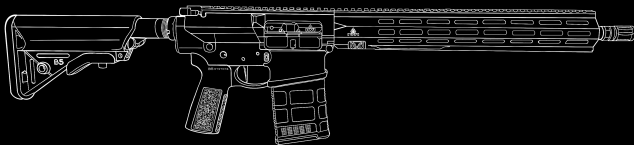


ZION Z-25 ®

Semi-Auto Rifles & Firearms



OPERATION MANUAL



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. 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 Tel: +1 (865) 582-0012 or info@iwi.us.



Congratulations on your purchase of the Zion Z-25 ® Semi-Auto Rifles & Firearms

Your packaging includes:

1. 1 - PMAG® LR/SR
2. Literature Packet
 - a. QR Manual card.
 - b. NSSF Firearms Safety Depends on You Pamphlet.
 - c. NSSF Firearms Responsibility in the Home Pamphlet.
 - d. IWI US, Inc. Limited Product Warranty Card.
 - e. National Rifle Association (NRA) Application.
 - f. IWI Decal.
3. Gun Cable Lock.
4. Protective VCI Bag.

If you notice that anything is missing from the above list, please contact IWI US customer service at either info@iwi.us or call +1865-582-0012.

We appreciate your business.

IWI US, Inc.

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WARNING

PRIOR TO REMOVING THIS FIREARM FROM ITS PACKAGING, AND PRIOR TO HANDLING, LOADING AND FIRING, CAREFULLY AND THOROUGHLY READ AND UNDERSTAND THIS ENTIRE OPERATOR MANUAL WHICH GIVES ADVICE ON THE FIREARM'S PROPER HANDLING, FUNCTIONING AND SAFE USE. 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 FIREARM 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.

MANUAL CONTENTS

- Important **WARNINGS** and **SAFETY PRECAUTIONS** that must be read and understood before using this firearm. **SAFE FIREARM 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, take out and others and damage to property.
- Directions and procedures for handling, loading, firing, unloading, disassembling and assembling this firearm.
- Instructions for care, cleaning and repair of this firearm.

This Operator Manual is designed to help you in learning how to properly and safely use and care for your Zion Z-25[®]. 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 at a firing range or other safe location.

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

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

WARNINGS AND PRECAUTIONS

Cardinal Rules of Firearms Safety

- Treat all firearm's as if they were loaded.
- Point the muzzle in a safe direction at all times.
(A "safe direction" is one in which no one would be injured if the firearm were to discharge.)
- Keep your finger off the trigger, straight along the frame and superior to the trigger until you are aimed at a safe target and intend to fire.
- Be sure of your target and what's around and beyond it.
- When you pick up a firearm that, even for an instant, has been out of your direct, continuous control, while following the above rules, open the firearm's action and determine whether or not the firearm is loaded.
- All firearms left unattended, even briefly, must be made inoperable or inaccessible to children and other unauthorized users.

Failure to comply with the warnings and precautions in this booklet may result in serious injury to you or others and/or damage the firearm or other property. Take note of the following warnings on the firearm handling before attempting to use the firearm:

Always check the chamber and magazine of any firearm before handling.

- Keep firearms and ammunition separate and in locked storage.
- Don't shoot unless absolutely sure of your target and what is beyond it.
- Always wear eye and ear protection when shooting.
- Always be sure the barrel is clear of obstructions.
- Only carry ammunition specifically intended for the firearm you are using.
- Never use alcohol or drugs of any kind while using your firearm.



WARNING! If your firearm 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 and the ejection port turned away from your face.

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



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



WARNING! If you notice an obvious change in sound and recoil while firing, **STOP FIRING!**

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

Immediately unload the firearm and remove the slide and barrel then check for unburned powder residue in the bore and the receiver or a bullet stuck in the bore. Remove the unburned powder before resuming fire. If a bullet is stuck in the bore, have a qualified firearm smith 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 causing serious injury or death.



WARNING! Careless and improper handling of this firearm 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 is 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! The firearm should be transported in quality firearm case or holster that blocks access to the trigger.

Important Note:

This Operator Manual and the instructions and warnings contained in it are intended for the civilian 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 safety rules and firearm 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 firearm handling procedures should not attempt to use this firearm 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 firearm pointed in a safe direction. Even after you have confirmed that the firearm 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 straight along the frame of the firearm until you intend to fire.



DANGER! DO NOT grasp the forward portion of the trigger guard/firearm grip frame with your non-shooting hand or allow any fingers of your non-shooting hand to enter the trigger guard at any time. If you do so, there is a chance your non-shooting hand or fingers could touch the trigger, unintentionally firing the firearm 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 firearm. Always keep your finger outside the trigger area, wrapped around the grip or braced on the firearm's frame, until you intend to fire.



WARNING! Upon firing, a hot, empty shell casing is forcefully ejected from the right side of the firearm. All persons present must wear suitable eye protection, and must stand clear of the case ejection area.



