



 **KSG**

KSG COMPACT

KSG TACTICAL

KSG25

KSG410

KS7

SHOTGUNS

SAFETY, INSTRUCTION & PARTS MANUAL



 **WARNING:** Read this manual carefully before loading or using the listed firearms.

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A. SAFETY INFORMATION AND WARNINGS

Read this manual and the warnings contained in it before loading or using the firearm. This manual explains the function and the handling of the firearm and warns of the potential dangers, including death or serious personal injury that can result from the unsafe use of the firearm. This manual should always accompany the firearm and be transferred with it if it is sold or loaned to another person.

Even if you are an experienced shooter, you must READ THIS ENTIRE MANUAL CAREFULLY before loading or firing the firearm. This manual gives basic instructions on the proper handling and functioning of the firearm. Your safety and the safety of others depends on you following the instructions and warnings in this manual and the constant use of safe firearms practices. If you are unfamiliar with firearms, take a course in the safe handling of firearms run by a qualified firearms instructor, your local gun club, or a similar qualified organization.

This manual contains several safety warnings and instructions preceded with  **WARNING**,  **CAUTION**, or  **NOTICE**. These signal words are designed to draw your attention to important safety information.  **WARNING** indicates a hazardous situation which, if not avoided, could result in death or serious injury.  **CAUTION** indicates a hazardous situation, which, if not avoided, could result in minor or moderate injury.  **NOTICE** addresses safety practices not related to personal injury.

 **WARNING** Firearms can cause death or serious personal injury. Safety must be the prime consideration of anyone who handles firearms.

 **WARNING** The firearm is designed to function reliably with proper care and knowledgeable use. Do not use your firearm unless you fully understand how to safely operate it.

 **WARNING** Only safe firearm handling habits will ensure the safe use of your firearm. This is your responsibility. Accidents are the result of violating the rules of safe firearms handling noted below and common sense.

 **WARNING** Always seek a doctor's advice if you are taking medication to be sure that you are able to shoot and handle a firearm safely. Never drink alcoholic beverages or take drugs before or while shooting. Your vision and judgment could be seriously impaired, making your firearm handling unsafe.

 **WARNING** Always treat a firearm as though it were loaded.

 **WARNING** Always keep the muzzle pointed in a safe direction. Never point a firearm at anyone or anything you do not intend to shoot.

 **WARNING** Always keep your finger off the trigger and outside the trigger guard until you have made the decision to fire.

⚠ WARNING

Never accept or pick up a firearm without checking the magazine and the chamber to make sure that it is unloaded.

⚠ WARNING

Do not trust the extractor to remove the shell from the chamber. Always check to confirm that it is empty.

⚠ WARNING

Always make sure the firearm is unloaded, on SAFE and the action is open before handing it to another person.

⚠ WARNING

Never allow a firearm to be used by individuals who are not familiar with its safe operation and rules of firearm safety.

⚠ WARNING

Never alter or modify the firearm because this could cause it to malfunction and create a dangerous condition.

⚠ WARNING

Be sure all accessories are compatible with the firearm. Be sure all accessories are properly installed on the firearm and that the accessories do not interfere with safe operation of the firearm. Follow the instructions provide by the accessory manufacturer to the extent those instructions are not inconsistent with the warnings and instructions contained in this manual.

⚠ WARNING

If the firearm is dropped or forcefully struck, it could be damaged and may not function properly; have it inspected by Kel-Tec CNC Industries, Inc. before continuing to use it.

⚠ WARNING

Never load a firearm except immediately before shooting. When transporting your firearm, be sure your firearm is unloaded, on SAFE and the action is open.

⚠ WARNING

Never store or transport firearms and ammunition together, keep them locked up and away from children or other unauthorized persons.

⚠ WARNING

Always secure firearms from children. You are responsible for the firearm's safety and security.

⚠ CAUTION

Most ammunition contains lead in the projectile and/or primer. Discharging firearms in poorly ventilated areas, cleaning firearms, or handling ammunition may result in exposure to lead and other substances known to cause birth defects, reproductive harm, cancer, and other serious physical injury. Have adequate ventilation at all times. Wash hands thoroughly after exposure.

NOTICE

The use of shot shells with aluminum or steel case heads in the "low brass" configuration is NOT recommended in this firearm.

Before it left the factory, the firearm was tested, carefully inspected, and packaged. Kel-Tec CNC Industries, Inc. cannot control what happens to the firearm after it leaves the factory, therefore, carefully examine the firearm when you acquire it to ensure that it is unloaded and undamaged. If you do not understand any of the warnings and instructions in this manual, have any problems operating the firearm, or need another copy of this manual, contact Kel-Tec CNC Industries, Inc. at:

KEL-TEC CNC INDUSTRIES INC

1505 Cox Road

Cocoa, FL 32926

Telephone Number: 321-631-0068

Toll free: 1-800-515-9983

Hours: M-F 9am-6pm EST (excluding holidays)

Website: <https://www.keltecweapons.com/>

Email: customerservice@keltecweapons.com

The current version of the instruction manual can also be downloaded at:

<https://www.keltecweapons.com/>

B. OVERVIEW

Description (ALL SHOTGUNS)

Since 2011, KelTec has expanded its world-renowned shotgun series, the KSG, to feature several different variants (size, capacity and caliber), most of which are dual-magazine, select-feed, pump action shotguns; KelTec also has a single magazine fed, pump action shotgun variant, the KS7. The bullpup shotgun design, single or dual-magazine, provides the operator with a more compact layout, better ergonomics and increased total capacity without the added length of a traditional shotgun.

All KelTec shotguns feature positive extraction and ejection, allowing it to be reliably fired in any shooting orientation. Loading and ejection are combined into a single port rearward of the grip assembly under the shotgun, enabling the shotgun to be fired from both the dominant and non-dominant side.

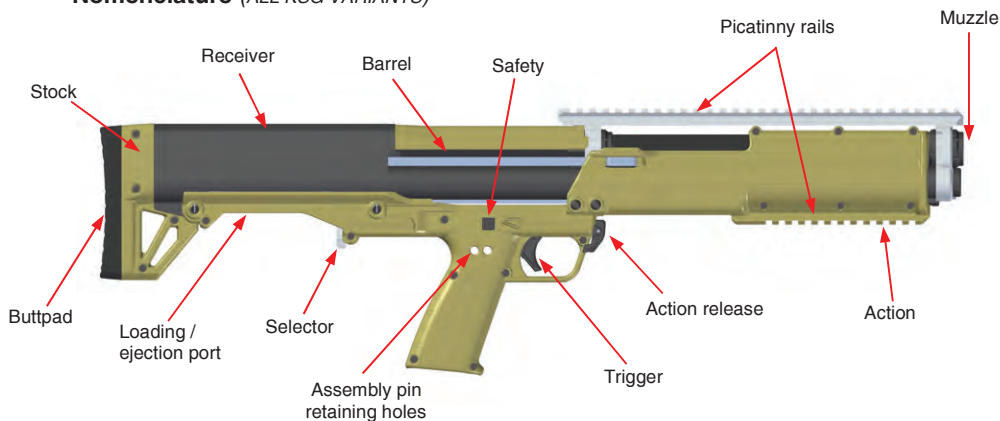
Depending on the variant, the shotgun is equipped with picatinny rails, M-LOK™ attachments or both, for mounting compatible accessories. Unloaded, the shotgun maintains a center of gravity over the grip assembly to facilitate ease of handling.

NOTICE This manual covers all KelTec shotguns with some specific sections dedicated to particular *functional* differences between the variants, magazine styles or calibers. Examples of some sections are listed below. NOTE: your particular variant may or may not have information in each section; this manual should be read and understood in its entirety.

- **ALL SHOTGUNS.** This section would apply to all shotguns.
- **ALL KSG VARIANTS, KSG410.** This section would apply to shotgun variants with two magazine tubes, all lengths and calibers.
- **KS7.** This section would apply to the KS7.

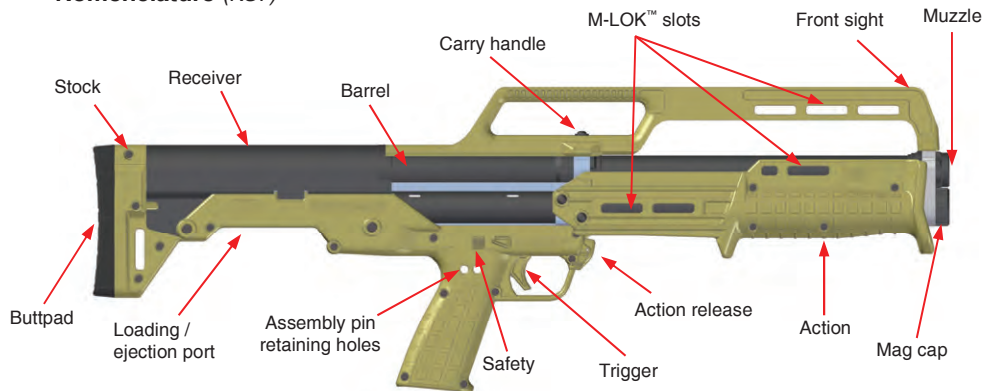
NOTICE It should be noted that there may be other accessory differences between variants such as the KSG410, ships with the carry handle and not a picatinny rail, unlike the other dual magazine tube variants. The KSG25 ships with flip-up sights, a vertical grip and upgraded aluminum followers and the KSG does not.

