

**Owners Manual
MAX-10/45
Upper Receiver**



LAGE Manufacturing, L.L.C. 916 E. Baseline Rd. STE #113 Mesa, AZ 85204

CM109mk2-300

Rev. A

NFA Warning

This upper receiver is designed to be used with the M-10/45 submachine gun. NFA (National Firearms Act, Title 26, United States Code) rules apply to its use and possession.

It is the owners/users responsibility to comply with all local, State and Federal laws and regulations in the use of this product.

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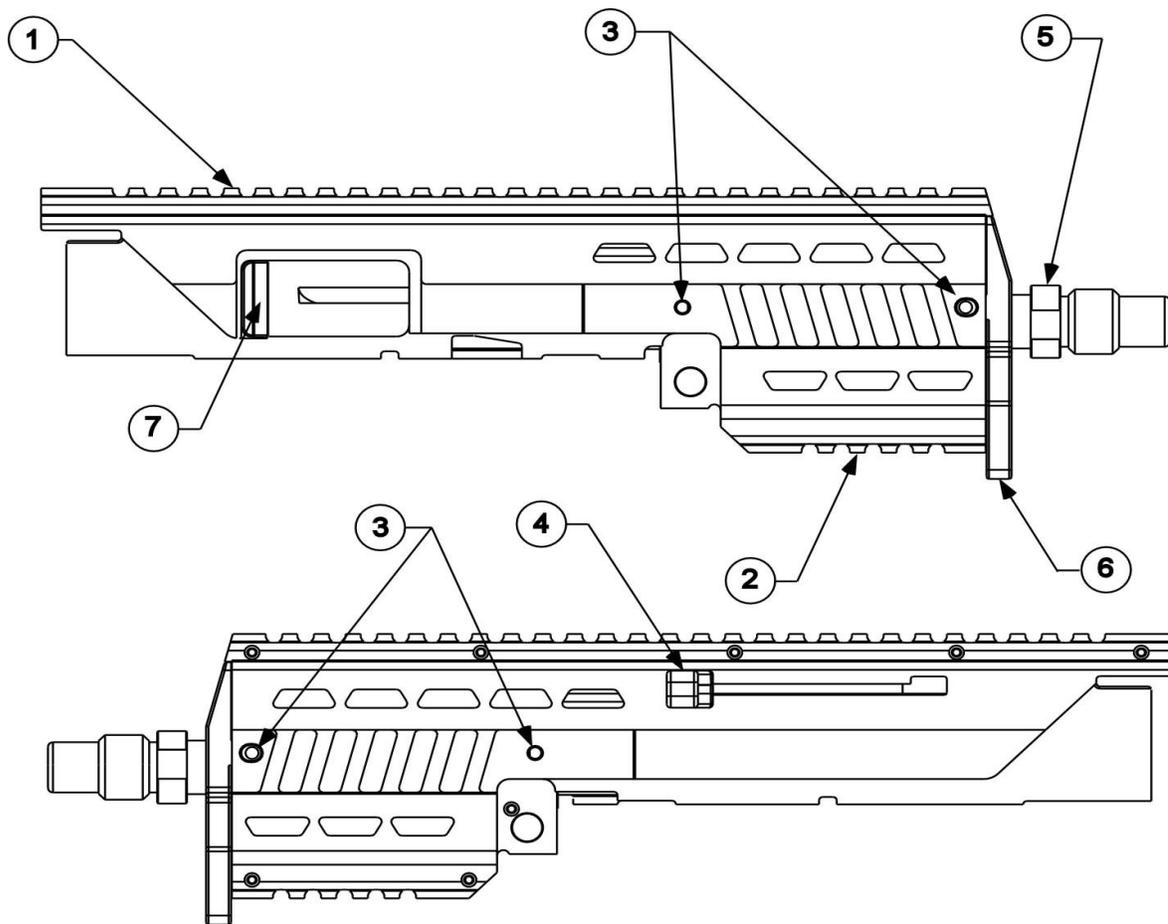
Description/Features

The MAX-10/45 mk2 Upper Receiver is designed to provide additional capability to the M-10/45 submachinegun. Utilizing a bolt weight, the rate of fire is reduced to around 750 rounds per minute. This allows easy controllability of fire and the ability to consistently fire single and two round bursts from the automatic setting. Other bolt assemblies are available to adjust the rate of fire to faster rates, if desired.

