



Safety, Instruction & Parts Manual

Boberg XR45-S Pistol



Caution

READ THESE INSTRUCTIONS AND WARNINGS CAREFULLY. BE SURE THAT YOU UNDERSTAND THESE INSTRUCTIONS AND WARNINGS BEFORE USING THIS FIREARM.

WARNING WARNING WARNING WARNING

CAN BE FIRED WHEN THE MAGAZINE IS REMOVED IF THE CARTRIDGE IS IN THE CHAMBER AND THE TRIGGER IS PULLED.

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This SAFETY, INSTRUCTION & PARTS MANUAL should always accompany this firearm and be transferred with it upon change of ownership or when the firearm is loaned or presented to another person. A copy of the SAFETY, INSTRUCTION & PARTS MANUAL is available FREE upon request from:

Boberg Arms Corporation, 1755 Commerce Court, White Bear Lake, Minnesota 55110
www.bobergarms.com

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BASIC RULES OF FIREARMS SAFETY

At home, in the field, at the range or anywhere, the first concern of every firearm owner should be safety. Apply the following safety rules in every situation, with any kind of firearm.

1. **Learn how to safely use your firearm.** No person should handle any firearm without first becoming familiar with how to operate it safely. Read this manual thoroughly until you understand how to operate the pistol safely.
2. **Always treat your pistol as if it were loaded and ready to fire if the trigger is pulled.** Always exercise the utmost caution when handling your pistol. DO NOT take anyone's word that the pistol is unloaded—always check for yourself.
3. **Always keep your finger off the trigger until you are ready to shoot.** Your pistol cannot fire unless the trigger is pulled.
4. **Always keep the muzzle pointed in a safe direction.** This is particularly important when loading, unloading or field stripping your pistol. Never point a firearm at anyone or anything you do not intend to shoot.
5. **Know your target and what is beyond it.** Always be sure of where the bullet will strike and shoot only where there is a safe backstop free of obstructions, water or other surfaces which can cause ricochets.
6. **Never store your pistol in a loaded condition.**
7. **Keep all firearms away from children.** Always secure your firearm from children or unauthorized persons. Always store your unloaded firearm and ammunition separately and in a secure place inaccessible to children.
8. **Use only the correct ammunition for your firearm.** Never use a cartridge not specifically designated for use in your pistol. The correct caliber designation is 9 mm Luger and is stamped on the frame.
9. **Make sure there are no obstructions in the barrel.** With the magazine removed and the slide open, visually inspect the chamber to determine that it is empty. Then check that the barrel is clear of obstructions.
10. **Wear eye and ear protection as appropriate.** Protect your vision and hearing from damage by always wearing safety glasses and hearing protection.
11. **Never use alcohol or drugs before or while shooting.**
12. **When transporting your firearm, make sure it is unloaded.**
13. **Use only appropriate accessories.** Be sure all accessories, such as holster and grips, are compatible with the firearm and that the accessories do not interfere with safe operation.

SAFETIES IN YOUR GUN

Boberg XR9 pistols are equipped with two safeties: a Double-Action Only (DOA) trigger, and a passive firing pin safety, which blocks the firing pin until you have drawn the trigger back most of the way.

GENERAL PREPARATION FOR FIRING

- ❖ Wear safety glasses and ear protection whether indoors or out.
- ❖ Select a place to shoot which has a safe backstop, is free from obstructions, water or other surfaces which cause ricochets. Check local and state laws to be sure that shooting is permitted at the site you have selected.
- ❖ Always be aware of other people so that persons cannot accidentally walk into the line of fire.
- ❖ Position the shooter and all others so that they are not within an area where they may be struck by particle-spitting from a revolver or by ejected cases from other types of firearms.
- ❖ Keep fingers and other parts of your body away from the muzzle and slide.
- ❖ When firing on a target range, be alert and follow the range officer's commands.
- ❖ Before anyone is allowed forward of the firing position, be sure that all cylinders and actions of firearms are open, that chambers are clear of cartridges, magazines are removed, and that firearms are pointing in a safe direction and **NOT HANDLED ON THE BENCH**. Do not handle firearms while someone is forward of the firing position.
- ❖ Never use alcoholic beverages or other drugs before or during shooting.
- ❖ Be alert at all times. Never shoot if you are tired, cold or impaired in any way.
- ❖ Never cross obstacles such as fences or streams with a loaded firearm.
- ❖ If you are carrying a loaded firearm in the field, keep the muzzle pointed in a safe direction.
- ❖ Think before shooting.
- ❖ **Guns don't think, so you must**

AMMUNITION

WARNING

Never use ammunition where the pressure levels exceed industry standards. Boberg XR Series pistols are manufactured from high quality material. However, +P+ cartridges – whose pressure often exceed even factory proof-test levels – should never be used in your pistol. All warranties, expressed or implied, are voided and Boberg Arms Corporation will not be liable for property damage or personal injury and consequential damages, if +P+ ammunition is used in Boberg XR Series pistols. See website for recommended ammunition.

A firearm and ammunition are a system. Their performance is closely related. Boberg XR Series pistols are designed for specific caliber ammunition, .45 ACP; do not alter the barrel or chamber of your Boberg XR Series pistol.

The caliber designation for this pistol is **clearly stamped on the left side of the frame**. Use only commercially manufactured ammunition for the caliber indicated on the barrel hood. **Never use** non-standard or **reloaded** ammunition.

Due to the Boberg XR Series' unique feed mechanism, aluminum-cased ammunition is not recommended (**See back cover for color example**). This type of ammunition has no crimp, and usually no adhesive, and could allow the bullet and case to become separated while being drawn from the magazine. While this is not considered a safety hazard, it can result in a mis-feed or jam. Please note that there may be styles of brass-cased ammunition that have no crimp that may cause feeding problems. Two such styles are Federal Champion (i.e. Wal-Mart special) and Blazer Brass. Information on crimp-less styles of ammunition can be found at www.BobergArms.com. We always recommend that you first test fire any style of ammunition in your XRSeries9 before using it for self-defense purposes.

LOADING

Do not load your Boberg XR45 pistol until you are ready to use it and thoroughly understand these instructions. Keep your finger outside the trigger guard until you are ready to fire. For safe and reliable performance, use only original Boberg XR45 magazines specifically manufactured for your pistol.