Nomenclature (ALL KSG VARIANTS)



Side view of a dual magazine tube shotgun (KSG shown)

Nomenclature (KS7)



Side View of a single magazine tube shotgun (KS7 shown)

Specifications (ALL SHOTGUNS)

Design Features	KSG	KS7	KSG410
Operating System	Pump Action	Pump Action	Pump Action
Gauge	12ga	12ga	.410 BORE
Capacity (3" shells)	6 + 6 + 1	6 + 1	5 + 5 + 1
Capacity (other)	7 + 7 + 1 (2.75")	7 + 1 (2.75")	7 + 7 + 1 (2.5")
Chamber	12-gauge 3.00" (76mm)	12-gauge 3.00" (76mm)	.410 BORE 3.00" (76mm)
Barrel Length	18.5" (470mm)	18.5" (470mm)	18.5" (470mm)
Length of Pull	13.0" (330mm)	13.0" (330mm)	13.0" (330mm)
Accessory Mount	Picatinny rail	M-LOK™	M-LOK™

Dimensions and Weight			
Total Length	26.1" (664mm)	26.1" (664mm)	26.1" (664mm)
Total Width	2.2" (56mm)	1.9" (48mm)	2.0" (52mm)
Total Height	8.0" (204mm)	9.3" (238mm)	8.6" (220mm)
Weight (unloaded)	6.9 pounds (3.1 kg)	5.9 pounds (2.7 kg)	5.4 pounds (2.5 kg)

Design Features	KSG25	KSG Compact	KSG Tactical (NFA)
Operating System	Pump Action	Pump Action	Pump Action
Gauge	12ga	12ga	12ga
Capacity (3" shells)	10 + 10 + 1	4 + 4 + 1	4 + 4 + 1
Capacity (other)	12 + 12 + 1 (2.75")	5 + 5 + 1 (2.75")	5 + 5 + 1 (2.75")
Chamber	12-gauge 3.00" (76mm)	12-gauge 3.00" (76mm)	12-gauge 3.00" (76mm)
Barrel Length	30.5" (775mm)	18.5" (470mm)	13.7" (343mm)
Length of Pull	13.0" (330mm)	13.0" (330mm)	13.0" (330mm)
Accessory Mount	M-LOK™, pic rail	Picatinny rail	Picatinny rail

Dimensions and Weight			
Total Length	38" (965mm)	26.1" (664mm)	21.5" (546mm)
Total Width	2.2" (56mm)	2.2" (56mm)	2.2" (56mm)
Total Height	8.0" (204mm)	8.0" (204mm)	8.0" (204mm)
Weight (unloaded)	9.5 pounds (4.2 kg)	6.8 pounds (3 kg)	6.2 pounds (2.8 kg)

Ammunition (ALL SHOTGUNS)



ALWAYS USE SHELLS OF THE CORRECT GAUGE, CALIBER AND LENGTH (OR SHORTER IN LENGTH). DO NOT USE NON-STANDARD AMMUNITION OR SHELLS WITH PRESSURES EXCEEDING SAAMI STANDARDS. FAILURE TO FOLLOW THIS WARNING MAY RESULT IN SERIOUS INJURY OR DEATH AND DAMAGE TO YOUR FIREARM.



The KS7 is a particularly lightweight bullpup shotgun, which when shot with high powered ammunition, may have a sharp recoil, similar to a lightweight over-under or side-by-side shotgun; selecting ammunition designed for reduced energy may soften the perceived recoil of the firearm.

The 12-gauge and .410 bore shotguns are chambered for 3" shells and may safely fire both lead and steel shot. For all shotguns, shells 2-3/4" and shorter are also safe to fire, but any shell shorter than 2-3/4" should be thoroughly tested for reliable feeding and ejection. For reference, the chamber gauge and length are indicated on the receiver of the shotgun.

Only use commercially available US-manufactured ammunition that meets SAAMI established standards. Inspect your ammunition to make sure it is clean, dry, and in good condition. Never use non-standard, reloaded or damaged shells. Any other ammunition is considered non-standard and its use may void the warranty on this firearm.

KelTec firearms are manufactured from high quality materials. It will provide a lifetime of service if properly maintained. However, all warranties, expressed or implied, are voided and KelTec will not be liable for property damage or personal injury and consequential damages, if faulty, non-standard, or reloaded ammunition is used in any KelTec firearm.

Sling Mounting (ALL KSG VARIANTS)

Most KelTec dual magazine tube shotguns come equipped with forward attachment points on the left and right sides of the barrel assembly (muzzle plate) as well as a single rear attachment slot in the stock. The different sling attachment points on the shotgun can be used to mount the included 1 1/4" wide nylon sling but will also accommodate aftermarket slings of the same width.



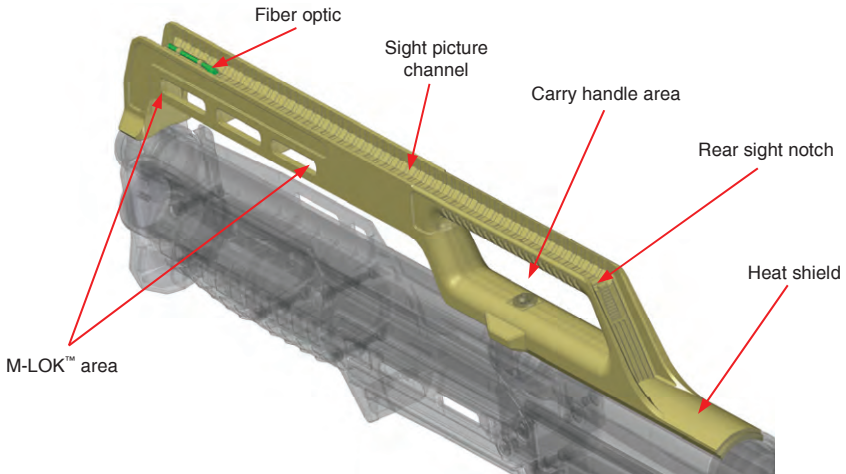
Sling attachment points (KSG shown)



NOTICE A few dual-magazine tube shotguns do not have sling attachment points, like the KSG410 and older versions of the KSG Compact and KSG Tactical (before 2016).

Carry Handle (KS7, KSG410)

Some shotguns are equipped with a fiber-glass reinforced carry handle located above the barrel assembly. The carry handle has several built-in features. The heat shield and carry handle grip are designed to allow the operator to handle the firearm without touching a potentially hot barrel. The M-LOK™ area is designed for M-LOK™ compatible accessory attachments. The fiber optic sight is used to assist in aiming the firearm, like a “bead sight” on a standard shotgun.



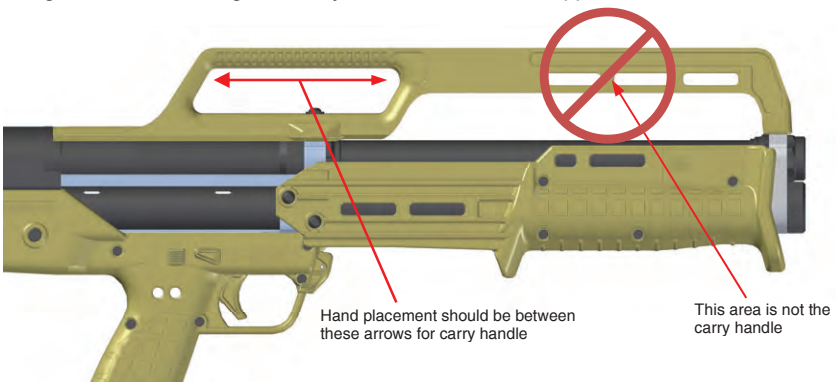
View of carry handle (KS7 shown)



The carry handle should only be used to move the firearm when the firearm is unloaded and on SAFE.



Mounting too many accessories to the carry handle could cause an increase in weight and could damage the carry handle or firearm if dropped.