WARNING! Keep the muzzle of the firearm pointed in a safe direction at all times. A safe direction is one in which a negligently discharged round 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 firearm were to fire. Always be sure of your target and what's beyond and around it before firing.



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 or placing it on a vehicle. Never let the muzzle of a firearm touch the ground, 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 safely 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 ZION Z-25 ®, 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 firearm case.



WARNING! Whenever you pick up any firearm that, even for an instant, has been out of your direct, continuous control, perform a condition check on the weapon. While keeping the muzzle pointed in a safe direction and your fingers out of the trigger area, remove is to 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 ejected shell cases, firearm powder gas, lubricant, dirt or metallic particles, carbon residue, sparks, bullet splash back from targets or other debris.



WARNING! Always wear and require others to wear commercially manufactured ear protection when shooting. Without ear protection, the noise from your firearm, and other firearms 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 ZION Z-25 RIFLE® firearm has some unique features. Do not assume that just because you have experience with other firearms, you know how to use the Zion Z-25 Rifle® firearm properly. Read and understand this manual. If there is anything you do not understand, contact your firearms retailer or IWI US, Inc. at info@iwi.us or telephone +1865-582-0012.



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 unless the firearm is secured in a quality holster that blocks the trigger guard and retains the weapon.



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



WARNING! A bullet fired into the air can travel over one mile and can kill or seriously injure someone 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 firearm 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 instruction 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, firearm 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 ZION Z-25 ® firearm that does not seem proper or that causes you concern, STOP, unload your firearm immediately, and do not load or fire your firearm until you have it inspected. If necessary, have the firearm repaired by a factory-trained armorer, or by IWI US, Inc. If you fire your ZION Z-25 ® firearm extensively, have it professionally inspected and serviced periodically.



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. Some medications can impair your vision, balance, reflexes, coordination, alertness or judgment. 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. Firearms 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.



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, handling or cleaning firearms may expose you to lead, which is a toxic substance.

REMEMBER, FIREARMS SAFETY DEPENDS ON YOU! THERE ARE NO "FOOLPROOF" FIREARMS, INCLUDING THE ZION Z-25 ®. A SINGLE MOMENT OF INATTENTION OR A SINGLE FAILURE TO FOLLOW THESE FIREARM SAFETY RULES AND WARNINGS CAN RESULT IN TRAGEDY. YOU ARE RESPONSIBLE FOR THE FIREARM THAT IS IN YOUR HANDS, IN YOUR POSSESSION, OR UNDER YOUR CONTROL. FIREARMS SAFETY DEPENDS "ON YOU!"

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 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 firearm 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 ZION Z-25 ® SEMI-AUTOMATIC FIREARM (see "INSTRUCTIONS - USING THE CABLE LOCK" on page xvi) is a good safety precaution, but not as good as locking your firearm in a metal firearm safe, where it is also out of sight and protected from fire, theft, and curious hands.
- 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://www.nssf.org/safety/lit/>.

INSTRUCTIONS - USING THE CABLE LOCK

Your ZION Z-25 ® Firearm 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 ZION Z-25 ® or any other firearm, as the cable could press against the trigger and fire the firearm, causing death or serious injury.



WARNING! The cable lock supplied with your ZION Z-25 ® Firearm may not fit or work properly on other firearms. This lock is intended for use only on your ZION Z-25 ®.

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 firearm in a metal firearm 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.

To use the cable lock, do the following:



WARNING! Keep the muzzle pointed in a safe direction, your fingers outside the trigger area throughout the process of putting the cable lock on your firearm.

1. Be sure your firearm is empty (unloaded) by following the Safety Inspection Procedures (Pg.11-13). Your Zion Z-25® should now be unloaded, with the safety lever on Safe ("S") position.
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 Zion Z-25® 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.



SAFETY PRECAUTIONS

Make sure that the firearm is unloaded and pointed in a safe direction when the firearm is not in use and before:

- Receiving or handling over a firearm.
- Transporting a firearm.
- Inserting the magazine.
- Cleaning or servicing a firearm.

Fundamental Safety Rules:

- Always assume that the firearm is loaded.
- Always remove the magazine immediately after firing and make sure the chamber is empty.
- Always wear ear and eye protection.
- Always be sure of your target backstop and what lies beyond it.

GENERAL DESCRIPTION AND CHARACTERISTICS

The Zion Z-25® is a direct impingement, gas operated rifle made from high quality components. Most of its mechanism parts are interchangeable with its different models.

The Zion Z-25® family has the familiar feel of weapons in its similar class and many additional features that separated it from other weapons in its category. This includes a free floated MLOK fore end, long continuous top rail and Sopmod Stock with storage for batteries.

Maintenance of the weapon in operator level is simple and special tools are not required when "stripping" the weapon.