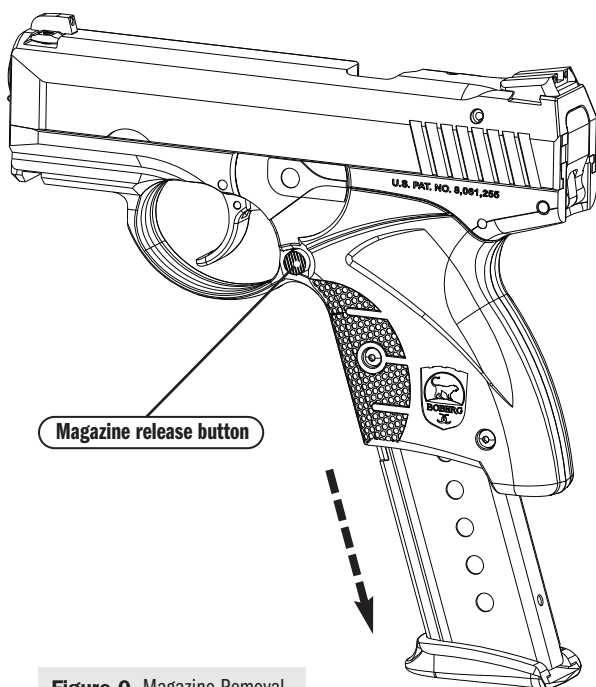


Figure 0. Magazine Removal

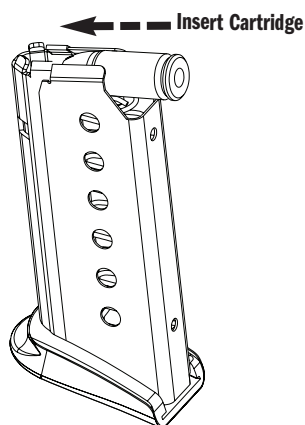


Figure 1. Magazine Loading

Remove the magazine from the pistol by depressing the magazine release. (See Figure 0.)

Note: This magazine does not have a magazine follower, but one can be ordered from Boberg Arms if desired. Load magazine by pressing the cartridge nose (front of the cartridge) downward on the rearward portion of the magazine spring and sliding the cartridge fully under the lips of the magazine until the cartridge head is all the way forward in the magazine. (See Figure 1.) Repeat this procedure until the number of cartridges you wish to load, up to the magazine capacity of seven (which can be viewed through the holes in the magazine) is attained.

Before inserting the magazine, hold the pistol in one hand with the muzzle pointing in a safe direction and with your trigger finger **outside** of the trigger guard. With the other hand, pull the slide back until you can look into the chamber, verify that the chamber is empty, and allow the slide to return forward. Insert the loaded magazine firmly into the magazine well of the pistol until it is locked in place. To make sure the magazine is fully and securely seated, apply some removal tension to the exposed portion of the magazine floor plate.

LOADING

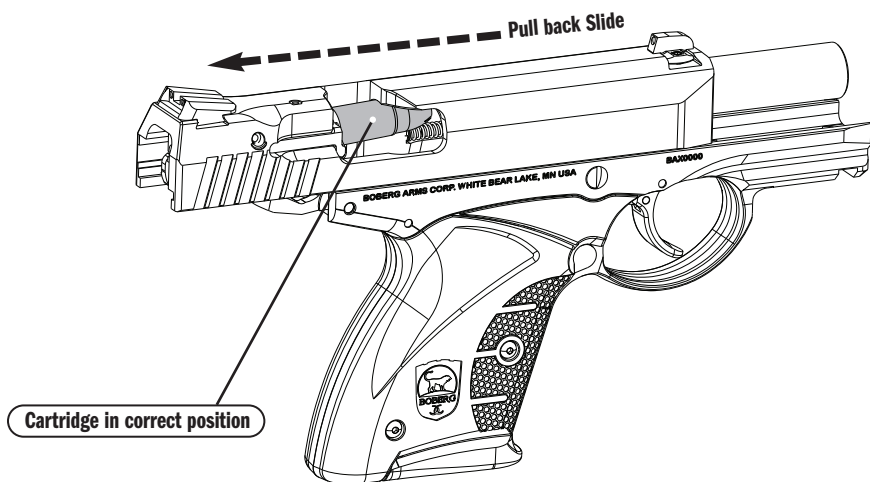


Figure 2. Chambering a Round

After securely inserting the magazine into the pistol, quickly pull the slide fully rearward. It is usually easier to pull the slide back more quickly than slowly. Since pulling the slide rearward actuates the feed mechanism, it is useful to become acquainted with the unique operation of the XR Series. To verify that the slide has successfully reached its full rearward position, look at the ejection port area of the slide to see if a live cartridge is fully upward and trapped against the underside of the slide. (**See Figure 2.**) If the cartridge is not in this position, continue drawing the slide rearward until this condition is met. If there is no cartridge present, release the slide, allowing it to go to its full forward (battery) position, and draw the slide back once again. If there is still no cartridge, verify that there are cartridges present in the magazine. If a cartridge is in the correct position as shown in **Figure 2**, release the slide sharply (in essence, “slingshotting” it forward). This chambers a cartridge, making the pistol ready to fire. **THE BOBERG XR45 PISTOL CAN NOW BE FIRED BY PULLING THE TRIGGER.**

If you wish to reload the magazine in your Boberg XR45 pistol to its full capacity, depress the magazine release and remove the magazine from the pistol. The Boberg XR Series pistols are capable of firing even when the magazine has been removed if the trigger is pulled. If the magazine is removed with a round left in the chamber, be sure to holster or otherwise secure the pistol under your direct control while the magazine is being reloaded. Load one cartridge into the magazine to replace the cartridge which was chambered when you allowed the slide to go forward. Reinsert the loaded magazine into the magazine well until it is locked into place. To make sure the magazine is again fully and securely seated, apply some removal tension to the exposed portion of the magazine (floor plate).

Your Boberg XR45 pistol is now fully loaded and ready to fire. Remember to keep your pistol pointed in a safe direction at all times and always keep your finger outside the trigger guard until ready to fire. Never leave any loaded firearm unattended.

FIRING

WARNING

Some users of Boberg XR Series pistols may “stage” the trigger in anticipation of firing a shot using its double-action-only (DAO) trigger. “Staging” is the act of pulling the trigger rearward toward—but just short of—the point where the hammer falls and the pistol fires. Such manipulation of the trigger can reduce the user’s control of the handgun and can result in an unintentional discharge. Furthermore, if the user decides not to fire, release of the trigger from a position close to the firing point in the “staging” process could result in a discharge. Obviously, “staging” the trigger violates a basic rule of firearm safety which warns you to keep your finger off the trigger and outside the trigger guard until ready to fire. We warn all users of our DAO pistols to refrain from “staging” the trigger.

Hold the pistol firmly in your shooting hand with your finger outside the trigger guard. After verifying that the target and the area beyond are safe, align the sights on the target. When you are ready to shoot, place the pad of your index finger on the trigger.

When the trigger is drawn fully to the rear, the hammer is released, striking the firing pin, which strikes the cartridge primer. Upon firing, the slide moves rearward, thereby extracting and ejecting the spent cartridge case. At the same time, a fresh cartridge is being drawn from the magazine and lifted into alignment with the barrel. On the forward stroke of the slide, the new cartridge is placed into the chamber. During firing operation, the thumb or any other part of the hand should not interfere with the slide. This sequence can be repeated until the last round has been fired.

Please note that the Boberg XR Series does not lock open on the last shot.

CLEARING MISFIRES

If a cartridge fails to fire, pull the trigger again. If this does not result in a discharge wait at least thirty seconds while keeping the muzzle pointed in a safe direction. Then draw back the slide to eject the bad round and chamber a new round.