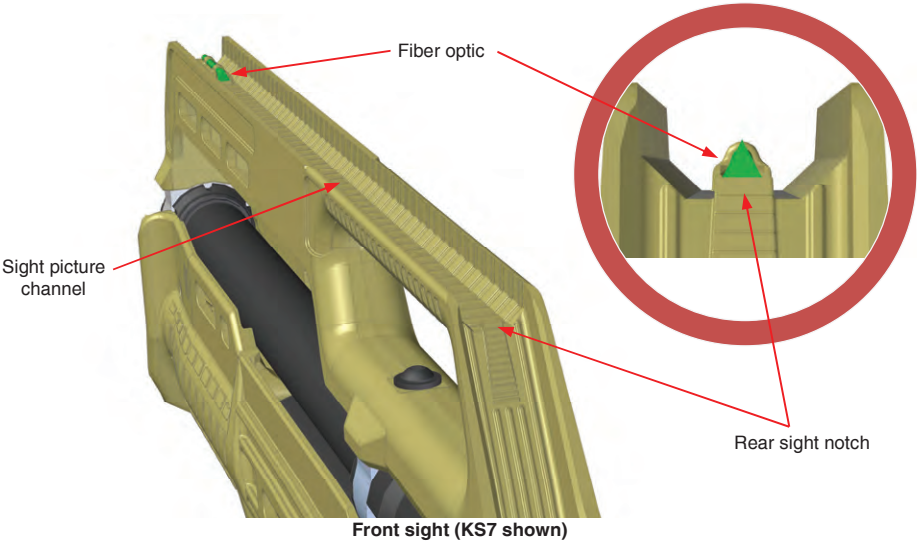


View of carry handle (KS7 shown)

The carry handle replaces the use of a nylon sling for moving and handling the firearm; additionally, the use of M-LOK™ attachments for “QD mounts” may be used for single point sling attachments.

Carry Handle Sight Picture (KS7, KSG410)

The sighting system has a fiber optic front sight and a rear sight notch built into the carry handle of the firearm. This fiber optic is used similarly to a “bead sight” on a standard shotgun. To gain a sight picture, the operator should center the fiber optic with the rear notch, placing the flat bottom of the fiber optic on the top flat of the rear notch. The fiber optic is not adjustable, however, the barrel assembly will accept the standard KSG picatinny rail, if the operator wishes to use after-market accessories, such as a red-dot or flip-up sights.

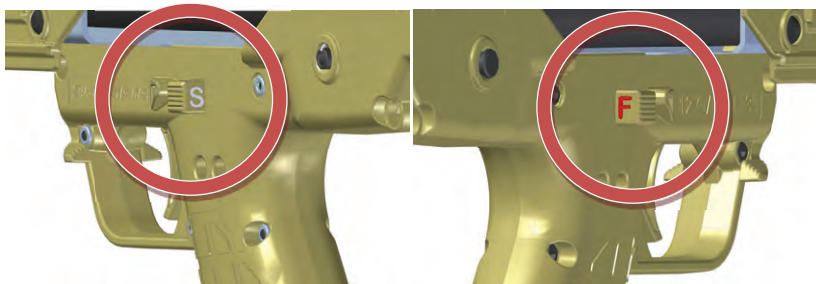


C. OPERATION INSTRUCTIONS

Safety (ALL SHOTGUNS)

All KelTec shotguns feature a cross-bolt safety located behind the trigger on the grip assembly. When the safety is activated, the cross-bolt blocks the sear from releasing and prevents the trigger from being pulled. Note that the safety will not engage unless the hammer is cocked.

For right-handed users, the safety is generally depressed with the right thumb until a noticeable “click” is heard and the red letter “F” emerges on the safety. The safety is color coded and labeled to enhance visibility and hasten safety assessment.

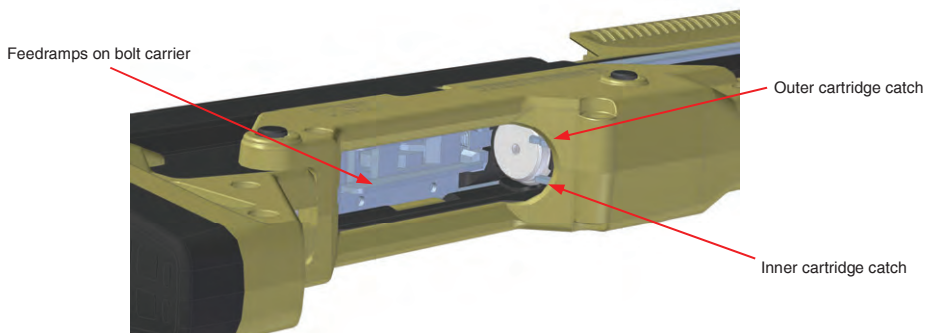


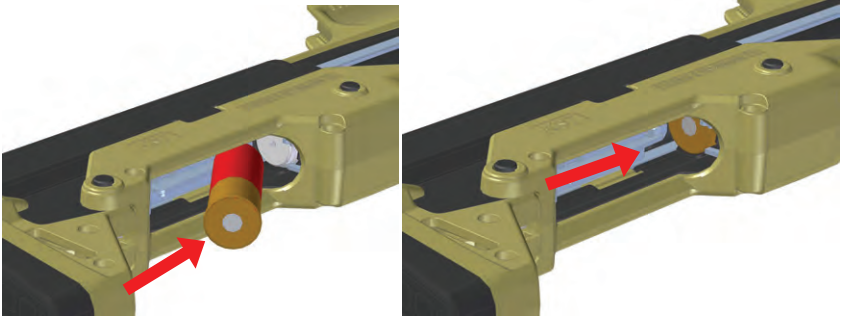
Pressed to the left, SAFE Configuration; Pressed to the right, Red for FIRE

WARNING Never totally rely on a mechanical safety as it can fail or become unintentionally disengaged. A mechanical safety is not a substitute for safe firearm handling practices.

Loading Magazine (KS7)

1. Ensure the muzzle is pointed in a safe direction before loading.
2. Engage the safety by ensuring the white “S” is visible.
3. Ensure the action is locked forward.
4. With thumb on the base of the shell, insert the shell into the loading/ejection port and slide the shell into the magazine.



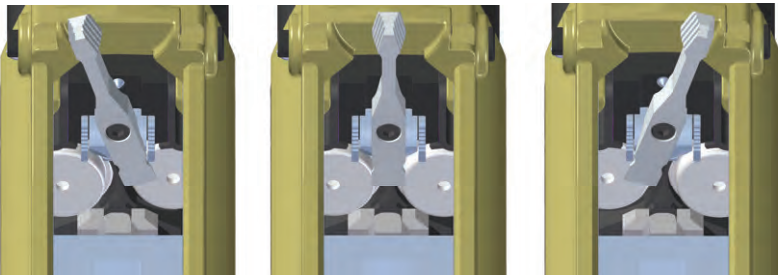


Loading a shell into the magazine tube (KS7 shown)

NOTICE There are built-in feedramps on the bottom of the bolt carrier to assist with feeding shells into the magazine tube.

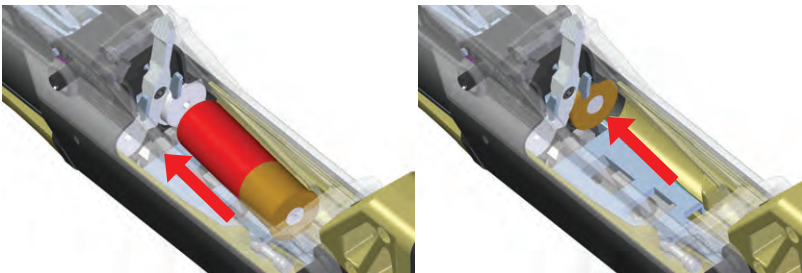
Loading Magazines (ALL KSG VARIANTS, KSG410)

1. Ensure the muzzle is pointed in a safe direction before loading.
2. Engage the safety by ensuring the white "S" is visible.
3. Ensure the action is locked forward.
4. Place the selector to the positions shown depending on desired loading configuration. The selector indicates which magazine is selected for loading by "pointing" to the active magazine. For example: if the selector is pointing left, the left magazine is available for loading.



Selector positions (KSG shown)

5. With thumb on the base of the shell, insert the shell into the loading/ejection port and slide the shell into the magazine using your thumb.

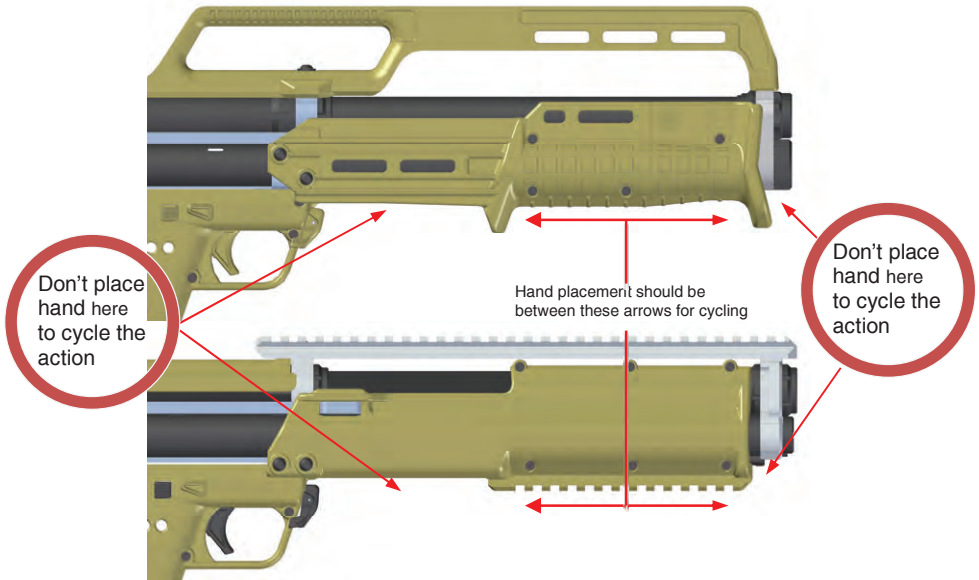


Loading a shell into the magazine tube (KSG shown)

Chambering from Magazine (ALL SHOTGUNS)

1. Press down on the action release and maintain downward pressure to unlock action.
2. Slide the action fully rearward and then fully forward to chamber a shell.