The Weapon has 1 continuous Picatinny rail that allows for a variety of optics, light and laser aiming modules. The M-LOK rail has attachment points for accessories at multiple points around the circumference of the rail.

The Zion Z-25® Rifle butt length can be adjusted for enhanced ergonomics to enhance the shooters experience.

AMMUNITION:

Use only high quality commercially manufactured ammunition in good condition of the appropriate caliber. The caliber of your rifle or pistol is marked on the receiver. Use only NATO or ammunition made to SAAMI specifications.

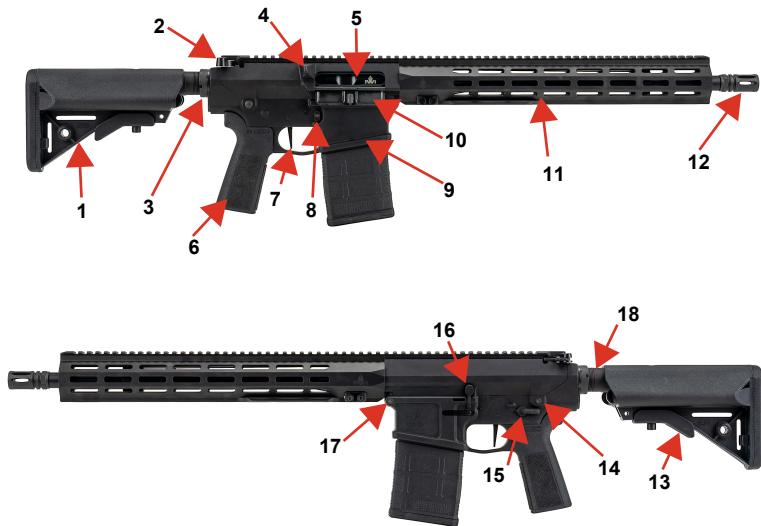
Not all ammunition produces the same result. IWI US, Inc. recommends that once you find a brand which functions best in your Z-25 keep using it.

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

TECHNICAL DATA

	Z-25 Carbine	Z-25 DMR	Z-25 DMR	Z-25 DMR
Caliber	.308 Win		6.5CM	
Length (to muzzle)	33.75" collapsed/ 37.125" extended	35.5" collapsed/ 38.875" extended	37.5" collapsed/ 40.875" extended	39.5" collapsed/ 42.875" extended
Barrel	16"	18"	20"	22"
Rifling	6 R.H grooves, 1:10" twist	6 R.H grooves, 1:10" twist	6 R.H grooves, 1:8" twist	6 R.H grooves, 1:8" twist
Magazine	PMAG 20 LR/SR	PMAG 20 LR/SR	PMAG 20 LR/SR	PMAG 20 LR/SR
Direct Impingement Gas tube length	Intermediate	Rifle	Rifle+2"	Rifle+2"
Weight	8lbs 14.5oz	9lbs 6.8oz	9lbs 12.4oz	10lbs 0.7oz
Stock	8 position B5	8 position B5	8 position B5	8 position B5
Free float Handguard	15" M-LOK w/3.5" Arca section	17" M-LOK w/ full length Arca rail	17" M-LOK w/ full length Arca rail	17" M-LOK w/ full length Arca rail

OVERVIEW ZION Z-25 RIFLE® PARTS



1	Stock	10	Ejection Port Cover
2	Charging Handle	11	M-LOK
3	Castle Nut and Endplate	12	Flash Suppressor
4	Brass Deflector	13	Stock Adjustment Lever
5	Bolt Carrier Group / Ejection Port	14	Rear Teardown Pin
6	Pistol Grip	15	Safety/ Selector
7	Trigger	16	Bolt Catch
8	Magazine Release Button	17	Pivot Pin
9	Magazine Well	18	Buffer Tube

OPERATING PRINCIPLES

Z-25 Cycle of Operation

The Z-25 is a mid-length, direct impingement rotating locking bolt system. When the round is chambered and the magazine is seated, firing begins when the trigger is pulled and the hammer falls.



The hammer will strike the back of the firing pin which strikes the back of the primer. The powder in the cartridge will ignite and force the round down the barrel.

Rifling in the barrel will twist the round as it proceeds forward. When the bullet passes the gas port hole at the top of the barrel (located at the gas block), heated gas from the burnt powder will flow upward and back down the gas tube toward the bolt group.



The gas flows through the gas carrier key and forces the bolt to rotate and unlock. At the same time, the hammer is cocked by the bolt's movement to the rear.



Once the bolt travels all the way to the rear, the spent case is ejected and another round is fed through the magazine into the chamber.



The bolt is forced forward by the compressed recoil spring. Once the bolt closes on the new round, the weapon is ready to fire once again. This process is repeated until the weapon is out of ammunition and the magazine follower pushes up on the bolt catch. Once the bolt catch is engaged, the bolt is locked to the rear.