After waiting at least sixty seconds, retrieve the misfired round and inspect it. If the firing pin indent on the primer is off center, light or non-existent. **(See Troubleshooting Guide on page 24.)** Be sure to dispose of the misfired round according to the ammunition manufacturer’s instructions.

UNLOADING

While keeping your finger outside the trigger guard and pointing the muzzle in a safe direction, depress the magazine release and remove the magazine. With your finger still outside the trigger guard and the muzzle still pointing in a safe direction, grasp the slide from the rear and briskly pull the slide fully rearward to eject the round from the chamber and lock back the slide with the takedown lever rotated down to the 6:00 position. (See Figure 3.) Visually inspect the barrel chamber to be sure it is empty. Unload the magazine by holding it with the bullet end of the cartridge pointing away from you and drawing each cartridge backward and out of the magazine.

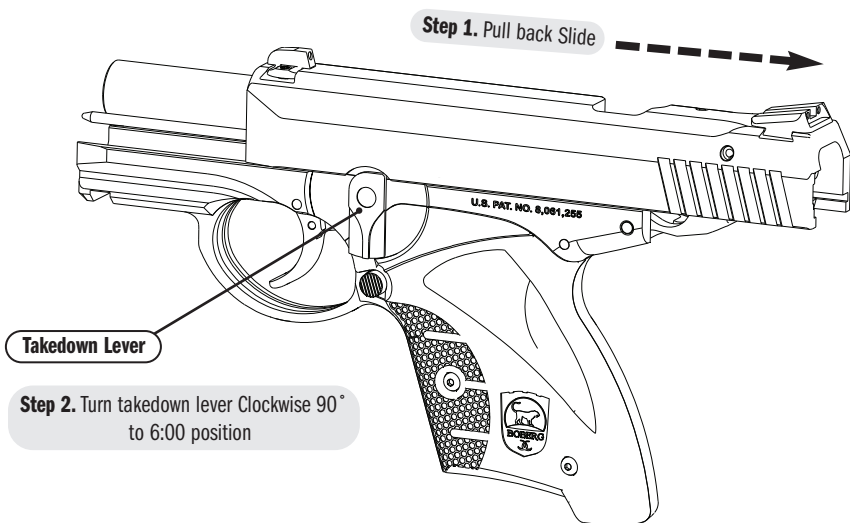


Figure 3. Slide Hold–Open

TARGETING & SIGHT ADJUSTMENT

To adjust for windage, simply move the rear sight in the direction you want the bullet to move on the target. For example, if you want the bullet to move to the right, move the rear sight to the right. To move the rear sight, simply loosen the set screw with a 1/16" hex key and re-tighten when sight is in desired position. Be careful not to lose control of the rear sight when loose—it contains the firing pin safety spring.

Dry Firing

It's OK to dry fire the XR Series pistol; this will not harm the gun in any way. However, **always make certain that the gun is unloaded and aimed in a safe direction.**

FIELD STRIPPING

*During field stripping of your pistol, **ALWAYS POINT THE MUZZLE IN A SAFE DIRECTION AND BE SURE TO KEEP YOUR FINGER OUTSIDE THE TRIGGER GUARD. BE SURE YOUR PISTOL IS UNLOADED BEFORE DISASSEMBLY.***

Disassembly

To disassemble, depress the magazine release and remove the magazine. Grasp the slide from the rear and briskly pull the slide fully rearward to eject the cartridge from the chamber and lock the slide open with the takedown lever rotated to the 6:00 position. **(See Figure 3.)** *Visually inspect the barrel chamber to be sure it is empty. Never clean, lubricate, disassemble or work on your pistol while it is loaded.*

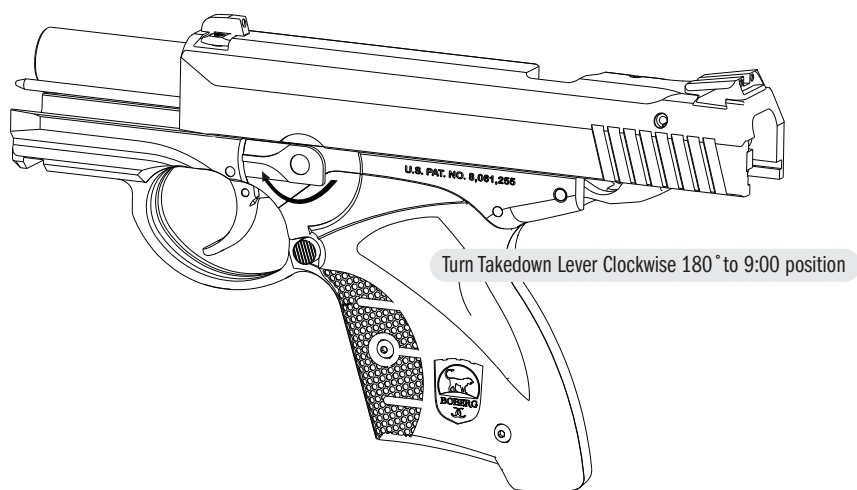


Figure 4. Field Strip—Takedown Lever at 9:00 Position

Now hold the slide back while rotating the takedown lever to the 9:00 position as shown in **Figure 4.**

FIELD STRIPPING



Figure 5. Slide Removal

The slide is now free to move forward for removal. (See Figure 5.)

Remove the recoil spring (with guide rod), unlock block and barrel as shown in Figure 6a, Figure 6b, and 6c.

Note: it may be necessary to tip the barrel slightly in order for the unlock block to be removed.

