

TAVOR® SAR

SEMI-AUTOMATIC RIFLE

CALIBER: 5.56 NATO/.223 REM

WITH CONVERSION KIT FOR CAL. 5.45X39mm & 9X19mm



OPERATOR MANUAL



Read the instructions and warnings in this manual carefully and understand them before using this firearm. If there is anything you do not understand, seek advice from your retailer or someone qualified in the safe handling of firearms, or contact IWI US, Inc. at 717-695-2081 or service@iwi.us

This Operator Manual should always accompany this firearm and be transferred with it upon change in ownership, or when the firearm is loaned or transferred to another person.



IWI US, Inc.

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1 Warning



PRIOR TO REMOVING THIS GUN FROM ITS PACKAGING, AND PRIOR TO HANDLING, LOADING AND FIRING, CAREFULLY AND THOROUGHLY READ AND UNDERSTAND THE ENTIRE OPERATOR MANUAL WHICH GIVES ADVICE ON THE RIFLE'S PROPER HANDLING, FUNCTIONING AND SAFE USE. HOWEVER, YOUR SAFETY AND THAT OF OTHERS (INCLUDING YOUR FAMILY) DEPENDS ON YOUR RESPONSIBLE COMPLIANCE WITH THAT ADVICE, GOOD JUDGMENT AND COMMON SENSE. **FIREARMS SAFETY DEPENDS ON YOU.** YOU CANNOT FORGET, YOU CANNOT OVERLOOK, YOU CANNOT ALLOW YOURSELF TO BE DISTRACTED, YOU CANNOT BECOME COMPLACENT OR CASUAL WITH FIREARMS.

THERE ARE NO "FOOLPROOF" FIREARMS. ONCE A SHOT IS FIRED, IT CANNOT BE CALLED BACK. A FIREARM IN YOUR HANDS CAN CAUSE UNINTENDED DEATH OR SERIOUS BODILY HARM IF YOU FAIL TO FOLLOW SAFE GUN HANDLING RULES AND PRACTICES SUCH AS THOSE CONTAINED IN THIS MANUAL. **REMEMBER, FIREARMS SAFETY DEPENDS ON YOU!**

IF UNFAMILIAR WITH FIREARMS, SEEK SUPERVISED INSTRUCTION FROM A CERTIFIED INSTRUCTOR.

2 This Manual Contains

- Important **WARNING AND SAFETY PRECAUTIONS** that must be read and understood before using this firearm. **SAFE GUN HANDLING IS YOUR PERSONAL RESPONSIBILITY AT ALL TIMES.** Disregarding the warnings and safety precautions in this manual can result in injury or death to you and others and damage to property.
- *Directions and procedures* for handling, loading firing, unloading, disassembling and assembling this rifle.
- *Instructions* for care, cleaning and repair of this rifle.

This Operator Manual is designed to help you in learning how to properly and safely use and care for your TAVOR® SAR. Only when you are certain you have fully familiarized yourself with the function of your firearm, should you practice loading, unloading, and firing with live rounds of ammunition.

This Operator Manual should always accompany the firearm and be transferred with the rifle on change of ownership or possession. Should you ever need to replace it, this manual is available FREE upon request from IWI US, Inc. or on the IWI US, Inc. website at www.iwi.us.

3 Icons in This Manual

Before you start, familiarize yourself with the icons you will see in the manual.

HAZARDS



DANGER—indicates an imminently hazardous situation which, if not avoided, will result in death or serious injury.



WARNING—indicates a potentially hazardous situation which, if not avoided, could result in death or serious injury.



CAUTION—indicates a potentially hazardous situation which, if not avoided, could result in minor or moderate injury or an unsafe practice that can lead to property damage.

NOTE

notifies of particularly important information

4 Illustrations in This Manual

The illustrations in this manual may differ slightly from the actual product.

The illustrations in this manual relate to the **right hand shooter** configuration. When converting the rifle to the left hand configuration, reposition the part/component on the reverse side whenever prompted.

5 Dangerous Procedures



WARNING! Do not use a bolt assembly from another TAVOR® SAR in your rifle without first having the headspace checked by a competent gunsmith with “Go” and “No-Go” gauges. Failure to check the headspace may result in personal injury or death to you and others and could cause severe firearm damage.



WARNING! If your gun misfires with a live round in the chamber of a hot barrel, immediately remove the round while keeping the barrel pointed in a safe direction.

If unable to remove the live round within 10 seconds, remove the magazine, keep the gun pointed in a safe direction, and wait 15 minutes for the barrel to cool. Then remove the round.

Continuous or rapid firing of your gun can cause the barrel temperature to reach a **“COOKOFF POINT”**, where the heat of the barrel can cause a live round to fire from remaining in contact with a hot chamber. If you have been firing continuously or rapidly, do not allow a live round to remain in the chamber when you finish firing, as it may **“COOK OFF”** (FIRE). Always keep your face away from the ejection port when clearing a hot chamber.



WARNING! Never fire your gun with water, grease, excess oil, or any other obstruction in the barrel as this could cause the gun to explode! Be sure the barrel is clear of obstructions before shooting.



WARNING! When firing and you experience a noticeable difference in sound or recoil, **STOP FIRING!**

The cause for either condition could be incomplete powder burn, a cartridge with a primer but no powder (**“SQUIB LOAD”**), and/or a bullet stuck in the bore.

Immediately clear the gun and check for unburned powder residue in the bore and the receiver or a bullet stuck in the bore. Remove the unburned powder before resuming firing. If a bullet is stuck in the bore, have a qualified gunsmith take care of the problem. Never try to **“SHOOT OUT”** a bullet stuck in the bore. Firing with unburned powder in the barrel or a bullet stuck in the bore could cause the barrel to explode.

6 General Safety Rules and Procedures



WARNING! Careless and improper handling of this gun could result in unintended discharge causing injury, death or property damage. Safety must be the first and constant consideration when handling a firearm and ammunition. **SAFETY DEPENDS ON YOU.**



WARNING! This firearm was designed to function properly in its original condition. Do not alter any parts. Do not replace any parts unless you are factory-trained to do so and then use only original factory parts from IWI US, Inc.



WARNING! This firearm should always be carried with the chamber empty and with the safety **"ON SAFE"** to prevent accidental discharge.

Important Note:

This Operator Manual and the instructions and warnings contained in it are intended for the civilian or recreational user, target shooter, or hunter, and not necessarily for the law enforcement, security, military, or other "defensive" user. Defensive use of this or any other firearm involves unusual, serious risks, and may at times require deviation from certain of the safety rules and gun handling procedures contained in this manual. Such defensive procedures and deviations are beyond the scope of this manual. In order to use such defensive procedures safely requires intensive initial training and qualification from a proper professional source, followed by "in service" training and qualification at appropriate intervals. Anyone who has not been properly and professionally trained in defensive gun handling procedures must not attempt to use the TAVOR in any manner other than as set out in this Operator Manual. Doing so can result in serious injury or death.



WARNING! Always handle and treat your firearm as if it were loaded so you will never fire it accidentally when you mistakenly think it is unloaded. Never take anyone's word that it is unloaded. Always check it yourself with your fingers off the trigger and the gun pointed in a safe direction. Even after you confirmed that the gun is unloaded, continue to treat it as if it were loaded.



WARNING! Never place your fingers inside the trigger guard area unless you are aiming at a proper target and intend to fire. Instead, keep your trigger finger wrapped around the grip or braced on the gun's frame until you intend to fire. Do not fire until the safety selector has been moved to the FIRE position.



DANGER! DO NOT grasp the forward portion of the trigger guard/pistol grip frame with your non-shooting hand. If you do so, there is a chance your non-shooting hand or fingers could touch the trigger, unintentionally firing the rifle and resulting in death or serious injury.



WARNING! If your finger is on the trigger or inside the trigger area, you may unintentionally discharge the firearm if you are startled, if you lose your balance, if you exert muscular force with your other hand or arm or with either leg, or if something comes in contact with your hand, arm, or the gun. Always keep the safety "ON SAFE" and your finger outside the trigger area, wrapped around the grip or braced on the gun's frame, until you intend to fire.



WARNING! Keep the gun's muzzle pointed in a safe direction at all times. A safe direction is one in which an unintentionally fired shot will not cause any physical injury or property damage. Never let the muzzle of a firearm point at any part of your body or another person, or in any direction where an injury may result if the gun were to fire. Always be sure of your target and what's beyond and around it before firing.



DANGER! Due to its compact design, the TAVOR® SAR is shorter than some other rifles. Be sure to keep your forward hand firmly anchored on the rifle's foregrip. If you allow your hand to move forward onto the area of the flash suppressor and muzzle while firing, serious, permanent injury will result.



WARNING! UNLOAD ALL FIREARMS WHEN NOT IN USE. NEVER STORE A LOADED FIREARM. Firearms and ammunition should be stored separately under lock and key so that they are inaccessible to children or unauthorized users.

Never leave a loaded firearm, or any firearm or ammunition, unattended where an unauthorized user might have access to it. At the range, any firearm you lay down on the shooting bench should be unloaded, with its action locked open. Never lean or place a firearm where it could slide or fall, such as leaning it against a vehicle.

Never let the muzzle of a firearm touch the ground, or touch mud, sand or snow that might obstruct the bore, causing the barrel to burst when you fire. If you drop a firearm, pick it up carefully with it pointed in a safe direction (have all other people move out of the direction of the muzzle), with your finger outside the trigger area and the safety in the "ON SAFE" position. Then unload the firearm, and check to be sure there are no obstructions in the bore. This can be done with a cleaning rod, or by disassembling the firearm and looking down the bore from the chamber (rear) end. If there is any possibility of damage to your TAVOR® SAR, have it inspected by a qualified gunsmith, or return it to IWI US, Inc. for inspection, before you load or fire it again.



WARNING! Always make sure your firearm is not loaded before cleaning, storing, transporting or handing it to another person. Firearms should be transported unloaded and in a protective gun case.



WARNING! Whenever you pick up any firearm that, even for an instant, has been out of your direct, continuous control, the first thing you must do, while keeping the muzzle pointed in a safe direction and your fingers out of the trigger area, is to open the firearm's action (mechanism) to determine whether or not it is loaded.



WARNING! Always wear and require others to wear wraparound ANSI or OSHA approved safety glasses while shooting to protect your eyes from injury by gun powder gas, lubricant, dirt or metallic particles, carbon residue, sparks, bullet splashback from targets or other debris.



WARNING! Always wear and require others to wear ear protection when shooting. Without ear protection, the noise from your gun, and other guns close to you, could leave a “ringing” in the ears for some time after firing, and could result in permanent hearing loss.



WARNING! Learn the mechanical and handling characteristics of the firearm you are using. Not all firearms are the same, and your TAVOR® SAR rifle has some unique features. Do not assume that just because you have experience with other firearms, you know how to use the TAVOR® SAR rifle properly. Read and understand this manual. If there is anything you do not understand, contact your firearms retailer or IWI US, Inc. at service@iwi.us or telephone 717-695-2081.



WARNING! Never climb or descend a tree, fence or wall, jump across a stream or ditch, or attempt to cross an obstacle, ice, or precarious terrain while carrying a loaded firearm. Whenever you are going to do anything awkward, unload the gun first!



WARNING! Do not shoot at a hard surface, or at water or ice. The bullet may ricochet and travel in unpredictable directions to strike you or another unintended object or an object that you cannot see.



WARNING! A pistol bullet fired into the air can travel over one mile, and can kill or seriously injure someone when it comes down. A rifle bullet fired into the air can travel several miles, and can cause similar injury when it comes down. Never fire into the air, or at a target or animal in a tree or on the crest of a hill.



WARNING! Before hunting with this or any other firearm, take an approved Hunter Safety Course, taught in all states by the state game commission or by the National Rifle Association (NRA). Follow your state's game laws at all times while hunting.



WARNING! Firing a gun near livestock or other domestic animals may startle them and cause them to injure themselves, other animals, or people, or to cause property damage. Think first before you discharge any firearm.



WARNING! If you have not received formal firearms instructions or if you have any doubts about your ability to handle or use this firearm safely, seek supervised instruction from a certified instructor. Information about sources of firearms instruction can often be obtained from your local police department, firearms retailer, gun club, shooting range, state game commission, or from the National Rifle Association ("NRA"), 11250 Waples Mill Road, Fairfax, Virginia 22030, telephone 1-703-267-1000 or 1-800-672-3888.



WARNING! If at any time you notice something about the appearance or functioning of your TAVOR® SAR rifle that does not seem proper or that causes you concern, STOP, unload your rifle immediately, and do not load or fire your rifle until you have it inspected and, if necessary, repaired by a factory-trained armorer, or by IWI US, Inc. If you fire your TAVOR® SAR rifle extensively, have it professionally inspected and serviced periodically (annually is a good average interval) by a factory-trained armorer or by IWI US, Inc.



WARNING! Firearms and alcohol do not mix. Never drink alcoholic beverages or take drugs before or during shooting. This constitutes criminal disregard for your safety and that of others. Never use a firearm while you are taking medication unless you have checked with your doctor to ensure your fitness to handle your firearm safely. Do not handle your firearm when you are ill, tired, upset or distracted.



WARNING! Horseplay has no place around firearms. Guns can't think – you can! **SAFETY DEPENDS ON YOU!**



WARNING! Remember, safety is your responsibility. Be a safe shooter. **SAFETY DEPENDS ON YOU!**



WARNING! FOLLOW THE LAW. Obey all local, state and federal laws regarding possessing, storage, shooting and transporting your firearm.

REMEMBER, FIREARMS SAFETY DEPENDS ON YOU! THERE ARE NO "FOOLPROOF" GUNS, INCLUDING THE TAVOR® SAR. A SINGLE MOMENT OF INATTENTION OR A SINGLE FAILURE TO FOLLOW THESE GUN SAFETY RULES CAN RESULT IN TRAGEDY. YOU ARE RESPONSIBLE FOR THE GUN THAT IS IN YOUR HANDS, IN YOUR POSSESSION, OR UNDER YOUR CONTROL. FIREARMS SAFETY DEPENDS ON YOU!

7 Firearms Safe Home Storage Checklist

- Firearms naturally attract the attention of children, teenagers and adults alike. Accordingly, it is YOUR responsibility to ensure that your firearms, when unattended, stored, or not in use, are secured under lock and key, safely out of the access of all unauthorized users. This is YOUR responsibility, and any mistake or laziness on your part can result in death or serious injury to your loved ones or others.
- Firearms must be securely stored under lock and key in a location inaccessible to children and other unauthorized persons.
- One of the safest ways to store your firearms is in a locking metal gun safe or lock box. Many models, including ones permitting quick access to the firearm if needed for self-defense, are now available at firearms retailers or via the internet. Using the cable lock provided with your TAVOR® SAR rifle (see “Instructions for Using the Cable Lock” on page 23) is a good safety precaution, but not as good as locking your rifle in a metal gun safe, where it is also out of sight and protected from fire, theft, and curious hands.
- Sporting firearms should be unloaded before they are brought into the home and never loaded while in the home.
- Sporting firearms should be immediately cleaned and placed in secure locked storage when they are returned from hunting or target shooting.
- When firearms are removed from storage, they must always immediately be carefully checked to confirm that they are unloaded.
- Ammunition should be stored under lock and key, in a separate location from firearms.
- The operator manual that came with your firearm must be read, understood and followed.

For more information on safe storage and use, refer to the NSSF pamphlets “Firearms Safety Depends on You” and “Firearms Responsibility in the Home”, available for download from the NSSF website at <http://nssf.org>.

8 General Description

8.1 Features

The TAVOR® SAR features include:

- Chambered for 5.56 NATO/.223 REM ammunition.
- Rear center of gravity.
- Body made of reinforced polymer.
- Barrel and Chamber are hard chrome lined.
- Safety Lever has two positions: Fire (F) and Safe (S).
- Folding iron sights of aperture type.
- No special tools required for field stripping.
- Bolt Carrier Stop.
- Adaptable for right/left-handed shooter with easy parts change.
- MIL STD 1913 Rails to mount optional equipment.
- Conversion Kit for cal. 9x19 mm Parabellum.
- Conversion Kit for cal. 5.45x39 mm.
- Optional integral Reflex Sight.



DANGER! Like other “bullpup” rifle designs, the standard TAVOR® SAR should be fired only from the right shoulder. Left-handed shooters and others wishing to fire the TAVOR® SAR from the left shoulder, must purchase the TAVOR® SAR TSB16L, a factory stock left-hand model, or must convert the rifle to left-hand use and install the left-hand bolt (*see page 41*). Firing the standard TAVOR® SAR from the left shoulder or the TAVOR® SAR with left-hand Conversion Kit in place from the right shoulder **WILL RESULT IN EJECTED CASES STRIKING THE SHOOTER IN THE FACE WITH CONSIDERABLE FORCE, LIKELY CAUSING SERIOUS EYE INJURY AND OTHER INJURY. FIRE THE TAVOR® SAR RIFLE ONLY FROM THE SHOULDER FOR WHICH IT IS SET UP!**

8.2 Function Overview

The TAVOR® SAR is a semi-automatic rifle that functions based on a closed bolt principle, with rotational bolt locking and gas impact on its piston head.

The movement of the safety lever and trigger are transferred rearward to the sear mechanism with the aid of a bar in the side of the TAVOR® SAR's body.