Safeties

The Zion Z-25 is equipped with mechanical safeties that prevent unintentional firing:

- a. Manual safety – in Safe ("S") position, the trigger is blocked by the safety catch, thus preventing the release of the hammer.
- b. No hammer / firing pin engagement, unless the bolt is completely locked.

FIRING PROCESS

General

This chapter contains safety operating and firing procedures.



Safety Inspection

A safety inspection must be performed:

- When receiving and handing over the rifle.
- After using live ammunition.

Unloading / Safety Inspection Procedures

Perform the safety inspection procedures as follows:

1. While keeping the weapon pointed in a safe direction, ensure there is no magazine in the weapon by depressing the magazine release button and removing the magazine.

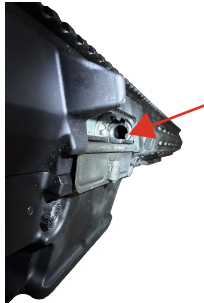


2. Ensure that the safety lever is on "Safe" position. (If the safety does not turn to the "safe" position, ensure the magazine is out of the weapon and pull the charging handle to the rear and release it.) Engage the safety.
3. Depress the bottom of the bolt catch and maintain pressure.
4. Pull the charging handle while maintaining downward pressure on the bolt catch.



5. The bolt should lock to the rear.
6. Push the charging handle in the forward position, locking it into place.

7. Check visually the chamber, bolt face and mag well to ensure there is no ammunition.



8. After verifying the weapon is clear, push the bolt release.
9. Close the ejection port cover.



SIGHTS AND ZEROING

The Z-25 is not supplied with sights but will accept a variety of optics, iron sights and scopes. It is generally recommended that the iron sights be attached at the furthest distance from each other that is practically possible. This will increase the sight radius and increase potential accuracy of the weapon. Optics and scopes are subjective to the shooters eye and eye relief of the individual scope. The suggested zero is based on a traditional height optic/ sight common to this platform.

Zeroing the Rifle

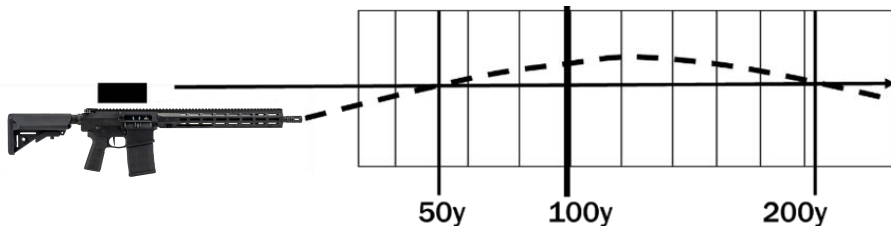
In order to adjust your sights, optics or scopes, please consult the manual of the optic/scope/sight you are using for adjustment distances at 25 yards. The following is based on a 50 yard zero at 25 yards. The chart below is an indication of 1 inch of movement in impact at 25, 50 and 100 yards based on typical adjustments on scopes, optics and sights. Please consult your sight manual for the appropriate adjustments.

Rear Sight/Windage knob	"R"	Rotating the screw/turret in the arrows direction will move the Mean Point of Impact (MPI) to the right.
Front Sight/ elevation knob	"Up"	Rotating the screw/turret in the arrows direction will move the impact up.

To Move Impact 1 inch	
Adjustment on scope/ sight	Clicks per inch at specific distance
1MOA adjustment	1 click at 100 yards 2 clicks at 50 yards 4 clicks at 25 yards
½ MOA adjustment	2 click at 100 yards 4 clicks at 50 yards 8 clicks at 25 yards
2 MRAD	1 click at 100 yards (.8 inch per click) 2 clicks at 50 yards (.4 inch per click) 5 clicks at 25 yards (.2 inch per click)

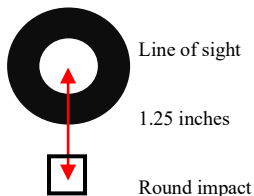
Sight Deviation Correction

The sight or sights will sit roughly 2.6 inches over the bore line. The process of zeroing is to have the line of sight meet the travel of the round at a specific distance. This means that the line of departure of the round actually fires the round at an upward angle to the line of sight. Eventually, gravity and drag slow the round down and it will fall below the line of sight again at another distance. Generally, a 50 yard zero will provide a 200 yard point of aim, point of impact. (These results can change based on bullet weight, design, velocity and atmospheric conditions.)



For scopes that have a bullet drop compensator built into the reticle, a 100 yard zero may be preferred so the round impacts at the various distance marks in the scope. Again, please consult your manual for optimum results.

To have a 50 yard zero at 25 yards, the impact of the rounds should be 1.25 inches low relative to the light of sight.



