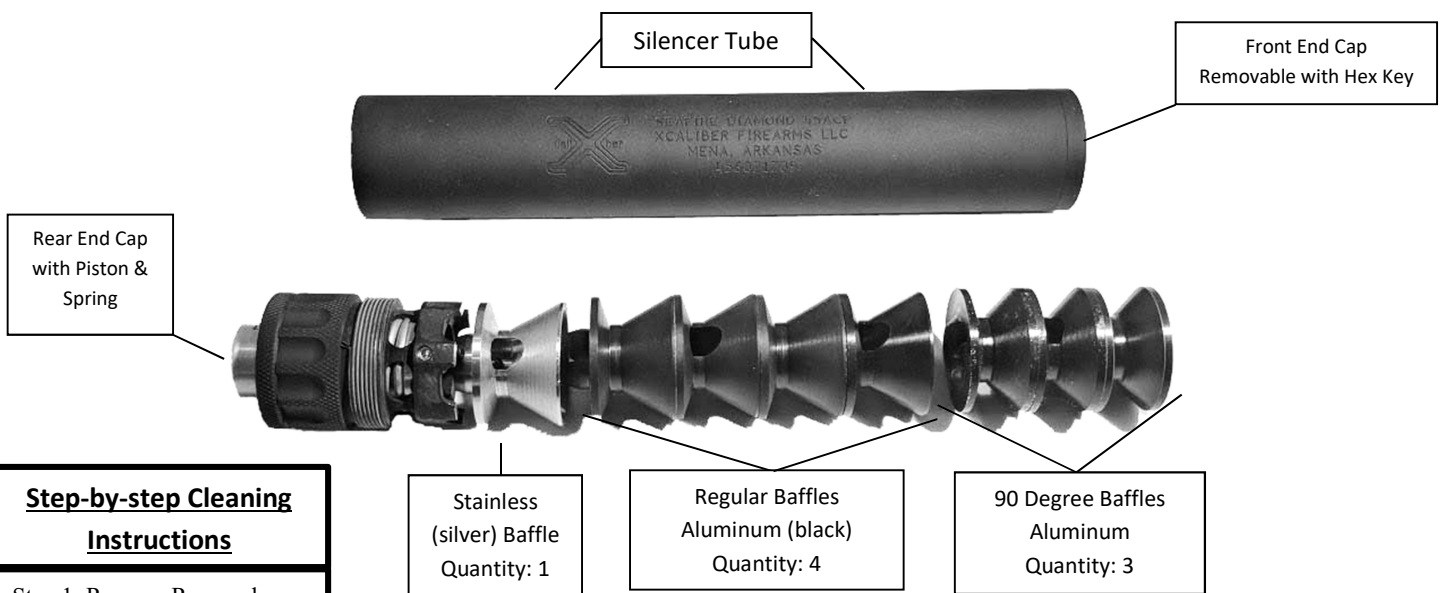


Xcaliber Firearms Seafire 45 Components and Design

Use the following model(s) to reassemble your Xcaliber Firearms Seafire 45 after cleaning. Please note that you do NOT need to remove the Front End Cap for disassembly.



Step-by-step Cleaning Instructions

Step 1: Remove Rear end cap containing piston and spring (these do not need to be taken apart)

Step 2: Remove all baffles (if baffles give resistance remove front endcap and use a wooden or plastic dowel slightly smaller than tube to push baffles out) if disassembly is tough use a penetrating-lubricating oil.

Step 3: Using a strong ammonia based cleaning solution and a cleaning brush, brush and remove all build up on baffles and tube.

Step 4: Starting with the Front endcap side, insert the 90 degree baffles "cone" side towards the FRONT endcap.

Step 5: Following diagram, insert remaining baffles and rotate each baffle in a 180 degree alignment (see checkmark) Baffles should appear opposite from one another.

Step 6: Thread rear endcap into tube and tighten.

Both Stainless and Regular baffles will have an extended "bottom" see below for example.

90 Degree baffle will have a flatter "bottom" see below for example.

Please note the stainless baffle will be the **ONLY** baffle that has a small 1/8th hole on the top.



CORRECT 180 degree alignment pattern



INCORRECT alignment pattern

