearm. Never use a firearm if you are taking any medication which impairs your mental or physical ability.
- ⚠ Never alter or modify a firearm. Never disassemble firearm beyond what is outlined in this manual. Have a qualified, experienced gunsmith service, repair or modify your firearm.
- ⚠ Understand all operational aspects of the firearm before handling. Every firearm is different. Before using firearm, read and follow this manual.

Familiarize yourself with all mechanical features of firearm. If you do not understand any part of this manual or have any questions about the safe operation of your firearm, contact Serbu Firearms at (813) 243-8899.

Serbu Firearms is not responsible for any physical injury or death, property damage, or damage to a firearm resulting in whole or in part from:

- Disregarding safety guidelines.
- Intentional or negligent discharge or firing of the firearm.
- Improper or careless use or handling of the firearm.
- Unauthorized modifications or repairs to the firearm.
- Defective, improper, non-standard, remanufactured or reloaded ammunition.
- Neglect of the firearm or other causes beyond the control of Serbu Firearms.

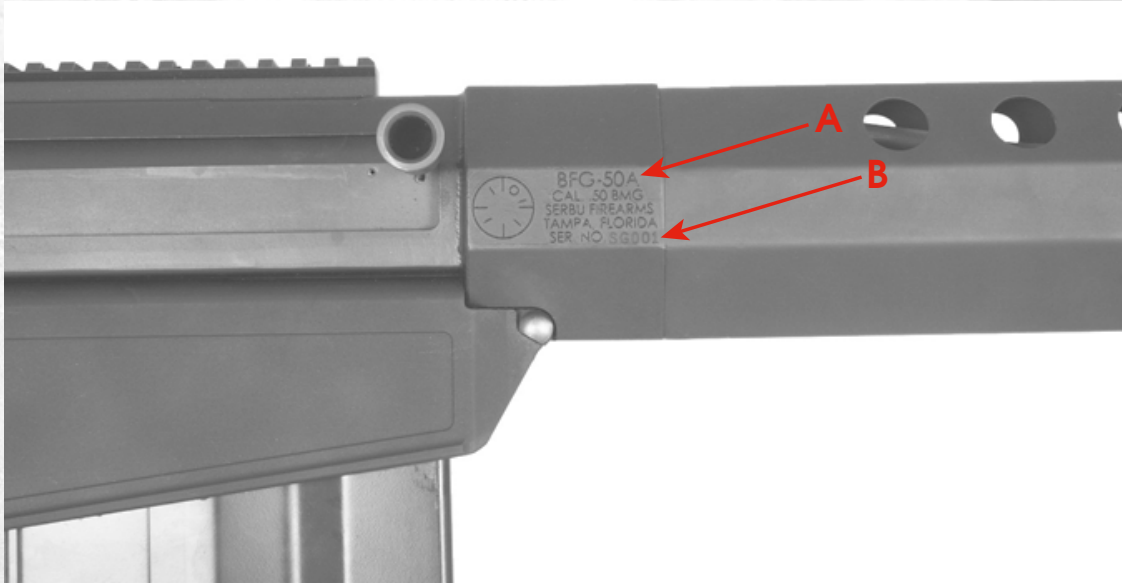
TECHNICAL DATA

SPECIFICATIONS	
Caliber	.50 BMG
Barrel	26 in. Chrome Moly, Nitrided, Serbu Accuracy Chamber, 1:15 Twist
Weight	23 lbs (Unloaded)
Action	Gas Operated Semi Automatic, 3-Lug Rotating Bolt, Hammer Fired, 11 Millisecond Lock Time
Recoil Attenuation	Muzzle Brake, Thick Buttpad, Hydraulic Buffer
Receiver Construction	Alloy Steel, Nitrided
Magazine	Standard M-82 / M-107, 10-Round Capacity
Overall Length	51.5 in.

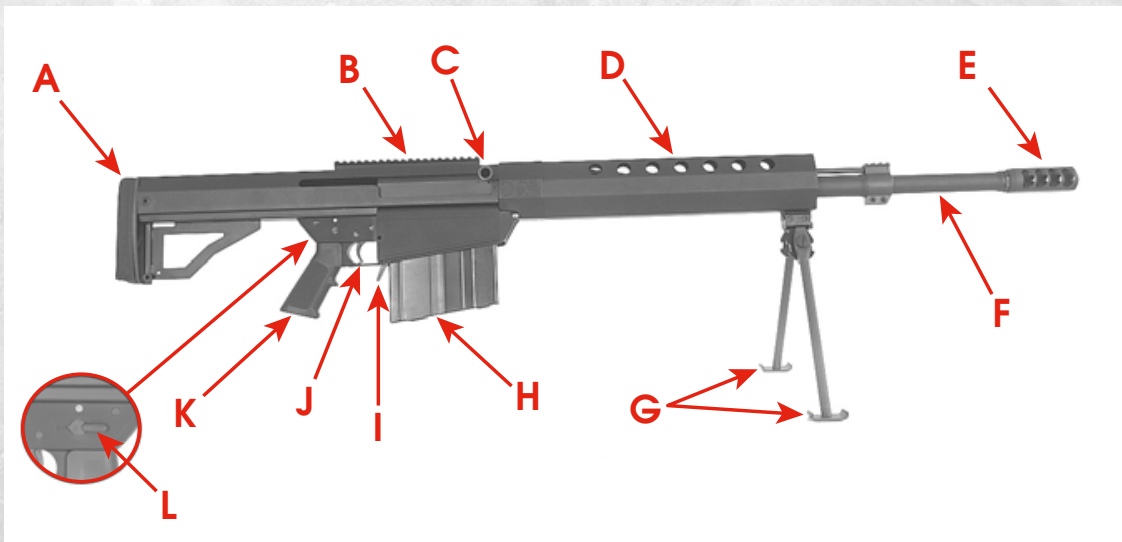
IDENTIFICATION

MODEL AND SERIAL NUMBER

The serial number (B) and model number (A) are located on the right side of the firearm.



PARTS IDENTIFICATION



- | | |
|------------------|--------------------|
| A. Buttpad | G. Bipod |
| B. Scope Mount | H. Magazine |
| C. Bolt Assembly | I. Magazine Catch |
| D. Handguard | J. Trigger |
| E. Muzzle Brake | K. Grip |
| F. Barrel | L. Safety Selector |

INSPECT FOR AMMUNITION

⚠ WARNING

- Prevent serious injury or death.
- A loaded firearm may discharge unintentionally.
- Point firearm in a safe direction while inspecting for ammunition.

1. Place safety selector (A) on SAFE.

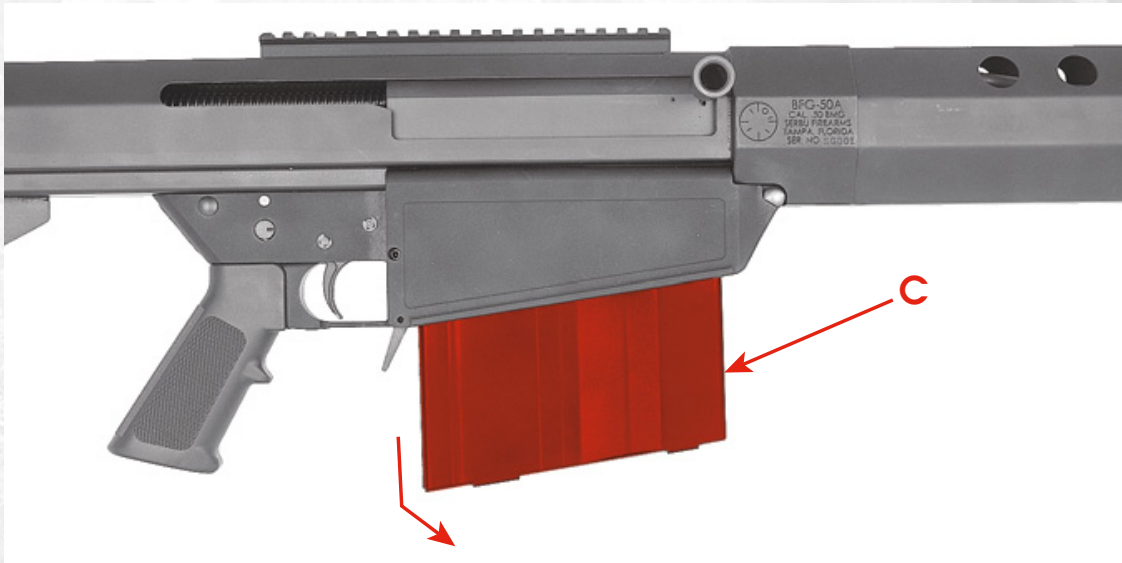
Note: If hammer is not cocked, safety selector can not be placed on SAFE.