LOADING AND FIRING

Loading the Magazine

To load the magazine:

1. With the front of the magazine forward, place a round between the magazine lips with the tip of the round pointed forward.
2. Push the round down into the magazine until it is retained by the magazine lips. The magazine will stagger rounds on both sides as it is fed.
3. Place the next round on top of the previous round and press down again. Repeat until the desired number of rounds are loaded. To load the magazine, perform the steps as follows.

Loading and firing the weapon

1. Loading the weapon

Note: ensure that the weapon is pointed in a safe direction at all times while loading, firing and unloading.

2. Hold pistol grip with one hand. Ensure the safety is on “safe”.
3. Hold the magazine with the other hand and insert it into the magazine well until you hear and feel it snap into place.
4. Pull the charging handle to the rear and release it.

DO NOT RIDE THE CHARGING HANDLE FORWARD.



5. If you are not immediately firing the weapon, you may close the dust cover.



6. The weapon is now ready to fire with the safety engaged.

Firing the weapon

Note: before firing the weapon, ensure that you and those around you have the appropriate eye and ear protection.

7. Place the stock into your shoulder while grasping the handguard and pistol grip.
8. Place your head on the stock and align your eye with the sights or sight on the rifle.
9. While pulling the rifle firmly into your shoulder and aligning the sights, sweep the safety off then press the trigger with even pressure to the rear until the weapon fires.
10. Repeat this procedure until the weapon runs empty.
11. The bolt will lock to the rear when the weapon is empty.
12. To reload, press the magazine release button, insert a full magazine and press the bolt release. The weapon is now reloaded.

Note: in particularly dirty environments, close the ejection port cover when the weapon is not in use. This will keep the internal components free of dirt and debris increasing reliability.

Unloading the weapon

All the following operations must be done while the barrel is pointing in a safe direction.

1. Ensure the weapon is on safe and remove the magazine by pressing the magazine release button.



2. Pull the charging handle and release it; if there was a live round in the chamber, it will be ejected.
3. To lock the bolt to the rear, depress the bottom of the bolt catch, then pull the charging handle to the rear simultaneously.



4. After the bolt is locked to the rear, push the charging handle forward until it is locked.
5. Inspect the chamber, bolt face and magazine well to verify there is no live ammunition present.

DISASSEMBLY AND ASSEMBLY

General

This chapter contains user level disassembly and assembly procedures. Disassembly beyond what is described in this manual should only be performed by an IWI US certified armorer or by IWI US, Inc.

Disassembled parts should be placed in an organized fashion in the order of removal beside the weapon.

Assembling is always performed in reverse order to disassembling unless otherwise specified.

CAUTION:

Before disassembly, remove the magazine and verify that the chamber is empty.

Also, ensure there is no live ammunition in the area where cleaning is being performed.

Wear safety glasses when performing maintenance.

Group Disassembly

1. After verifying the weapon is clear and no ammunition is present, push the captured tear down pin located at the rear of the lower receiver from left to right.
2. The upper receiver will hinge upward. Pull the charging handle and remove the bolt carrier group.



3. Pull the charging handle further to the rear then gently pull down until it drops out of the upper receiver.



4. Push the pivot pin from left to right until the upper receiver separates from the lower receiver.



5. The weapon is now broken down into its 4 groups: upper receiver, lower receiver, bolt and charging handle.



Bolt Group Disassembly

1. Push the firing pin retaining pin from right to left and remove it from the bolt carrier.
2. the bolt carrier up and remove the firing pin from the back.



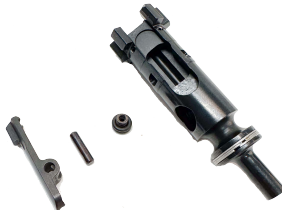
3. Push the bolt as far back as it will go into the bolt carrier and remove the cam pin from the top (Note, the cam pin is already aligned and unlike an AR-15, it does not need to be rotated at all).



4. Pull forward on the bolt and remove it from the front of the bolt carrier.



5. Place pressure on the back of the extractor and push the extractor pin through. **DO NOT REMOVE THE EXTRACTOR SPRING.**



6. The bolt is now disassembled.

Lower receiver disassembly

1. Ensure that the hammer is cocked and that the safety is on.
2. Using the charging handle or other object, push down on the buffer spring retaining detent and remove the buffer spring and assembly.



NOTE: use caution when removing, it will spring out of the receiver extension.

3. The lower receiver needs no further disassembly.

4. To lower the hammer for maintenance, DO NOT JUST PRESS THE TRIGGER. Place the weapon on fire and use your thumb to lower the hammer. Dropping the hammer may, over time, damage the lower receiver.



5. Ensure that the hammer is re-cocked and the safety is on before reassembly.

NOTE: The weapon is now disassembled for maintenance.

Assembly

To reassemble, reverse the order of above.

NOTE: When the bolt group has been reassembled, push the bolt into the bolt group. Grab the end of the bolt carrier and whip the carrier downward in an aggressive motion. The bolt should extend into the unlocked position. Do this a few times before returning the bolt to the upper receiver. The bolt should be extended all the way before being placed back into the receiver and under the charging handle.