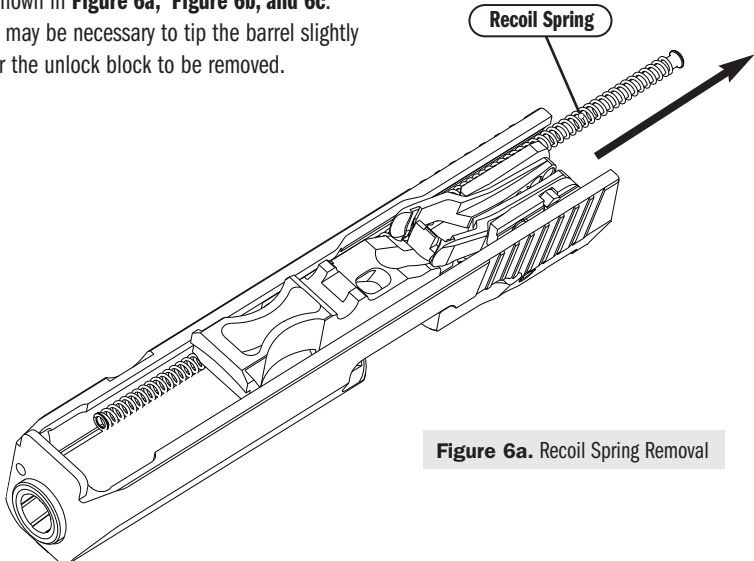


Figure 6a. Recoil Spring Removal

FIELD STRIPPING

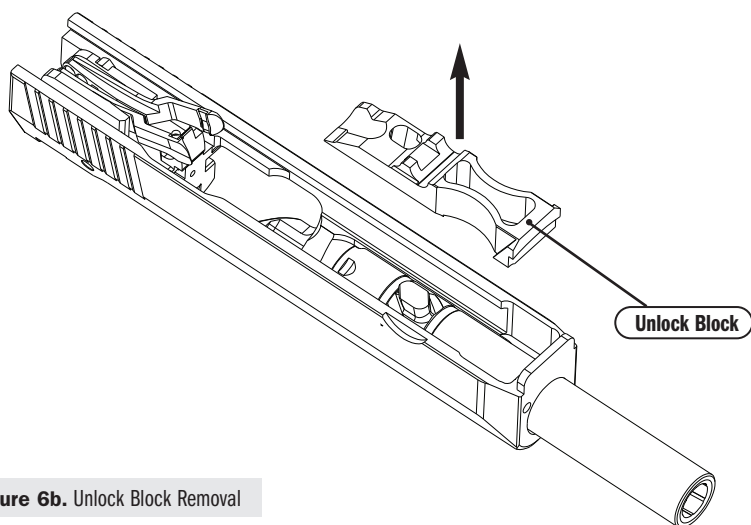


Figure 6b. Unlock Block Removal

Now with the unlock block removed, the barrel can be tipped out as shown in **Figure 6c**.

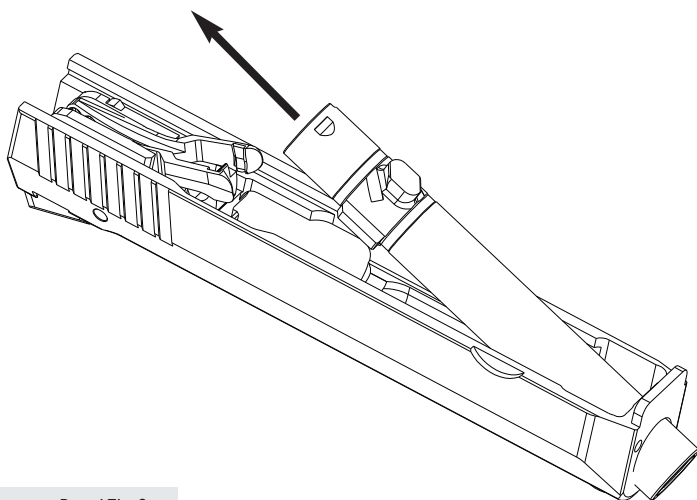


Figure 6c. Barrel Tip-Out

The pistol is now ready for normal cleaning and lubrication. **Further disassembly is not recommended and should only be undertaken by Boberg Arms Service Department.**

FIELD STRIPPING

Reassembly

With the bottom of the slide turned up, replace the barrel in the slide by tipping it back into place. Replace the Unlock Block as shown in **Figure 7**. It is helpful to have the barrel slightly tipped. Replace the recoil spring with the guide rod inside. Be sure the recoil spring is properly seated in the corner of the slide. (**See Figure 8.**) Now push the unlock block rearward as shown in **Figure 9**, locking it into its rearward position under the tongs.



Figure 7. Installing Unlock Block



Figure 8. Recoil Spring Seated in Corner of Slide

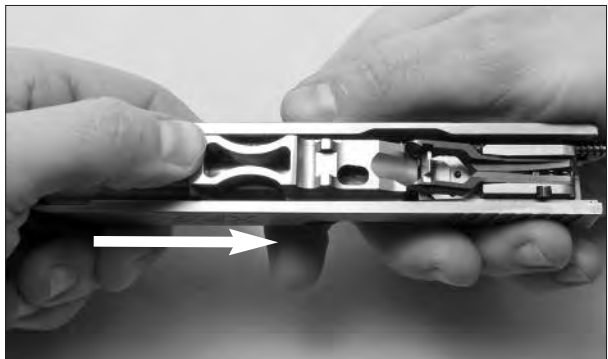
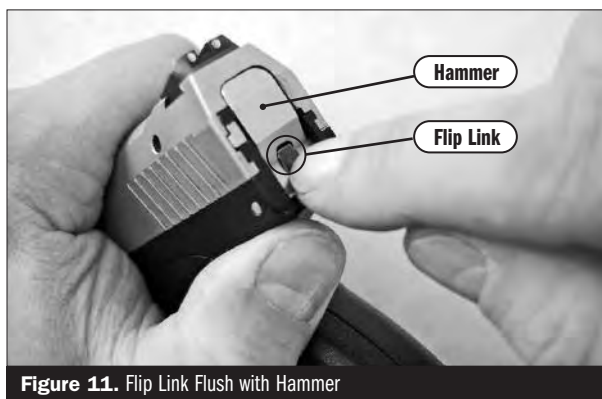


Figure 9. Crowding the Unlock Block

FIELD STRIPPING



Holding the slide assembly in one hand, move the rear of the slide onto the frame rails. It is recommended that this be done with the gun upside-down. When installing the slide onto the frame, be certain that the recoil spring/guide rod is seated into the notch in the frame. **(See Figure 10.)** If the slide does not go on completely at this point, check to make sure that the flip link is flush with the hammer. **(See Figure 11.)** If it is not, hold it in while installing the slide. Once these requirements have been met, continue moving the slide onto the frame until the slide is fully rearward before rotating the takedown lever back to its 3:00 position. The gun is now assembled.

WARNING

Manipulation of the hammer other than by the trigger will damage your firearm and void warranty.

CLEANING AND MAINTENANCE

Follow this routine maintenance procedure to ensure that your pistol functions properly.

Cleaning

After firing your Boberg XR45 pistol, be sure to unload it following the procedure outlined in the section entitled “Unloading” (See page 8.) before field stripping and beginning any cleaning or maintenance procedure. Clean the barrel bore with a premium quality, powder removing solvent and bore brush. Wipe the bore clean with a bore patch or swab. Using a small brush and solvent, remove all deposits from around the breech of the barrel, and chamber, extractor, locking lugs, bolt face and adjacent areas which have been subjected to the action of the powder or primer residue. Remove any residue on the frame with light brushing and solvent. Clean the magazine well by removing any grit, dust, or residue with a magazine well swab.

Magazine Disassembly

Hold magazine with floor-plate facing up and front of magazine facing away from you. Use a small screwdriver to lift the leg of the magazine spring out of the groove while shoving the magazine floorplate forward. (See Figure 12.) Exercise caution during floorplate removal since the magazine spring is under compression. Always wear eye protection when performing such tasks.

Magazine Cleaning

Swab the inside of the magazine tube with a clean brush to remove lint and debris.

Magazine Reassembly

Insert spring. Then slide floorplate over the spring until the floor plate comes to a stop. Use a small screwdriver to lift the spring leg into the groove in the floor plate. (See Figure 12 below.)