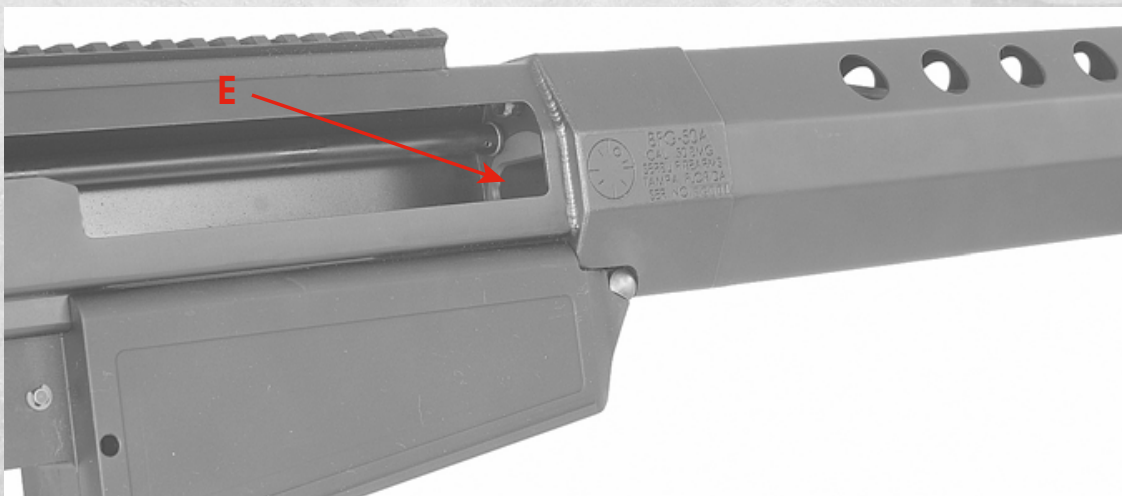
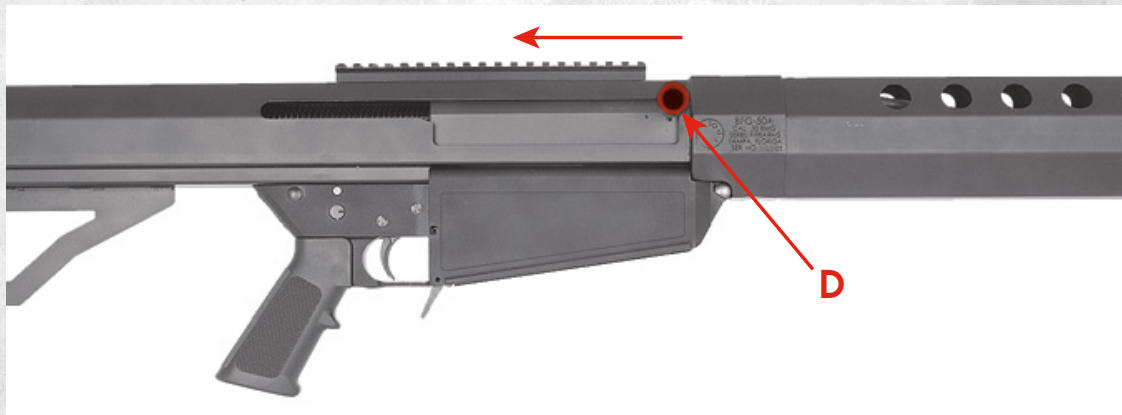
2. Grasp firearm while keeping your finger off trigger. Press magazine catch (B) forward to release magazine (C).



3. Move magazine (C) downward and pivot forward to remove.



4. Pull bolt handle (D) rearward and look into receiver to verify that there is no ammunition in chamber (E). With safety selector pointing toward SAFE, allow bolt handle to go forward.



5. Follow this inspection procedure before storage, before cleaning, transporting, before handing to another person or when handed to you.

AMMUNITION

⚠ WARNING

- Prevent serious injury or death.
- Failure to use proper gauge or caliber of ammunition will cause your firearm to fail when firing.
- Always use ammunition that meets industry standards and is specifically designed for use in this firearm.

⚠ WARNING

- Prevent serious injury or death.
- A loaded firearm may discharge unintentionally.
- Point firearm in a safe direction while inspecting for ammunition.

This firearm has been designed for ammunition of a specific caliber and type. The firearm and ammunition work together as a system. You must use the correct ammunition for your firearm.

Locate caliber mark (A) on firearm. This designates ammunition caliber that must be used in firearm.



Always inspect ammunition before loading. Never use damaged or corroded ammunition which could lead to a burst cartridge, causing damage to firearm and possible personal injury or death.

Always use factory new ammunition (not reloaded or remanufactured), made by a reputable commercial ammunition manufacturer in the appropriate caliber and bullet weight for the firearm's chamber and rifling.

LOADING

⚠ WARNING

- Prevent serious injury or death.
- Point barrel of firearm in a safe direction when loading or unloading.

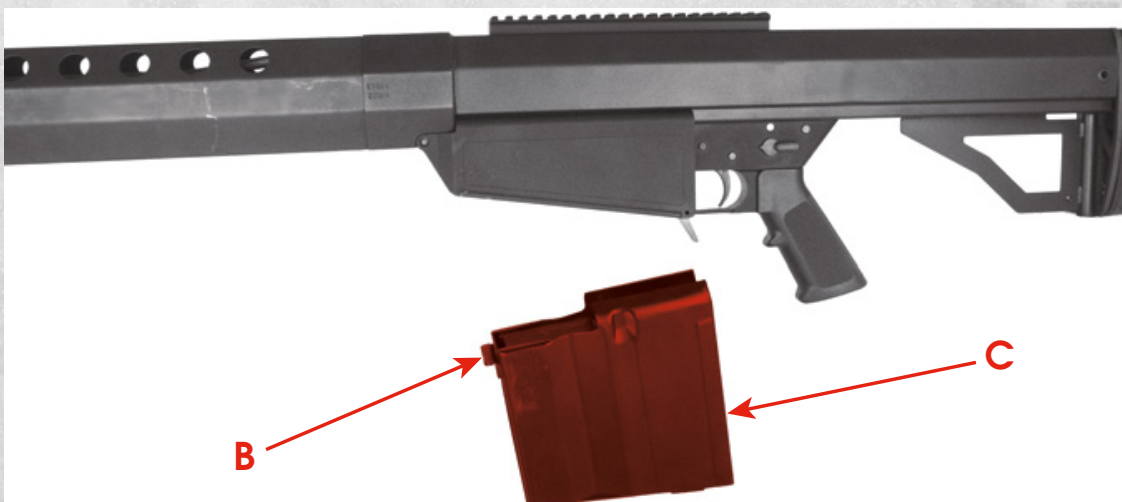
Clean firearm before first use. The firearm has been treated at the factory to prevent corrosion. Chamber, bore, and exterior surfaces must be cleaned to remove excess oil.

1. Inspect firearm for ammunition if you have not done so. See Inspect For Ammunition on page 8.
2. Verify that safety selector (A) is in SAFE position.

Note: If hammer is not cocked, safety selector can not be placed on SAFE.



3. Inspect each cartridge for signs of damage. Do not load damaged ammunition. Load magazine with proper caliber of undamaged ammunition.
4. Insert tab (B) on magazine (C) into indent on magazine housing. Pivot magazine into housing until catch is engaged. Use your hand to tap on bottom of magazine to be sure it is seated.



LOADING

⚠ WARNING

- Prevent serious injury or death.
 - After performing step 5, firearm is loaded and will fire if safety selector is set to FIRE and trigger is pulled. Keep firearm pointed in a safe direction at all times.
5. To load a round into the chamber, pull the bolt handle (D) fully rearward and release, allowing the recoil spring to propel the bolt forward. A round from the magazine is now loaded into chamber.



Never insert a round into chamber through ejection port. Load chamber by feeding a round from magazine only.

FIRING

⚠ WARNING

- Prevent serious injury or death.
- You must follow all safety guidelines for the safe use of a firearm. Failure to follow these basic firearm safety guidelines may result in an unintended discharge which could cause serious injury or death.

⚠ WARNING

- Prevent serious injury or death.
- Always point firearm in a safe direction.
- Be aware of others. Persons in vicinity of shooting may unintentionally walk into line of fire.
- Keep bystanders clear of blast which exits the muzzle brake ports.
- Stay clear of ejected shell casings.
- Stay clear of recoiling bolt handle and ejection port.
- Always wear appropriate eye and ear protection while firing. Be sure others in the vicinity have protection.

1. Grasp firearm with one hand on handguard and the other on grip.
2. Move safety selector (A) to FIRE.



3. Place buttpad against shoulder. Aim at target and gently pull trigger with finger to fire. Release trigger and point firearm in a safe direction.
4. Remove finger from trigger.

FIRING

5. Move safety selector (B) to SAFE.



⚠ WARNING

- Prevent serious injury or death.
 - Firearm may have a round in chamber even though magazine has been removed.
 - Keep firearm pointed in a safe direction while magazine is reloaded.
6. When you have stopped firing, remove finger from trigger and remove magazine. Reload magazine if you plan to continue shooting.
 7. If shooting has stopped in the middle of a loaded magazine, follow the instructions for unloading firearm. See Unloading Firearm procedure on page 17.

MALFUNCTIONS

⚠ WARNING

- Prevent serious injury or death.
- If firearm is not operating properly, stop firing immediately.
- Point firearm in a safe direction and unload firearm. Safely store firearm and take to a qualified gunsmith for inspection.