Function Check

A function check is a method of verifying the weapon is assembled properly and that the system is working correctly. The function check is to be performed in the following steps.

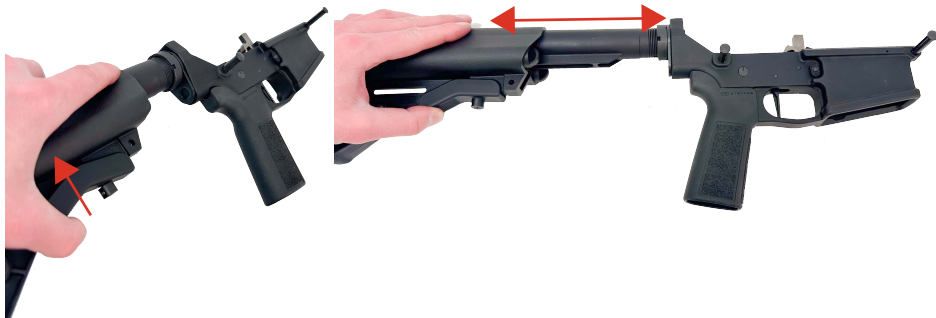
1. Cycle the bolt a couple of times by pulling and releasing the charging handle.
2. With the safety on and the weapon pointed in a safe direction, attempt to pull the trigger; it should not fall.
3. Place the weapon on fire and press the trigger; the hammer should fall.
4. WHILE HOLDING THE TRIGGER TO THE REAR, rack the bolt using the charging handle.
5. Slowly release the trigger; the trigger should reset. For semi auto systems, the function test is complete.

The following additional check is for fully automatic rifles

6. Place the weapon on "auto" and press the trigger.
7. WHILE HOLDING THE TRIGGER TO THE REAR, rack the bolt using the charging handle.
8. Release the trigger; the hammer should have fallen.
9. Rack the bolt using the charging handle.
10. Press the trigger; the hammer should fall.
11. The function test is complete.

Buttstock Length Adjustment

1. To adjust the 6-position buttstock length, perform the steps as follows see Figures - Press on the buttstock catch (1) and adjust the length (2), verify that the buttstock catch is locked.



Removing the Buttstock

To remove the buttstock, perform the steps as follows:

1. Place the stock in the rearward most position.
2. Pull downward on the front portion of the buttstock lever, then slide the stock backwards until it is off of the receiver extension/ buttstock tube.



Removing the Storage Sleeve

The storage sleeve is designed to contain batteries or other essential support equipment for the weapon.

1. Remove the stock from the receiver extension.
2. Turn the cap inward toward the center of the stock.



3. Pull the sleeve from the stock and remove the cap for access to the compartment. The cap is water proof, it may require a forceful twisting motion to remove the cap.



Inserting the Buttstock

To insert the buttstock, perform the steps

1. Place the stock onto the receiver extension/ buttstock tube.
2. While pulling downward on the front of the adjustment lever, push the stock onto the tube then release the lever once its attached.

Adjusting the receiver tension screw

Your Z-25 is equipped with a receiver adjustment screw which tightens the mating of the upper and lower receiver. The screw to adjust the tension is located under the pistol grip. To adjust the screw:

1. Remove the pistol grip taking care not to lose the inserted takedown pin and safety detent springs or detents. (Note that some pistol grips have a hole allowing the screw to be adjusted using a long 1/8" hex.).



(or)



2. Adjust the tension of the screw by leaving the upper and lower receiver attached together and tightening.
3. Re-attach the pistol grip. Ensure that the safety spring and detent are intact and that the spring does not kink.

ZION Z-25 Gas Block and Trigger

The Zion Z-25 is supplied with an adjustable gas block identifiable by two set screws at the top and front of the gas block and is also equipped with a factory two-stage precision cassette-style trigger.

Gas Block Adjustment:

The gas block is adjusted by turning the stainless steel set screw on the right hand side of the unit. From factory, these are set at almost full-open for regular use and locked into place with the second (black oxide) set screw visible from the front of the block. To adjust:

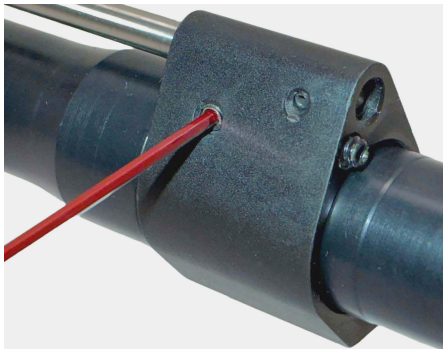
1. Loosen the front set screw using a 1/16" Allen wrench by at least ½ turn, multiple turns are not necessary. (Note: removal of the handguard may be needed to access these set screws. The Z-25 uses an anti-rotation steel pin nested between the upper and handguard. Take care not to lose this pin during this process.)