Figure 12. Magazine Assembly/Disassembly

LUBRICATION GUIDE

The Boberg XR45 comes pre-lubricated at the factory with a non-evaporating lubricant. However, it is recommended that the XR45 be periodically lubricated, especially after cleaning. **In Figures 13-21 the key lubrication points are shown.** One drop of oil in each area is recommended. Any excess lubricant should be wiped off, especially on the grip area. While we currently use Break-Free CLP™ brand lubricant; any product of equivalent performance should be sufficient.

Note: The Unlock Block well is lubricated with moly-based anti-seize, which is required for the system to function properly. Reapply two small pea sized drops of anti-seize as shown below whenever pistol is cleaned. When lubricating the Unlock Block utilize an anti-seize that **does not contain metals!** Re-apply this compound whenever cleaning the firearm. Apply at points shown below in **Figure 13.**



Figure 13. Unlock Block well with anti-seize applied

LUBRICATION GUIDE



LUBRICATION GUIDE



Figure 16. Left Slide Rail oiling point

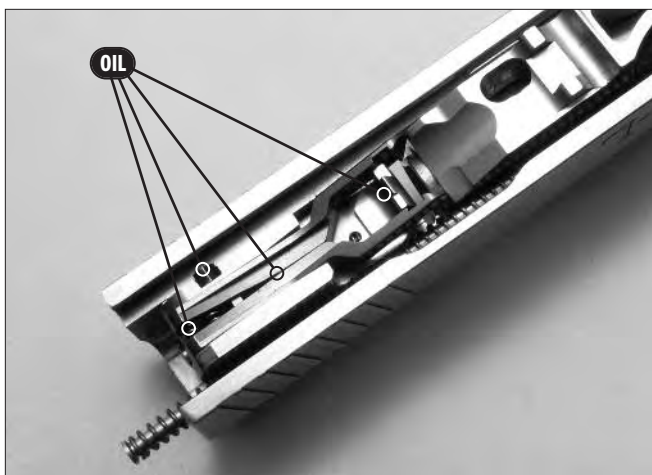
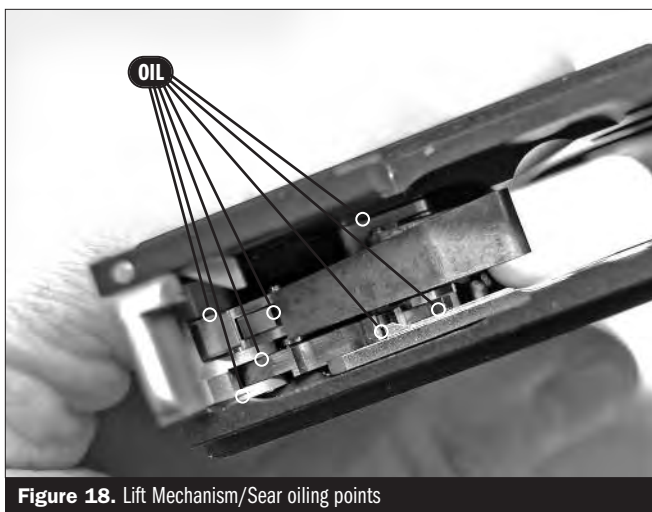


Figure 17. Tong and Firing Pin Safety oiling points

LUBRICATION GUIDE



LUBRICATION GUIDE

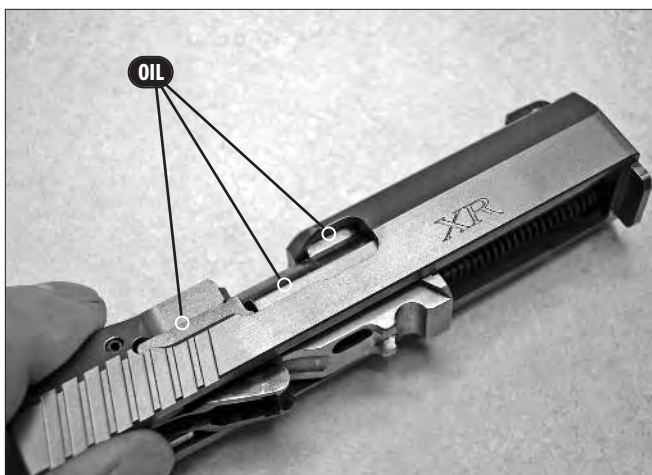


Figure 20. Extractor/Locking Lug oiling points

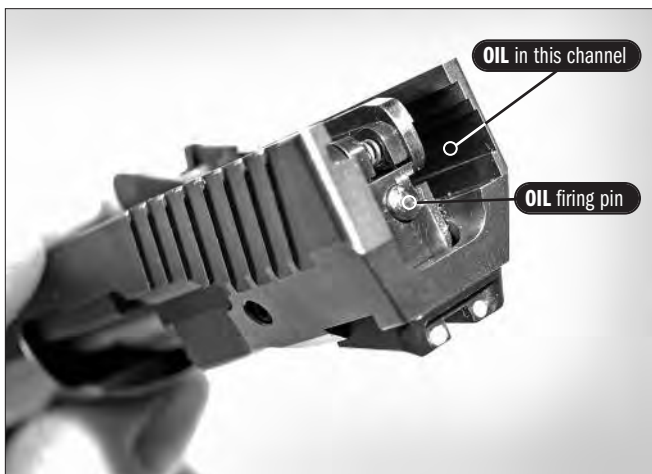


Figure 21. Ejector Cam oiling point

TRANSPORTATION AND STORAGE

WARNING

ALWAYS UNLOAD YOUR PISTOL BEFORE STORING OR TRANSPORTING.

To protect your Boberg XR Series pistol from damage, unauthorized use and theft; secure it in the case provided. Store your ammunition separately. If your pistol is to be stored for an extended period of time, treat the bore and chamber with corrosion inhibiting lubricant. Clean the bore and chamber before using again.

When transporting any firearm, it is your responsibility to learn and obey all applicable laws.

USE OF THE GUN LOCK

THIS GUN LOCK IS APPROVED FOR USE IN THE STATE OF CALIFORNIA BY
THE CALIFORNIA DEPARTMENT OF JUSTICE.

Safe firearm ownership is your responsibility. Only the firearm owner can and should prevent misuse and/or accidental discharges.

The enclosed device is not a substitute for common sense and personal liability. As with all mechanical devices, it can be defeated.

Take all recommended precautions with attaching this device and store the firearm in a safe and responsible manner.

THIS GUN LOCK IS DESIGNED TO KEEP YOUR FIREARM STORED IN A SAFE CONDITION. USE OF THIS DEVICE DOES NOT RELIEVE THE HANDLER OR OWNER OF THE FIREARM FROM ALWAYS FOLLOWING PROPER FIREARM SAFETY RULES. THIS DEVICE IS DESIGNED TO PREVENT THE UNAUTHORIZED USE OF THE FIREARM ON WHICH IT IS BEING USED. THE DEVICE IS NOT INTENDED TO PREVENT THEFT. TO PREVENT THEFT WE STRONGLY RECOMMEND KEEPING ALL FIREARMS IN AN APPROVED FIREARM SAFE OR OTHER TYPE OF SECURE STORAGE SYSTEM. ALWAYS OBSERVE THE WARNINGS AND INSTRUCTIONS WHEN USING THIS DEVICE ON A FIREARM.