The MAX-10/45 mk2 attaches to the stock M-10/45 lower receiver without any modification to the lower receiver.

Features:

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|--|---|
| 1) Scope/Optics Rail 11-3/4" | 5) 9 inch barrel length, removeable
(threaded 7/8-9) |
| 2) Bottom Accessory Rail 3" | 6) Hand Stop |
| 3) Side Accessory Rail Mounting Points | 7) Shell Deflector |
| 4) Cocking Handle (reciprocating) | |



Installation

- ① Insure firearm is unloaded. Point in a safe direction. Remove magazine and pull bolt to the rear to insure chamber is empty.



- ② While holding cocking knob, pull trigger and ease bolt forward into closed position.



- ③ Remove front retaining pin and detach upper receiver from lower receiver.



- ④ Install Cocking Knob. Retract bolt until slot in bolt aligns with the rear of the slot in the upper receiver. Slide in cocking knob until it seats. Slide bolt and cocking knob forward.



- ⑤ Slide rear of upper receiver assembly into rear of lower receiver until receiver holes align.



- ⑥ Install retaining pin.



Removal

- ① Point firearm in a safe direction and insure it is unloaded and magazine is removed.
- ② Remove retaining pin.



- ③ Remove upper receiver from lower receiver.



Operation

Cocking

Pull cocking knob to rear and release. Bolt will remain open.
Cocking knob will remain in rear position.



Upper Scope/Optics Rail

A full length rail for mounting a scope or other aiming device is located on the top of the upper receiver. The profile of the rail is a standard Mil-Std-1913 style and will accept Weaver or Mil-Std-1913 scope rings or mounting systems.



Lower Accessory Rail

A rail for attaching a front hand grip, laser aiming device, tactical flashlight or other device is attached to the bottom of the front handgrip.

Please note, some hand grips are not manufactured to the correct dimensions to mount on a Mil-Std-1913 rail. Insure the grip is correct before attaching. The recommended front grip is our Forward Canted K-Grip.

Additionally, tactical flashlights designed for use with pistol accessory rails will fit on the accessory rail but, will be a tighter fit.



Side Accessory Rails (optional)

The MAX-10/45 mk2 can be fitted with left and right side accessory rails for mounting additional accessories. The optional accessory rails come with additional mounting screws. They are installed by removing the existing side grip mounting screws, placing the rails over the grip sides and installing the mounting screws. When installing the new screws, use Loctite 242® on the threads and be careful not to overtighten the screws.



Attachment of a Sound Suppressor

A sound suppressor may be attached to the MAX-10/45 mk2. The threads on the MAX-10/45 mk2 barrel are 7/8-9. When using a suppressor, regularly tighten the suppressor to the barrel threads. It will have a tendency to loosen during firing. This is typical of the 7/8-9 mounting thread and is not related to the design of the MAX-10/45 mk2 upper receiver.

CAUTION:

Prior to installation and use of a sound suppressor, it is recommended that the suppressor be installed by a qualified gunsmith and the mounted suppressor be inspected for alignment prior to firing. Additionally, some suppressor manufacturers' warranties expressly require that they thread the barrel for the firearm that their suppressor will be used on. The warranty for the MAX-10/45 mk2 Upper Receiver applies only to the upper receiver assembly and not any accessories subsequently attached by the Customer.

Removal of Barrel

The barrel has been designed to allow easy removal and installation. There are 7/8" wrench flats at the muzzle end.

To Prevent marring the finish of the upper receiver use a padded vise or hard wood inserts. Alternatively, apply a couple layers of masking tape to the retaining pin hole area. Secure in vice firmly at this location on the body. Using a 7/8" open end wrench on the wrench flats at the muzzle end, turn the wrench counter clockwise to loosen and remove the barrel. The trunnion will come loose after removal of the barrel.