If a cartridge jams or hangs up while moving from magazine to chamber, do not attempt to force cartridge into chamber.

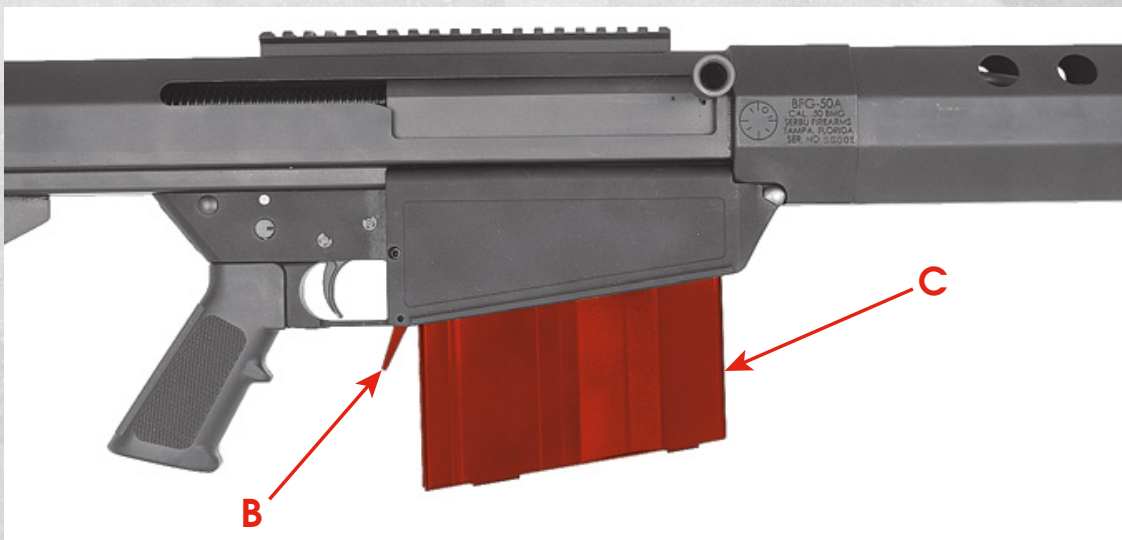
If your firearm misfires or jams:

1. Place safety selector (A) on SAFE.

Note: If hammer is not cocked, safety selector can not be placed on SAFE.



2. Grasp firearm while keeping finger off trigger. Press magazine catch (B) and remove magazine (C).



UNLOADING

! Firearms must be unloaded when not in use. Completely unload firearm as soon as you are finished shooting. Unload firearm before storing it, traveling, laying it down or entering a vehicle or building. Always verify that a firearm is unloaded. Do not take anyone's word that a firearm is unloaded. Never pass your firearm to another person until both you and the other person have visually checked that it is unloaded. Keep your firearm unloaded and safely stored when not in use.

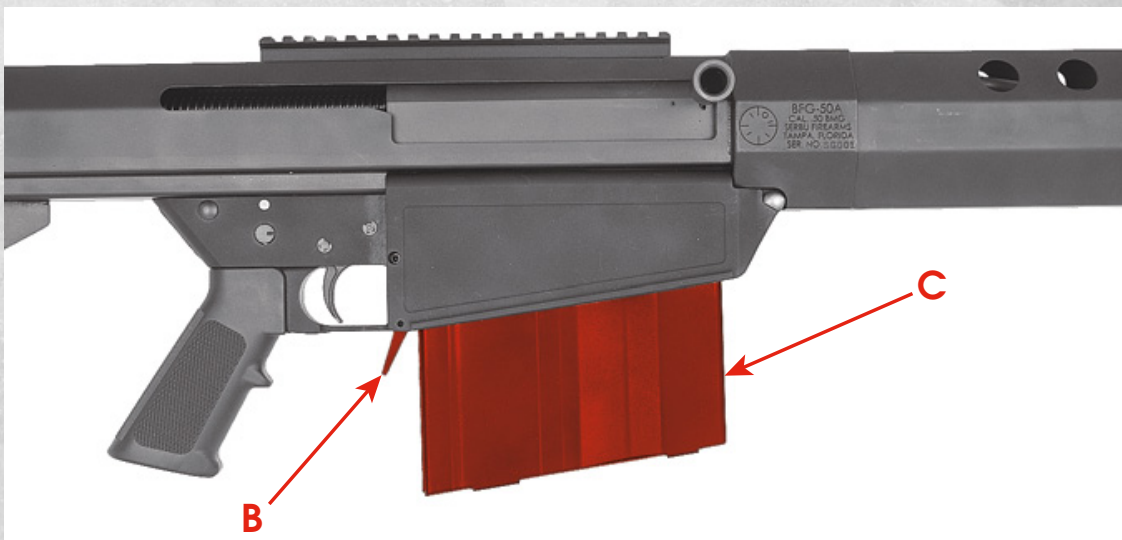
! **WARNING** - Always point the firearm in a safe direction.

1. Place safety selector (A) on SAFE.

Note: If hammer is not cocked, safety selector can not be placed on SAFE.

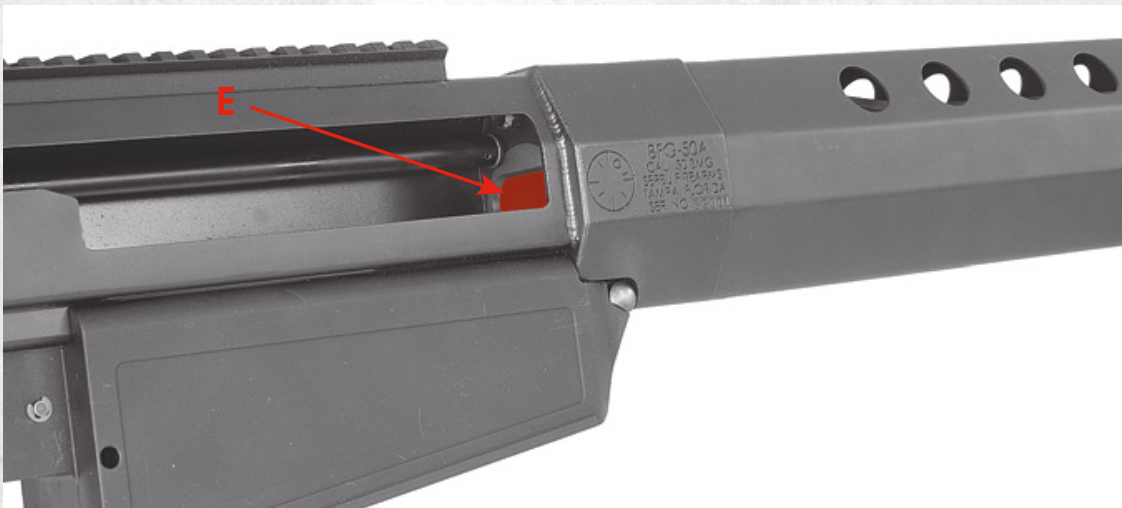
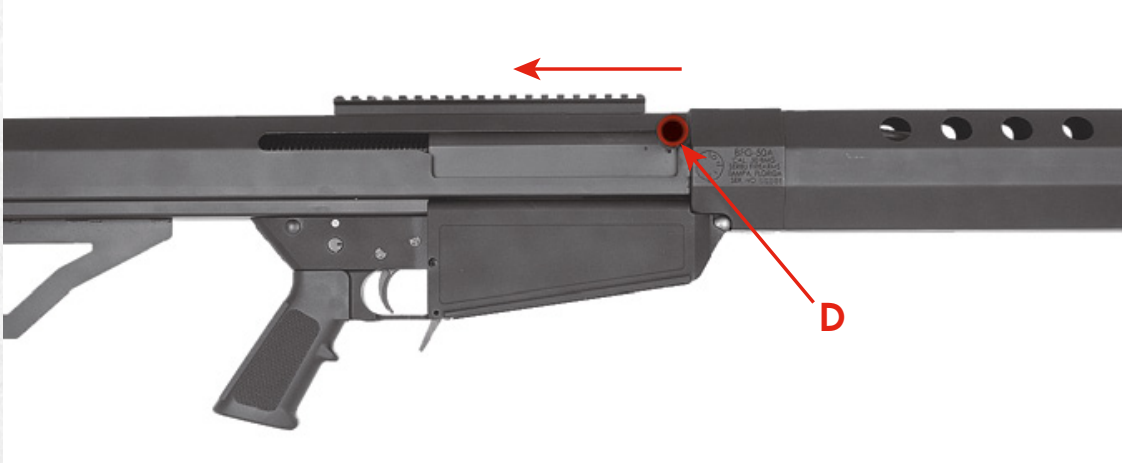