Keep firearms and ammunition stored separately and securely. Keep firearms and ammunition out of the reach of children.

USE OF THE GUN LOCK

WARNING

NEVER INSTALL THIS DEVICE OR ANY OTHER TYPE OF FIREARM SAFETY DEVICE ON A LOADED FIREARM. ALWAYS UNLOAD THE FIREARM BEFORE INSTALLING THIS DEVICE OR BEFORE STORAGE.

THE USE OF THIS GUN LOCK WILL HELP TO PREVENT YOUR FIREARM FROM BEING USED (DISCHARGED) BY UNAUTHORIZED PERSONS. THIS DEVICE IS NOT INTENDED TO PREVENT THE FIREARM FROM BEING STOLEN. STRICT FIREARM SAFETY PRACTICES SHOULD ALWAYS BE FOLLOWED WHEN YOUR FIREARM IS SECURED BY THIS SAFETY DEVICE.

Installation

1. Unload all ammunition in a safe manner as explained in your firearm owner's manual. **(See page 8.)**
2. Visually inspect the chamber(s), feed mechanism, receiver and magazine to confirm the firearm is completely unloaded.
3. Use the key to release the cable.
4. For proper installation of this lock on your new Boberg XR Series firearm **see Figure 22.**
5. Remove magazine.
6. Check to ensure the gun is completely empty of loaded shells.
7. While pulling the slide partially rearward, insert cable through the ejection port and push down through the magazine well.
8. Insert open end of cable into the lock body and turn key to lock.
9. Remove keys.
10. Pull on lock body to ensure the device has locked properly.
11. Store your keys in a secure location.



Figure 22. Proper Installation of the Gun Lock*

* Shown here installed on the XR9-S

TROUBLESHOOTING

In the unlikely event that the Boberg XR45 fails to perform as expected, there are a few things you can check before contacting us so that we can better serve you.

LIVE ROUND FALLS OUT DURING FIRING

After firing your Boberg XR45 pistol, be sure to unload it following the procedures outlined in the section entitled “Unloading” (See page 8.) before field stripping and beginning any cleaning or maintenance procedure. Clean the barrel bore with a premium quality, powder removing solvent and bore brush. Wipe the bore clean with a bore patch or swab. Using a small brush and solvent, remove all deposits from around the breech of the barrel, and chamber, extractor, locking lugs, and adjacent areas which have been subjected to the action of the powder or primer residue. Remove any residue on the frame with light brushing and solvent.

Possible cause #1: Magazine not latched.

Remedy: If the magazine is not latched, it may not be high enough for the tongs to grab the cartridge. Make certain that the magazine is latched by pushing up on it until an audible clicking sound is heard.

Possible Cause #2: Broken or damaged tong.

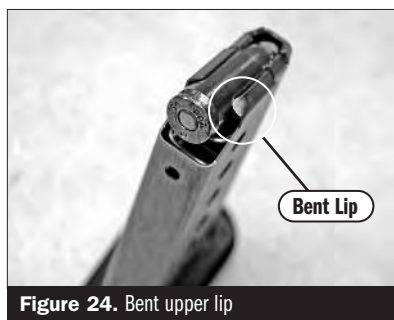
Remedy: While this is an unlikely occurrence, remove the slide assembly (see field stripping section) and examine the tongs. They should look like **Figure 23** below. You can also insert a cartridge into the tongs to verify that the tongs have a positive grip. If, for any reason, either tong is not intact, or has become bent or damaged in any way, contact repair@BobergArms.com.



TROUBLESHOOTING

Possible Cause #3: Damaged magazine.

Remedy: If the upper portion of the magazine has been bent, the top cartridge may be presented off-center, not allowing the tongs to get a full grip. (See Figures 24 and 25 below.) Replace magazine.



Possible Cause #4: worn out magazine spring.

Remedy: The magazine spring can lose force if cycled several thousand times. Check spring force by inserting a magazine containing only 3 cartridges. If you are not able to successfully chamber a round, then replace the magazine spring. Long-term storage of a full magazine affects spring force to a very small degree.

Possible Cause #5: Dirty magazine.

Remedy: If the magazine has a significant amount of build-up or debris in it, it can impede the upward flow of cartridges. A quick way of checking this is to manually unload a full magazine and watch if the cartridge column moves up quickly. If it moves up slowly, or not at all, disassemble the magazine and clean the interior thoroughly. A narrow toothbrush will work well for this.

STOVEPIPE

The term “stovepipe” refers to when an empty case gets caught in the ejection port. While this occurrence is rare, it can occur with the last cartridge from a magazine since the empty case does not receive the additional ejective action from another rising cartridge. To clear the ejection port, simply draw the slide back and tip the gun so that the empty case falls out.

MAGAZINE SPRING POPS OUT OF THE TOP OF THE MAGAZINE

If the magazine is not removed during field stripping, the magazine spring can get caught by the tongs and get partially pulled out. To re-insert the magazine spring, remove the floor plate, (See Figure 12.) and work the spring in from the top, one coil at a time, then re-install floorplate.

TROUBLESHOOTING

LIGHT FIRING PIN STRIKES

Possible Cause: Worn Mainspring.

Remedy: With heavy use, the mainspring can lose force. Normal life is between 2000 and 5000 rounds, depending on the types of ammunition used. If light strikes occur, and you are not using older Russian or Sellior & Bellot ammunition, it is recommended to replace the mainspring and order an additional spare.

To replace the mainspring, make the sure the gun is unloaded. Then turn the takedown lever to the position **shown below in Figure 26.**



Figure 26. Proper position of the Takedown Lever

TROUBLESHOOTING

LIGHT FIRING PIN STRIKES **Cont.**

Then remove both grip panels using a 1.5mm hex key and un-hook the spring as shown in **Figures 27 and 28 below**. Note that the open part of the spring hooks face backward, with the longer hook pointing upward. If you plan on firing a lot of imported ammunition that may have been intended for sub-machine guns, it is recommended that you order and install our optional 9lb mainspring.



Figure 27. Remove Grip Screws



Figure 28. Hook/Unhook Mainspring

TROUBLESHOOTING

CARTRIDGE SEPARATION

This problem can occur when using incompatible ammunition. It may present itself in a few different ways. The bullet may remain in the magazine and the case will not chamber properly. If the case and bullet separate, cease firing and thoroughly clean the firearm. Secondly, the bullet may not completely separate but may protrude from the case far enough to cause loading issues. In this case, remove the magazine and unload the unspent case. Dispose of the unspent case in a range approved safe manner.

Possible cause #1: Aluminum-Cased Ammunition.

Remedy: As stated earlier, the Boberg XR Series is not rated for aluminum-cased ammunition—cease using this type of ammunition immediately.

Possible Cause #2: Ammunition with little or no crimp.