To re-install barrel, replace trunnion into the body, beveled side forward with largest bevel down towards retaining pin hole. Place a snap cap round into the extractor in the bolt for barrel alignment. Replace bolt and use it to keep the trunnion in place. Apply Loctite Threadlocker 242 to the barrel threads and insert barrel into trunnion while applying pressure to the back of the recoil assembly. Hand thread barrel and tighten by turning the wrench clockwise. Use a torque wrench to tighten to 40 foot/pounds.



Cleaning, Lubrication and Maintenance

Cleaning and lubrication should be carried out per the original manual provided with the M-10/45 with the following additional requirements:

Recommended cleaning interval is after each shooting session or 500 rounds of use.

Remove the upper receiver from the lower receiver. Slide the bolt assembly fully rearward. Remove the cocking knob from the left side of the receiver. Remove bolt assembly from upper receiver.

Clean upper receiver with solvent. The metal finish and polymer grips are resistant to most cleaning chemicals including Mineral Spirits, Acetone and MEK. Inspect all mounting screws for tightness.

Clean barrel using your preferred method.

Lightly coat all surfaces with gun oil. Wipe away any excess oil.

Clean the bolt assembly in solvent. Brush the bolt face and breach area with a nylon or brass brush to remove any built-up carbon deposits. Insure the bolt face is clean and free of debris.

Using a fingertip, apply a thin coat of gun oil to the bolt surfaces. Wipe away any excess oil. Add a drop of gun oil to the recoil spring where it meets the back of the bolt. Inspect the sear engagement surface for rounding or burrs. Small burrs may be removed with a file. If the surface is worn and preventing the sear from reliably engaging, discontinue use and have it repaired immediately.

Insert the bolt assembly into the upper receiver. Slide bolt assembly forward until hole in bolt assembly lines up with rear of slot in upper receiver. Install cocking knob and push bolt assembly forward. Re-install upper receiver and front hand grip to lower receiver.

Parts Replacement

The MAX-10/45 mk2 Upper Receiver uses some parts that are common to the original M-10/45. All replacement parts can be purchased from LAGE Manufacturing, L.L.C.. Additionally, you can purchase the following parts from any company that sells parts for the M-10/45:

- Buffer
- Back Plate
- Recoil Rod
- Ejector Rod
- Extractor Spring
- Extractor Roll Pin

Referenced Manufacturers

Loctite Threadlocker 242®

Loctite is a trademark of Loctite Corp, 1001 Trout Brook Crossing
Rocky Hill, CT 06067

TROS

PO Box 680
Clackamas, OR 97015
www.trosusa.com

Warranty and Repair

WARRANTY

Note: Use of reloaded/remanufactured ammunition or steel or aluminum cased ammunition will void your warranty

The MAX-10/45 mk2 Upper Receiver has been manufactured in a manner to insure it is defect free and durable. LAGE Manufacturing, L.L.C. warrants to the original purchaser that this product is free from defects in materials and workmanship for the period of One Year from the original date of purchase. This warranty does not apply to damage due directly or indirectly, to misuse, abuse, negligence or accidental, repairs or alterations outside our facilities or to lack of maintenance. We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special or consequential damages arising from the use of this product. The above limitation of exclusion may be subject to state law and may not apply to you.

To utilize this warranty, the MAX-10/45 mk2 Upper Receiver must be returned to us packaged in a manner to preclude damage during transit and with shipping charges prepaid. Proof of purchase date, and a written description of the complaint must be included. If upon inspection, the complaint is verified, we will either repair or replace the product at our election or we may elect to refund the purchase price if we cannot readily and quickly provide a replacement. We will return the repaired product at our expense, but if we determine that there is no defect, or that the defect was a result of causes not within the scope of this warranty, then you must bear the cost of returning the product.

This warranty gives you specific legal rights and you may have other rights, which vary from state to state.