2. Grasp the firearm while keeping your finger off the trigger. Press the magazine catch (B) and remove magazine (C).



UNLOADING

3. Pull bolt handle (D) rearward and look into receiver to verify that there is no ammunition in chamber (E).

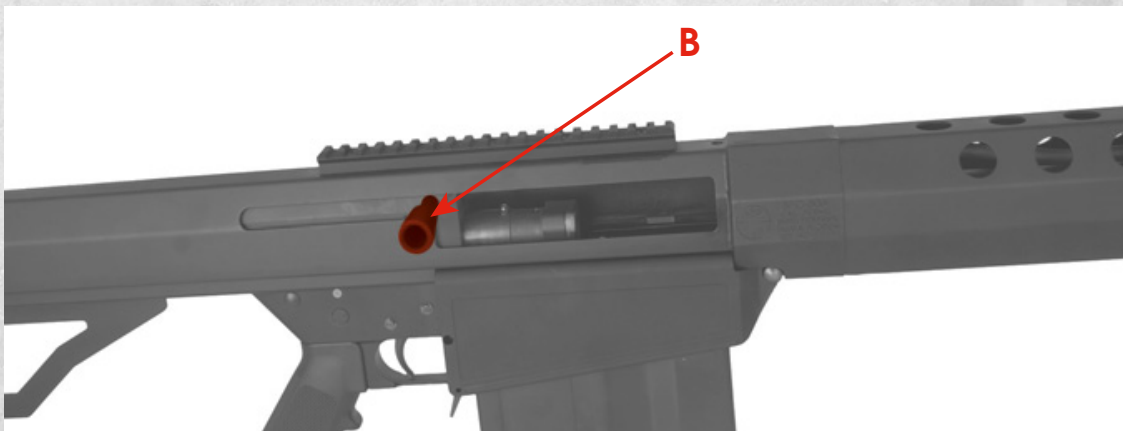


DISASSEMBLY

- ⚠ **WARNING** - Verify that the firearm is not loaded before any disassembly or cleaning. Always point the firearm in a safe direction.
- ⚠ **WARNING** - Do not disassemble the firearm any further than instructed in this manual. Do not modify or alter the firearm.
- ⚠ **WARNING** - Wear eye protection while disassembling firearm.
- ⚠ **CAUTION** - Allow components to cool after firing.

REMOVE BOLT

1. Pull bolt back and depress bolt handle retaining plunger (A) with a dummy round or punch. Hold back against recoil spring and remove bolt handle (B).

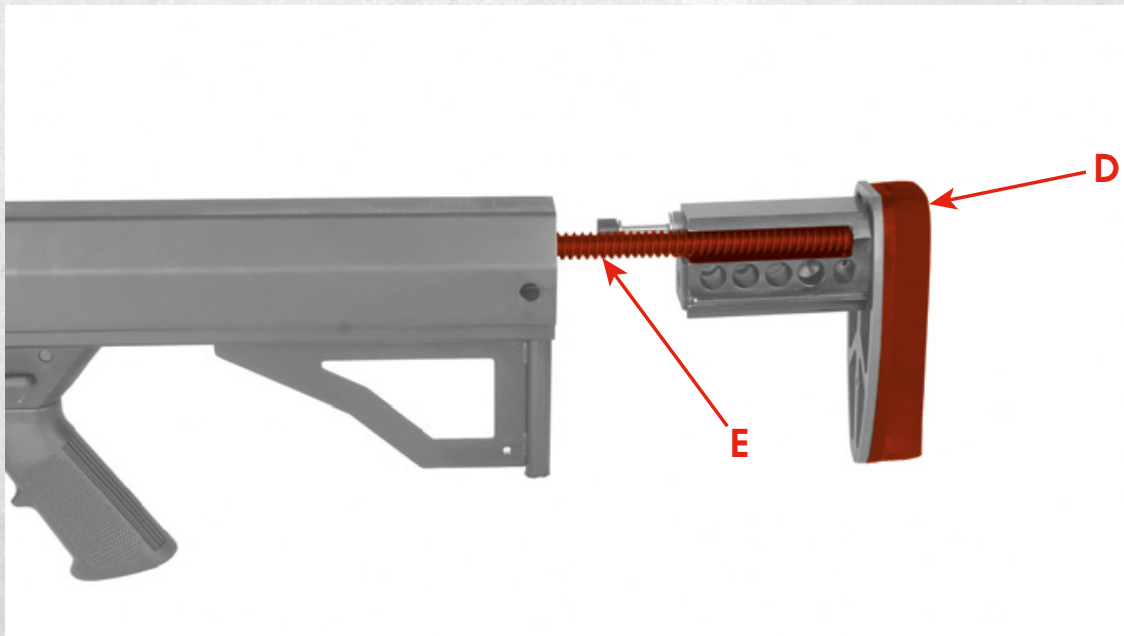


DISASSEMBLY

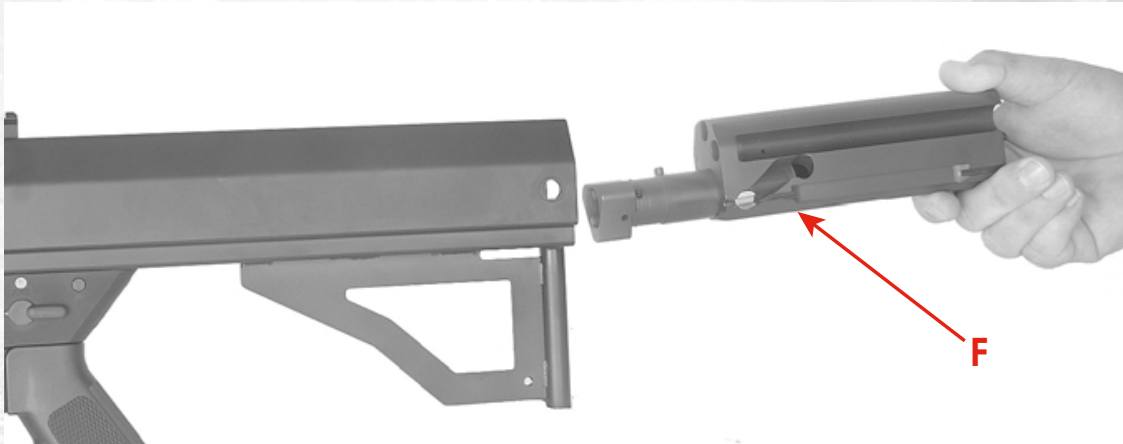
2. Push in on takedown pin (C) with a dummy round or punch. While holding onto buttpad (D) remove pin.



3. Remove buttpad assembly (D) and recoil spring (E).

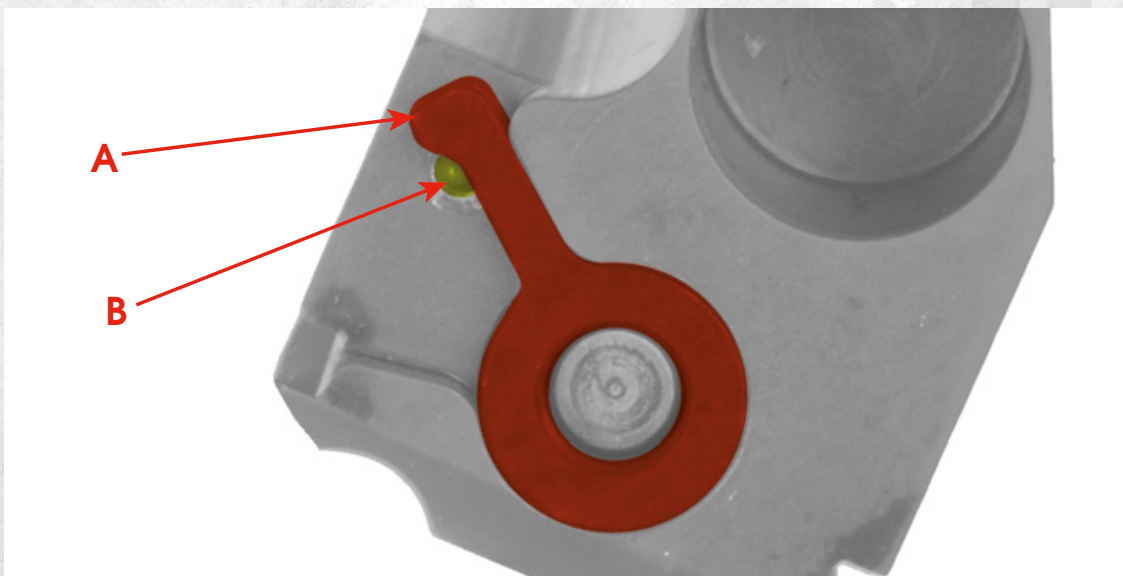


- 4, Remove bolt assembly (F).