CAUTION Ensure your non-dominant hand is placed on the action of the firearm in a proper manner for cycling; not doing so could short stroke the action and pinch your hand.



CAUTION Do not hold the action behind the picatinny rail; doing so could short stroke the action and pinch your hand.

Manual Chamber Loading (ALL SHOTGUNS)

The procedure for loading a shell directly into the chamber of the shotgun is different than most other shotguns because of the combined loading and ejection port. To load a shell into the chamber of the shotgun, use the following procedure as a guideline.

1. Ensure the muzzle is pointed in a safe direction before loading.
2. Engage the safety by ensuring the white "S" is visible.
3. Press down the action release to unlock action.
4. Slide the action rearward so that it is about a 1/2" from the rearmost position to prevent the lifters from rotating downwards and blocking access to the chamber.
5. Place shell in chamber and slide the action forward to chamber inserted shell.

Firing (ALL SHOTGUNS)

⚠ WARNING Before firing the firearm, run a clean patch through the barrel, from the chamber end, using a cleaning rod. Repeat this procedure until the patch comes out of the barrel with no gun oil or cleaner-lubricant-preservative on it because any obstruction in the barrel could prevent the firearm from firing properly and result in death or serious personal injury and/or damage to the firearm.

⚠ WARNING Ensure the barrel is free of obstructions prior to firing. Open the action and clear the firearm of all ammunition before checking the barrel of the unloaded firearm. Any obstruction in the barrel could prevent the firearm from firing properly and result in death or serious personal injury and/or damage to the firearm.

⚠ WARNING In case of a failure to fire, continue to hold the firearm pointed towards the target for at least 30 seconds. If a hangfire (slow ignition) has occurred, the shell should fire within approximately 30 seconds. If the shell has not fired, slide the forend to its rearmost position, engage the safety by ensuring the white "S" is visible and remove the unfired shell from the chamber while keeping the firearm pointed in a safe direction. NOTE: dispose of misfired shells in accordance with the ammunition manufacturer's instructions.

⚠ WARNING Never use the firearm if it fails to function properly, and never force the action forward on a jammed shell because it could cause the shell to explode or damage the firearm.

⚠ WARNING Never pull the trigger if the action does not fully close to prevent a possible out of battery firing. If this happens, unload the firearm as described on the next page, examine the shell that was in the chamber, and check the chamber to ensure that there are no obstructions or debris in it.

⚠ WARNING Never discharge a firearm without proper safety glasses and ear protection.

⚠ WARNING Never shoot until you are sure of your backstop and what lies beyond it.

⚠ WARNING Never shoot at a hard surface, such as a rock, or a liquid surface, such as water, because a bullet may ricochet and travel in any direction, striking you or someone else.

⚠ WARNING When firing on a target range, be alert and follow the range officer's commands. Always be aware of other people so that they cannot accidentally walk into the line of fire. Make sure your "audience" is always 5 feet in back of you, not next to you, when firing.

⚠ WARNING Always carry the firearm unloaded, on SAFE and with the action open while on a range until preparing to fire. Always keep the firearm pointed towards the backstop when loading, firing, and unloading it.



WARNING After firing several rounds, the exterior metal parts of the firearm get very hot and can cause severe burns if touched.

1. Load a shell into the chamber of the firearm manually or from the magazine.
2. Aim at the target, taking notice of the target's backdrop.
3. Disengage the safety, taking notice of the red letter "F" that is visible on the safety.
4. Place trigger finger into trigger guard.
5. When the trigger is pressed, the firearm will fire.
6. Slide the action fully rearward to eject the empty shell and then slide the action fully forward to feed a new shell.



NOTICE FOR ALL KSG VARIANTS, KSG410: In order to continue firing after one magazine tube becomes empty, move the selector from empty magazine tube to the opposing magazine tube, and cycle the action to chamber another shell.

Unloading (ALL SHOTGUNS)

1. Ensure the muzzle is pointed in a safe direction before unloading.
2. Ensure the action is locked in the forward position.
3. Engage the safety by ensuring the white "S" is visible.
4. Rotate outer cartridge catch down (away from the shells) to release one or more shells from the magazine tube. NOTE: shells will eject with some force from the magazine tube.
5. Magazine is empty when the magazine follower is visible through the ejection port.
6. Switch the selector to select the other magazine tube for unloading, if applicable.
7. Repeat steps 4-5, if applicable.
8. With the action fully rearward, always visually and tactually check the chamber to confirm the firearm is unloaded.

D. FIELD STRIP



WARNING If the firearm has been fired, wait a sufficient amount of time for the components to cool before attempting field stripping; failure to do so may result in burns.



WARNING Never rely on your memory to determine whether the firearm is loaded or unloaded. Always open the action and then visually and tactually (with your finger) check to make sure there is not a shell in the chamber.



WARNING Never alter or modify the firearm because this could cause it to malfunction and create a dangerous condition.



WARNING Always wear safety glasses when disassembling the firearm to protect your eyes from components that are under pressure, such as springs.

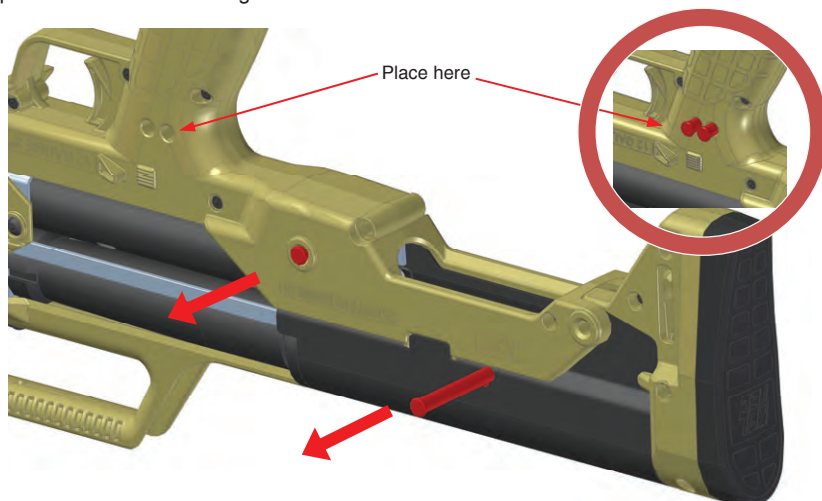
For regular maintenance of the firearm, it will be necessary that you become familiar with field stripping (disassembly of) the firearm. The following sections should be followed in sequential order and continued as needed depending on desired maintenance; each step has an assembly highlighted in **RED** to assist with identification of the focus of the process.



NOTICE For simplicity of the disassembly and reassembly, this section covers all shotguns with highlights for magazine tube differences.

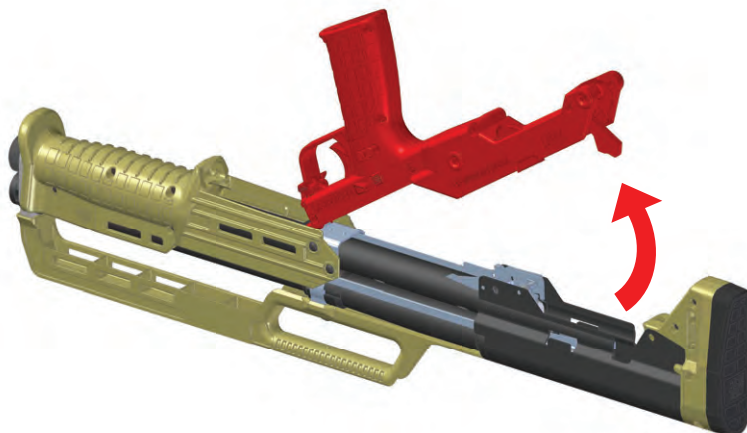
Removal of Grip Assembly (*ALL SHOTGUNS*)

1. Engage the safety by ensuring the white “S” is visible.
2. Place magazine selector to the center position, if applicable.
3. Remove the frame pins adjacent to the ejection port located on the grip assembly and place them in the retaining holes as shown below.