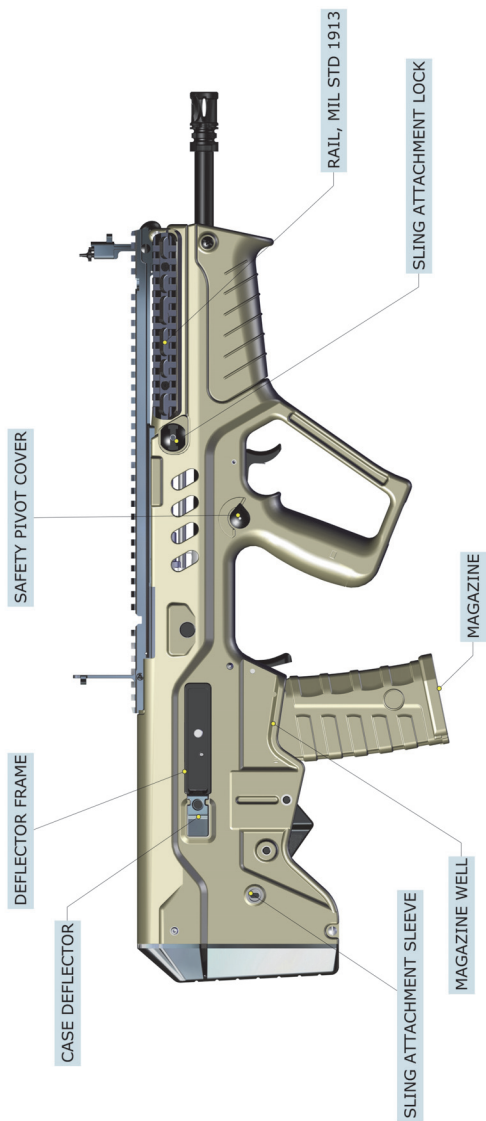
The TAVOR® SAR has a 1:7 in twist barrel for accurate firing of 5.56 NATO/.223 REM ammunition.

The TAVOR® SAR uses a NATO STANAG type 30-round magazine. IWI polymer magazines or other good quality AR-15 or M16 magazines may be used.

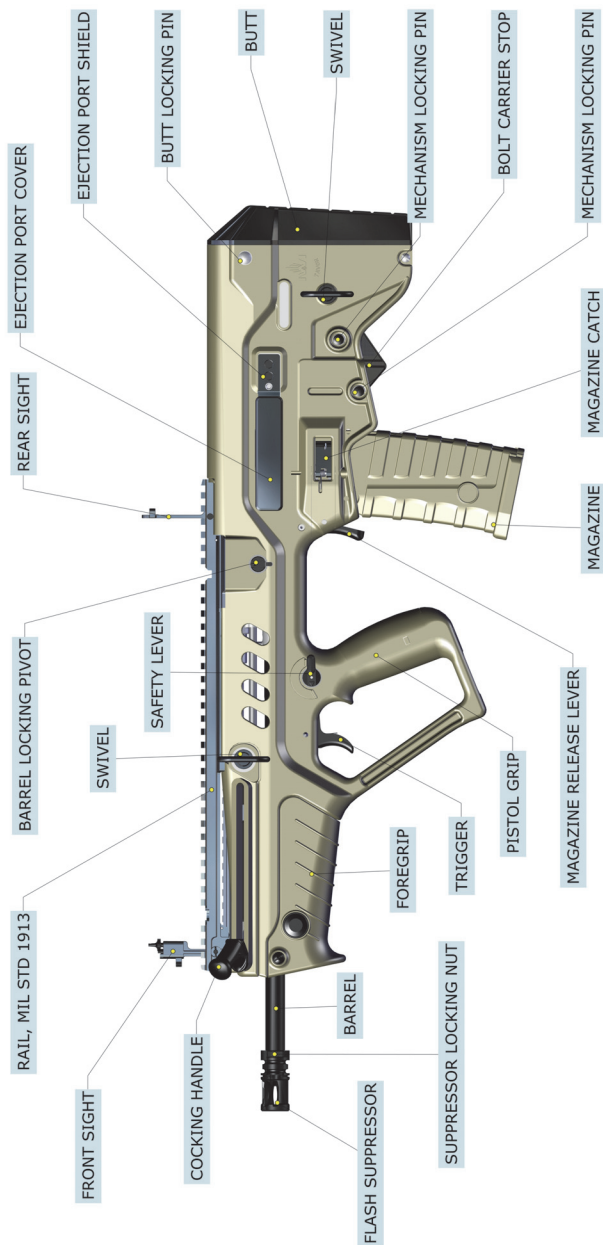
8.3 Technical Data

MODEL	TAVOR® SAR W/16.5" BARREL	TAVOR® SAR W/18" BARREL
CALIBER	.223 Remington/5.56 NATO	
AMMUNITION	M193/SS109 or other NATO or SAAMI specification ammunition	
OPERATION PRINCIPLE	Closed rotating bolt, long gas stroke on piston head	
FIRE MODE	Semi-Automatic	
WEIGHT (WEAPON ONLY)	7.9 Lbs.	8.5 Lbs.
OVERALL LENGTH	26⅞ inch	27⅞ inch
BARREL LENGTH	16½ inch	18 inch
RIFLING	Right Hand, 6 Grooves, 1:7 inch twist	
MUZZLE VELOCITY	2979 ft/sec (M193) 2929 ft/sec (SS109)	3044 ft/sec (M193) 2965 ft/sec (SS109)
SIGHTS	Folding front sight (blade) and rear sight (aperture)	
COLOR	Black, Flat Dark Earth	
OPTIONAL EQUIPMENT	• Integral MEPRO 21 Reflex Sight • Conversion Kit for cal. 9x19 mm Parabellum (<i>see page 38</i>) • Conversion Kit for cal. 5.45x39 mm (<i>see page 40</i>)	

8.4 Right External View



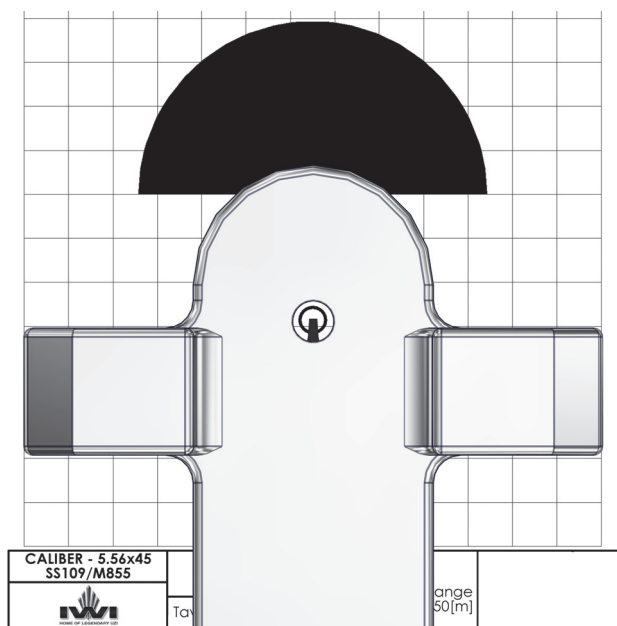
8.5 Left External View



8.6 Aiming System



Folding front and rear sights are of blade and aperture type respectively, which enables aiming by viewing the blade through the aperture, and visually centering the top of the blade in the aperture.



For more on the aiming system, (see “Adjusting the Sights” on page 30).

8.7 Ammunition



WARNING! Discharging firearms in poorly ventilated areas, cleaning or handling firearms, or handling ammunition may result in exposure to lead and other substances that may cause birth defects, reproductive harm, and other serious physical injury. Have adequate ventilation at all times. Wash your hands and face thoroughly after exposure, and before eating or drinking. Shooting or cleaning guns may expose you to lead, which is a toxic substance.

Use only high quality commercially manufactured ammunition in good condition of the appropriate caliber. The caliber of your rifle is marked on the barrel. The TAVOR® SAR is chambered in 5.56 NATO, which will also fire .223 Rem caliber ammunition. Use only NATO or SAAMI specification ammunition.

Not all ammunition produces the same result. IWI US, Inc. recommends that once you find a brand which functions best, keep using it.

IWI US, Inc. does not recommend using hand loads, reloads or remanufactured ammunition, or foreign or military surplus ammunition of unknown or questionable quality. The use of this ammunition will void the IWI US, Inc. warranty, and may be dangerous, possibly causing death or serious injury if the ammunition is not made to the proper specifications.

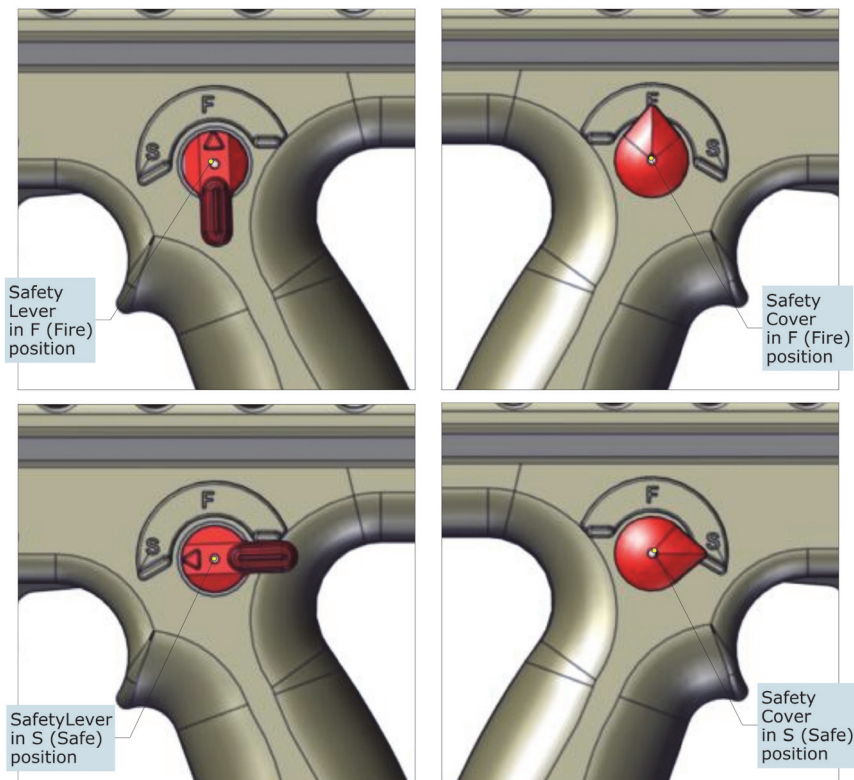
8.8 Safety Lever



WARNING! Safety is the first and foremost concern when handling any firearm. Always keep the muzzle pointed in a safe direction! Keep your fingers outside the trigger area until you are aimed at a proper (safe) target and intend to fire! Keep the safety lever "ON SAFE" until you are aimed at a proper target and only then move the safety lever to the FIRE position.

The Safety Lever is located on the left side of TAVOR® SAR body and has two positions: **FIRE (F)** and **SAFE (S)**.

The Safety Lever position is also visible from the right side of TAVOR® SAR body, with the tip of the safety cover pointing to the F or S markings.



Safety Lever Positions



WARNING! The Safety Lever is not intended as a replacement for safe gun handling practices. Do not rely on the Safety Lever alone to keep you and others safe.

For more details, (see “Function Test of the Safety Lever” on page 26).

9 Instructions for Using the Cable Lock

Your TAVOR® SAR rifle is supplied with a quality cable lock. Properly used, this lock will help you to secure your firearm from children and other unauthorized users to reduce the chance of an accident, either in the home or while transporting your firearm, provided you take the other reasonable safety precautions contained in this Operator Manual.



WARNING! NEVER attempt to use the cable lock on a loaded firearm - always unload the firearm before installing the cable lock. Otherwise, the firearm could discharge, causing death or serious injury.



WARNING! NEVER insert the cable lock into the trigger guard or trigger area of the TAVOR® SAR or any other firearm, as the cable could press against the trigger and fire the gun, causing death or serious injury.



WARNING! The cable lock supplied with your TAVOR® SAR rifle may not fit or work properly on other firearms. This lock is intended for use only on your TAVOR® SAR rifle..

To use the cable lock, do the following:

1. Be sure your firearm is empty (unloaded) by following the **Unloading and Safety Check** procedure on page 25.

Your TAVOR® SAR should now be unloaded, with the safety lever "ON SAFE" and the bolt carrier locked open (to the rear).



WARNING! Keep the muzzle pointed in a safe direction, your fingers outside the trigger area, and the safety lever "ON SAFE" throughout the process of putting the cable lock on your rifle.

2. Using the key, open the cable lock. Leave the key in the lock.
3. Insert the end of the cable lock cable through the ejection port and out through the empty magazine well.

4. Insert the end of the cable lock cable into the lock body and hold the end of the cable fully into the lock body while you turn and remove the key to lock the lock.
5. Tug hard on the cable several times to be sure the lock is locked securely.
Used in this way, the cable lock will prevent the TAVOR® SAR's bolt carrier from closing, preventing the rifle from being fired.
6. Take the key with you, or store the key securely in a remote location from the firearm.
7. Store your firearm in a secure place out of sight, and out of reach of children.

NOTE

While the cable lock can be an important part of your firearms security program, for home storage it is not as secure as locking your gun in a metal gun safe or lock box. Use of the cable lock alone will not prevent your firearm from being stolen, and will not keep your firearm out of view of unauthorized users. The cable lock can be cut off the firearm with a hacksaw, bolt cutter or cable cutter.

10 Operating Instructions



WARNING! Before your firearm left the factory, it was function tested, inspected and packaged. IWI US, Inc. can not control the product handling after it has left our factory. Therefore, at the time of purchase carefully examine the rifle to be sure it is unloaded and undamaged and all components are included. Seek your dealer's help for assistance in examining the firearm and to answer your questions.

10.1 Preparation for Firing



WARNING! Always handle and treat your firearm as if it is loaded! Never take anyone's word that it is unloaded. Keep the muzzle pointed in a safe direction at all times. Keep your fingers outside the trigger area until you are aiming at a safe target and intend to fire.

10.1.1 Unloading and Safety Check

To unload or clear your rifle of live ammunition or to make sure it is unloaded, keep the muzzle pointed in a safe direction and your finger outside the trigger area while performing the following steps:

1. Using your thumb, ensure that the Safety Lever is positioned to S (Safe).
2. Press the Magazine Release Lever and pull the magazine down and out of the rifle.
3. Hold the rifle grip with all five fingers.
4. Raise the muzzle of the rifle 60° upward.
5. Cock and release the Cocking Handle fully three times releasing the Cocking Handle to let the bolt carrier move forcefully each time (do not "RIDE" the cocking handle forward).

Lean slightly forward, turn the rifle so its butt is horizontal with its right side on top, and brace the butt of the rifle securely against the "pocket" where the top of your right thigh meets your waist. Pull and hold the Cocking Handle fully to the rear and move your right hand to push in the front end of the bolt carrier stop, letting the bolt then move slightly forward to lock the bolt back (to the rear).

6. Lower the muzzle 45° downward.
7. Check visually that the barrel chamber is empty ("CLEAR"). If there is not enough light for you to see clearly that the chamber is empty, use a flashlight or other artificial light. You must not "think" the chamber is empty, you must KNOW it is empty, because if you are wrong, death or serious injury may result.

8. Pull back on the Cocking Handle and release, or depress the rear of the bolt carrier stop, to close the bolt for storage. Be sure the safety lever is "ON SAFE" when you store the rifle.



WARNING! Check the rifle to make sure there is no excessive oil or other obstruction in the bore. Always clean a new rifle before firing!

10.1.2 Function Test of the Safety Lever



WARNING! Make sure the rifle is cleared, unloaded, the magazine has been removed, and the chamber is clear ("EMPTY") before performing the safety function test and that the muzzle is pointed in a safe direction at all time.

1. Pull the Cocking Handle to the rear and release. Place the Safety Lever in the S (Safe) position (see *(see Safety Lever Positions)* on page 22, bottom-left). Pull the trigger. The hammer should not fall (see *(see Hammer Positions)* on page 49, left).
2. Move the Safety Lever to the F (Fire) position (see *(see Safety Lever Positions)* on page 22, top-left). Pull the trigger. The hammer should fall (see *(see Hammer Positions)* on page 49, right).
3. Hold the trigger to the rear. Pull the Cocking Handle to the rear and release. Release the trigger with a slow and smooth motion until the trigger is fully forward. An audible click should be heard. The hammer should not fall.
4. With the hammer in the forward position (fired position), attempt to place the Safety Lever in the S (Safe) position. The Safety Lever should not be able to move to the S (Safe) position with thumb pressure.



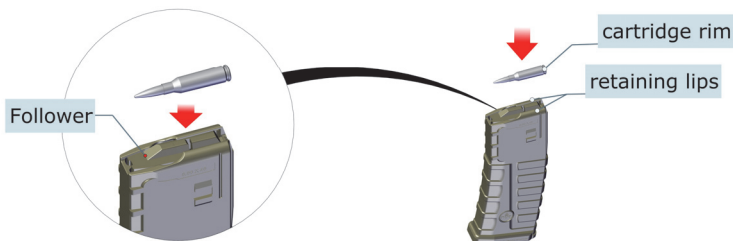
WARNING! If the rifle fails any of the following steps of the test, **do not load or use** the rifle and return it to IWI US, Inc. for inspection and repair.

10.2 Loading



WARNING! Always check that the ammunition is clean and undamaged, and the correct caliber for the rifle. Forcing damaged ammunition into the chamber could result in injury, death, damage to property and damage to your rifle.

1. To load the magazine:
 - a. With the front of the magazine forward, place a round between the magazine lips with the round pointed forward.
 - b. Push the round down into the magazine until it is retained by the magazine lips.