Remedy: While we at Boberg Arms have no control over ammunition manufacturing, you should always test fire ammunition at a range before using for self-defense. Our recommended minimum crimp pull-out force is 30 lbs (many styles of hollow-point ammunition achieve 100 lbs or more). While this is difficult for most people to measure, we recommend you use only high-quality name brands of ammunition. Hand-loaded ammunition is not recommended and will invalidate any warranties.

Possible cause #3: Dirty Chamber.

Remedy: Clean chamber with bore brush and solvent (at least after every 200 rounds). A partially-clogged chamber throat can cause excessively high pressure spikes that can significantly increase slide acceleration and potentially damage your weapon.

TROUBLESHOOTING

“CATCHY” TRIGGER – OR – HAMMER DROPS BACK

Probable cause: Mainspring partially hooked or totally unhooked.

Remedy: Remove grip panels and properly re-install mainspring. The longer spring hook points upward. Note that the spring should hang squarely on the anchor link as shown in Figure 29. Check to make sure that the upper (longer) spring hook is not damaged—its shape should look like a perfect letter “J”.



Figure 29. Correct Mainspring attachment



Figure 30. Incorrect mainspring attachment

OPTIONAL MAGAZINE FOLLOWER

If you have purchased the optional magazine follower, to install it, remove magazine floorplate and spring. Exercise caution during floorplate removal since the magazine spring is under compression. Always wear eye protection when performing this task. Once the spring is removed, place magazine follower on top of it and insert on the large end of the spring **as shown in Figure 31**.



Figure 31. Proper insertion of magazine follower

Make sure that the follower sits over the top coils of the magazine spring and not under **as shown in Figure 32**.



Figure 32. Proper magazine spring position under follower

SERVICE AND RETURNS

Should your Boberg XR Series pistol require adjustment or repair, please return it in its original case to the factory *after you are absolutely certain that it is unloaded*. Be sure to include a note briefly stating the reason you are returning your Boberg XR Series pistol with a contact phone number and shipping address. **Do not send it to a Boberg Arms unauthorized gunsmith**, return to Boberg Arms Service Department. Before returning, please call Boberg Arms Corp. Service Department for a Return Authorization (RA) number. Returns should be sent to:

Boberg Arms Corporation
1755 Commerce Court
White Bear Lake, Minnesota 55110
(651) 209-4812

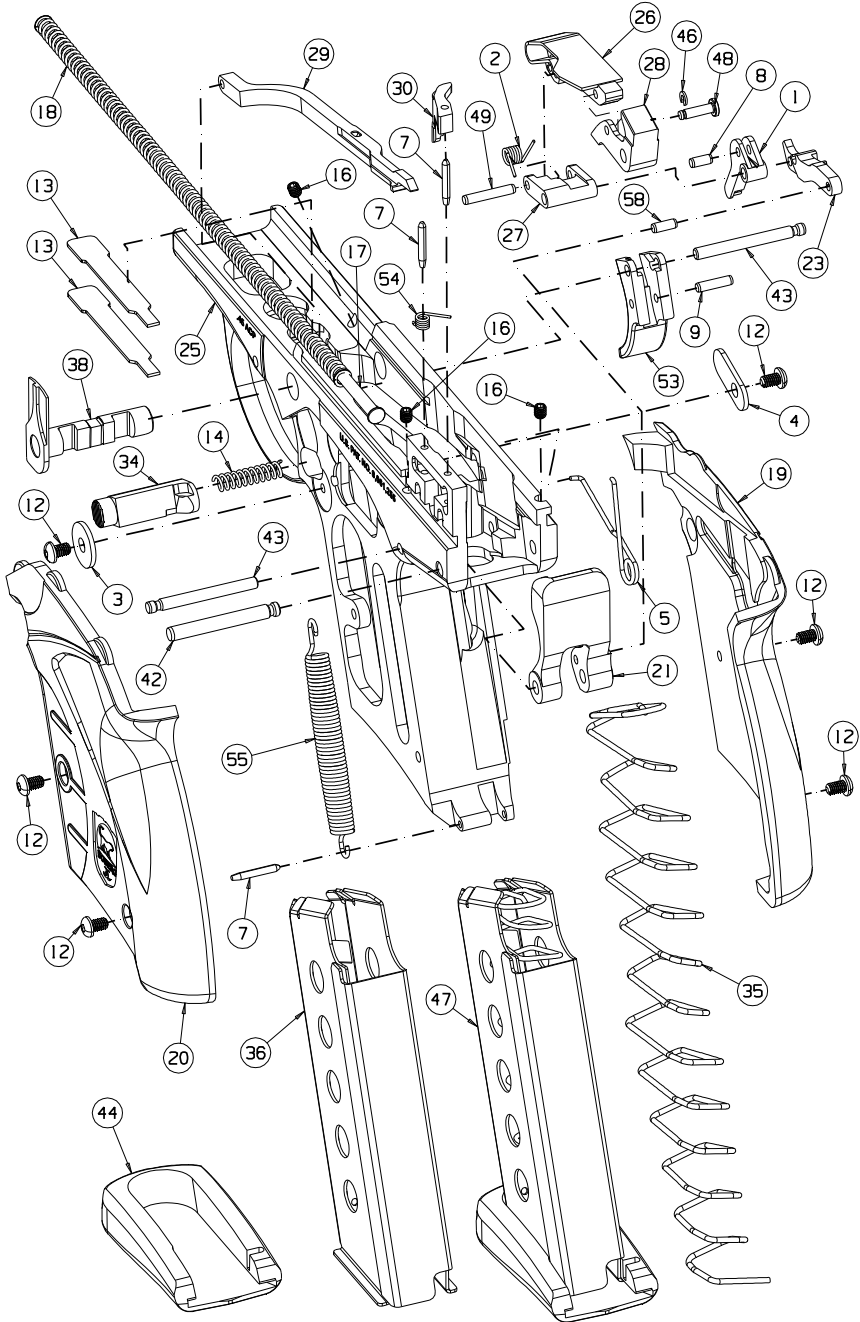
PARTS AND ACCESSORIES

Replacement parts and accessories for your Boberg XR Series pistol are available for purchase from Boberg Arms Corporation by shopping at our web address, mailing, faxing, or calling the factory. When ordering parts directly from the factory, please provide the serial number and approximate date of purchase of your XR Series pistol. Be sure to include the part number (BA-000-XXXX format) and description of the parts or accessories you want to order. **(See Figure 33 on page 30.)**

For information on Parts and Accessories contact:

Boberg Arms Corporation
1755 Commerce Court
White Bear Lake, Minnesota 55110
(651) 209-4812 FAX (651) 209-4813
www.BobergArms.com