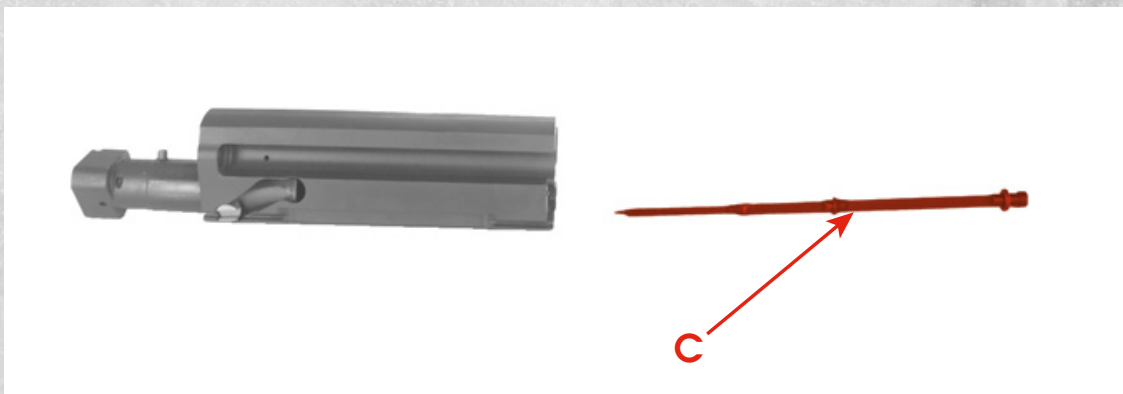


DISASSEMBLE BOLT

1. Push in on detent (B) and rotate firing pin retainer (A) all the way down. Remove firing pin retainer.

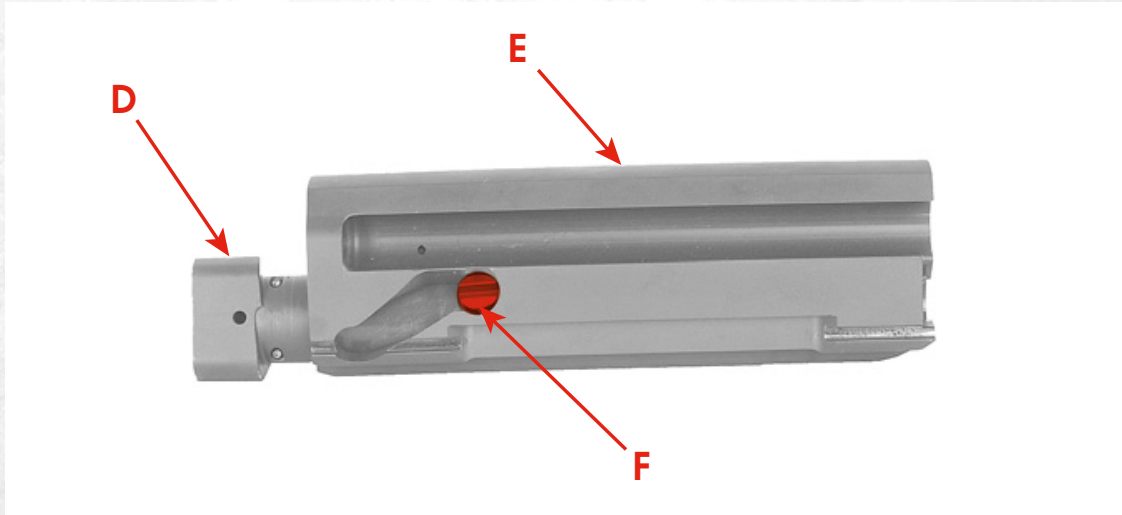


2. Remove firing pin (C).



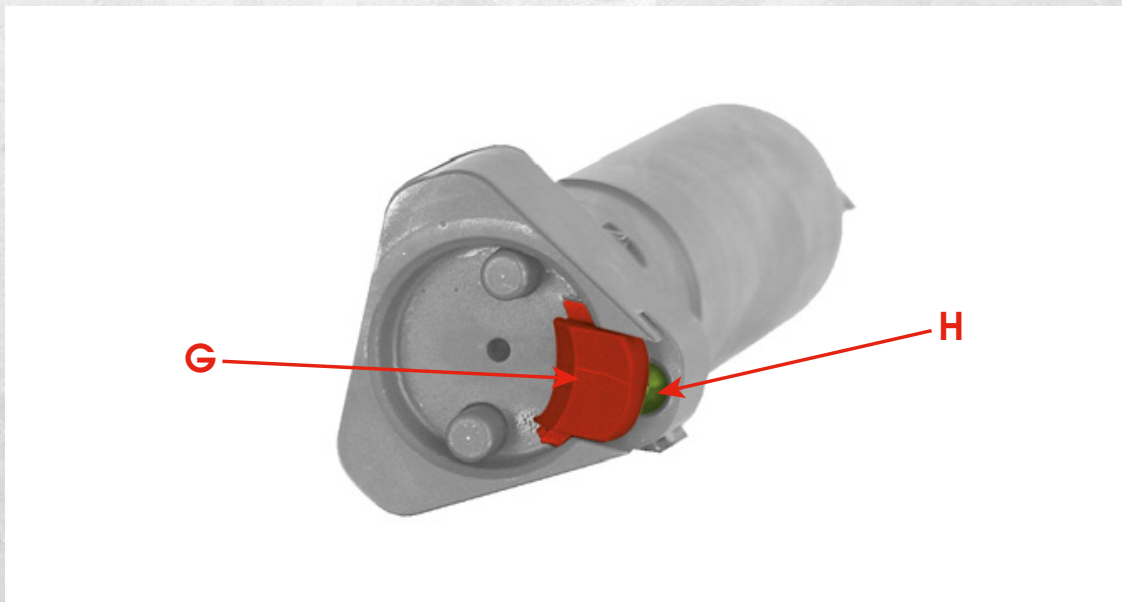
DISASSEMBLY

3. Push bolt head (D) into bolt carrier (E) until cam pin (F) lines up with round access hole. Remove cam pin and bolt head.



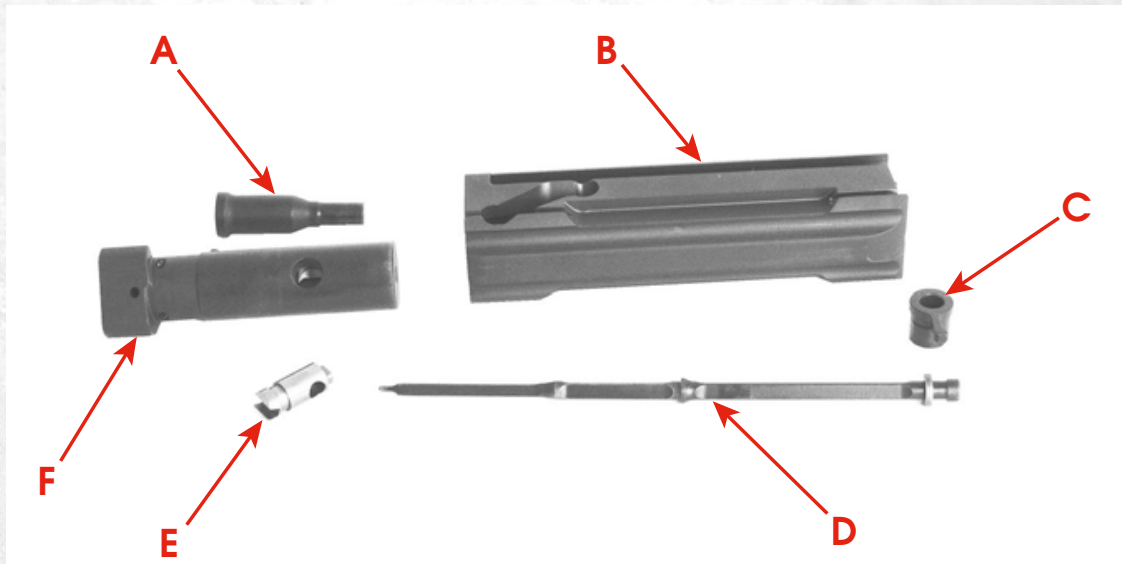
Note: Plunger is under pressure. Plunger and spring will release from bolt head once extractor has been removed.

4. Push in on extractor (G) and depress extractor plunger (H) with a small diameter punch. Slide extractor past plunger and remove from bolt head.



DISASSEMBLY

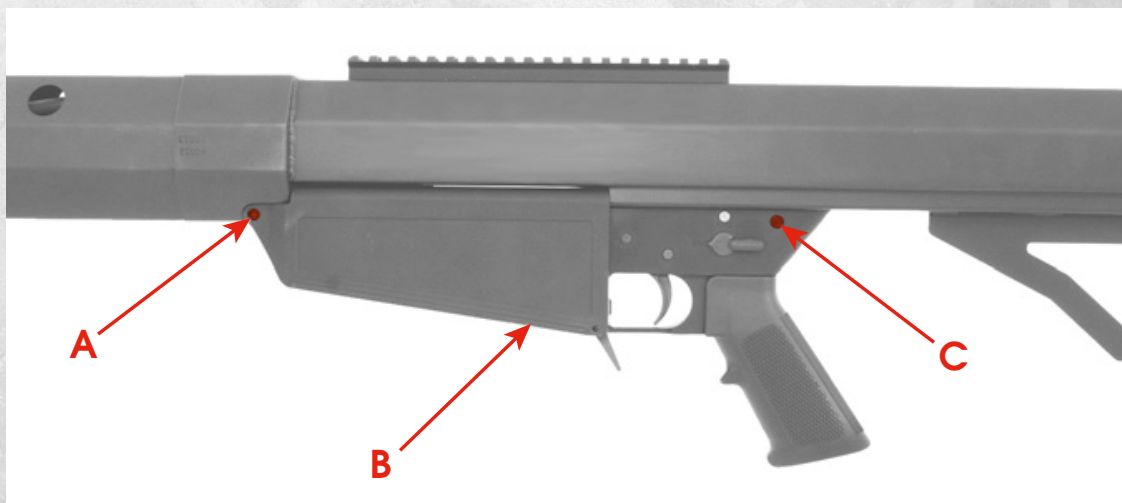
Bolt Assembly - Exploded View



- | | |
|------------------------|---------------|
| A. Bolt Handle | D. Firing Pin |
| B. Bolt Carrier | E. Cam Pin |
| C. Firing Pin Retainer | F. Bolt Head |

REMOVE TRIGGER/MAGAZINE HOUSING ASSEMBLY

Push in on pins (A and C). Remove trigger/magazine housing assembly (B).