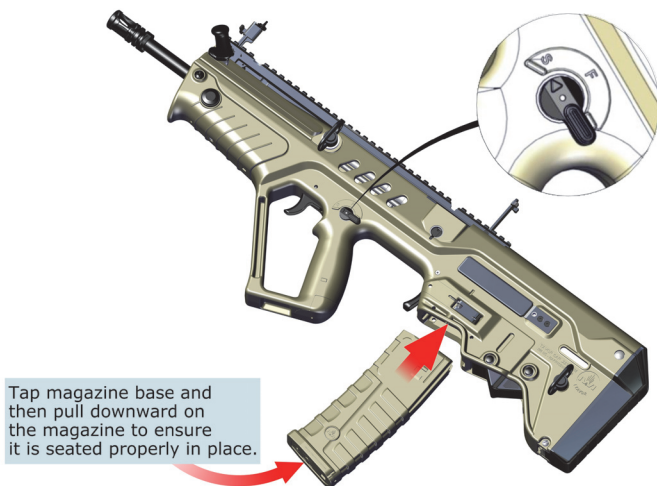


- c. Place the next round on top of the previous round and press down again. Repeat until the desired number of rounds are loaded.
2. To load the rifle:



WARNING! Always position the Safety Lever in the S (Safe) position when loading and unloading the firearm!

- a. Raise the rifle 60° up.
 - b. Hold the rifle grip with all five fingers.
 - c. Using your thumb, ensure that the Safety Lever is positioned to S (Safe).
 - d. Insert the magazine in the magazine well; tap the magazine base to ensure the magazine is locked in place.



- e. Cock the rifle by releasing the bolt to move forward forcefully (do not "RIDE" the bolt forward) if the bolt is locked open, or by pulling the cocking handle fully rearward and releasing if the bolt is closed.

THE RIFLE IS NOW READY TO BE FIRED WITH A ROUND IN THE CHAMBER AND THE SAFETY LEVER ON S (SAFE).

10.3 Firing



WARNING! Do not chamber a round until you are ready to fire the rifle. Always keep the muzzle pointed in a safe direction. Do not disengage the safety or put your finger into the trigger area until you are aimed at a safe target and intend to fire. Always wear eye and hearing protection when firing your rifle.

1. With the rifle loaded and the Safety Lever on S (Safe), firmly position the butt to your shoulder with one hand on the foregrip and the other hand on the pistol grip with the trigger finger alongside the rifle's frame or trigger guard. **DO NOT HAVE YOUR TRIGGER FINGER ON THE TRIGGER AT THIS TIME.**
2. Aim by aligning the front and rear sights on the target.

3. Move the Safety Lever to the F (Fire) position.
4. Gently pull the trigger until the hammer releases and the rifle fires. Release the trigger.



WARNING! This semi-automatic rifle will automatically eject the spent case and load the next round from the magazine into the chamber, ready to fire if you pull the trigger again.

Repeat pulling the trigger and releasing to fire the next round and subsequent rounds, until you are finished firing or the magazine is empty.

5. When finished firing, remove the finger from the trigger and move the Safety Lever to the S (Safe) position.

After the last round is fired from the magazine (when the magazine is empty), the bolt carrier will lock in the rear position.

...WHEN THE MAGAZINE IS EMPTY:

6. Remove the empty magazine by pressing the Magazine Release Lever.

To continue firing, insert another loaded magazine, release the bolt carrier stop and a new round will be chambered. Be careful because the rifle is now ready to fire again if the trigger is pulled.

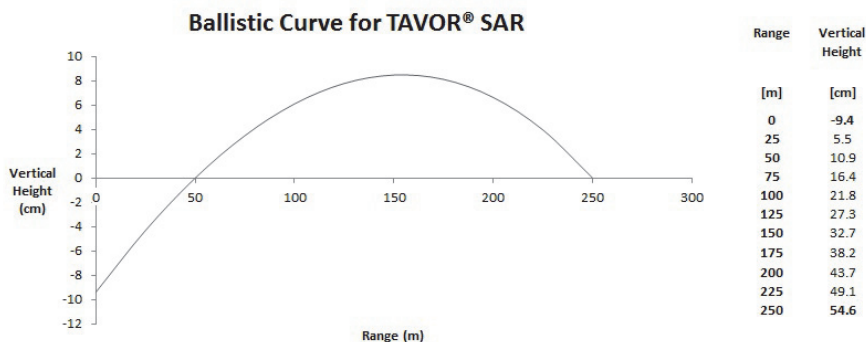
7. Whenever you stop firing, even momentarily, place the safety lever in the S (safe) position.
8. When you finish firing, unload the rifle and confirm that it is empty ("clear"). See the **Unloading and Safety Check** procedure on page 25.

11 Adjusting the Sights

11.1 Zeroing Procedure

1. Fire 5 rounds at a zeroing target placed at a 25 m distance.
2. Once you achieve your group, calculate the MPI (Mean Point of Impact, the geometrical center of all the points of impact).
3. Using the squares on the zeroing target, calculate the number of "clicks" needed to bring the MPI to the OPI (Optimal Point of Impact).

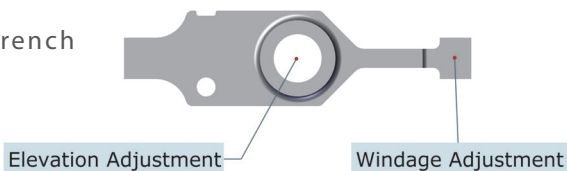
One click equals 1.4 cm (one square on the zeroing target) at 25 meters both for windage and elevation.



11.2 Zeroing Wrench

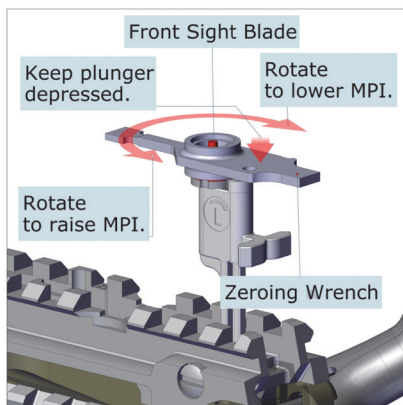
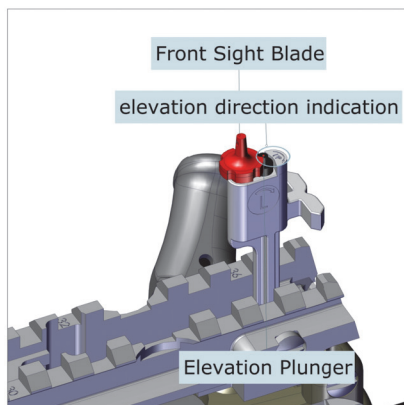
The zeroing correction is done by rotating the *front sight blade* (see left figure in paragraph 11.3) and *windage screw* (see left figure in paragraph 11.4) with the zeroing wrench (during rotation, clicks sound).

Zeroing wrench



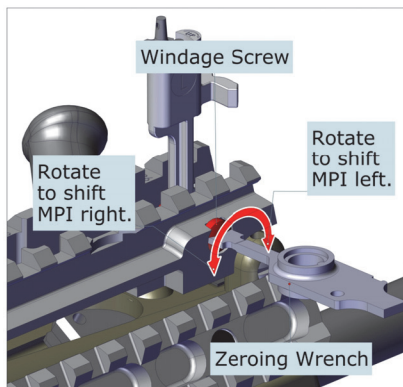
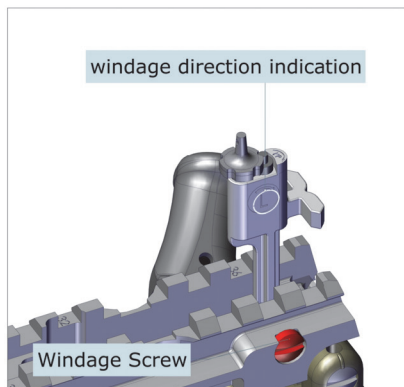
11.3 Adjusting Elevation

1. Hold the zeroing wrench with its shorter end pointing in the firing direction.
2. Place the zeroing wrench on the front sight blade and push it down to depress the elevation plunger.
3. While pressing the zeroing wrench, rotate it as follows:



11.4 Adjusting Windage

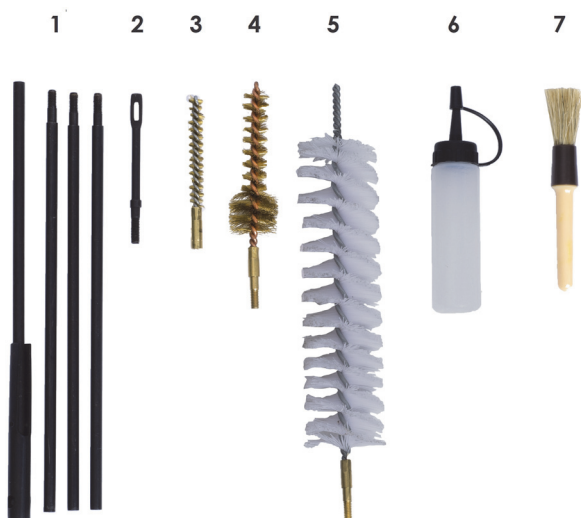
1. Insert the tip of the longer part of the zeroing wrench into the slot on the head of the windage screw.
2. Rotate the zeroing wrench as follows:



12 Stoppage Management

STOPPAGE	POSSIBLE CAUSE	MANAGEMENT
BOLT CARRIER IN FORWARD POSITION	• Magazine not seated properly. • No round in chamber. • Bolt not locked due to dirt or lack of lubrication. • Dud bullet.	1. Tap magazine base. 2. Cock firearm. 3. Continue firing.
	Firing pin broken or worn out.	Contact service@iwi.us.
BOLT CARRIER IN MIDDLE POSITION	• Double feeding -two rounds chambered simultaneously. • Cartridge case was not properly extracted.	1. Move safety lever to S ("SAFE") position and remove magazine. 2. Cock firearm with ejection port pointing towards the ground. 3. Insert magazine. 4. Cock firearm, disengage safety and continue firing.
	Faulty extractor or ejector.	Contact service@iwi.us.
BOLT CARRIER IN REAR POSITION	Magazine empty.	1. Move safety lever to S ("SAFE") position and remove magazine. 2. Insert a full magazine. 3. Cock or release bolt carrier stop to chamber a round. 4. Disengage safety and continue firing.

13 Cleaning & Maintenance



- 1 cleaning rods
- 2 cleaning rod slot tip
- 3 brass brush for barrel cleaning
- 4 chamber & barrel extension cleaning brush
- 5 internal receiver cleaning brush
- 6 oil can
- 7 general cleaning brush

13.1 Pre-Firing Maintenance

1. Perform **Unloading and Safety Check** (*see p. 25*).
2. Wipe out sand and dust from external parts with the general cleaning brush.
3. Perform **Primary Disassembly** (*see p. 45*).
4. Pass the cleaning rod with clean cleaning patch through the barrel and chamber to be sure the bore is not obstructed and to remove any grease or excess oil.
5. Perform **Primary Reassembly** (*see p. 46*).

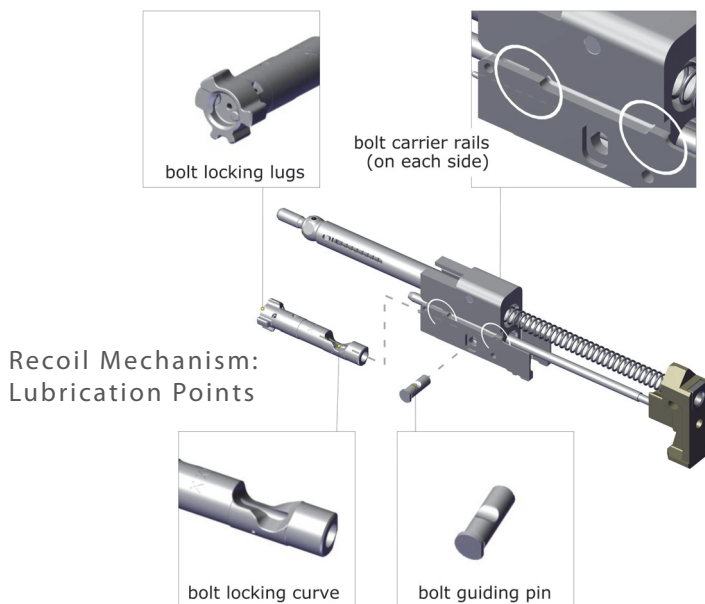
End of Task

13.2 Post-Firing Maintenance

1. Perform **Unloading and Safety Check** (*see p. 25*).
2. Perform **Primary Disassembly** (*see p. 45*).
3. Pass the cleaning rod with oily cleaning patch through the barrel.
4. Perform **Secondary Disassembly/Reassembly** (*see p. 51*) and lubricate as follows:

...for semi-automatic 5.56 NATO rifle:

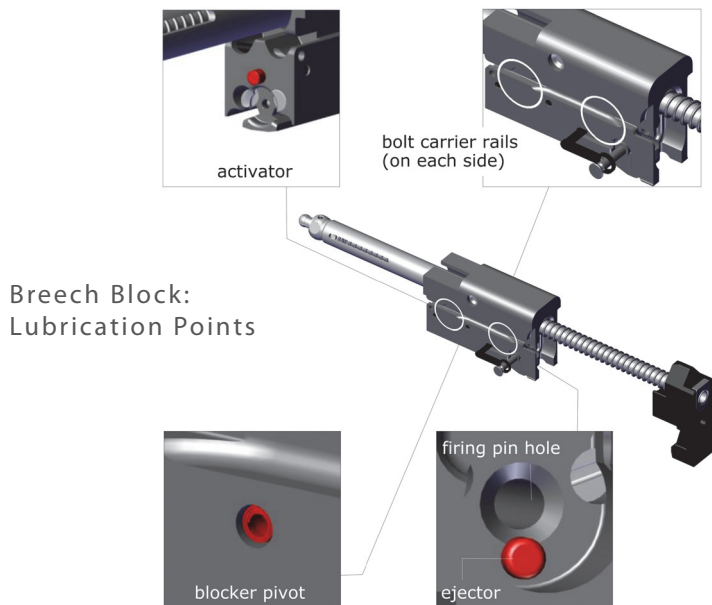
- a. Perform **Recoil Mechanism Partial Disassembly** (*see p. 51*).
- b. Clean the recoil mechanism's parts thoroughly.
- c. Apply a thin coat of oil to the following:



- bolt carrier rails on both sides: one drop of oil on each point of contact with the insert receiver rails
 - bolt locking lugs: one drop per lug
 - bolt locking curve
 - bolt guiding pin
- d. Perform **Primary Reassembly** (*see p. 46*).

...for rifle converted to Cal. 9x19 mm Parabellum:

- a. Perform **Breech Block Assembly Partial Disassembly** (see p. 52).
- b. Clean the breech block assembly's parts thoroughly.
- c. Lubricate as follows (see *Breech Block: Lubrication Points*):



- Place one drop of oil inside the firing pin hole. Insert the firing pin into its hole and pull it out. Repeat several times to ensure smooth movement.
 - Place one drop of oil on the ejector head. Depress the ejector several times to work the oil in.
 - Lubricate the rails on the breech block (one drop per side on both sides of the breech block).
 - Place one drop of oil on each tip of the blocker pivot.
 - Place one drop of oil on the head of the firing pin blocker activator. Depress the firing pin blocker activator several times to work the oil in.
- d. Perform **Breech Block Assembly Reassembly** (see p. 54).

5. Perform **Primary Reassembly** (see p. 46).

End of Task

13.3 Periodic Maintenance

1. Perform **Unloading and Safety Check** (*see p. 25*).
2. Perform **Primary Disassembly** (*see p. 45*).
3. Remove the **Sear Mechanism** (*see page 48*).
4. Clean the recoil mechanism using cleaning mixture.
5. Clean the exterior body with the general cleaning brush.
6. Use the chamber and barrel extension cleaning brush to clean the chamber and locking lugs on the barrel extension.
7. Use the internal receiver cleaning brush to clean the interior body.
8. Perform **Secondary Disassembly/Reassembly** (*see p. 51*) and lubricate as follows:

...for semi-automatic 5.56 NATO rifle:

- a. Perform **Recoil Mechanism Partial Disassembly** (*see p. 51*).
- b. Clean the recoil mechanism's parts thoroughly.
- c. Lubricate according to the instructions in **step c** on page 34.
- d. Check the integrity of the bolt and firing pin surface and the springiness of the extractor and ejector.
- e. Perform **Recoil Mechanism Reassembly** (*see p. 53*).

...for rifle converted to Cal. 9x19 mm Parabellum:

- a. Perform **Breech Block Assembly Partial Disassembly** (*see p. 52*).
 - b. Clean the breech block assembly's parts thoroughly.
 - c. Lubricate according to the instructions in **step c** on page 35.
 - d. Check the breech block surface to be sure it is intact.
 - e. Perform **Breech Block Assembly Reassembly** (*see p. 54*).
9. Lightly lubricate the hammer spring (*see Sear Mechanism: Lubrication Points*).

Sear Mechanism:
Lubrication
Points



10. Install the **Sear Mechanism** (*see page 49*).
11. Perform **Primary Reassembly** (*see p. 46*).
12. Check the integrity of the foregrip and cocking handle and the proper operation of the safety lever.

End of Task

14 Rifle Conversion

14.1 Conversion to Cal. 9x19 mm Parabellum

Components & Parts

- TAVOR® SAR
- Conversion Kit to Cal. 9x19 mm Parabellum

Initial Setup

- 1 **Unloading and Safety Check** of the rifle performed (*see page 25*).
- 2 **Primary Disassembly** performed (*see page 45*).



Conversion Procedure



WARNING! KEEP THE MUZZLE POINTED IN A SAFE DIRECTION AT ALL TIMES. REMOVE ALL AMMUNITION FROM THE WORK AREA BEFORE YOU BEGIN.