Note:

The locking set screw in this photo, with the **SILVER** wrench, must be loosened *before* the adjustment set screw can be turned/adjusted. (seen on pg.41)

2. Using the same 1/16" Allen wrench, turn the right side adjustment set screw clockwise to reduce the flow of gas to the system, or counterclockwise to increase gas flow. It is not recommended to turn this screw more than 1 rotation counterclockwise from the factory setting. (Doing so can increase the size of the adjustment chamber and actually reduce cycling function pressure, cause the locking set screw not to hold the adjustment screw in place properly, or even allow the set screw to fall out.)



Remember:

The set screw in this photo, with the **RED** wrench, can only be turned *after* the front set screw is loosened (seen on pg.40), which unlocks the adjustment screw.

3. Adjustments are recommended in ¼ turn increments to “step” the adjustment effect to the user’s desired settings.
4. One best practice is to load a single round into the magazine and fire at each adjustment “step” to ensure the system is receiving enough gas to operate and cycle the bolt to the rear fully to come to rest on the bolt stop with the magazine empty.
5. It is also recommended that upon reaching the lowest adjustment point of cycling and locking back correctly, backing off the adjustment screw by at least ¼ to ½ of a turn to allow more than the minimum of operating gas may minimize malfunctions due to under-gassing in the future such as-
 - a. If/when the system becomes dirty

- b. Ammunition pressure variation
 - c. Changes to atmospherics/temperature effecting ammunition pressures.
- 6. Once the desired setting is achieved, tighten the front 1/16" set screw back down to lock the adjustment screw into place.
- 7. Note that the design of this style of gas block is not meant to be adjusted often but rather set for the longer-term desired rifle configuration. After time, the set screws will become difficult to adjust as normal fouling from use occurs and may require soaking in a carbon cleaning solution to allow the screws to adjust as new.

Cassette-style Trigger:

The trigger included with the Zion Z-25 is a cassette-type design made for IWI US by Timney Triggers. Due to the nature of cassette triggers, these do not retain the trigger pins via the trigger springs but rather utilize a pair of set screws, accessible from the top of the cassette, to apply pressure to the lower receiver trigger pocket floor in order to friction retain the trigger screws. These set screws are tightened to **10in/lbs** from factory and may be removed and/or reinstalled using a 5/64" (or 2mm) Allen wrench. **DO NOT OVERTIGHTEN! Doing so may damage the lower receiver.**



MAINTENANCE

General

Experience shows that the majority of malfunctions are caused by improper maintenance of the weapon rather than mechanical defects.

Comprehensive knowledge of servicing and handling weapons is very important. Special attention must be paid to cleaning and lubricating the weapon.

Materials Required

At a minimum, we suggest the following materials to properly clean the ZION Z-25 ®:

No.	Items	No.	Items
1	Cleaning rods	7	Rag
2	Cleaning rod slot tip	8	Patches
3	Brass brush for cleaning barrel bore	5	Lubricant and solvent
4	Brush for cleaning chamber & barrel extension	6	General cleaning brush

Post-Firing Maintenance

Upon completion of firing, clean the weapon thoroughly (with special attention to the parts that are in contact with the exhaust gas).

Carbon and other deposits (such as, gunpowder residue) accumulate inside the bore and inner rifle parts causing corrosion.

Perform post-firing maintenance as follows:

1. Field-strip the rifle.
2. Place a chamber brush on the end of 2 rod sections and push it into the chamber.
3. Turn the chamber brush while it's in the chamber and remove. Repeat until the chamber area appears clean.
4. Using a cleaning rod, eyelet adapter and patches, push the appropriate sized brush with solvent through the chamber end to the muzzle.
5. Use a brass brush when needed and push the brush from the chamber to the muzzle 1-5 times.
6. Repeat using patches soaked in solvent until the patches appear clean.
7. Dry the chamber and bore.

8. Wipe out the inside of the upper receiver, ensure the feed ramps are clean and lightly oil the inside of the upper receiver.
9. Scrape off the back of the bolt and inside of the bolt carrier. Clean the bolt and carrier with a solvent, then dry those parts.
10. Remove the recoil spring in the lower receiver, wipe off the spring, lightly oil and return it to the lower receiver.
11. Turn the safety off, place a thumb over the hammer, press the trigger and slowly lower the hammer.
12. Clean the trigger mechanism with a toothbrush and swabs. Lightly oil the springs, re-cock the hammer and turn the safety on.
13. Wipe off the charging handle and lightly oil the outside.
14. Re-assemble the weapon and perform a function test.

Maintenance under Extreme Conditions

1. Cold Climate Maintenance and Cleaning

When the temperature is below freezing all the moving parts of the weapon must be kept absolutely free from moisture. It is a well-known fact that excessive oiling of the moving parts will result in the oil coagulating and obstructing the action of the mechanism. Thus, ensure that you have a high-quality weapons oil rated for extremely low temperatures.