⚠ WARNING - Do not disassemble the firearm any further than instructed in this manual.

⚠ WARNING - Do not modify or alter any part of the firearm. Contact Serbu Firearms at (813) 243-8899 for replacement parts and/or technical information.

CLEANING

⚠ WARNING - Always point the firearm in a safe direction.

⚠ WARNING - Wear eye protection while cleaning firearm.

NOTICE

NOTICE - Risk of firearm damage. Some cleaning solutions and solvents may damage your firearm. Use a cleaning solution that is designed for use on firearms.

A cleaning kit made specifically for .50 BMG rifles is available from Serbu Firearms, Inc. Follow the instructions included with the kit for cleaning the BFG-50A. If this kit is not purchased, use a high quality firearm cleaning kit that includes a cleaning rod, swab holder, cotton flannel bore patches, a small toothbrush, brass wire bristle bore and chamber brushes and a Cleaner/Lubricant/Preservative.

Before initial use and after firing, clean your firearm as soon as possible to make the job easier and to avoid allowing the development of any corrosion.

When your firearm has not been fired, you should clean it at least once or twice a year if you live in a temperate climate, or as often as once a week in a tropical climate.

If you get your firearm wet, clean it as soon as possible.

CLEANING THE EXTERIOR

⚠ Remove the magazine, verify that the firearm is not loaded and safety selector is on SAFE.

Note: If hammer is not cocked, safety selector can not be placed on SAFE.

Wipe all metal surfaces with a clean cloth and then follow up with a lightly oiled cloth.

CLEANING THE BARREL

⚠ Remove the magazine, verify that the firearm is not loaded and safety selector is on SAFE.

Note: If hammer is not cocked, safety selector can not be placed on SAFE.

Clean the barrel with a cotton patch attached to a cleaning rod. Moisten the patch with cleaning solution. Repeat with clean patches until patch stays clean. Apply cleaning solvent to a bronze bore brush to help loosen particles inside the barrel. After cleaning, run a dry patch through the barrel and then follow with a lightly oiled patch.

CLEANING

CLEANING THE CHAMBER

⚠ Remove the magazine, verify that the firearm is not loaded and safety selector is on SAFE.

Note: If hammer is not cocked, safety selector can not be placed on SAFE.

Clean the chamber with solvent and a chamber cleaning brush. Move the brush through the chamber several times to scrub the inside of the chamber. Use a clean patch to wipe the chamber after cleaning. Repeat with clean patches until patch stays clean. After cleaning, run a dry patch through the chamber. Do not oil the chamber.

CLEANING THE TRIGGER/MAGAZINE HOUSING

⚠ Remove the magazine, verify that the firearm is not loaded and safety selector is on SAFE.

Note: If hammer is not cocked, safety selector can not be placed on SAFE.

Wipe all metal surfaces with a clean cloth and then follow up with a lightly oiled cloth. Compressed air is useful when cleaning the trigger/magazine housing. Always wear eye protection when cleaning with compressed air.

Wipe any debris from the trigger mechanism.

Never apply grease to the trigger mechanism except to the hammer and trigger sear surfaces.

CLEANING THE RECEIVER

⚠ Remove the magazine, verify that the firearm is not loaded and safety selector is on SAFE.

Note: If hammer is not cocked, safety selector can not be placed on SAFE.

Wipe all interior and exterior surfaces with a clean cloth and then follow up with a lightly oiled cloth.

Wipe any debris from the bolt carrier channel.

CLEANING

CLEANING THE BOLT CARRIER GROUP

Wipe all bolt carrier group surfaces with a clean cloth and then follow up with a lightly oiled cloth.

Wipe any debris from the bolt, firing pin, retaining pin, cam pin and extractor.

CHECKS:

- Check the bolt for cracks or fractures, especially in the cam pin hole area. Bolts with any pitting extending into the firing pin hole must be replaced.
- Check the firing pin to see if it is bent, cracked, too blunt, too sharp or if tip is pitted. If so, it must be replaced.
- Verify that the firing pin moves freely forward and rearward when inserted into the bolt.
- Check firing pin retainer to see if it is bent or badly worn. If so, it must be replaced.
- Check the cam pin to see if it is cracked, worn or chipped. If so, it must be replaced.
- Check the extractor to see if it is deformed, particularly in the area of the two tangs that engage the slot in the bolt head. If it's worn to the point where a lot of up and down movement of the extractor is allowed, it must be replaced.

LUBRICATING

RECIEVER

Lightly Lubricate With Cleaner/Lubricant/Preservative:

- The inside of the receiver, bore and chamber using the cleaning rod and a patch.
- The outer surfaces of barrel.
- The guide rod and action spring.

TRIGGER/MAGAZINE HOUSING

- Lightly Lubricate With Cleaner/Lubricant/Preservative:
- All moving trigger/magazinehousing parts including the trigger, hammer, safety, bolt catch and their various pins and detents. Don't forget the takedown pin, pivot pin and detents.
- Using Cleaner/Lubricant/Preservative and a clean cloth, wipe the trigger/magazine housing and any other components clean of fingerprints.

BOLT CARRIER GROUP

Lightly Lubricate With Cleaner/Lubricant/Preservative:

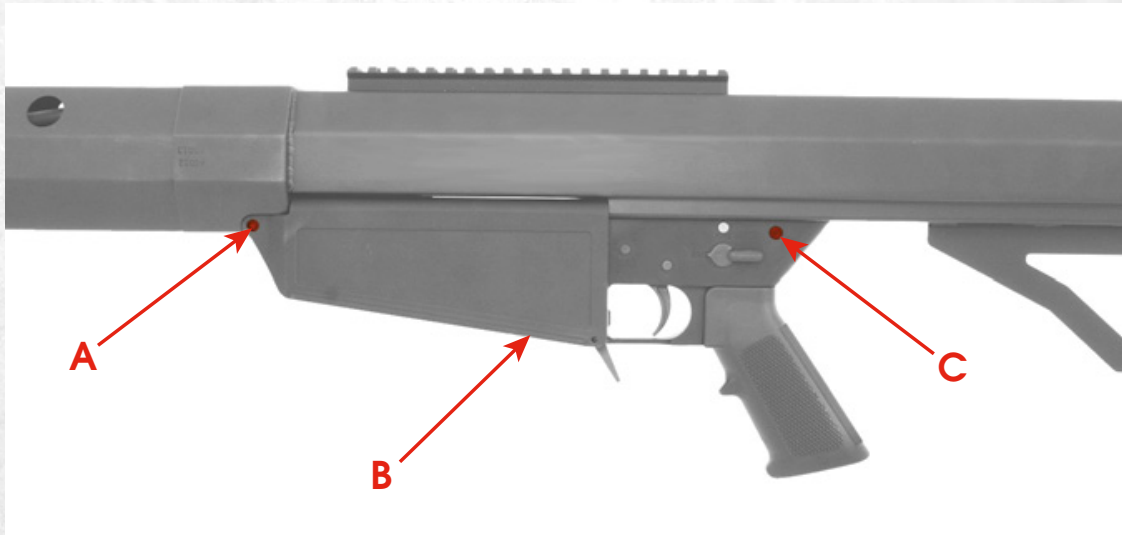
- The firing pin and the firing pin recess in the bolt.
- The bolt and cam pin.
- The extractor and extractor pin.
- The cam cutout and cam pin area of the bolt carrier.

ASSEMBLY

⚠ WARNING - Wear eye protection while assembling firearm.