To convert between the 5.56 NATO and 9x19 mm Parabellum calibers, perform the following tasks:

To convert the barrel:

1. Remove the Long Flattop Rail (*see page 57*).
2. Remove the Front Swivel and Lock (*see page 58*).
3. Remove the Foregrip Group (*see page 60*).
4. Remove the Cocking Group (*see page 61*).
5. Remove the Barrel Group (*see page 64*).
6. Change the barrel group to Cal. 9x19 mm Parabellum:
 - a. Disassemble the Barrel Group (*see page 66*).
 - b. Replace the 5.56x45 mm barrel unit with the 9 mm barrel unit and reassemble the Barrel Group (*see page 67*).
7. Install the Barrel Group (*see page 65*).
8. Install the Cocking Group (*see page 61*).
9. Install the Foregrip Group (*see page 60*).
10. Install the Front Swivel and Lock (*see page 59*).
11. Install the Long Flattop Rail (*see page 57*).

To replace the deflector:

1. Remove the Deflector (*see page 69*).
2. Remove the Deflector Frame (*see page 70*).
3. Install the 9 mm deflector assembly according to instructions of **Installing the Deflector** (*see p. 69*)

To accommodate the 9 mm magazine:

Install the 9 mm Magazine Adapter Assembly (*see page 74*).

To reassemble the rifle:

1. Replace the recoil mechanism with the breech block assembly.
2. Perform **Primary Reassembly** (page 46).
3. Perform **Unloading and Safety Check** (page 25).



End of Task

14.2 Conversion to Cal. 5.45x39 mm

Components & Parts

- TAVOR® SAR
- Conversion Kit to Cal. 5.45x39 mm

Initial Setup

- 1 **Unloading and Safety Check** of the rifle performed (see page 25).
- 2 **Primary Disassembly** performed (see page 45).
- 3 **Recoil Mechanism Partial Disassembly** performed (see page 51).



Conversion Procedure



WARNING! KEEP THE MUZZLE POINTED IN A SAFE DIRECTION AT ALL TIMES. REMOVE ALL AMMUNITION FROM THE WORK AREA BEFORE YOU BEGIN.

To convert between the calibers 5.56 mm and 5.45x39 mm, perform the following tasks:

To convert the barrel:

1. Remove the Flash Suppressor and Locking Nut (*see page 56*).
2. Removing the Long Flattop Rail (*see page 57*).
3. Remove the Front Swivel and Lock (*see page 58*).
4. Remove the Foregrip Group (*see page 60*).
5. Remove the Cocking Group (*see page 61*).
6. Remove the Barrel Group (*see page 64*).
7. Replace the 5.56x45 mm barrel to 5.45x39 mm barrel:
 - a. Separate the barrel assembly and the rail bases according to instructions in **Disassembling the Barrel Group** (*page 66*).
 - b. Replace the 5.56x45 mm barrel assembly with the 5.45x39 mm barrel assembly according to instructions in **Reassembling the Barrel Group** (*page 67*).
8. Install the barrel unit according to instructions in **Installing the Barrel Group** (*page 65*).
9. Install the Cocking Group (*see page 61*).
10. Install the Foregrip Group (*see page 60*).
11. Install the Front Swivel and Lock (*see page 59*).
12. Install the Long Flattop Rail (*see page 57*).
13. Install the Flash Suppressor and Locking Nut (*see page 56*).

To replace the deflector:

1. Remove the Deflector (*see page 69*).
2. Installing the 5.45x39 mm deflector according to instructions in **Installing the Deflector** (*page 69*).

To convert the bolt:

Replace the 5.56x45 mm bolt assembly with the 5.45x39 mm bolt assembly and perform **Recoil Mechanism Reassembly** (page 53).

To reassemble the rifle:

1. Perform **Primary Reassembly** (page 46).
2. Perform **Unloading and Safety Check** (page 25)..



End of Task

14.3 Conversion to Left Hand Configuration

Components & Parts

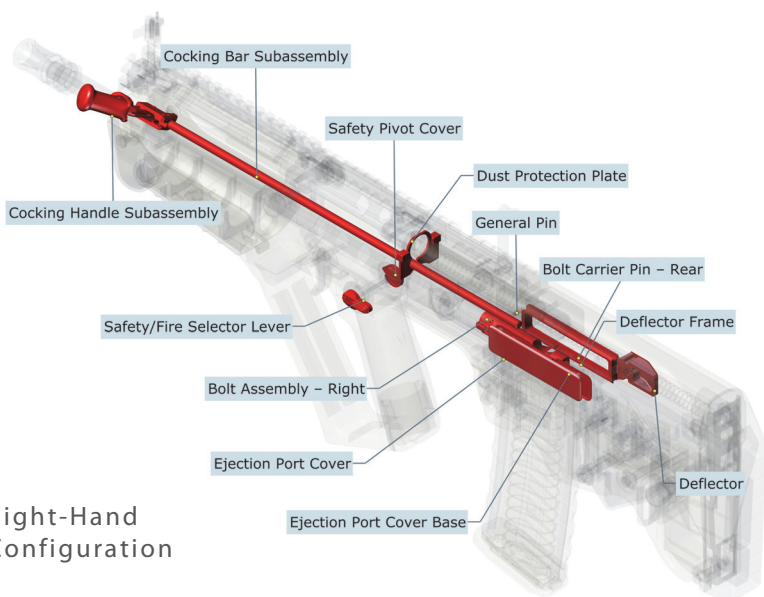
- TAVOR® SAR
- Bolt assembly-left

Initial Setup

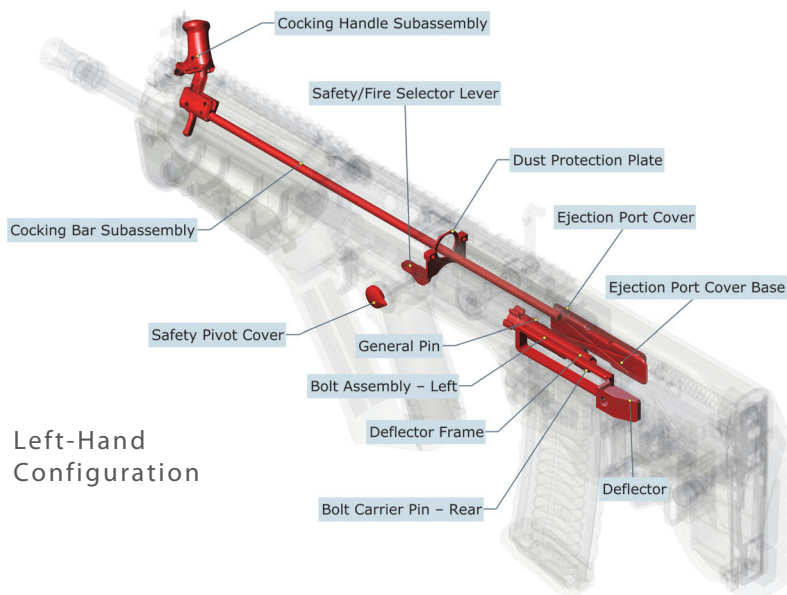
- 1 **Unloading and Safety Check** of the rifle performed (see page 25).
- 2 **Primary Disassembly** performed (see page 45).
- 3 **Recoil Mechanism Partial Disassembly** performed (see page 51).



Right-Hand Configuration



Left-Hand Configuration





WARNING! KEEP THE MUZZLE POINTED IN A SAFE DIRECTION AT ALL TIMES. REMOVE ALL AMMUNITION FROM THE WORK AREA BEFORE YOU BEGIN.

To convert between the right hand and left hand configurations, perform the following tasks:

To shift the cocking handle to the right:

1. Remove the Long Flattop Rail (*see page 57*).
2. Remove the Front Swivel and Lock (*see page 58*).
3. Remove the Foregrip Group (*see page 60*).
4. Remove the Cocking Group (*see page 61*).
5. Converting the cocking group to the left hand shooter:
 - a. Disassemble the Cocking Group (*see page 62*).
 - b. Reinstall the cocking bar and cocking handle on the right side according to instructions in **Reassembling the Cocking Group** (*page 63*).
6. Remove the Barrel (*see page 64*).
7. Convert the dust protection plate to left hand shooter:
 - a. Remove the Gas Cylinder and Dust Protection Plate (*see page 67*).
 - b. Position the dust protection plate so that the cocking bar hole is on the right and install the Gas Cylinder (*see page 68*).
8. Install the Barrel Group (*see page 65*).
9. Install the Cocking Group (*see page 61*).
10. Install the Foregrip Group (*see page 60*).
11. Install the Front Swivel and Lock (*see page 59*).
12. Install the Long Flattop Rail (*see page 57*).

To shift the fire selector lever to the right:

1. Remove the Safety Lever and Safety Pivot Cover (*see page 72*).
2. Reposition the Safety Lever and Safety Pivot Cover (*see page 73*) on the reverse sides (*see page 73*)..

To shift the deflector to the left:

1. Remove the Deflector (*see page 69*).
2. Remove the Deflector Frame (*see page 70*).
3. Remove the Ejection Port Cover and Cover Base (*see page 71*).
4. Reinstalling the parts on the reverse sides according to instructions in **Installing the Ejection Port Cover and Cover Base** (*page 71*).

To convert the moving parts to the left hand shooter:

...for semi-automatic 5.56 NATO rifle:

1. Reinstall the bolt carrier rear pin and the general pin on the bolt carrier left side (*see page 75*).
2. Replace the right bolt assembly with the left bolt assembly and perform **Recoil Mechanism Reassembly** (*page 53*).

...for rifle converted to Cal. 9x19 mm Parabellum:

Reinstall the general pin on the left side of the breech block (*see page 77*).

To reassemble the rifle:

1. Perform **Primary Reassembly** (*page 46*).
2. Perform **Unloading and Safety Check** (*page 25*).



End of Task

15 Disassembly & Reassembly Instructions



WARNING! Be sure the rifle is unloaded before starting the disassembly! Keep the muzzle pointed in a safe direction except when the rifle is disassembled and incapable of firing.

15.1 Primary Disassembly/Reassembly

Tools

None.

Initial Setup

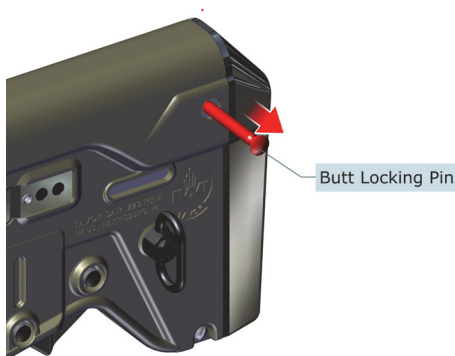
Unloading and Safety Check of the rifle performed (*see page 25*).

Primary Disassembly

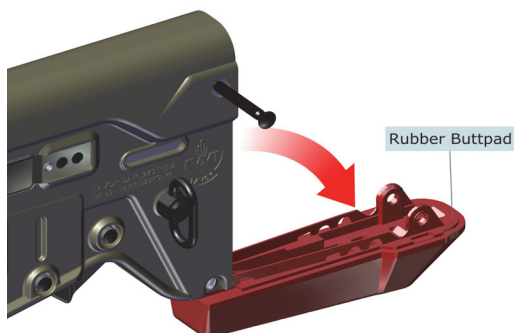
1. Push the butt locking pin on the right side and pull it through the rifle to the left side until it stops..

NOTE

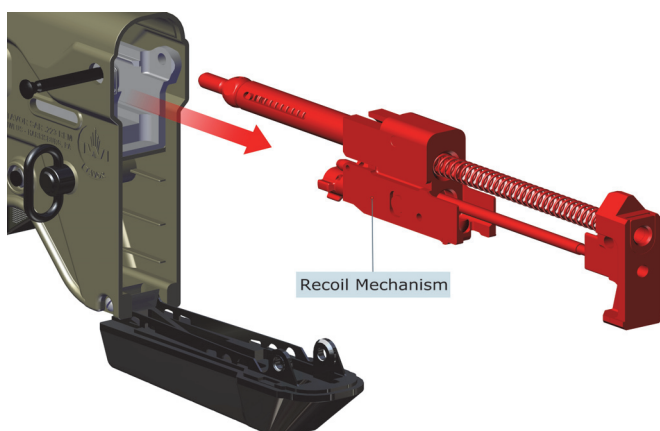
The pin has a detent to prevent it from being pulled out completely.



2. Open the butt.



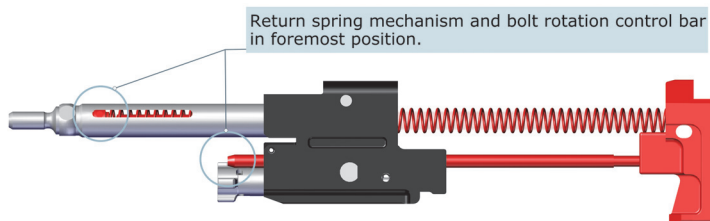
3. Pull the recoil mechanism out of the rifle.



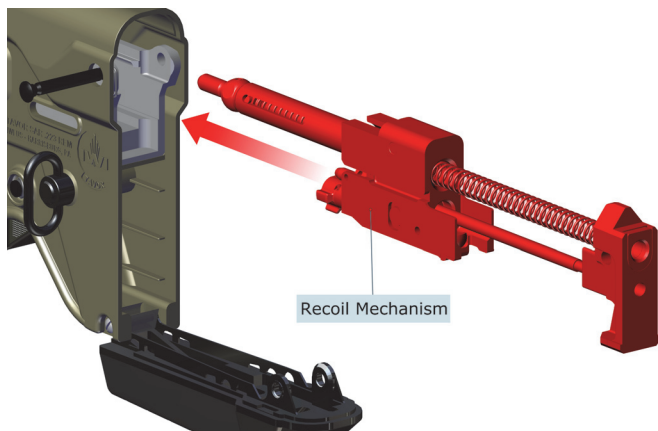
End of Task

Primary Reassembly

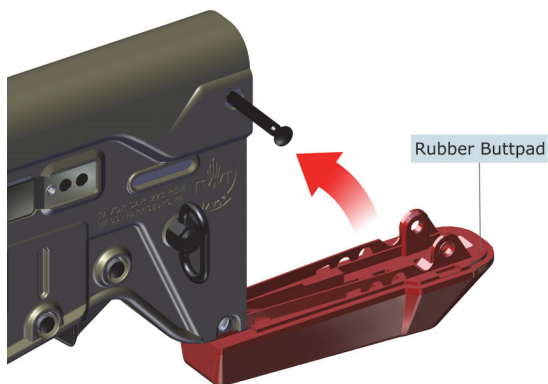
1. Move the return spring mechanism to its foremost position.



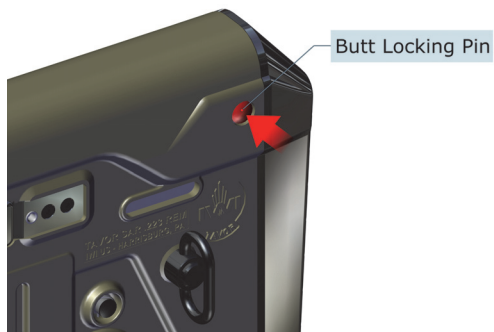
- Slide the recoil mechanism forward into the body through the rear.



- Close the butt.



- Press the butt locking pin to lock the butt.



- Perform **Unloading and Safety Check** (*see p. 25*).

End of Task

15.2 Removal/Installation of Sear Mechanism

Tools

None.

Initial Setup

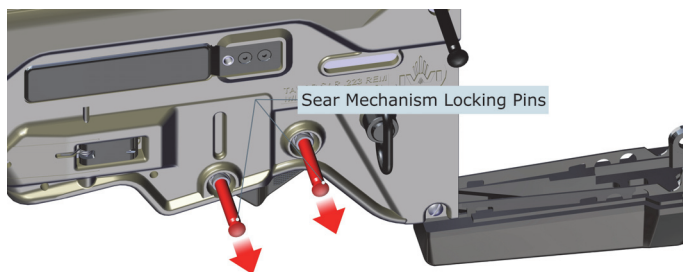
- 1 **Unloading and Safety Check** of the rifle performed (*see page 25*).
- 2 **Primary Disassembly** performed (*see page 45*).

Removing the Sear Mechanism

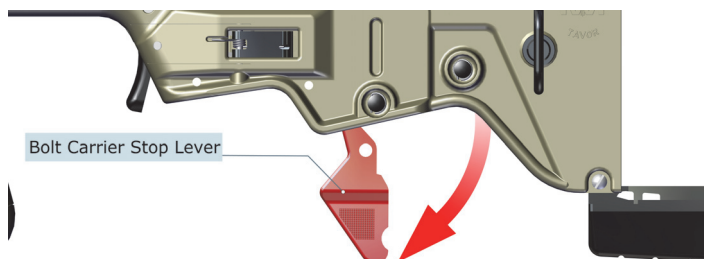
1. Press both locking pins on the right side and pull them through the rifle to the left side until they stop.

NOTE

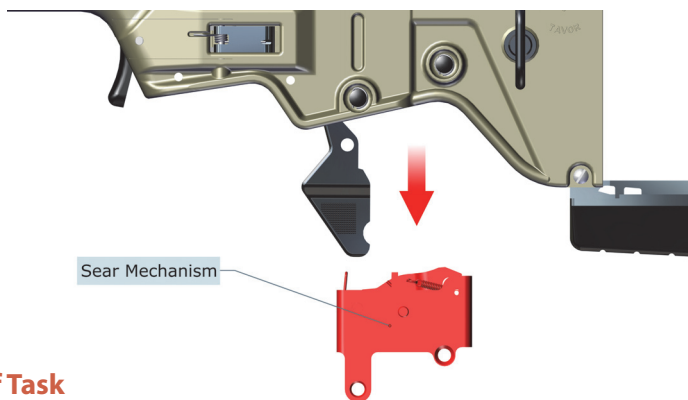
The pins have detents to prevent them from being pulled out completely.