2. Hot/Dry Climate Maintenance and Cleaning

In a hot and dry climate, sand and dust penetrate into the mechanism and barrel bore. The weapon must be cleaned daily and even several times a day. Dismantle the weapon on a user's level and clean thoroughly. When used in sandy areas, leave a thin layer of oil on the weapon to prevent the sand from sticking to the lubricant. Sand will cause stoppages and abrasions, which will cause malfunctioning of the mechanism.

3. Mud and Wet Conditions

In this case the oil is washed off, thereby increasing friction between the moving parts. In this case heavily lubricate the rifle, especially the contact surfaces between the moving parts and the receiver, the bolt carrier, and the bolt.

TROUBLESHOOTING

General

This chapter contains the troubleshooting information for the IWI ZION Z-25 ®. For each symptom, the probable reason is provided, as well as the instructions for remedial action.



WARNING

Before proceeding to investigate the cause of any malfunction, verify that:

- The firearm is properly assembled.
- The firearm is properly cleaned and lubricated. Ensure that the barrel, chamber, and breech face are completely dry.
- The ammunition has been inspected and approved for use.
- The magazine is intact and not loaded with more rounds than the capacity of the magazine.

Immediate Action

If the firearm fails to fire, immediate action must be taken before investigating the cause of the fault. Immediate action involves the following operation:

1. **TAP** - and pull on the magazine with your hand to make sure it is properly seated.
2. **RACK** - the charging handle all the way back, and watch for the ejection of cartridge.
3. **RE - ASSESS** - and re-engage if necessary.

Remedial Action

- a) **POINT** - Point weapon in a safe direction.
- b) **Lock** the bolt to the rear.
- c) **Strip** the magazine.
- d) **Sweep** the chamber area through the mag well if necessary to clear brass.
- e) **Drop** the bolt.
- f) **Reload** the magazine and load the weapon with the charging handle.
- g) **Re-assess** and re-engage if necessary.

Troubleshooting Table

The troubleshooting table below contains reference to potential malfunctions in operating the IWI ZION Z-25 ®. For each malfunction, the possible cause is provided as well as the instruction for remedial action.

Failure	Reason	Remedy
Failure to feed	Bad magazine	Replace magazine
	Magazine not inserted	Tap and pull on magazine and rack the bolt
	Insufficient movement of the bolt to the rear	Tap and pull on magazine and rack the bolt
	Weapon is not oiled or dirty	Clean and oil weapon
Double feeding	Magazine lips spread	Replace magazine
	Extractor spring weak	Replace extractor and spring
	Extractor broken	Replace extractor and spring
	Gas key loose	Send bolt back to the factory
	Fired casing left in chamber due to ripped rim	Clear the weapon out use a cleaning rod to clear brass. Clean chamber. Bad ammunition, change ammunition
Failure to fire	Gas rings bad	Replace gas rings
	Round in chamber, hammer fell, bad primer	Tap and pull on magazine and rack the bolt
	Round in chamber with no primer strike bad/broken firing pin	Replace firing pin
Failure to lock to the rear on last round	Weapon not oiled or excessively dirty	Clean and oil
	Weak ammunition	Change ammunition
	Gas rings bad	Replace gas rings

LIMITED PRODUCT WARRANTY

1. This Warranty is given by "IWI US, Inc." solely to the original purchaser (the "Purchaser") of IWI US, Inc.'s ZION Z-25 ® (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. Any cosmetic damage that does not impede form, fit, and function of the Product.
 - 4.3. Products that show evidence of tampering.
 - 4.4. IWI US, Inc. does not warrant that the operation of the product will be uninterrupted, or error-free, or free of stoppages or malfunctions.
- 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 HEREINABOVE 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.

REPAIR SERVICES

If you need assistance with your firearm, please call +1865-582-0012, Monday through Friday, 7:30AM to 4:30 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, armorer is warranted, please prepare and ship as follows:

1. Complete a Firearm Return Form found at <https://iwi.us/firearm-return-form/> (OR) Request a Return Authorization number (RA#) from the IWI US, Inc. Customer Service Representative. Please note that IWI US, Inc. will refuse return/repair shipments without a RA#.
2. Record the serial number of your firearm before packing and shipping.
3. Check to make sure your firearm is unloaded.
4. Remove all accessories from the firearm 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.
5. Pack your firearm in the original box. If the original box is not available, pack your firearm in a box that will protect it from any handling and/or shipping damage. Be sure that there are no markings and/or words on the outside of the box that indicate there is a firearm inside the box. This will help to deter theft of the firearm while in-transit to IWI US, Inc.

6. 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.
7. Ship your firearm by UPS. 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
RA#

1485 Mountain Road
Andersonville, TN 37705



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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In the interest of product improvement, design and performance characteristics may be changed at any time without prior notice.

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