Place pins in retaining holes (KS7 shown)

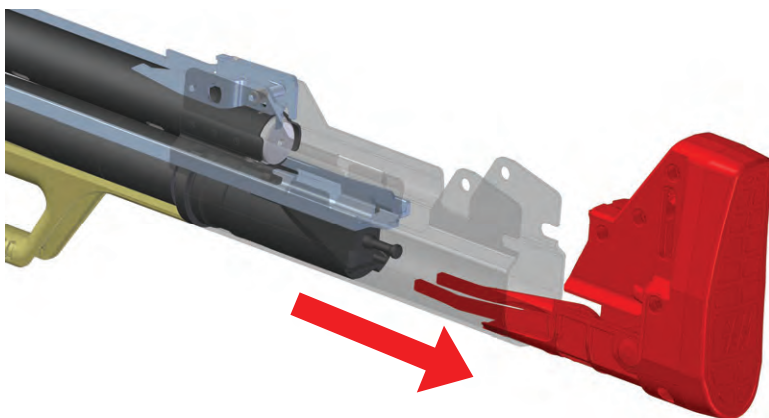
4. Remove the grip assembly by rotating the rear of the assembly directly upwards as shown below.



Rotate grip assembly upwards (KS7 shown)

Removal of the Stock (*ALL SHOTGUNS*)

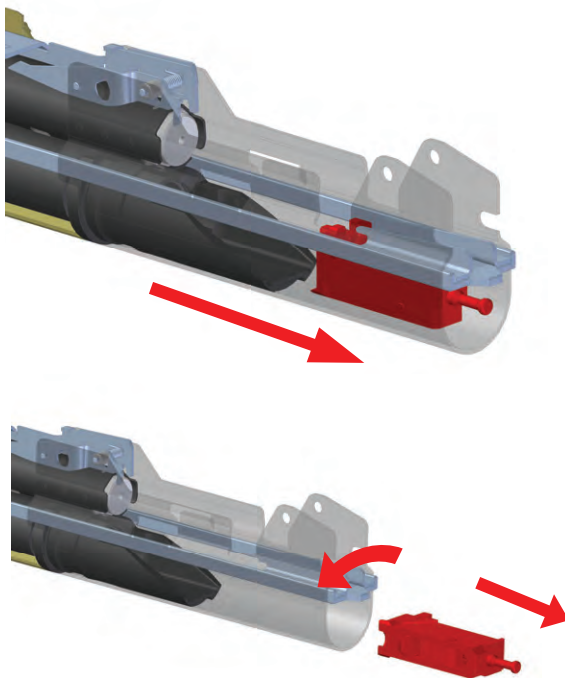
1. Grip the stock as shown below and pull rearward to remove.



Pull stock rearward (KS7 shown)

Removal of the Bolt (ALL SHOTGUNS)

1. Move the forend to its rearmost position to gain access to the bolt.
2. The bolt should now be resting in the receiver of the shotgun and can be easily removed by reaching in and rotating the bolt on its side.



Remove bolt from receiver (KS7 shown)

Separation of the Barrel and Receiver Assemblies (KS7)

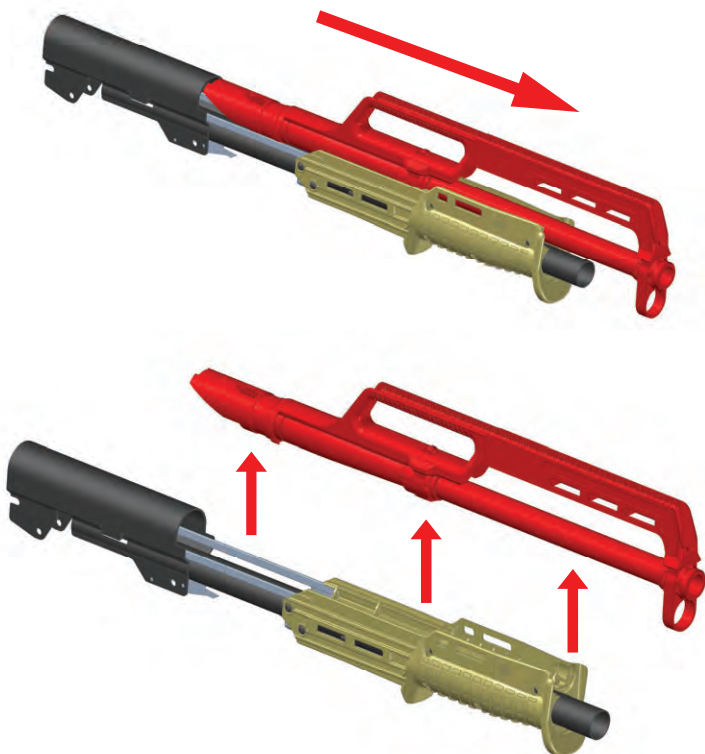
1. The barrel assembly is secured to the receiver assembly by the mag cap, located on the front of the firearm.
2. Rotate the mag cap counter-clockwise to remove the mag cap.

CAUTION The mag cap is under heavy spring pressure from the magazine spring and may cause injury if unintentionally released from the firearm.



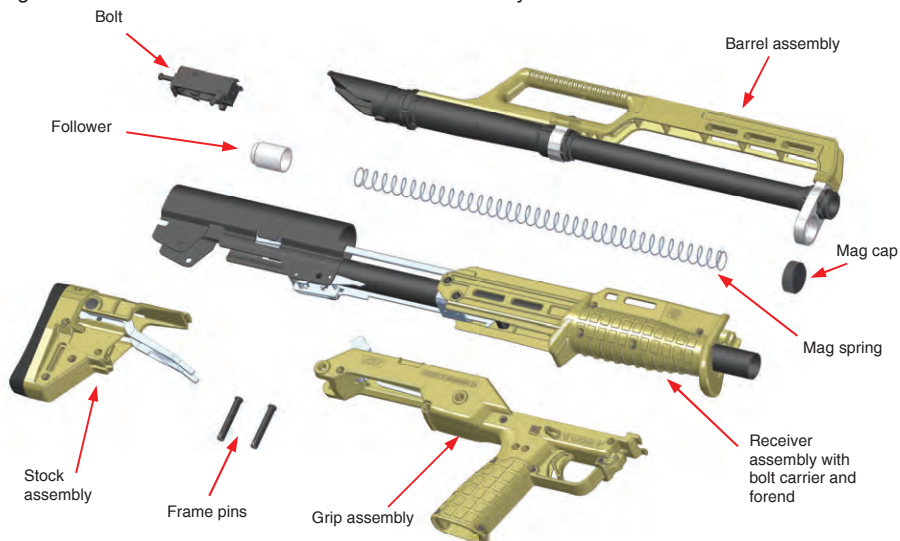
Remove mag cap (KS7 shown)

3. Once the mag cap is removed, the magazine spring and follower may be removed as well; place parts in a secure location, if removed.
4. The barrel assembly may slide off the receiver assembly by pulling linearly apart, as shown below.



Remove barrel assembly from receiver assembly (KS7 shown)

NOTICE Complete field stripping (disassembly) of the firearm should look similar to the image below. The action and bolt carrier assemblies may remain attached to the receiver.



Field stripped assemblies and parts

Separation of the Barrel and Receiver Assemblies (ALL KSG VARIANTS, KSG410)

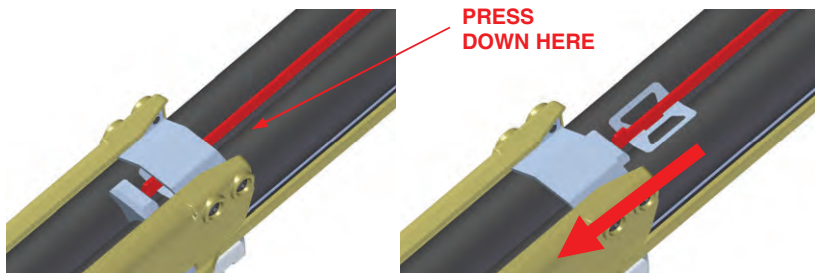
The barrel assembly is secured to the receiver assembly via two slotted magazine bolts located on the front of the shotgun. To remove these assemblies, the magazine bolts must be unscrewed using an object with a flat edge such as a quarter or the rim of a spent shell casing.

1. Using your tool of choice, unscrew the magazine bolts at the same rate alternating between the two bolts a half-turn at a time. This procedure is illustrated below.