2. Open the bolt carrier stop lever.



3. Pull the sear mechanism out of the rifle.

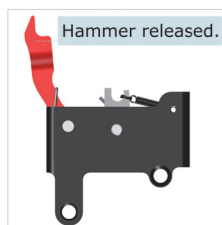


End of Task

Installing the Sear Mechanism

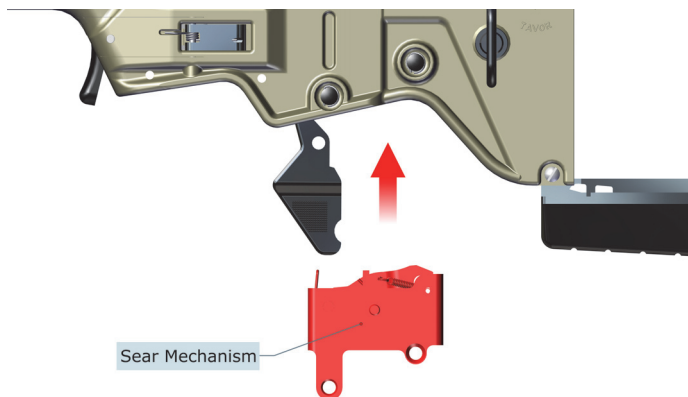


CAUTION! Be sure the Hammer is cocked during the installation procedure (*see Hammer Positions*).

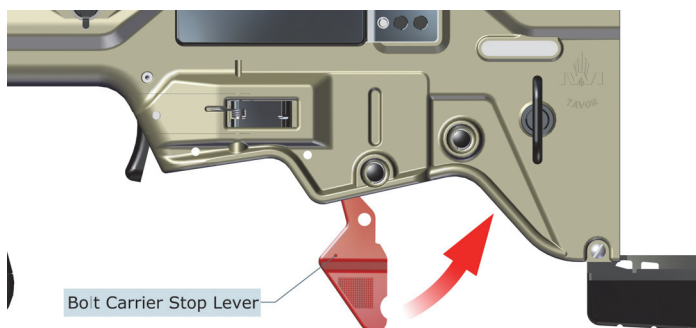


Hammer
Positions

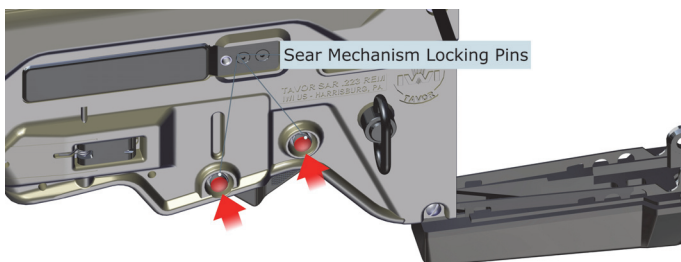
1. Position the sear mechanism inside the rifle body.



2. Close the bolt carrier stop lever.



3. Push the locking pins all the way into the body to secure the sear mechanism and the bolt carrier stop lever in place.



End of Task

15.3 Secondary Disassembly/Reassembly

Secondary Disassembly

...for semi-automatic 5.56 NATO rifle:

Recoil Mechanism Partial Disassembly

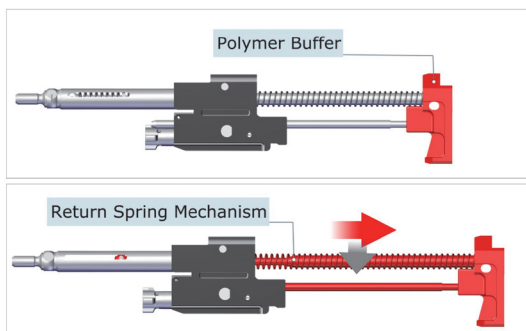
Tools

- punch 5 mm
- plastic hammer

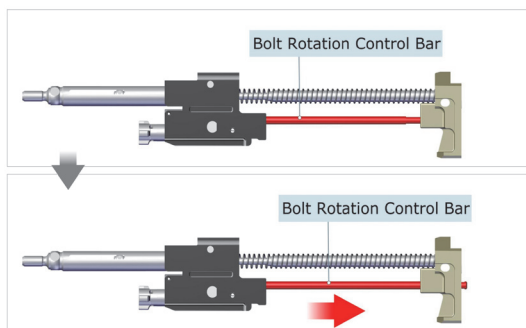
Initial Setup

- **Primary Disassembly** performed (*see page 45*).

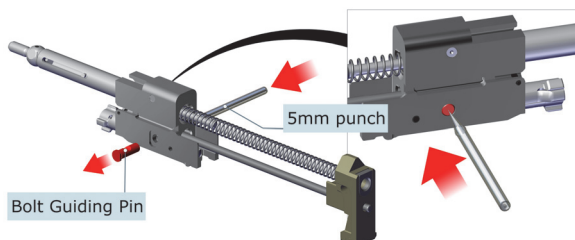
1. Pull on the buffer and move the return spring mechanism all the way to the rear.



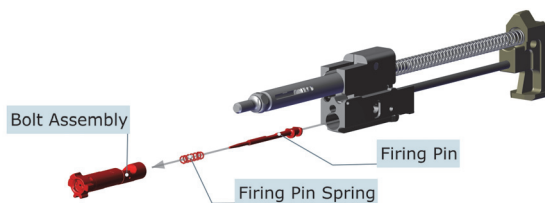
2. Draw the bolt rotation control bar all the way to the rear.



- Using a 5 mm punch, push the bolt guiding pin out of the bolt carrier.



- Extract the bolt assembly, firing pin spring, and firing pin from the bolt carrier.



End of Task

...for rifle converted to Cal. 9x19 mm Parabellum:

Breech Block Assembly Partial Disassembly

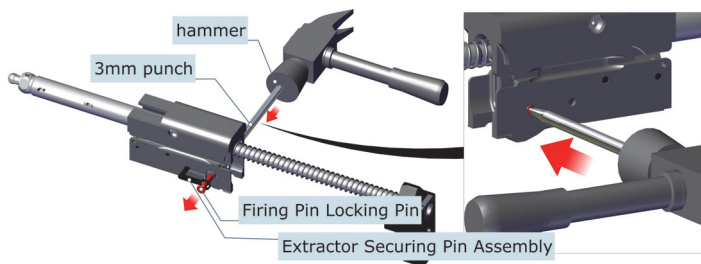
Tools

- punch 3 mm
- plastic hammer

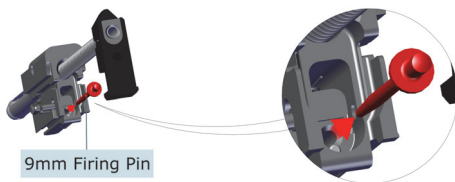
Initial Setup

- Primary Disassembly performed (see page 45).

- Using a 3 mm punch and a hammer, slightly push the firing pin locking pin on the right side of the breech block until it is stopped by the detent against the locking spring. **DO NOT PUSH THE FIRING PIN LOCKING PIN OUT COMPLETELY.**



2. Remove the firing pin from the breech block.



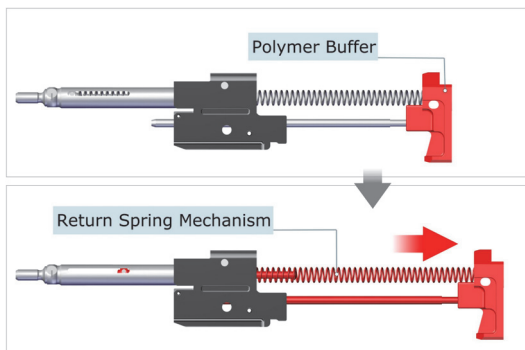
End of Task

Secondary Reassembly

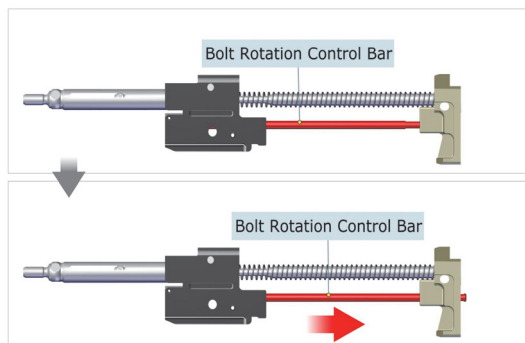
...for semi-automatic 5.56 NATO rifle:

Recoil Mechanism Reassembly

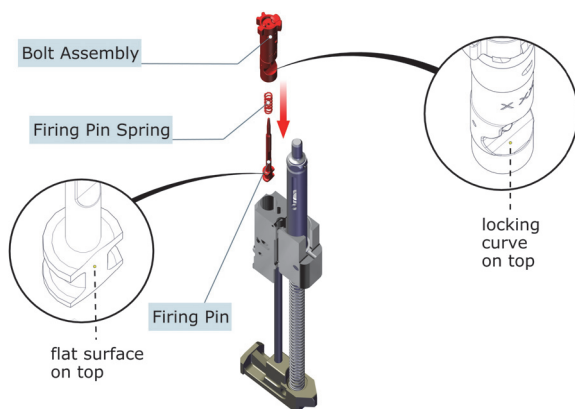
1. Pull on the buffer and move the return spring mechanism all the way to the rear.



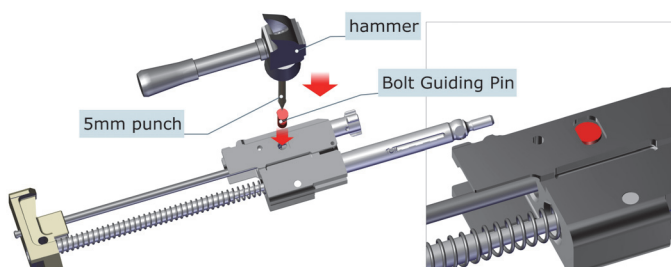
2. Draw the bolt rotation control bar all the way to the rear.



3. Insert the firing pin, firing pin spring, and bolt assembly, in the bolt carrier.



4. Install the bolt guiding pin using a 5 mm punch and a hammer.

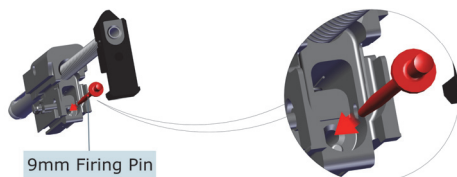


End of Task

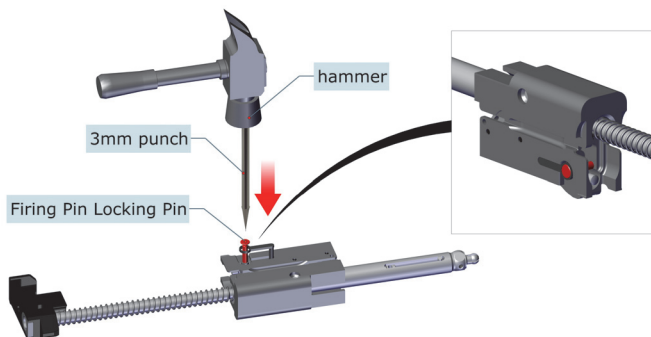
...for rifle converted to Cal. 9x19 mm Parabellum:

Breech Block Assembly Reassembly

1. Insert the firing pin into the breech block.



2. Using a hammer and a 5 mm punch, push the firing pin locking pin all the way into the breech block.



End of Task



STOP! You should not disassemble your TAVOR® SAR rifle any further, unless you are a factory-trained and certified armorer.



WARNING! Further disassembly by individuals who are not factory trained and certified as TAVOR® SAR armorers can result in damage to or destruction of the rifle, voiding of the warranty, and possibly the creation of **UNSAFE CONDITIONS THAT COULD RESULT IN DEATH OR SERIOUS INJURY.**

15.4 Removal/Installation of Flash Suppressor and Locking Nut

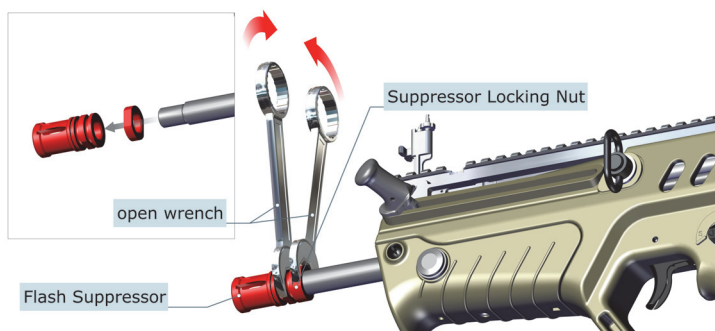
Tools

Initial Setup

- open wrenchx2 1 **Unloading and Safety Check** of the rifle performed (*see page 25*).
- 2 **Primary Disassembly** performed (*see page 45*).

Removing the Flash Suppressor and Locking Nut

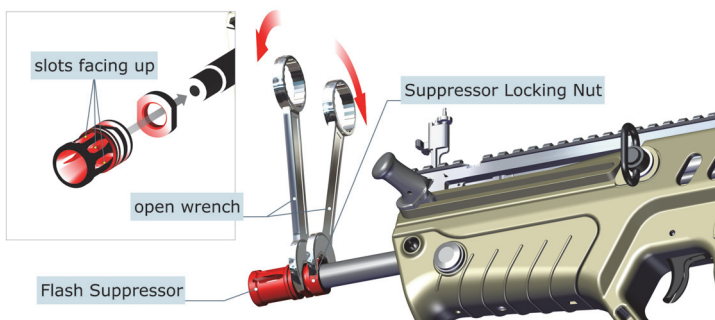
Unscrew the flash suppressor and its locking nut from the barrel using two open 19 mm wrenches.



End of Task

Installing the Flash Suppressor and Locking Nut

Mount the locking nut and flash suppressor on the barrel so that the suppressor slots are facing up. Screw into place using two open 19 mm wrenches.



End of Task

15.5 Removal/Installation of Long Flattop Rail

Tools

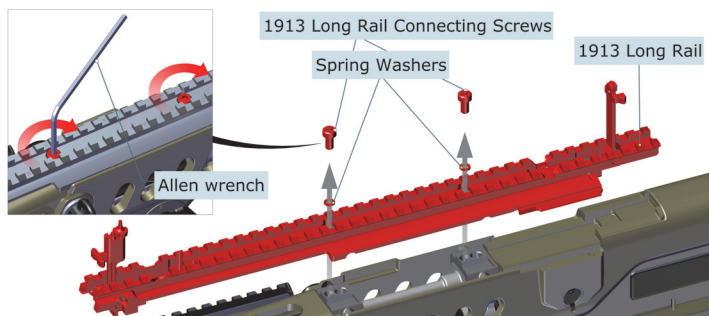
- Allen wrench
- Loctite glue 242/270

Initial Setup

- 1 **Unloading and Safety Check** of the rifle performed (*see page 25*).
- 2 **Primary Disassembly** performed (*see page 45*).

Removing the Long Flattop Rail

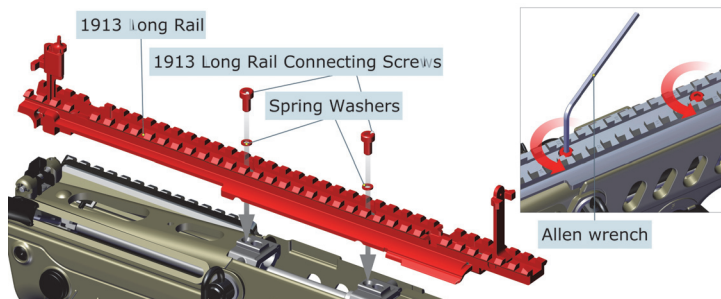
Using an Allen wrench, unscrew both connecting screws and remove the long rail. Keep both rail bases connected to the barrel.



End of Task

Installing the Long Flattop Rail

1. Position the long rail on the rail bases.
2. Apply a thin coat of Loctite 242 or similar to both rail connecting screws. Place the screws on the rail and tighten the screws using an Allen wrench.



End of Task

15.6 Removal/Installation of Front Swivel and Lock

Tools

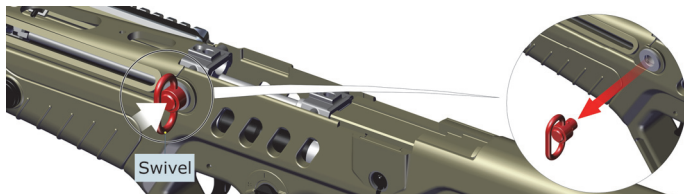
- punch
2 mm

Initial Setup

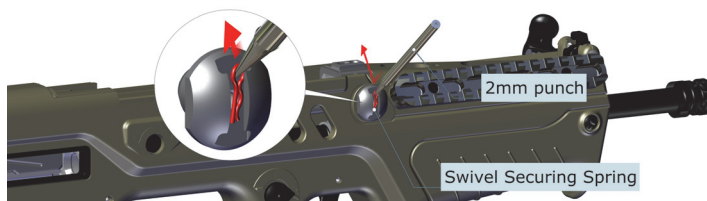
- 1 **Unloading and Safety Check** of the rifle performed (*see page 25*).
- 2 **Primary Disassembly** performed (*see page 45*).

Removing the Front Swivel and Lock

1. Press the swivel button and remove the front swivel from its sleeve.



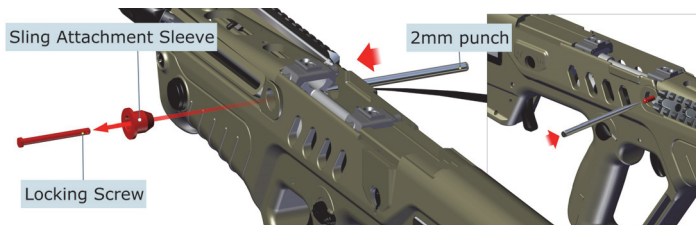
2. Insert a 2 mm punch in the eye of the securing spring and pull the securing spring out of its recess in the sling attachment lock.