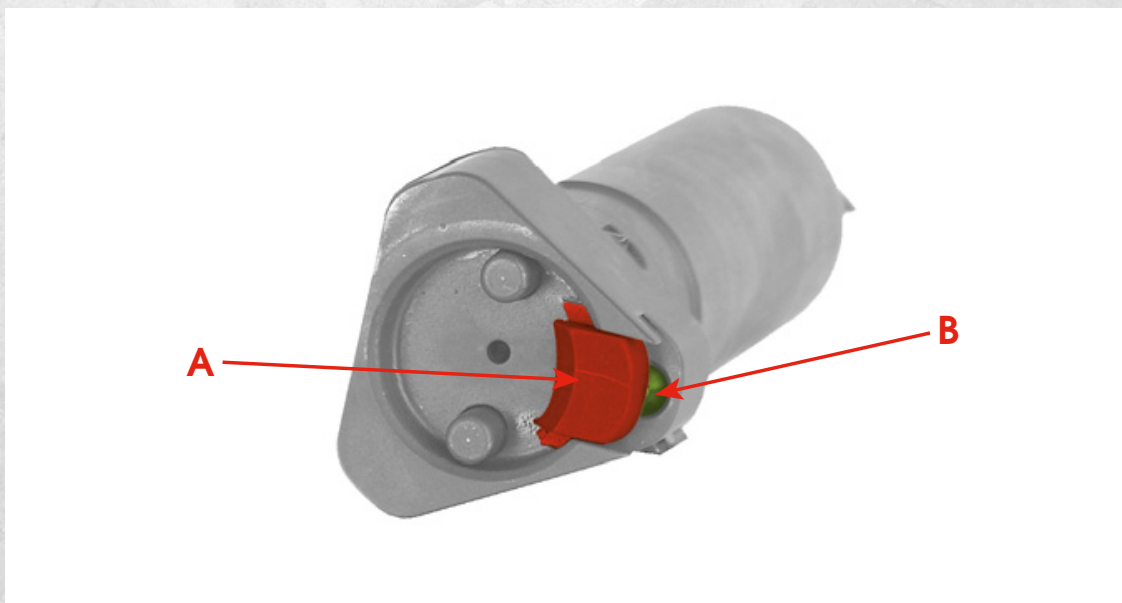
INSTALL TRIGGER/MAGAZINE HOUSING ASSEMBLY

1. Attach trigger/magazine housing assembly (B) and push in pins (A and C).



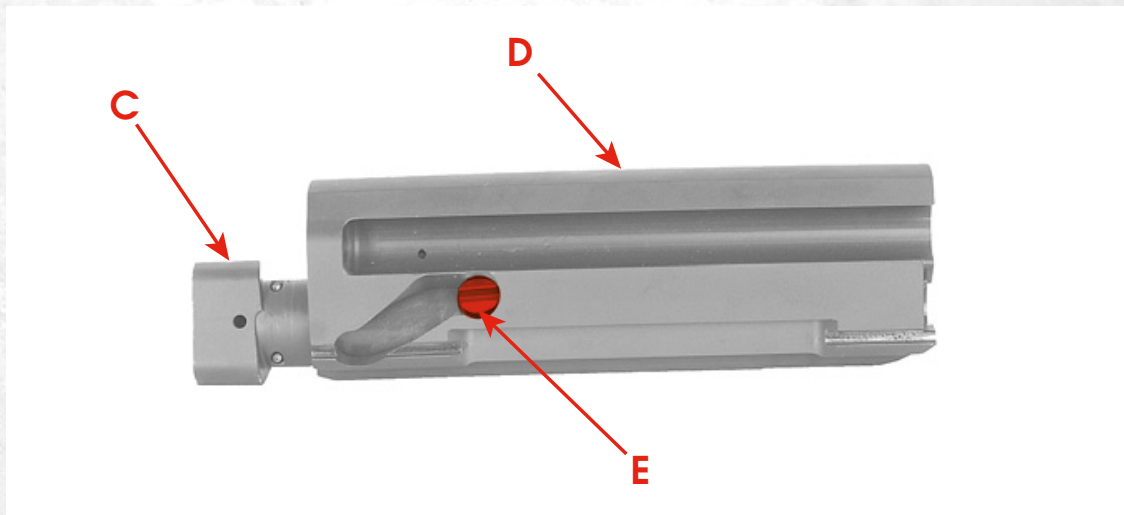
ASSEMBLE BOLT

2. Install spring and extractor plunger. Depress extractor plunger (B) and install extractor (A).

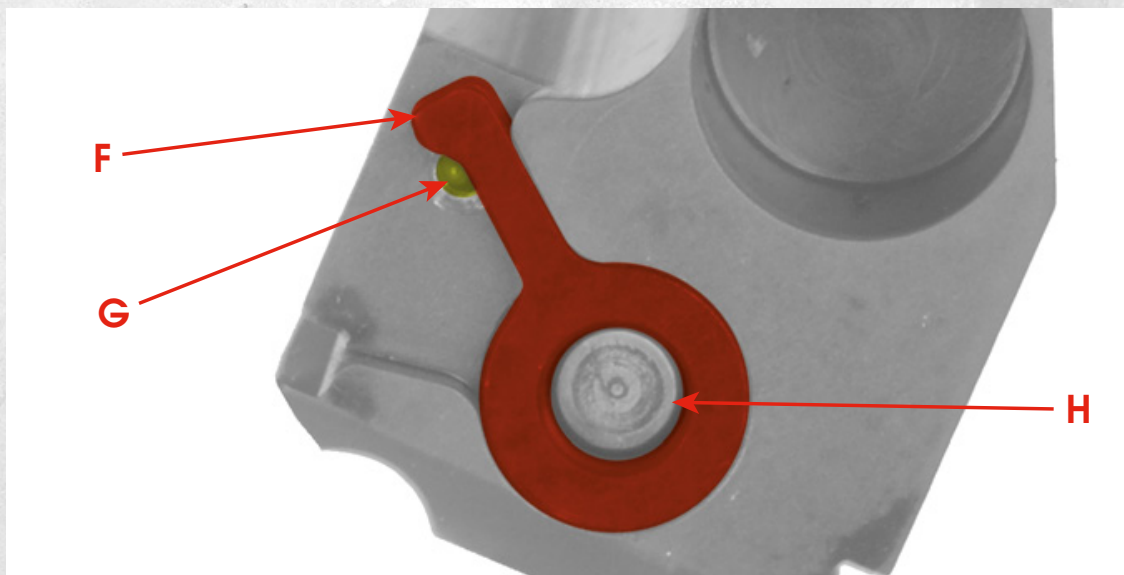


ASSEMBLY

3. Slide bolt head (C) into bolt carrier (D). Install cam pin (E).

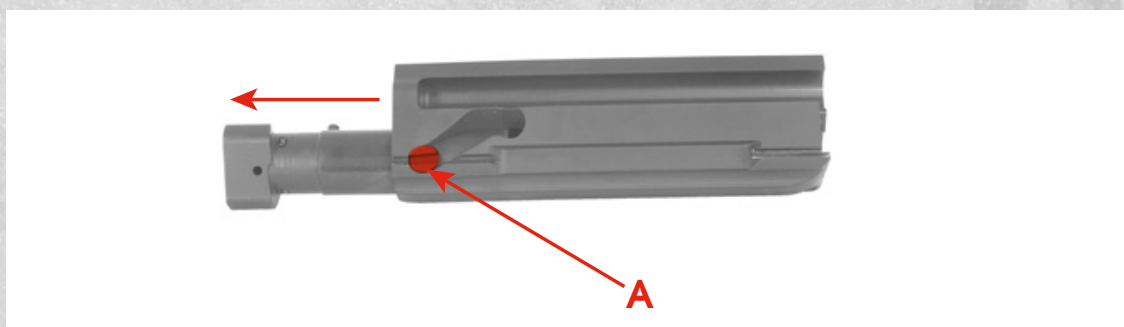


4. Install firing pin (H). Install firing pin retainer (F) and rotate past detent (G).



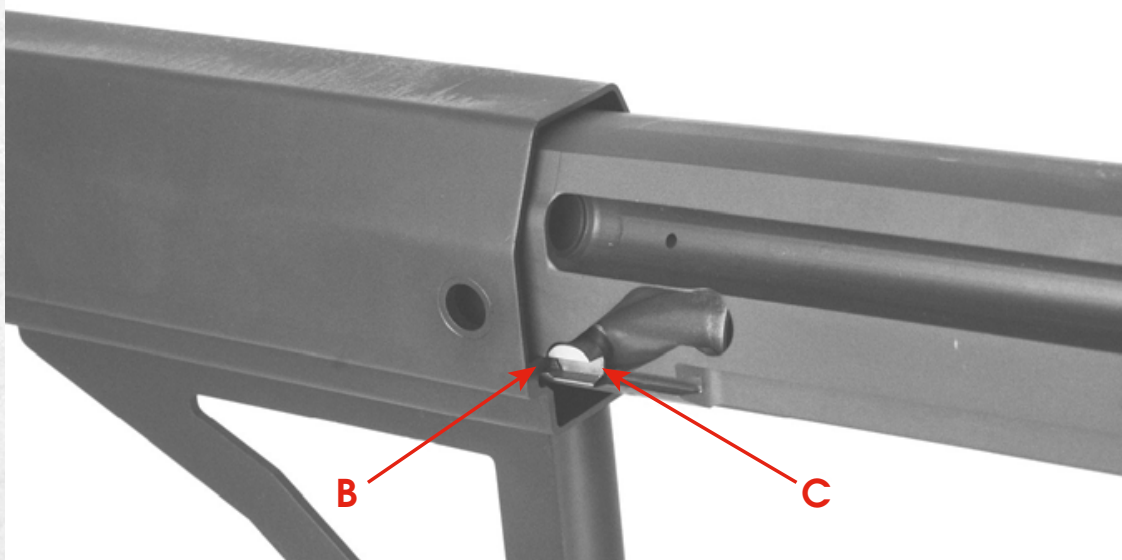
INSTALL BOLT

1. Move bolt head forward, so cam pin (A) is in position shown.

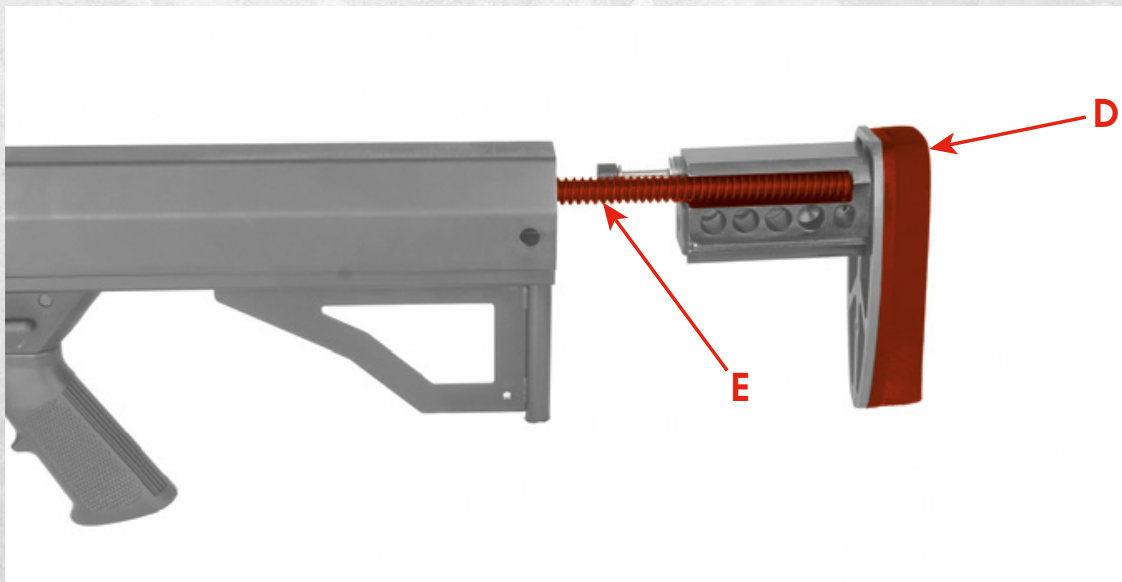


ASSEMBLY

2. Slide bolt into receiver and verify cam pin groove (C) is engaging receiver rail (B) as shown.



3. Install buttpad assembly (D) and recoil spring (E).

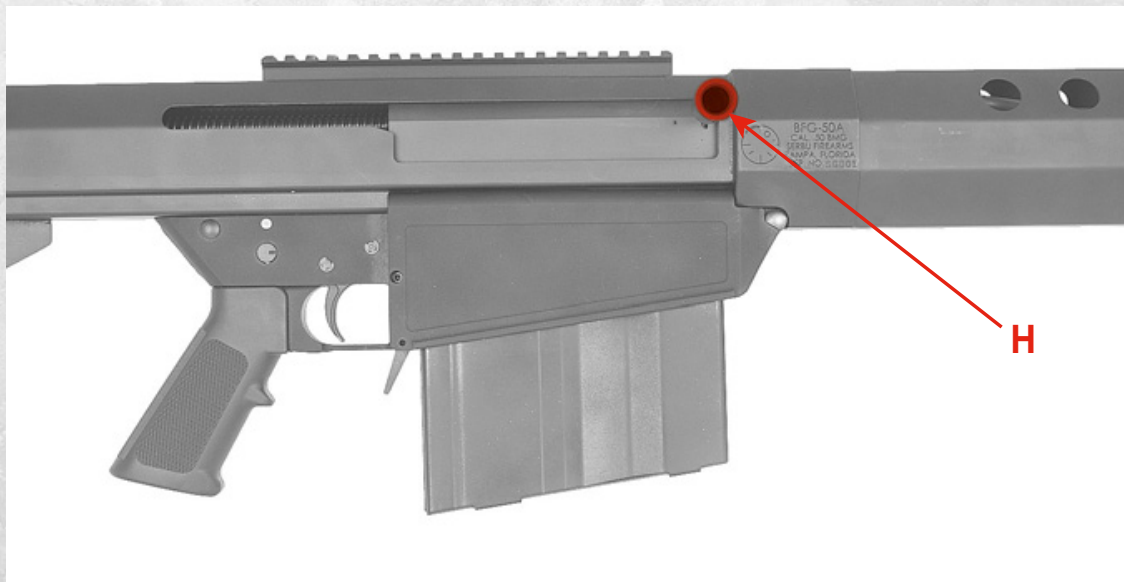


ASSEMBLY

4. Hold buttpad (G) in place and install takedown pin (F).



5. Push bolt handle (H) into bolt. The bolt handle is installed properly after you hear it snap past the detent.



TROUBLESHOOTING

Problem	Check	Solution
Won't fire.	Selector on SAFE.	Place selector on FIRE.
	Defective ammunition.	Remove magazine and install new, undamaged ammunition. See Loading on page 11.
	Improper assembly of firing pin.	Assemble correctly. See Assembly on page 28.
	Too much carbon on firing pin.	Too much oil in firing pin. Remove firing pin and wipe out with cotton swab. See Disassembly on page 19.
Won't extract.	Carbon in chamber.	Clean chamber. See Cleaning on page 24.
	Fouling or carbon in extractor.	Remove and clean extractor. See Disassembly on page 19.
	Extractor sticking or seized.	Remove and clean extractor and recess in bolt. See Disassembly on page 19.
	Restricted movement of carrier.	Remove, clean and lube bolt carrier. See Disassembly on page 19 and Cleaning on page 24.
Won't feed from magazine.	Dirty, damaged or corroded ammunition.	
	Dirty magazine.	Remove and clean magazine.
	Defective magazine.	Replace magazine.
	Too many rounds in magazine.	Remove excess rounds from magazine. See Loading on page 11.
	Magazine not fully seated.	Seat magazine in receiver. See Loading on page 11.

TROUBLESHOOTING

Problem	Check	Solution
Won't feed from magazine. (Continued)	Dirty/fouled chamber.	Clean chamber. See Cleaning on page 24.
Bolt won't unlock.	Dirty or burred bolt.	Remove bolt assembly and clean or see a competent and qualified gunsmith. See Disassembly on page 19.
	Dirty/fouled chamber.	Clean chamber. See Cleaning on page 24.