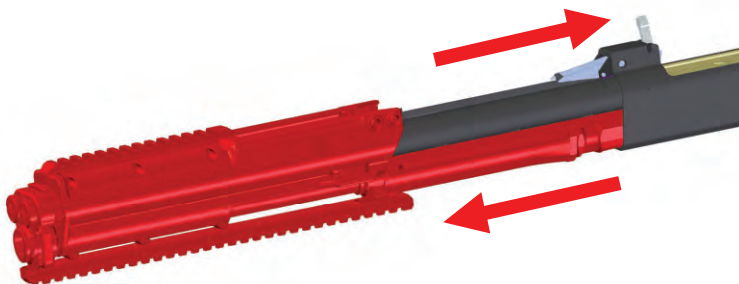
Unscrew magazine bolts with alternating 1/2 turns (KSG shown)

2. The Actuator must be pressed down for clearance as the barrel and receiver assemblies are separated.



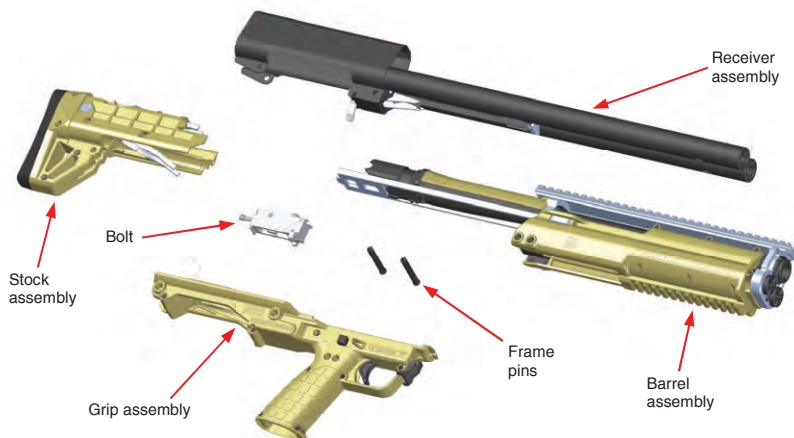
Press down CTG stop actuator and slide action (KSG shown)

3. With the shotgun upside-down, simultaneously pull the barrel assembly and receiver assembly linearly apart as shown below.



Pull barrel assembly apart from receiver assembly (KSG shown)

NOTICE Complete field stripping (disassembly) of the firearm should look similar to the image below. The action may remain attached to the barrel.



Field stripped assemblies and parts (KSG shown)

WARNING Further disassembly should only be performed by a certified gunsmith or KelTec. Attempting further disassembly could void your warranty.

E. ASSEMBLY

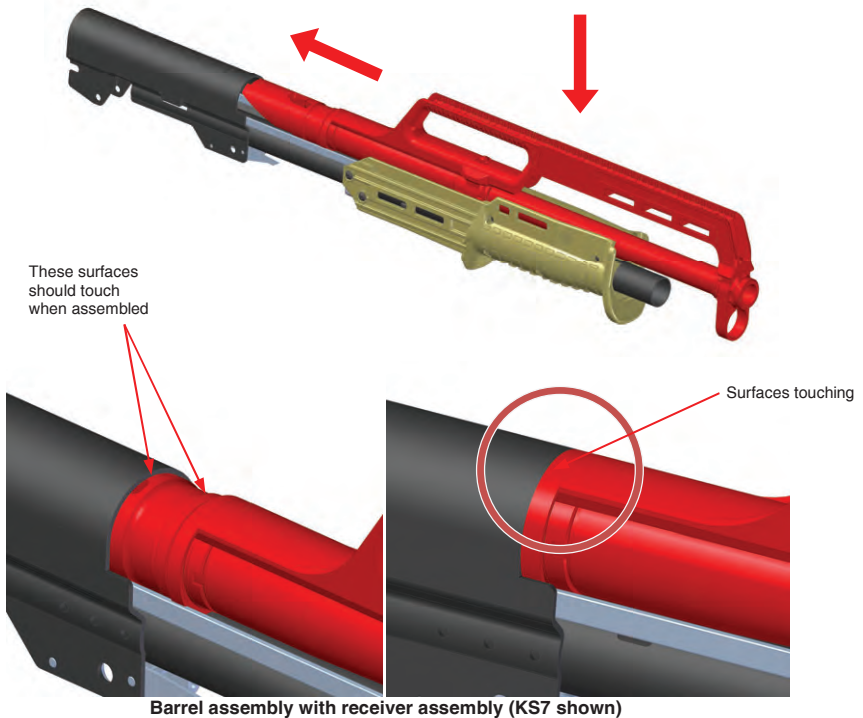
WARNING Never alter or modify the shotgun because this could cause it to malfunction and create a dangerous condition.

WARNING Always wear safety glasses when disassembling the shotgun to protect your eyes from components that are under pressure, such as springs.

NOTICE The following sections should be followed in sequential order; each step has an assembly highlighted in **RED** to assist with identification of the focus of the process.

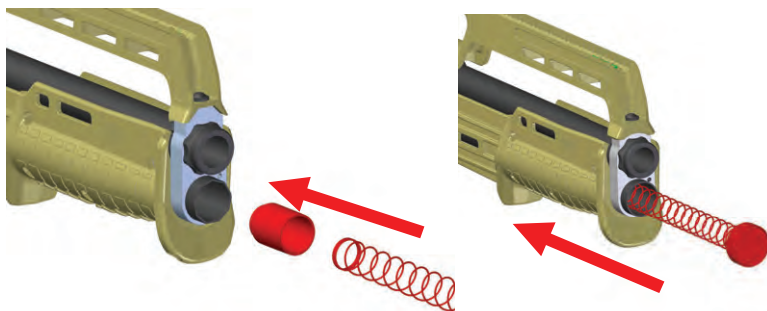
Joining of the Barrel and Receiver Assemblies (KS7)

1. Place the barrel assembly on top of the receiver assembly as shown below and slide the barrel assembly into the receiver.
2. Ensure the magazine tube protrudes through the muzzle plate.
3. The barrel extension should slide into the receiver until it bottoms out and touches the receiver.



5. Add follower, magazine spring and mag cap.
6. The magazine spring should slide into the hollow cavity in the follower and the follower should slide through the magazine tube until stopping towards the ejection port end of the receiver.
7. The mag cap should be placed on the spring as shown below.

8. The magazine spring will need to be compressed so the mag cap can be threaded onto the magazine tube; this will cause the magazine spring to be under tension.

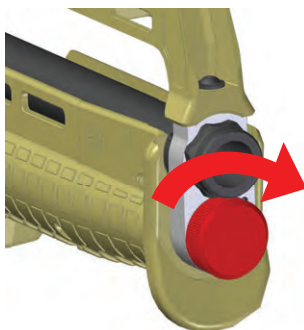


Add the follower, magazine spring and mag cap (KS7 shown)

CAUTION The mag cap is under heavy spring pressure from the magazine spring and may cause injury if unintentionally released from the firearm.

CAUTION The mag cap and magazine tube have a fine thread pitch; use caution on threading mag cap onto magazine tube, as to not damage the threads.

9. Cautiously ensure the mag cap is properly added to the magazine tube by starting to rotate the mag cap clock-wise.
10. Continue to rotate the mag cap onto magazine tube until the mag cap stops on the muzzle plate.
11. Assembly should look like the examples below.



Tighten mag cap on assembly (KS7 shown)



Barrel assembly with receiver assembly (KS7 shown)

Joining of the Barrel and Receiver Assemblies (ALL KSG VARIANTS, KSG410)

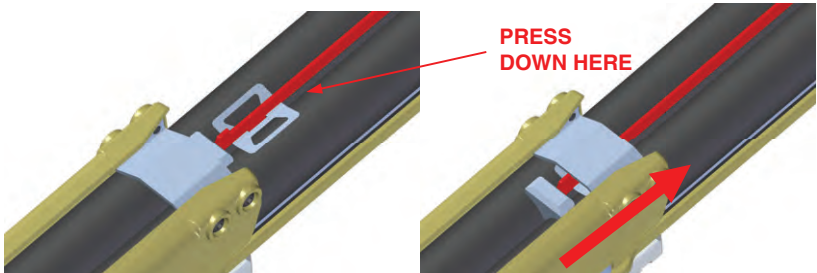
1. Orient the barrel and receiver assemblies as shown below and push the two units together, ensuring the magazine bolt screw threads seat into the magazine plug screw threads.



Barrel assembly with receiver assembly (KSG shown)

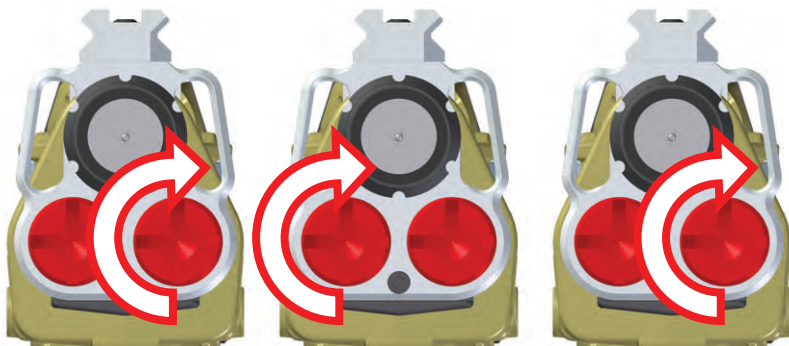
NOTICE In order to assemble the KSG410 barrel assembly on to the KSG410 receiver, the bolt carrier and forend must be slide to the rear of the barrel assembly and enter the receiver's housing first before the barrel extension.