3. Unscrew the sling attachment lock by rotating counter-clockwise.



4. Using a 3 mm punch, push out the swivel sleeve and locking screw.



End of Task

Installing the Front Swivel and Lock

1. Insert the swivel sleeve and locking screw into place on the rifle body.



2. On the rifle opposite side, install the sling attachment lock.



3. Insert the securing spring into the sling attachment lock.



4. Position the front swivel on the swivel sleeve and push into place



End of Task

15.7 Removal/Installation of Foregrip Group

Tools

- Phillips screwdriver
- Loctite glue 242/270

Initial Setup

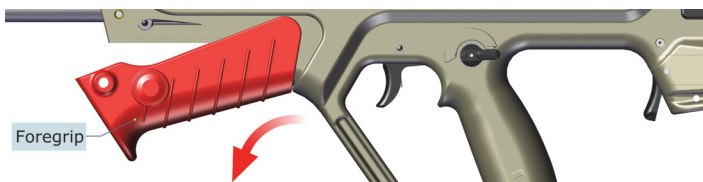
Front Swivel and Lock removed (*see page 58*).

Removing the Foregrip Group

1. Unscrew the foregrip fastening screws on both sides of the rifle using a Phillips screwdriver.



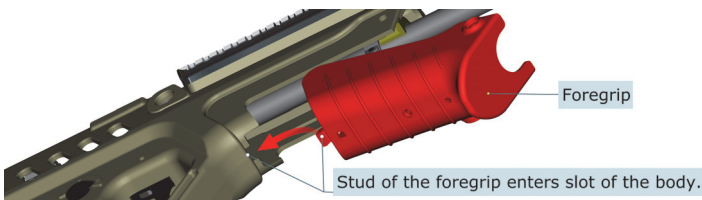
2. Hold the foregrip by its front section and pull the foregrip group down gently from the rifle body.



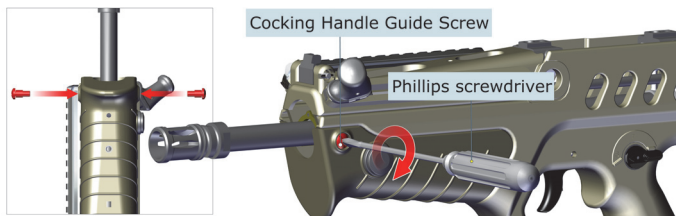
End of Task

Installing the Foregrip Group

1. Place the foregrip on the rifle body, so that the stud on the foregrip enters the slot on the body.



2. Apply a thin coat of Loctite No. 242 or similar to both foregrip fastening screws, tighten the screws using a Phillips screwdriver.



End of Task

15.8 Removal/Installation of Cocking Group

Tools

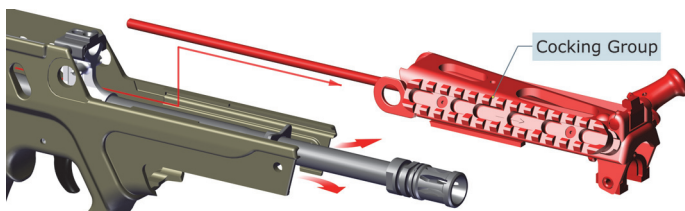
None.

Initial Setup

Foregrip group removed (*see page 60*).

Removing the Cocking Group

Slightly pull the body walls apart and remove the cocking group.



End of Task

Installing the Cocking Group

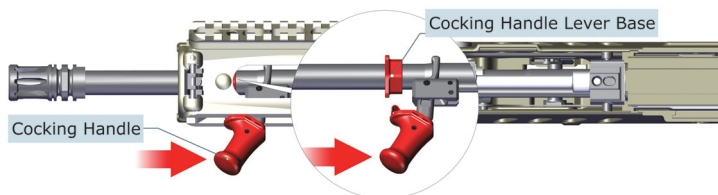


CAUTION! Verify the white mark on the barrel locking pivot is aligned with L (Locked) (*see step 2 of Installing the Barrel Group on page 66*).

1. Insert the cocking group into the rifle body, so that the cocking bar enters its hole on the dust protection plate.



2. Move the cocking handle behind the cocking handle lever base.



End of Task

15.9 Partial Disassembly/Reassembly of Cocking Group

Tools

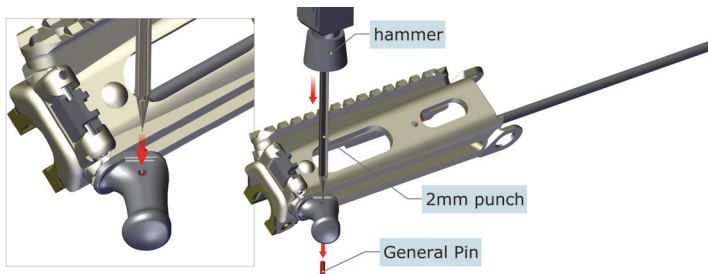
- Allen wrench
- punch 2 mm

Initial Setup

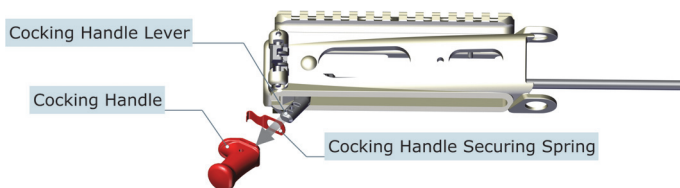
Cocking group removed (*see page 61*).

Disassembling the Cocking Group

1. Remove the cocking handle and cocking bar subassembly as follows:
 - a. Using a 2 mm punch, push the general pin out of the cocking handle.



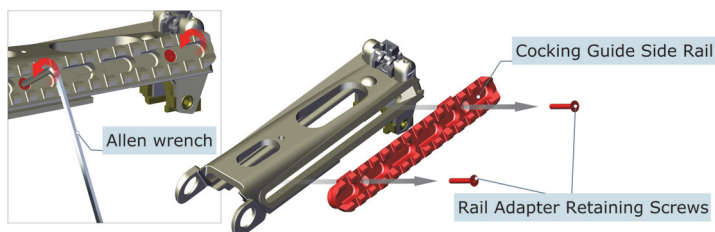
- b. Pull the cocking handle and its securing spring off the cocking guide.



- c. Separate the cocking bar subassembly from the cocking guide.



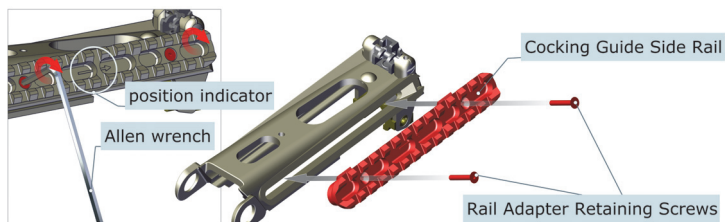
2. Use an Allen wrench to unscrew both retaining screws and separate the side rail from the cocking guide.



End of Task

Reassembling the Cocking Group

1. Position the side rail on the correct side* of the cocking guide according to arrow direction (position indicator). Tighten the retaining screws with an Allen wrench.



*. The illustrations in this manual relate to the right hand shooter configuration. When converting the rifle to the left hand configuration, reposition the part/component on the reverse side whenever prompted.

2. Install the cocking bar subassembly and cocking handle subassembly as follows:
 - a. Position the cocking bar subassembly on the correct side of the cocking guide according to the shooter configuration.



- b. Assemble the cocking handle and its securing spring on the cocking handle lever.



End of Task

15.10 Removal/Installation of Barrel Group

Tools

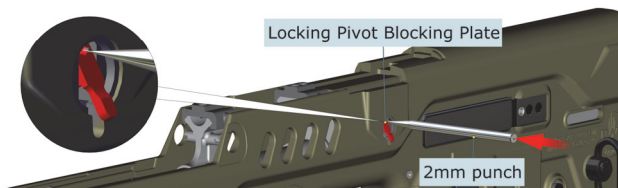
- punch 2 mm
- barrel wrench

Initial Setup

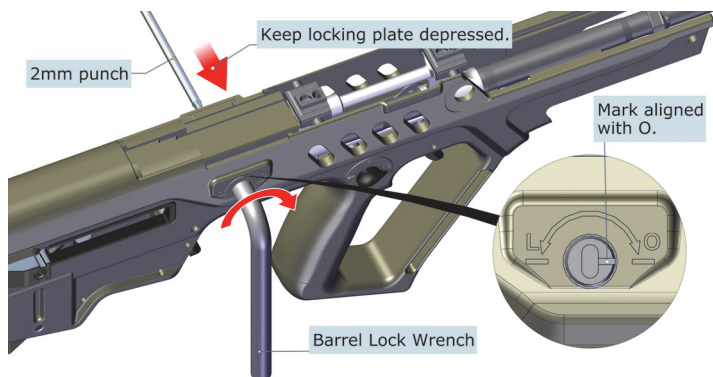
- 1 **Long Flattop Rail** removed (*see page 57*).
- 2 **Cocking Group** removed (*see page 61*).

Removing the Barrel Group

1. Using a 2 mm punch, unlock the blocking plate of the barrel locking pivot.

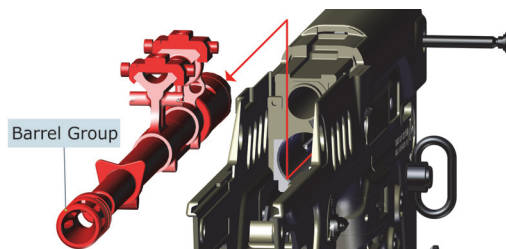


2. While pressing the barrel locking pivot from the left, rotate it 180° clockwise with the barrel wrench, so that the white mark on the barrel locking pivot becomes aligned with O (Open).



The barrel is now unlocked.

3. Pull the barrel group out of the rifle.



End of Task

Installing the Barrel Group

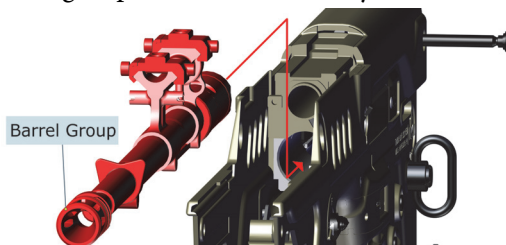


CAUTION! Verify the white mark on the barrel locking pivot is aligned with O (Open) (see **step 2 of Removing the Barrel Group** on page 64).

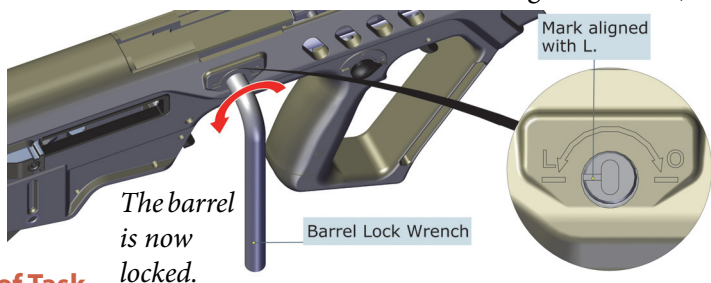
NOTE

*Verify the Dust Protection Plate is installed according to the shooter configuration to accommodate the cocking bar (see **step 1 of Installing the Gas Cylinder and Dust Protection Plate** on page 68).*

1. Position the barrel group inside the rifle body.



- Using the barrel wrench, rotate the barrel locking pivot 180° counter-clockwise, so that the white mark becomes aligned with L (Locked).



End of Task

15.11 Partial Disassembly/Reassembly of Barrel Group

Tools

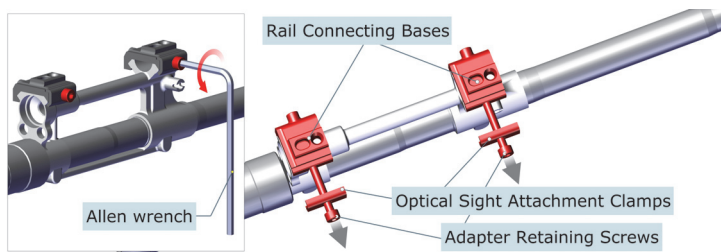
- Allen wrench 3 mm

Initial Setup

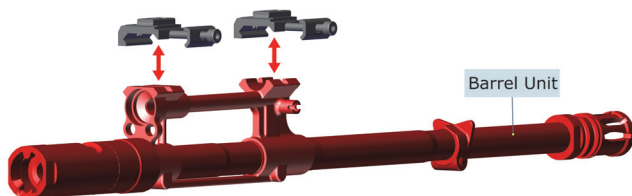
Barrel Group removed (*see page 64*).

Disassembling the Barrel Group

- Using a 3 mm Allen wrench, release both adapter retaining screws. **DO NOT REMOVE THE SCREWS COMPLETELY—KEEP THEM CONNECTED TO THEIR BASES.**



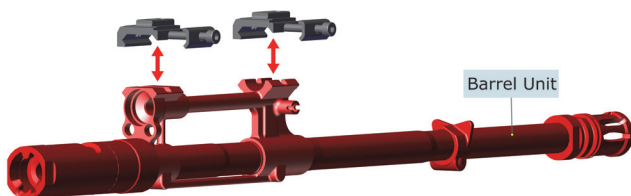
- Separate the barrel unit from the connecting bases.



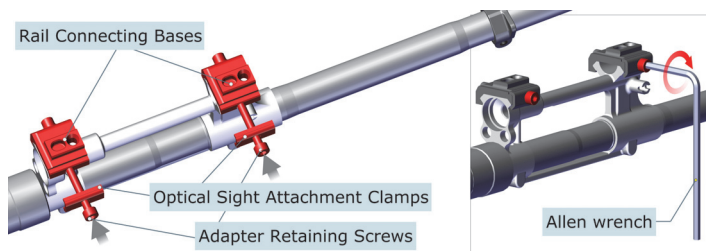
End of Task

Reassembling the Barrel Group

1. Install the rail bases group on the sight base.



2. Tighten the adapter retaining screws on their bases using a 3 mm Allen wrench.



End of Task

15.12 Removal/Installation of Gas Cylinder and Dust Protection Plate

Tools

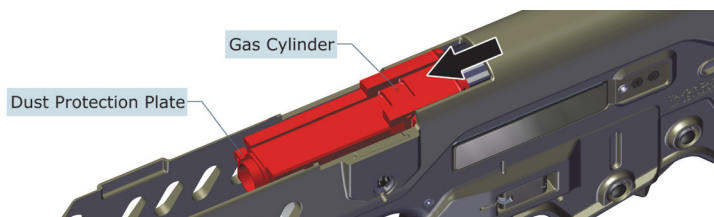
None.

Initial Setup

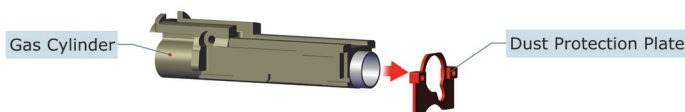
Barrel Group removed (*see page 64*).

Removing the Gas Cylinder and Dust Protection Plate

1. Push the gas cylinder forward and remove the gas cylinder and dust protection plate unit from the rifle body.



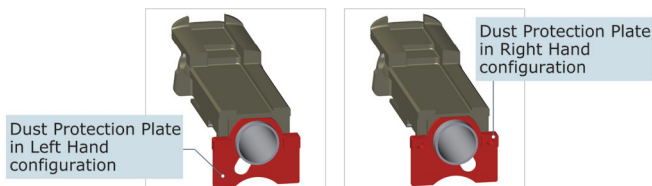
2. Separate the dust protection plate from the gas cylinder.



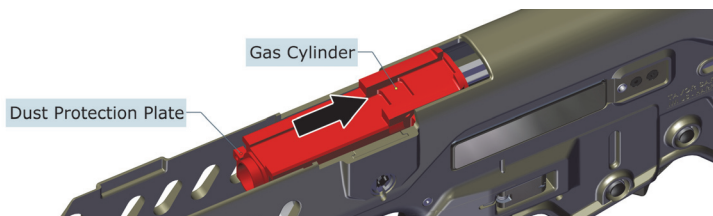
End of Task

Installing the Gas Cylinder and Dust Protection Plate

1. Position the dust protection plate on the gas cylinder according to the shooter configuration.



2. Insert the gas cylinder and dust protection plate unit into the rifle body and push it into place.



End of Task

15.13 Removal/Installation of Deflector

Tools

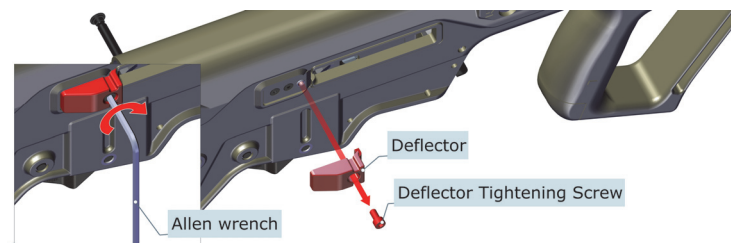
- Allen wrench

Initial Setup

1. **Unloading and Safety Check** of the rifle performed (*see page 25*).
2. **Primary Disassembly** performed (*see page 45*).

Removing the Deflector

Using an Allen wrench, unscrew the deflector tightening screw and remove the deflector.



End of Task

Installing the Deflector

Position the deflector and its tightening screw on the ejection port shield on the correct side of the rifle^{*}; tighten the screw using an Allen wrench.



End of Task

^{*}. The illustrations in this manual relate to the right hand shooter configuration. When converting the rifle to the left hand configuration, reposition the part/component on the reverse side whenever prompted.

15.14 Removal/Installation of Deflector Frame

Tools

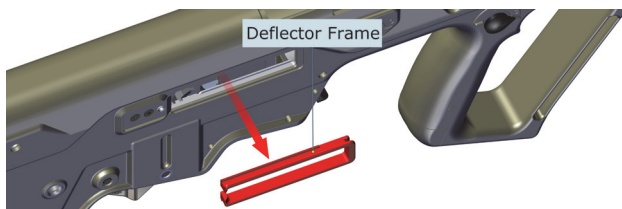
None.