Won't chamber.	Dirty, damaged or corroded ammunition.	Remove magazine and install new undamaged ammunition. See loading on Loading on page 11.
	Defective magazine.	Replace magazine.
	Carbon in chamber.	Clean chamber. See Cleaning on page 24.
Bolt won't fully close.	Debris or blown primer in action.	Remove debris or blown primer.
Won't extract.	Extractor sticking.	Remove and clean extractor. See Disassembly on page 19.
	Restricted movement of bolt carrier.	Remove, clean and lube bolt carrier. See Disassembly on page 19 and Cleaning on page 24.
	Blown primer in or under extractor.	Remove primer.
Safety selector binds.	Needs oil.	Lubricate with Cleaner/Lubricant/Preservative.
	Debris in trigger.	Clean trigger. See Cleaning on page 24.

NOTES

ATTENTION SHOOTERS!

Congratulations on your new purchase. Refer to the manual included with your firearm for assistance with disassembly, cleaning and re-assembly of your firearm.

Note: This rifle may require a break-in period. It may take as many as 100 rounds through the gun before it functions reliably.

WARNING

If this firearm is carelessly or improperly handled, unintentional discharge could result and could cause injury, death or damage to property.

Do not use handloads, reloads or remanufactured ammunition in your Serbu Firearms firearm. Use of this ammunition is dangerous and by using it you assume all risks associated with its use.

IMPORTANT!

Before your firearm left the factory, it was tested, carefully inspected and packaged. Serbu Firearms cannot control product handling after it leaves the factory. Therefore, please examine this firearm carefully at the time of purchase to insure that it is unloaded and undamaged.

Serial # _____

Purchase Date _____

Dealer _____

WHY NO WARRANTY CARD HAS BEEN PACKED WITH THIS NEW FIREARM

The Magnuson-Moss Act (Public Law 93-637) does not require any seller or manufacturer of a consumer product to give a written warranty. It does provide that if a written warranty is given, it must be designated as "limited" or as "full" and sets minimum standards for a "full" warranty. Serbu Firearms, Inc. has elected not to provide any written warranty, either "limited" or "full", rather than to attempt to comply with the provisions of the Magnuson-Moss Act and the regulations issued thereunder. There are certain implied warranties under state law with respect to sales of consumer goods. As the extent and interpretation of these implied warranties varies from state to state, you should refer to your state statutes. Serbu Firearms, Inc. wishes to assure its customers of its continued interest in providing service to owners of Serbu Firearms firearms.