2. When joining the Barrel and Receiver Assemblies, the Actuator may need to be pressed down for clearance under the Mag Stop Actuator. This process is illustrated below.



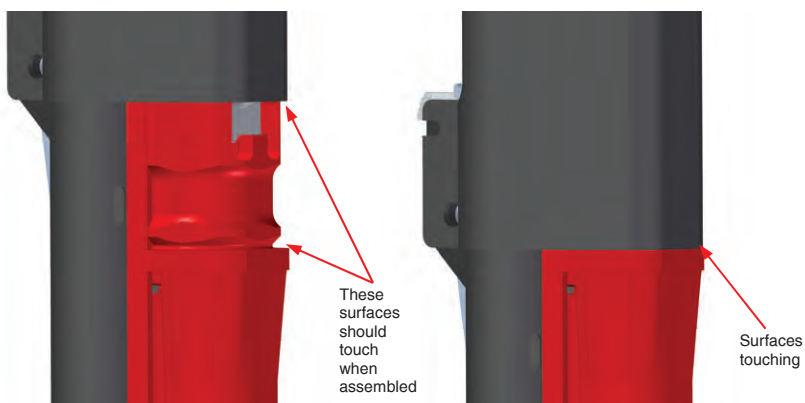
Press down CTG stop actuator and slide action (KSG shown)

3. Using your tool of choice, tighten the magazine bolts into the magazine plugs at the same rate, alternating between the two bolts a half-turn at a time until both bolts firmly resist further tightening. This must be done because the bolts screw into the same piece and will prematurely bind if one bolt is tightened faster than the other.



Tighten the magazine bolts with alternating 1/2 turns (KSG shown)

4. To ensure the two assemblies are properly joined, visually check that no gap exists between the barrel extension and receiver, as shown below.



Barrel assembly with receiver assembly (KSG shown)

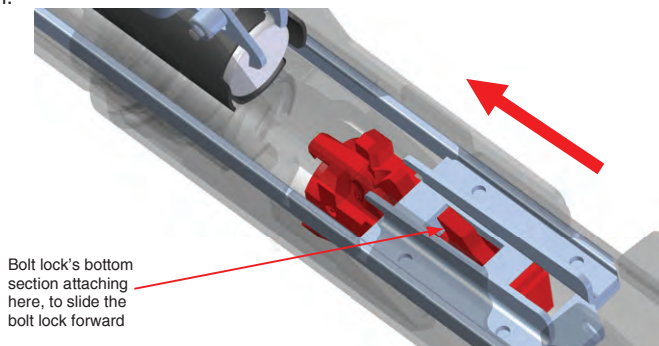
5. Assembly should look like the example below.



Barrel assembly with receiver assembly (KSG shown)

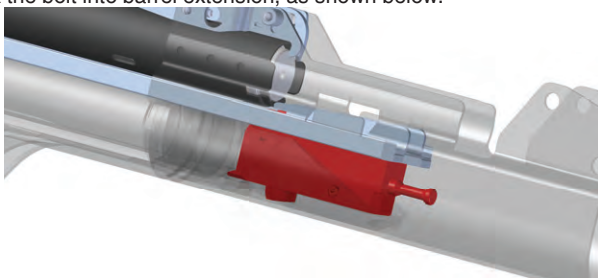
Insertion of the Bolt (ALL SHOTGUNS)

1. Move the action to its rearmost position.
2. Position the bolt in the receiver so it can be attached to the bolt carrier, as shown below. Bolt lock's bottom angled section should attach to the bolt carrier's angle section.



Bolt on bolt carrier (KS7 shown)

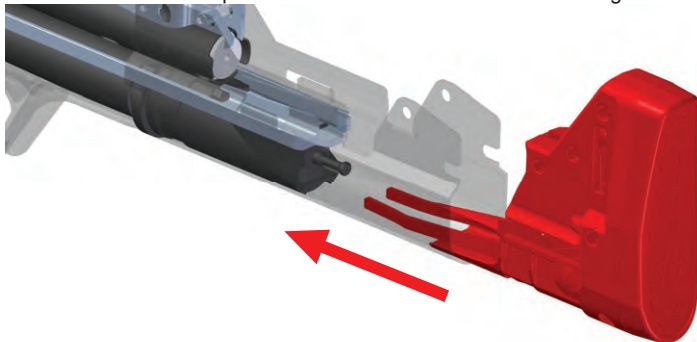
3. With the bolt on the bolt carrier, slide the action to the forward most position, which should lock the bolt into barrel extension, as shown below.



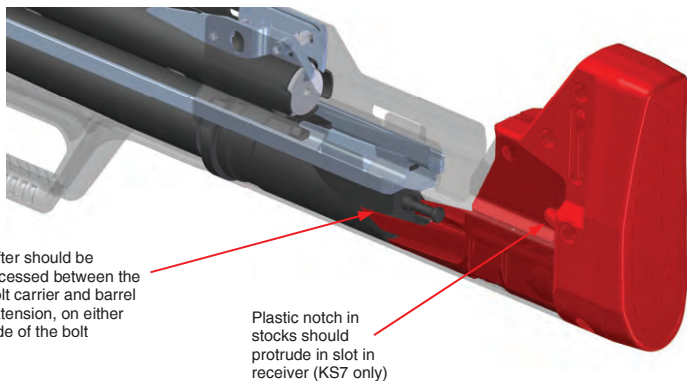
Bolt locked into barrel extension (KS7 shown)

Insertion of the Stock (ALL SHOTGUNS)

1. Slide the stock into the receiver as shown below.
2. The lifter's arms should pass on either side of the bolt while sliding into the receiver.



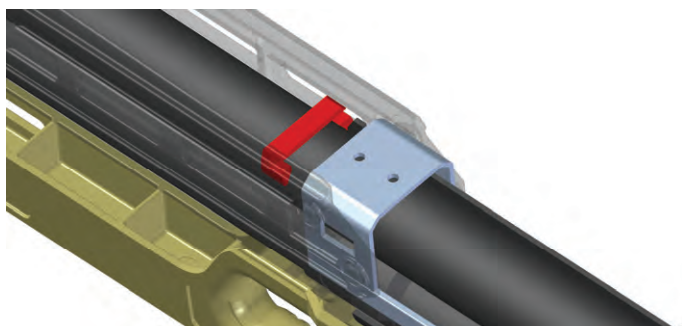
Slide stock into receiver (KS7 shown)



Push stock forward (KS7 shown)

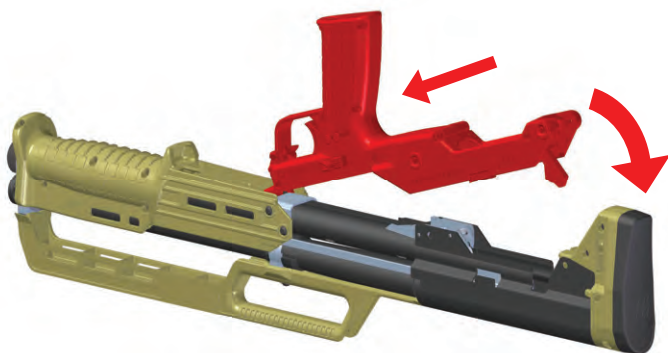
Insertion of Grip and Frame Pins (ALL SHOTGUNS)

3. The grip catch on the receiver holds the front area of the grip in place; the location of this is shown below.



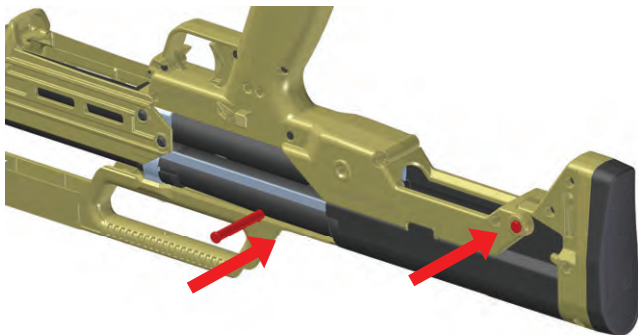
Grip catch area on receiver (KS7 shown)

4. Place the front area of the grip into the grip catch and rotate the grip down, onto the receiver as shown below.



Rotate grip onto receiver

5. Ensure frame pin holes line up and add the frame pins.



Add frame pins

6. After the shotgun is assembled it should look similar to the examples below. Once assembled, ensure the firearm functions properly by cycling the action of the firearm.



Example of KS7 and KSG



After re-assembly, always re-check to ensure that any accessory, to include any sub-assembly, are still properly installed on the firearm and did not become loose or disengaged, and will not interfere with safe operation of the firearm.

F. CLEANING AND MAINTENANCE

Maintenance (ALL SHOTGUNS)

⚠ WARNING Empty the magazine(s) of the firearm, verify that the chamber is unloaded, and remove all live ammunition from the area before working on the firearm to reduce the chance of a negligent discharge.

⚠ WARNING Always wear safety glasses when cleaning the firearm to protect your eyes from cleaning materials.