PARTS LIST AND EXPLODED VIEW



PART LIST AND EXPLODED VIEW

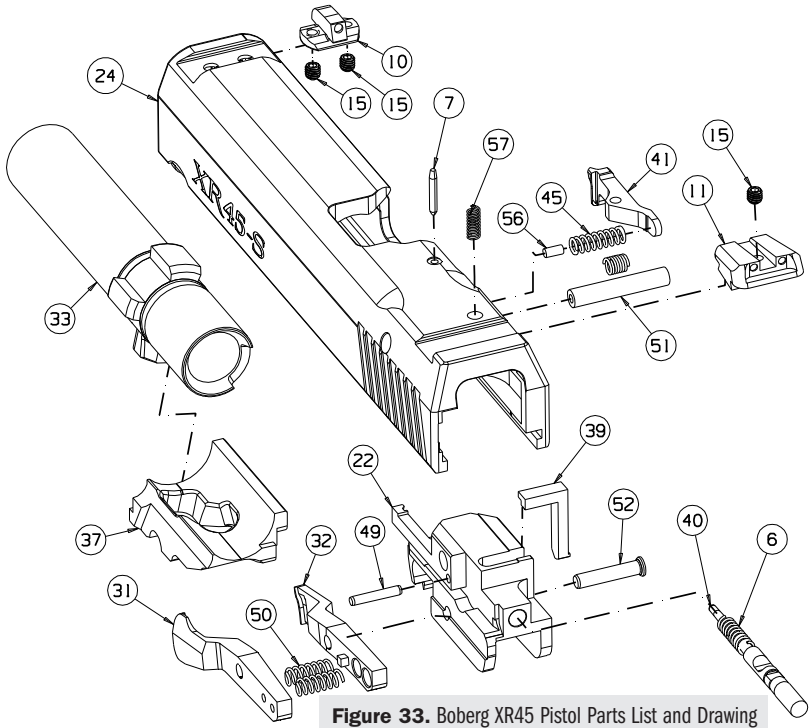


Figure 33. Boberg XR45 Pistol Parts List and Drawing

ITEM NO	PART NO.	QTY	TITLE	ITEM NO	PART NO.	QTY	TITLE
1	BA-000-0015	1	ANCHOR LINK	30	BA-000-0128	1	EJECTOR LEVER, XR45
2	BA-000-0023	1	SPRING, LOWER LINK	31	BA-000-0127	1	LEFT TONG, XR45
3	BA-000-0027	1	RETENTION WASHER	32	BA-000-0128	1	RIGHT TONG, XR45
4	BA-000-0034	1	SPRING COVER	33	BA-000-0129	1	BARREL, XR45-S
5	BA-000-0037	1	SPRING, TRANSFER BAR	34	BA-000-0134	1	Magazine Release, XR45
6	BA-000-0038	1	SPRING, FIRING PIN	35	BA-000-0135	1	MAGAZINE SPRING, XR45
7	BA-000-0043	4	DOWEL PIN, .063 DIA X 7/16" LG	36	BA-000-0136	1	MAGAZINE TUBE, XR45
8	BA-000-0045	1	DOWEL PIN, M2 X 5	37	BA-000-0137	1	UNLOCK BLOCK, XR45-S
9	BA-000-0046	1	DOWEL PIN, M2 X 8	38	BA-000-0138	1	TAKE DOWN LEVER, XR45
10	BA-000-0051	1	FRONT SIGHT	39	BA-000-0139	1	FIRING PIN SAFETY, XR45
11	BA-000-0052	1	REAR SIGHT	40	BA-000-0140	1	FIRING PIN, XR45
12	BA-000-0060	6	BHCS, M2.5X4	41	BA-000-0143	1	EXTRACTOR, XR45
13	BA-000-0064	2	LEAF SPRING	42	BA-000-0145	1	PIVOT PIN, HAMMER
14	BA-000-0067	1	SPRING, MAGAZINE RELEASE	43	BA-000-0146	2	PIN, TRIGGER AND LIFT MECH.
15	BA-000-0081	3	#5-44 X 1/8" SH55	44	BA-000-0147	1	FLOOR PLATE, XR45
16	BA-000-0083	3	M2.5X3 SH55	45	BA-000-0148	1	SPRING, EXTRACTOR
17	BA-000-0103	1	GUIDE ROD	46	BA-000-0149	1	E-RING, Truarc #D1500-0015
18	BA-000-0104	1	SLIDE SPRING	47	BA-000-0150	1	MAGAZINE ASS'Y, XR45
19	BA-000-0110	1	RIGHT GRIP PANEL	48	BA-000-0151	1	PIN, FLIP LINK
20	BA-000-0111	1	LEFT GRIP PANEL, XR45	49	BA-000-0152	2	PIN, LOWER LINK
21	BA-000-0112	1	HAMMER, XR45	50	BA-000-0153	2	SPRING, TONGS
22	BA-000-0113	1	INSERT BLOCK, XR45	51	BA-000-0154	1	COILED PIN, 5/32X7/8
23	BA-000-0114	1	SEAR LINK, XR45	52	BA-000-0156	1	PIN, Insert Block, xr45
24	BA-000-0115	1	SLIDE, XR45	53	BA-000-0177	1	TRIGGER
25	BA-000-0116	1	FRAME, XR45-S	54	BA-000-0178	1	Ejector Spring, XR45
26	BA-000-0117	1	PLATFORM ASSY	55	BA-000-0179	1	B# MAINSPRING, XR45
27	BA-000-0120	1	LOWER LINK, XR45	56	BA-000-0182	1	BACKUP PIN, M2 X 4
28	BA-000-0121	1	FLIP LINK, XR45	57	BA-000-0185	1	F-PIN SAFETY SPRING
29	BA-000-0125	1	TRANSFER BAR, XR45	58	BA-000-0186	1	PIN, HAMMER

IMPORTANT! IMPORTANT! IMPORTANT!

READ AND UNDERSTAND THE ENCLOSED MANUAL ("SAFETY, INSTRUCTIONS & PARTS MANUAL") INCLUDING SPECIAL WARNINGS AND PRECAUTIONS CAREFULLY BEFORE REMOVING THIS FIREARM FROM ITS PACKAGE!

RECORD YOUR SERIAL NUMBER HERE AND KEEP THIS BOOKLET WITH YOUR PISTOL CASE FOR YOUR CONVENIENCE.

Name of Owner _____

Address _____

City _____ State _____ Zip _____

Contact Phone No. _____

Model _____ Caliber _____

Serial No. _____

Where Purchased _____

Date of Purchase _____



**BOBERG ARMS
CORPORATION**

1755 Commerce Court, White Bear Lake, Minnesota 55110



BOBERG ARMS CORPORATION

Caution Due to the Boberg XR45's unique feed mechanism, aluminum-cased ammunition is not recommended. This type of ammunition has no crimp, and usually no adhesive, and could allow the bullet and case to become separated while being drawn from the magazine. While this is not considered a safety hazard, it can result in a mis-feed or jam. Please note that there may be styles of brass-cased ammunition that have no crimp that may cause feeding problems.



Information on crimp-less styles of ammunition can be found at www.BobergArms.com. We always recommend that you first test fire any style of ammunition in your XR45 before using it for self-defense purposes.

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(651) 209-4812 FAX (651) 209-4813 www.BobergArms.com