Initial Setup

Deflector removed (*see page 69*).

Removing the Deflector Frame

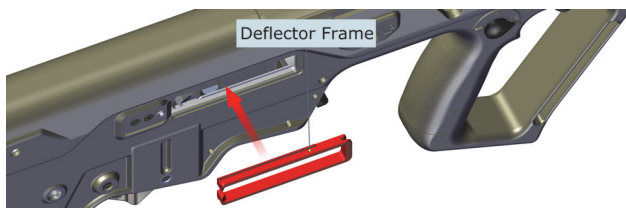
Remove the frame from the rifle body.



End of Task

Installing the Deflector Frame

Position the deflector frame in its place on the rifle body, on the correct side* according to the shooter's configuration.



End of Task

*. The illustrations in this manual relate to the right hand shooter configuration. When converting the rifle to the left hand configuration, reposition the part/component on the reverse side whenever prompted.

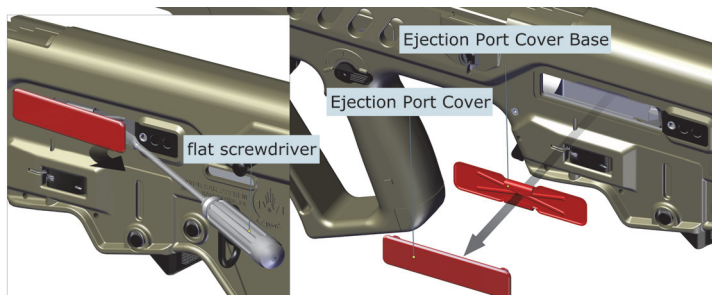
15.15 Removal/Installation of Ejection Port Cover and Cover Base

Tools Initial Setup

- flat screwdriver 1 Unloading and Safety Check of the rifle performed (*see page 25*).
- 2 Primary Disassembly performed (*see page 45*).

Removing the Ejection Port Cover and Cover Base

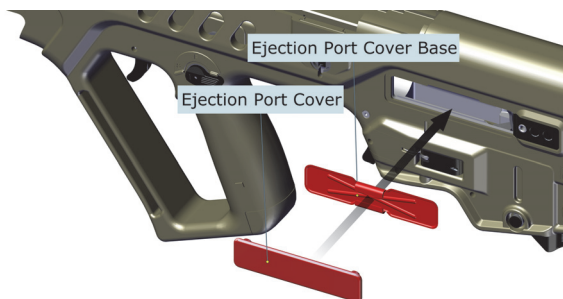
Using a flat screwdriver, gently pry up one edge of the ejection port cover. Remove the cover and its base from the rifle body.



End of Task

Installing the Ejection Port Cover and Cover Base

Position the ejection port cover base and port cover on the correct side of the rifle body*, according to the shooter's configuration.



End of Task

*. The illustrations in this manual relate to the right hand shooter configuration. When converting the rifle to the left hand configuration, reposition the part/component on the reverse side whenever prompted.

15.16 Removal/Installation of Safety Lever and Safety Pivot Cover

Tools Initial Setup

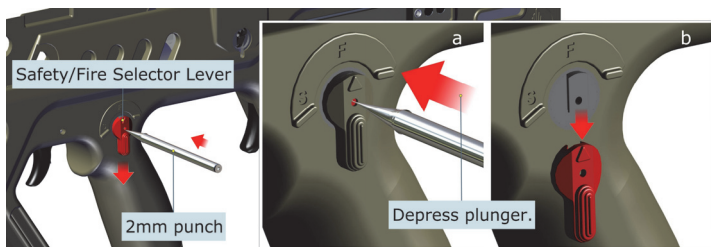
- punch 2 mm
- 1 Unloading and Safety Check of the rifle performed (*see page 25*).
 - 2 Primary Disassembly performed (*see page 45*).

Removing the Safety Lever and Safety Pivot Cover

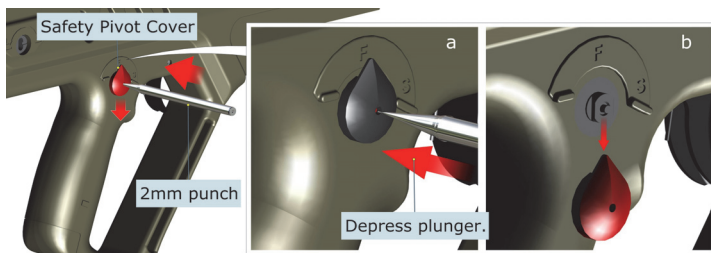
- 1 Move the Safety Lever to the F (Fire) position.



- 2 On the rifle left-hand side, depress the safety plunger with a 2 mm punch and slide the fire selector lever off the safety assembly.



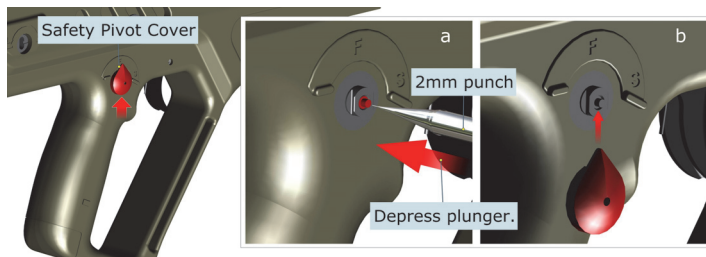
- 3 On the rifle right-hand side, depress the safety plunger with a 2 mm punch and slide the safety pivot cover off the safety assembly.



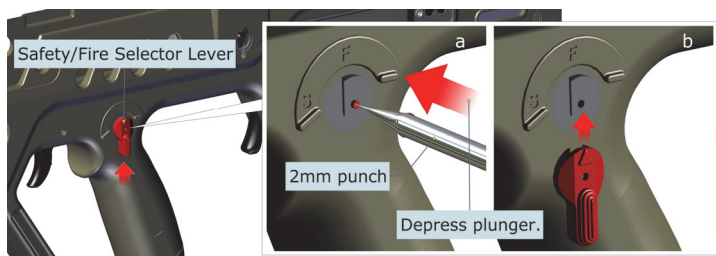
End of Task

Installing the Safety Lever and Safety Pivot Cover

1. Depress the safety plunger with a 2 mm punch and install the safety pivot cover on the safety assembly on the rifle side* according to the shooter's configuration.



2. On the rifle opposite side, depress the safety plunger with a 2 mm punch and install the fire selector lever on the safety assembly.



End of Task

15.17 Removal/Installation of 9 mm Magazine Adapter Assembly

Tools

- punch 3 mm
- plastic hammer

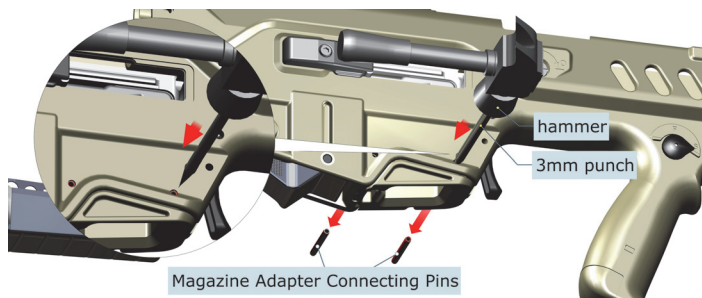
Initial Setup

- 1 **Unloading and Safety Check** of the rifle performed (*see page 25*).
- 2 **Primary Disassembly** performed (*see page 45*).

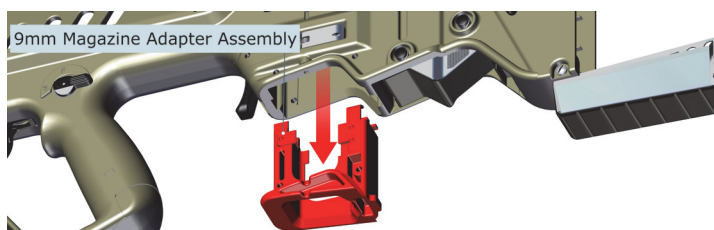
*. The illustrations in this manual relate to the right hand shooter configuration. When converting the rifle to the left hand configuration, reposition the part/component on the reverse side whenever prompted.

Removing the 9 mm Magazine Adapter Assembly

1. Using a 3 mm punch and a hammer, remove the connecting pins securing the adapter assembly.



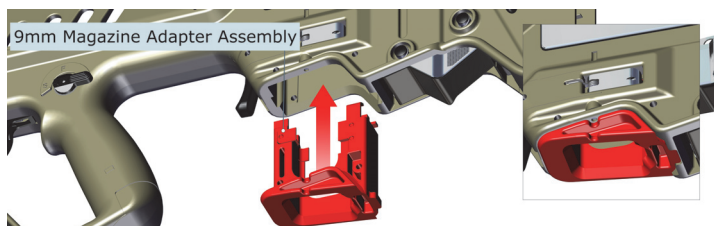
2. Remove the adapter assembly from the rifle body.



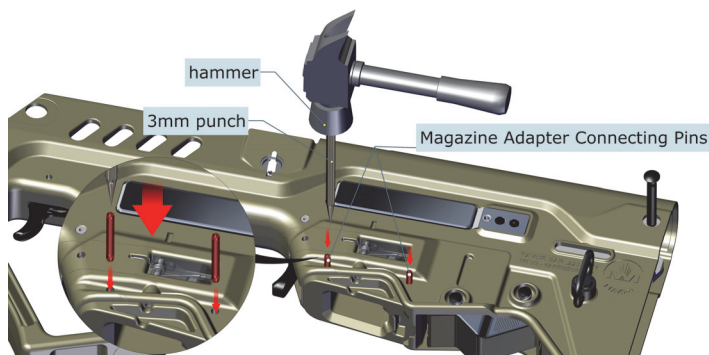
End of Task

Installing the 9 mm Magazine Adapter Assembly

1. Insert the adapter assembly through the magazine well into the rifle body.



- Using a 3 mm punch and a hammer, install the connecting pins to secure the adapter assembly in place.



End of Task

15.18 Converting the Moving Parts to Left-Hand Shooter

...for semi-automatic 5.56 NATO rifle:

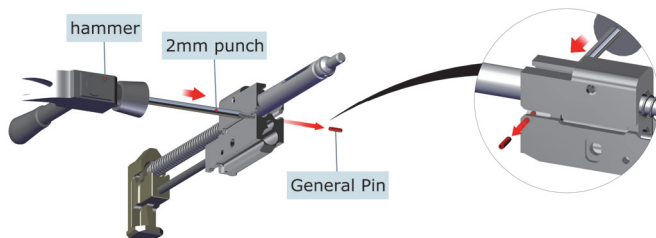
Tools

- punch 2 mm/3 mm
- plastic hammer

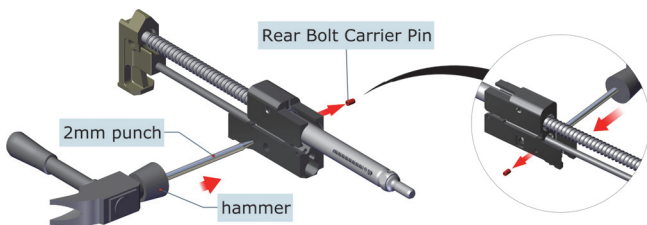
Initial Setup

- Unloading and Safety Check** of the rifle performed (*see page 25*).
- Primary Disassembly** performed (*see page 45*).
- Recoil Mechanism Partial Disassembly** performed (*see page 51*).

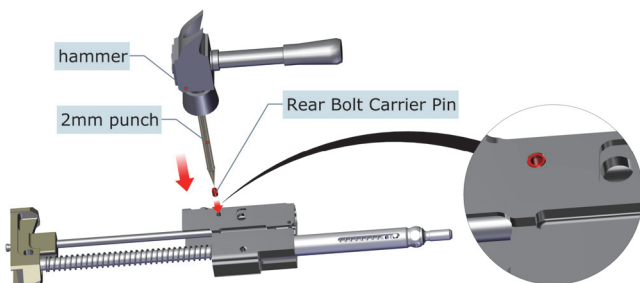
- Using a 3 mm punch and a hammer, remove the general pin from the right side of the bolt carrier.



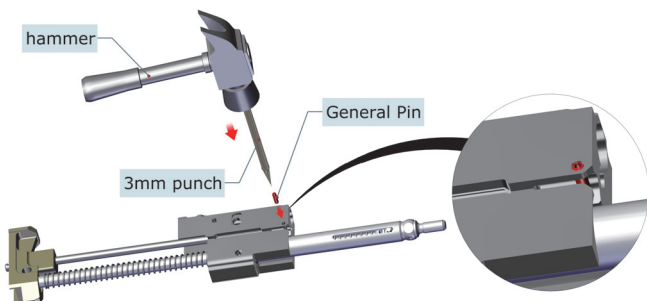
- Using a 2 mm punch and a hammer, remove the rear bolt carrier pin from the right side of the bolt carrier.



- Install the rear bolt carrier pin on the left side of the bolt carrier using a 2 mm punch and a hammer.



- Install the general pin on the left side of the bolt carrier using a 3 mm punch and a hammer.



End of Task

...for rifle converted to Cal. 9x19 mm Parabellum:

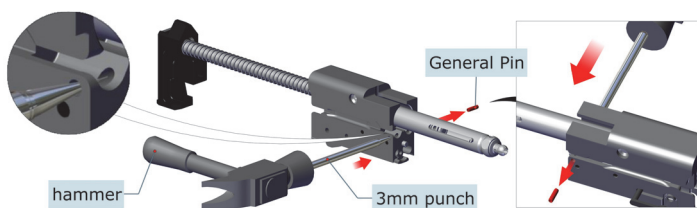
Tools

- punch 3 mm
- plastic hammer

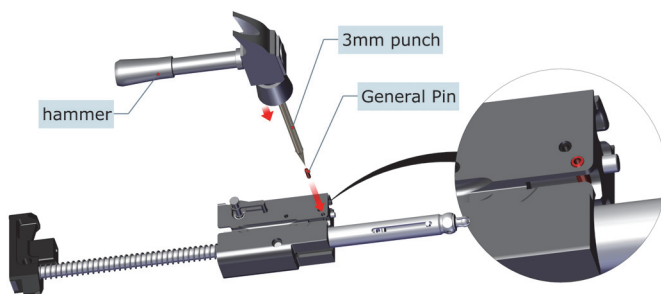
Initial Setup

- 1 **Unloading and Safety Check** of the rifle performed (*see page 25*).
- 2 **Primary Disassembly** performed (*see page 45*).
- 3 **Breech Block Assembly Partial Disassembly** performed (*see page 52*).

1. Using a 3 mm punch and a hammer, remove the general pin from the right side of the breech block.



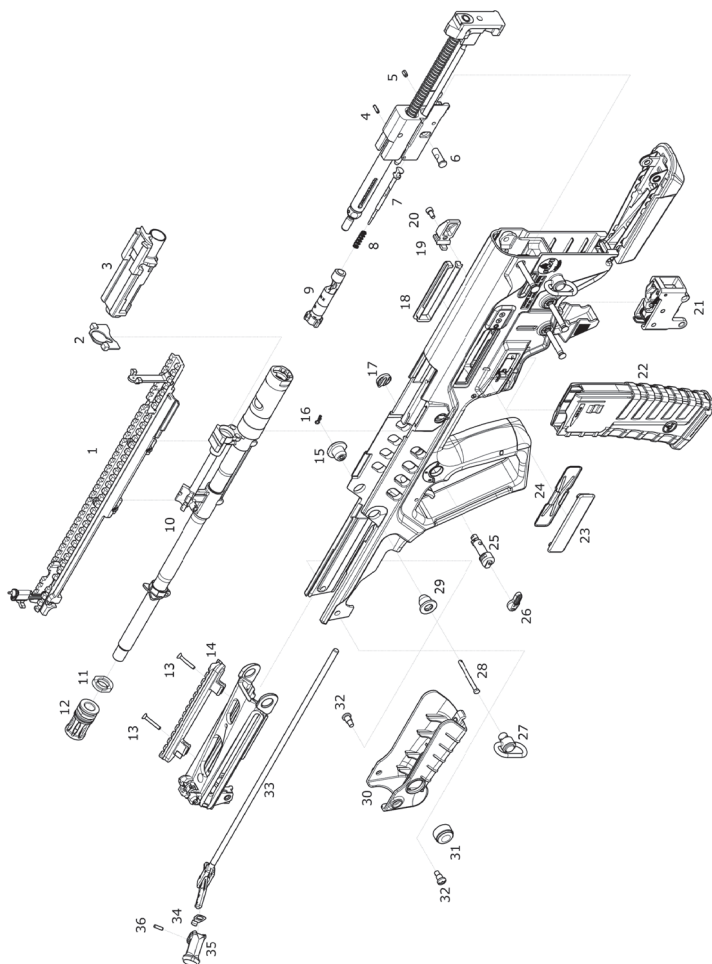
2. Using a 3 mm punch and a hammer, install the general pin on the left side of the breech block.



