User Operator’s Manual
Stoner SR-25 7.62mm Mark 11 mod 0 Type Rifle Systems
This Manual is Intended for Airsoft Operator Use Only
Caution / Warning

- Always wear eye protective gear.
- You may be punished if you are shooting for practical jokes.
- Never shoot the gun at places where people and cars pass cross.
- Never aim or shoot a person or animal as a target.
- Never look into the gun muzzle.
- Always direct the muzzle towards a safe direction.
- Avoid pulling the trigger carelessly.
- Please put away from your fingers from the trigger, except when you are ready to shoot a target.
- Always put the gun in a case or bag when you are carrying it.
- Keep out of reach of children.

Specification

- Over all: 1118 mm
- Inner Barrel: 491 mm
- Weight: 3110 g / 3506g (with Magazine)
- Bullet: 6 mm
- Capacity: 20 Rds
- Muzzle Speed: 125 m/sec

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1-2 Selector and Safety Setting

a. The safety is located on the left rear side of the lower receiver. The safety has two position: SAFE and FIRE are both dearly marked on the lower receiver. When the safety is rotated to SAFE position, the rifle (hammer) is fully cocked, but the firing sear is blocked from movement providing protection from accidental discharge under normal usage when the safety is properly engaged and serviceable.

b. To rotate the safety to the SAFE position, pull the charging handle fully to the rear visually checking that the chamber is clear by observing through the ejection port as the bolt is retracted by the charging handle. The safety may be rotated to the SAFE position any time the bolt is held fully to the rear or when the bolt is forward and the hammer is cocked.

NOTE:
1-3 Flip-Up Sights

A. Flip-Up Front Sight

B. Flip-Up Rear 600m Sight
1-4 Install Bipod Adapter

Clamp bipod adapter onto rail handguard and tighten screw to lock.

1-5 Install Sound Suppressor

Pull locking latch up to install suppressor onto barrel (please keeping lever on topside). When it's in the end position, Press down latch to lock. Press down latch to lock.

1-6 Install Handguard Panel

Press locking clip to attach or remove rail protection panels.
1-7 Buttstock

Pull lever down to open rear access door, Tools storage designed inside.

1-8 Magazine

If you'd like to firing without BB bullets, You could pull the Blank Firing Switch to the rear side for disable bolt lock-back function. (Ref. 2-6, page 11)

NOTE:
Please push down the connecting plate(the plate shape part on magazine's rear topside) before pulling switch back, Force on the switch may cause parts damage.
2-1 Checking Before You Fire

a. Remove the Magazine
Press Magazine catch button and remove the Magazine.

b. Cocking the Bolt
Lock Bolt open, Pull Charging handle rearward to check that there is no BBs in the chamber, Return Charging handle to forward. If there is, please remove the BBs from the chamber. Check the Bolt and Charging handle to ensure free movement in the receiver.

CAUTION: Do Not Put Your Finger Into The Chamber, It's Dangerous.
c. Check the Selector Lever
Perform safety function check to ensure that safety selector lever works properly.

d. Safety Setting
Place safety selector lever on safe.

NOTE:

WARNING:
Always Point The Muzzle In A Safe Direction.
2-2 Load the BBs

a. BB Loader

b. Insert the BBs to Loader

Always use the quality BBs for this airsoft gun, we will not be held responsible for any damage and accidents arising from using of bad quality BBs.

- Diameter Larger Than 6mm
- No True Round Bbs
- Both Halves Not Aligned
- With Flash
- Used Or Soiled

C. Load BBs

Insert the BBs into the Magazine.
The maximum capacity is 30 round.

CAUTION: Do Not Force To Over Load.
2-4 Setting Magazine

Push magazine up in to magazine well. Make sure to set the magazine upwards and connect it firmly until a CLICK SOUND is heard.

2-5 Ready to Fire

a. Check the Chamber
   Open bolt and check firing chamber. Make sure it is clear.

b. Return the Charging Handle
   Forward the charging handle to locked position.

c. Firing Mode Select
   – To rotate the safety selector lever on Fire Position.
   – Pull the Trigger to fire.

WARNING: Always Point The Muzzle In A Safe Direction.
2-3 Filling the Gas

a. Check the Nozzle
Push the gas canister nozzle into the Filling gas nozzle. Make sure the canister is in vertical position when charging.

b. Filling the Gas
For the better performance of the GBB rifle. Do not shoot the rifle right after charging the gas.

CAUTION / WARNING
You may experience a delay action if the surrounding temperature drops below 20° C/68° F. Remember, do not expose magazine directly under the sun or incinerate the magazine, it may cause bursting. It is strongly recommended to empty gas from magazine after shooting. Be sure to avoid direct gas contact with Eyes or Skin when gas is being released, it will cause frostbite.

1. Check canister for any cracks or leaks before using.
2. Do not expose canister over 40° C/ 104° F.
3. Do not leave canister directly over fire.
4. Do not boil canister.
5. Keep canister away from direct sunlight.
6. Do not leave canisters inside the vehicle.
2-6 Release Bolt

Press the Button release Bolt to Chamber.