End of Task

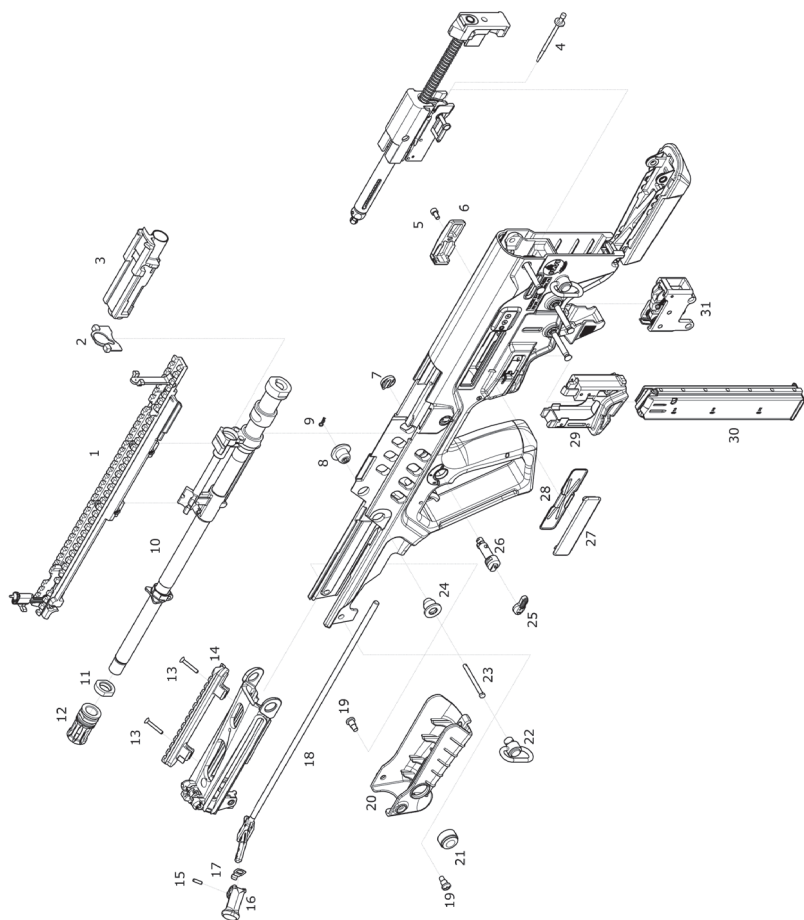
16 Parts Lists and Breakdown Diagrams

16.1 TAVOR® SAR 5.56 NATO Semi-Automatic Rifle



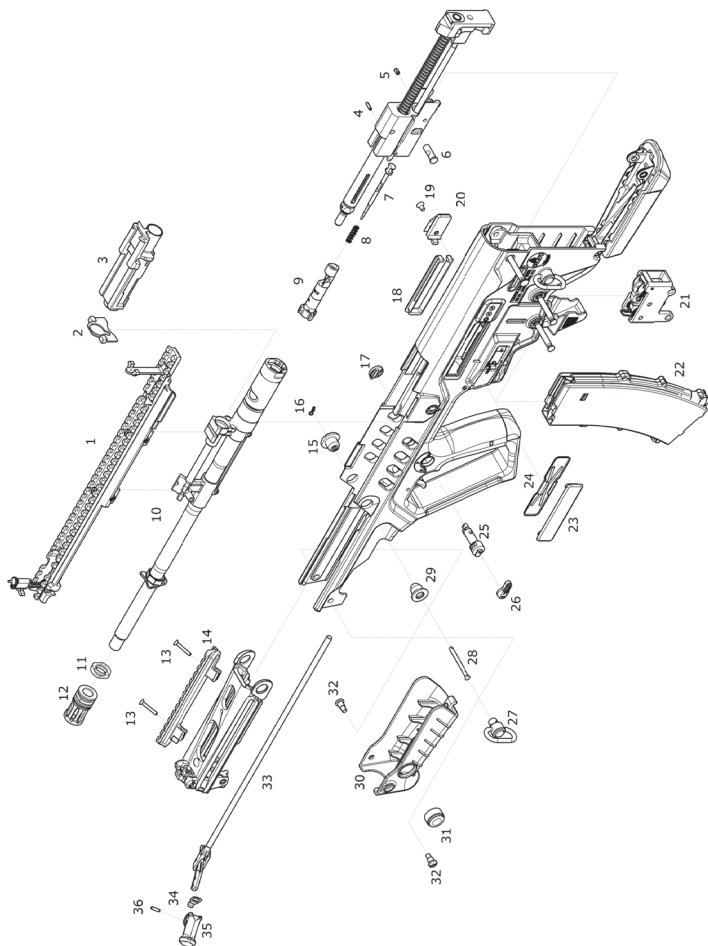
#	Description	Qty
1	1913 Long Rail Assembly	1
2	Dust Protection Plate	1
3	Gas Cylinder	1
4	General Pin	1
5	Rear Bolt Carrier Pin	1
6	Bolt Guiding Pin	1
7	Firing Pin	1
8	Firing Pin Spring	1
9	Bolt Assembly	1
10	Barrel Assembly	1
11	Suppressor Locking Nut	1
12	Flash Suppressor	1
13	Rail Adapter Retaining Screw	2
14	Cocking Guide Slide Rail	1
15	Sling Attachment Lock	1
16	Swivel Securing Spring	1
17	Safety Pivot Cover	1
18	Deflector Frame	1
19	Deflector	1
20	Deflector Tightening Screw	1
21	Sear Mechanism	1
22	5.56 NATO Magazine Assembly	1
23	Ejection Port Cover	1
24	Ejection Port Cover Base	1
25	Safety Assembly	1
26	Safety/Fire Selector Lever	1
27	Swivel	1
28	Locking Screw	1
29	Sling Attachment Sleeve	1
30	Foregrip	1
31	Laser Activating Button Cover	1
32	Fastening Screw	2
33	Cocking Bar Subassembly	1
34	Cocking Handle Securing Spring	1
35	Cocking Handle	1
36	General Pin	1

16.2 TAVOR® SAR Converted to Cal. 9x19 mm Parabellum



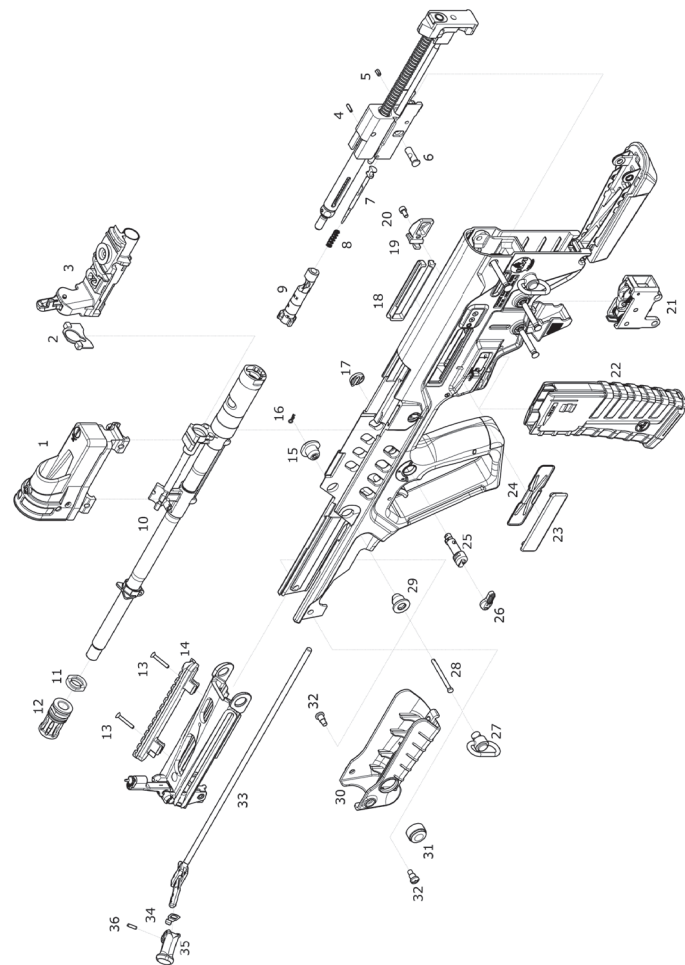
#	Description	Qty
1	1913 Long Rail Assembly	1
2	Dust Protection Plate	1
3	Gas Cylinder	1
4	9mm Firing Pin	1
5	Deflector Tightening Screw	1
6	9mm Deflector Assembly	1
7	Safety Pivot Cover	1
8	Sling Attachment Lock	1
9	Swivel Securing Spring	1
10	9mm Barrel Assembly	1
11	9mm Suppressor Locking Nut	1
12	9mm Flash Suppressor	1
13	Rail Adapter Retaining Screw	2
14	Cocking Guide Side Rail	1
15	General Pin	1
16	Cocking Handle	1
17	Cocking Handle Securing Spring	1
18	Cocking Bar Subassembly	1
19	Fastening Screw	2
20	Foregrip	1
21	Laser Activating Button Cover	1
22	Swivel	1
23	Locking Screw	1
24	Sling Attachment Sleeve	1
25	Safety/Fire Selector Lever	1
26	Safety Assembly	1
27	Ejection Port Cover	1
28	Ejection Port Cover Base	1
29	9mm Magazine Adapter Assembly	1
30	9mm Magazine Assembly	1
31	Sear Mechanism	1

16.3 TAVOR® SAR Converted to Cal. 5.45x39 mm



#	Description	Qty
1	1913 Long Rail Assembly	1
2	Dust Protection Plate	1
3	Gas Cylinder	1
4	General Pin	1
5	Rear Bolt Carrier Pin	1
6	Bolt Guiding Pin	1
7	Firing Pin	1
8	Firing Pin Spring	1
9	5.45x39mm Bolt Assembly	1
10	5.45x39mm Barrel Assembly	1
11	Suppressor Locking Nut	1
12	Flash Suppressor	1
13	Rail Adapter Retaining Screw	2
14	Cocking Guide Side Rail	1
15	Sling Attachment Lock	1
16	Swivel Securing Spring	1
17	Safety Pivot Cover	1
18	Deflector Frame	1
19	5.45x39mm Deflector Tightening Screw	1
20	5.45x39mm Deflector	1
21	Sear Mechanism	1
22	5.45x39mm Magazine Assembly	1
23	Ejection Port Cover	1
24	Ejection Port Cover Base	1
25	Safety Assembly	1
26	Safety/Fire Selector Lever	1
27	Swivel	1
28	Locking Screw	1
29	Sling Attachment Sleeve	1
30	Foregrip	1
31	Laser Activating Button Cover	1
32	Fastening Screw	2
33	Cocking Bar Subassembly	1
34	Cocking Handle Securing Spring	1
35	Cocking Handle	1
36	General Pin	1

16.4 TAVOR® SAR—IDF Model



#	Description	Qty
1	Integral MEPRO 21 Reflex Sight	1
2	Dust Protection Plate	1
3	IDF Gas Cylinder Assembly	1
4	General Pin	1
5	Rear Bolt Carrier Pin	1
6	Bolt Guiding Pin	1
7	Firing Pin	1
8	Firing Pin Spring	1
9	Bolt Assembly	1
10	Barrel Assembly	1
11	Suppressor Locking Nut	1
12	Flash Suppressor	1
13	Rail Adapter Retaining Screw	2
14	Cocking Guide Side Rail	1
15	Sling Attachment Lock	1
16	Swivel Securing Spring	1
17	Safety Pivot Cover	1
18	Deflector Frame	1
19	Deflector	1
20	Deflector Tightening Screw	1
21	Sear Mechanism	1
22	5.56 NATO Magazine Assembly	1
23	Ejection Port Cover	1
24	Ejection Port Cover Base	1
25	Safety Assembly	1
26	Safety/Fire Selector Lever	1
27	Swivel	1
28	Locking Screw	1
29	Sling Attachment Sleeve	1
30	Foregrip	1
31	Laser Activating Button Cover	1
32	Fastening Screw	2
33	Cocking Bar Subassembly	1
34	Cocking Handle Securing Spring	1
35	Cocking Handle	1
36	General Pin	1

17 Limited Product Warranty

- 1 This Warranty is given by "IWI US, Inc." solely to the original purchaser (the "Purchaser") of IWI US, Inc.'s TAVOR® Semi-Automatic Rifle (the "Product") for a period of 5 years commencing from the date of Product retail purchase (the "Warranty Period").
- 2 Subject to the limitations and exclusions contained below, IWI US, Inc. warrants the Product to be free from defects in design, materials and workmanship. Consequently, should any failure to conform to this Warranty be discovered and brought to the attention of IWI US, Inc. during the Warranty Period, and be substantiated by examination at IWI US, Inc.'s facility or by duly authorized and certified field personnel on IWI US, Inc.'s behalf, IWI US, Inc., at its sole option and free of charge, shall either repair, replace or refund the purchase price of any non-conforming Product.
- 3 This Warranty shall only apply provided that:
 - 3.1 The Product has been transported and stored, handled, maintained, operated and used properly; all in accordance with IWI US, Inc.'s instructions found in this manual.
 - 3.2 No changes, repairs or services were made to the Product by any party other than IWI US, Inc. or an authorized representative of IWI US, Inc.
 - 3.3 The Product was not damaged as a result of improper operation, misuse (whether intentional or otherwise), abuse, negligence, accident or flood, fire, earthquake or other external causes.
 - 3.4 Only appropriate, non-defective new commercial ammunition was fired from the Product.
 - 3.5 The defective Product and/or defective parts shall have been returned by the Purchaser to IWI US, Inc. immediately upon request in conformance with IWI US, Inc.'s return procedures.
- 4 This Warranty does not apply to:
 - 4.1 Maintenance, repair or replacement of parts due to normal wear and tear.

- 4.2 Expendable items such as batteries (including battery leaks), bulbs, cleaning supplies and other consumables.
- 4.3 Any cosmetic damage that does not impede form, fit, and function of the Product.
- 4.4 Products that show evidence of tampering.
- 4.5 IWI US, Inc. does not warrant that the operation of the product will be uninterrupted or error-free.
- 5 In the event a Product returned to IWI US, Inc. is not defective in design, materials or workmanship or not returned within the Warranty Period, a test and evaluation charge, as determined by IWI US, Inc. will apply.
- 6 IWI US, Inc. will be the sole determining evaluator and authority for adjudicating Warranty claims hereunder.
- 7 THE REPAIR, REPLACEMENT, OR REFUND AS PROVIDED HEREIN ABOVE IS THE SOLE AND EXCLUSIVE REMEDY OF THE PURCHASER, AND IS PROVIDED IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OF IMPLIED, INCLUDING, WITHOUT LIMITATION, THE IMPLIED WARRANTIES OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE, NON-INFRINGEMENT, COURSE OF DEALING AND USAGE OF TRADE. IN NO EVENT SHALL IWI US, Inc. BE LIABLE TO PURCHASER, PURCHASER'S CUSTOMERS OR ANY THIRD PARTY, WHETHER IN CONTRACT OR TORT (INCLUDING NEGLIGENCE AND STRICT LIABILITY) FOR DAMAGES IN EXCESS OF THE PURCHASE PRICE OF THE PRODUCT, OR FOR ANY INDIRECT, INCIDENTAL, SPECIAL, PUNITIVE, OR CONSEQUENTIAL DAMAGES OR EXPENSES OF ANY KIND, OR PERSONAL INJURIES OR DAMAGE TO PROPERTY OF ANY KIND OR CHARACTER, OR LOSS OF REVENUE OR PROFITS, LOSS OF USE, LOSS OF BUSINESS, LOSS OF INFORMATION OR DATA OR OTHER FINANCIAL LOSS ARISING OUT OF OR IN CONNECTION WITH THE ABILITY OR INABILITY TO USE THE PRODUCT TO THE FULL EXTENT THESE DAMAGES MAY BE DISCLAIMED BY APPLICABLE LAW.
- 8 Some states do not allow the exclusion of consequential or incidental damages, so the above limitations may not apply to you.

18 Repair Services

If you need assistance with your TAVOR® SAR, please call +1-717-695-2081, Monday through Friday, 8:30AM to 4:30PM US Eastern time and ask to speak to Customer Service. If it is determined that shipment of your firearm to IWI US, or an authorized IWI US Service Center is warranted, please prepare and ship as follows:

1. Record the serial number of your TAVOR® SAR before packing and shipping.
2. Check to make sure your rifle is unloaded.
3. Remove all accessories from the rifle to prevent loss or damage. IWI US, Inc. will not be responsible for any loss or damage to non-IWI US, Inc. firearms or accessories.
4. Pack your firearm for safety and to prevent any damage in shipping and handling. Preferably ship in the original box your firearm came in.
5. Enclose a letter with the firearm detailing the model name and serial number of your firearm along with a full description of the problem. Be sure to include your full name and street address city and state, including zip code, daytime telephone number and email address.
6. Ship your firearm by UPS, FedEx or USPS (US Postal Service). IWI US, Inc. is not responsible for damage or loss during shipment, so you may elect to purchase insurance from the carrier. Ship to the following address:

IWI US, Inc.
Attn. Service Department
5480 Linglestown Road
Harrisburg, PA 17112



WARNING! DO NOT SEND LIVE AMMUNITION OR SPENT (FIRED) SHELLS/CARTRIDGES IN YOUR FIREARM OR IN THE SAME BOX WITH YOUR FIREARM. THIS IS A VIOLATION OF FEDERAL LAW. IF YOU FEEL YOU MUST SEND SPENT (FIRED) SHELLS/CARTRIDGES, PLEASE SHIP THEM IN A SEPARATE PACKAGE AND INCLUDE A COPY OF THE LETTER THAT YOU PACKED WITH YOUR FIREARM.

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DISCHARGING FIREARMS IN POORLY VENTILATED AREAS, CLEANING FIREARMS, OR HANDLING FIREARMS OR AMMUNITION MAY RESULT IN EXPOSURE TO LEAD AND OTHER SUBSTANCES KNOWN TO CAUSE BIRTH DEFECTS, REPRODUCTIVE HARM, AND OTHER SERIOUS PHYSICAL INJURY. HAVE ADEQUATE VENTILATION AT ALL TIMES. WASH YOUR HANDS AND FACE THOROUGHLY AFTER EXPOSURE AND BEFORE EATING OR DRINKING.

SHOOTING, HANDLING OR CLEANING GUNS MAY EXPOSE YOU TO LEAD WHICH IS A TOXIC SUBSTANCE.

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2013