2-7 Variable HOP-UP System

Turn the adjustment towards "Left" to give bullets more hop up. (+)
Turn the adjustment towards "Right" to give bullets less hop up. (-)

2-7 Adjust HOP effect

⚠️ Too much hop-up
(Return the lever toward NORMAL)

✔️ Best position

⚠️ Not enough hop-up (Move the lever toward HOP)
Or, too much hop-up (Return the lever toward NORMAL)

NOTE:
Never hold the gun sideways as BB bullets will curve right or left. This is due to the HOP UP system. The Best setting is, where bullets fly horizontally.
Chapter 3 - Maintenance

3-1 Field Striping

a. Remove the Magazine
Press Magazine catch button and remove the Magazine.

b. Cocking the Hammer
Pull the Charging handle rearward, Cocked the Hammer,
Return Charging handle to forward.

c. Safety setting
Place safety selector lever on safe.
d. Pull Up the Take Down Pin and Pivot Pin
   - Push in Take down pin as far as it will go. Pivot Upper receiver from lower receiver.
   - Push in pivot pin. Separate Upper and lower receiver.

e. Remove the Bolt Assembly
   Pull back the charging handle. Take down the bolt carrier and blot.

c. Remove the Buffer Assembly
   Press the Buffer stop pin,
   Pull out the Action Spring and Buffer.
3-1 Field Striping
3-2 Cleaning and Maintenance

CAUTION: Use silicone oil the lubrication only. Do not use WD-40 as lubrication.

a. Lower Receiver
Lightly lubricate all moving parts inside the lower receiver.

d. Buffer Assembly
Clean all areas and use silicone oil lightly lubricate all contact area.

b. Upper Receiver
Clean all areas and out of fouling, Metal debris and dirt.

e. Magazine
Clean all areas and out of fouling, Metal debris and dirt.

f. Inner Barrel
Use patch holder to clean the inner barrel.

c. Bolt Assembly
Use silicone oil lightly lubricate all contact area.
### 3-4 Trouble Clinic

<table>
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<th>Cause</th>
<th>Action</th>
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| No operation at all.     | 1. No Gas in Magazine.  
2. Selector lever on safe.  
3. Not loaded.  
4. The Magazine is in low temperature.  
5. The pressure inside the Magazine is too high. | 1. Unload the Magazine and filling the Gas.  
2. Turn the selector lever on semi/full auto sites.  
3. Pull the Charging handle, loading the rifle.  
4. After running fire, the Magazine will be in low temperature. Please, unload the Magazine until the Magazine temperature rise to normal.  
5. Do not use GAS which pressure is surpassed 12 bl, and Do not warming the Magazine. |
| Magazine leak.           | 1. O ring aged.  
2. O ring broken.  
3. Charging valve broken. | 1. Purchase the replacement part at your dealer or from VFC.  
2. Purchase the replacement part at your dealer or from VFC.  
3. Purchase the replacement part at your dealer or from VFC. |
| The recoil force decreases.| 1. The Magazine is in low temperature.  
2. The gas pressure is insufficient  
3. Lubrication insufficiency  
4. Bolt O ring broken | 1. After running fire, the Magazine will be in low temperature. Please, unload the Magazine until the Magazine temperature rise to normal.  
2. Unload the Magazine and refill the gas.  
3. The moving part needs lubrication.  
4. Purchase the replacement part at your dealer or from VFC. |
| The trajectory is not steady | 1. Too much hop setting.  
2. Inner Barrel or Hop parking contaminated by oil or dirt.  
3. Worn or damaged hop parking.  
4. Improper or too large size BB bullets. | 1. Gradually return adjustment lever towards normal.  
2. Clean the oil or dirt.  
3. Purchase the replacement part at your dealer or from VFC.  
4. Use the quality BBs. |
3-3 Parts List
Stoner SR-25 7.62mm Mark 11 mod 0 Type Rifle Systems

02 LOWER RECEIVER
02-1 VG27LRLV030
02-2 VG20LRLV090
02-3 VG20SPG010
02-4 VG27LRLV010
02-5 VG20SPG008
02-6 VG20LRLV150
02-7 VG27BF020
02-8 VG20SPG019
02-9 VG27LRLV020
02-10 VG27LRLV060
02-11 VG20THG020
02-12 VG20TGDO000
02-13 PBOT031501
02-14 VG29SPG010
02-15 VG20GRP010
02-16 PSCW062504

03 BARREL/FOREARM
03-1 VG27BRL030
03-2 VG27SRLO20
03-3 VG27GBK010
03-4 VG27GBK020
03-5 VG27SUR010
03-6 PSCW040403
03-7 VG27HGD000
03-8 VG27BRL010
03-9 PSCW040303
03-10 VG29BRL010
03-11 PSCW054004
03-12 VG27LURV010
03-13 VG27HGD030
03-14 VG27URV030

07 HOP SYSTEM
07-1 VG27THOP010
07-2 PRIG000026
07-3 PSCW030627
07-4 VG27THOP020
07-5 PRIG000052
07-6 V003TUB491
07-7 PBOT151002
07-8 VG29HOP020
07-9 VG29HOP030
07-10 VG29HOP010
07-11 PSCW260804
07-12 VG00HOP010
07-13 VG29HOP050
07-14 PSCW040503
07-15 VG29HOP060

08 TRIGGER SYSTEM
08-1 VG27LRV050
08-2 VG27FVN050
08-3 VG20SPG014
08-4 PSCW032522
08-5 VG27FVN000
08-6 VG29SPG009
08-7 VG29PLK000
08-8 VG20LRLV010
08-9 VG20SPG016
08-10 VG20THG011
08-11 VG28MSY110
08-13 VG20MSY020
08-14 VG20SPG011
08-15 PSCW030803
SUPREME PRECISION GRADE BBs
For Your Gas Rifle And Pistol  100% Made In Taiwan

Diameter
5.95mm ± 0.01mm

CERTIFICATIONS:
Biodegradable Test Report ISO 14855-1 in connection with DIN EN 13432
Certified EN71 part 3:2013
Compliant with ASTM D-6400-99 “Standard Specifications for Compostable Plastics”
The replica KAC Stoner SR25 Rifle MK11 MOD 0 is produced with the full cooperation and support of Knight's Armament Company, USA.

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