⚠ WARNING Always make sure that no ammunition is located in the area where you clean the firearm. Cleaning solvents can affect the primer and powder in ammunition and cause it to malfunction. This could result in a bullet being pushed into the barrel of the firearm and getting stuck. Firing another shell with a bullet stuck in the barrel could cause the barrel to burst and result in death or serious personal injury and/or damage to the firearm.

⚠ WARNING If the shotgun has been fired, wait a sufficient amount of time for the components to cool before attempting disassembly; failure to do so may result in burns.

Your KelTec shotgun is a precision instrument and will provide a lifetime of faithful service if it is properly cleaned and maintained. It is recommended that you clean your firearm after every shooting session or more frequently if needed. Be sure to unload your firearm before performing any cleaning or maintenance procedures.

NOTICE Only use commercially available gun solvent and gun oil or a cleaner-lubricant-preservative. Use of improper cleaning fluids could damage the firearm and void your warranty.

1. Disassemble the firearm (*see Field Strip on pg.15*).
2. Thoroughly clean all exterior sides of the bolt and receiver with solvent and brush.
3. Brush the barrel bore and chamber with a good powder removing solvent and bore brush. Wipe the areas clean with patches or a swab.
4. Using a small brush dipped in solvent, remove all deposits from around the breech of the barrel and barrel extension, as well as all adjacent areas that have been subjected to powder or primer residue.
5. Clean the magazine tubes with solvent and brush if needed.

Lubrication (ALL SHOTGUNS)

After cleaning the entire firearm, use a cloth to apply a light coating of high-quality gun oil to all internal and external metal surfaces; let the oil soak into the external surface for approximately five (5) minutes and then wipe clean.

Manually cycle the action back and forth to check the function of the firearm. If any parts are damaged or badly worn or the firearm does not work correctly, the firearm should not be fired and should be returned to KelTec for servicing immediately.

⚠ WARNING Discharging a firearm with oil, grease, or any other material even partially obstructing the bore could result in serious injury or death and serious damage to your firearm.

Troubleshooting *(ALL SHOTGUNS)*

Proper function of your firearm is directly related to maintenance and care, and to the ammunition you use. Some of the more common types of malfunctions which may occur are as follows:

Misfire: Failure of the shell to ignite when the hammer falls. If this occurs, keep the firearm pointed in a safe direction, wait 30 seconds to avoid hangfires. Cycle the action manually to eject the misfired shell; if there are unfired shells in the magazine tube, ensure no shells are released from the magazine tube into the ejection port. Place the firearm in SAFE configuration. Continue to unload the firearm until all ammunition has been removed and placed in a safe location. Disassemble the firearm so you can inspect the barrel assembly to check for any obstructions or issues. The most common cause of misfire is faulty ammunition.

Failure to Feed: This occurs when a shell has been fed from a magazine but not fully chambered. If this occurs, keep the firearm pointed in a safe direction. Place firearm on SAFE and remove the shell from the ejection port of the firearm. Inspect the cartridge and magazine for any issues. The most common causes are dirt or foreign objects impeding the magazine follower; improperly crimped cartridges are another cause.

Failure to Eject or Extract: A fired shell is not fully extracted from the chamber or ejected from the firearm. If this occurs, keep the firearm pointed in a safe direction, cycle the action manually to attempt to eject the shell; if there are unfired shells in the magazine tube, ensure no shells are released from the magazine tube into the ejection port. Place the firearm in SAFE configuration. Continue to unload the firearm until all ammunition has been removed and placed in a safe location. Disassemble the firearm so you can inspect the barrel and bolt assembly to check for any obstructions or issues. The most common causes are a damaged extractor, ejector or ammunition; improperly loaded or sized cartridges can cause this also.

If any of the above problems are not solved by cleaning or by use of other brands of ammunition, stop firing, unload and return the firearm to our service department.

G. SERVICE, REPAIR, AND WARRANTY



Always make sure the firearm is unloaded before sending it in for service.

If your firearm ever requires adjustment, refinishing or repair, it should be returned to Kel-Tec CNC Industries, Inc.'s service department. The unloaded firearm should be sent with prepaid shipping to:

Kel-Tec CNC Industries, Inc.
Service Department
1505 Cox Road
Cocoa, FL 32926

Contact your chosen carrier to determine its requirements for shipping firearms. In certain states, your firearm may have to be returned to you through a local federally licensed firearms dealer. Be sure to securely package your firearm and insure it for its full value because Kel-Tec CNC Industries, Inc. is not responsible for firearms lost or damaged during shipment.

To ensure prompt service and handling, include a brief letter including your name, address, telephone number, the serial number of your firearm, and what you would like to be done with it, or the issue that you would like to be addressed. No return authorization number is required. Once your firearm has been received, we will provide a quotation of all charges (unless the repairs are covered by the warranty) and will not begin work until we receive your approval. Charges for adjustments, refinishing, and repairs are payable by money orders, Master Card, Visa, and American Express. No COD or personal checks are accepted.

LIMITED LIFETIME WARRANTY

Subject to the terms, conditions and limitations outlined below, Kel-Tec CNC Industries, Inc. guarantees your firearm defects in materials and workmanship for the lifetime of the original consumer purchaser.

To make a claim under this warranty, return your firearm pursuant to the instructions above and include a copy of a bill of sale in your name, or a copy of the 4473 form, showing that you are the original consumer purchaser. For repairs that are covered by the warranty, Kel-Tec CNC Industries, Inc. will pay the transportation and insurance charges to return your firearm.

LIMITATIONS OF WARRANTY

The warranty will be void if any of the following occur:

- (1) the instructions in the Instruction Manual are not followed;
- (2) the firearm or any of its parts are altered or modified from their original state;
- (3) damage is caused by misuse, abuse or improper maintenance; or
- (4) the firearm is disassembled beyond the instructions in the Instruction Manual.

There are no warranties which extend beyond the description on the face hereof.

The sole and exclusive remedy pursuant to this warranty is the repair or replacement of the firearm, at the sole discretion of Kel-Tec CNC Industries, Inc.

The implied warranties of merchantability and fitness for a particular purpose are expressly disclaimed.

All disclaimers and limitations of liability shall still apply even if the limited remedy of repair and replacement fails of its essential purpose.

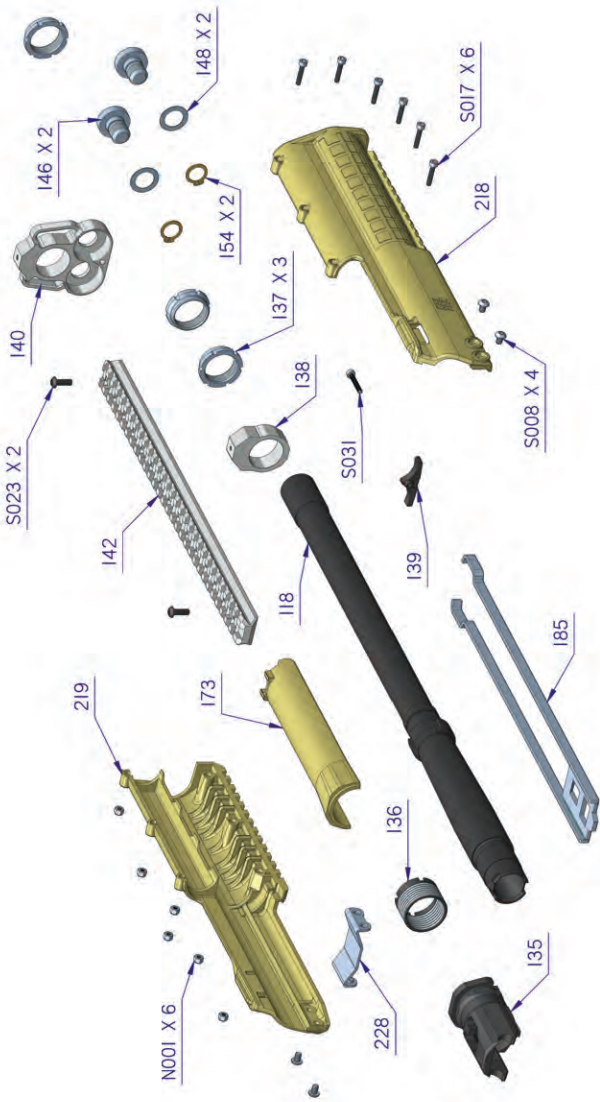
In states where permitted, Kel-Tec CNC Industries, Inc. assumes no liability for incidental or consequential damage or for incidental expenses.

Any action against Kel-Tec CNC Industries, Inc. based on an alleged breach of this warranty must be brought within one (1) year of the claimed breach.

Kel-Tec CNC Industries, Inc.'s liability for breach of warranty shall be limited to repair or replacement of the firearm, at the sole discretion of Kel-Tec CNC Industries, Inc.

Firearms can be dangerous when not used properly. The purchaser assumes all liability resulting from unsafe handling or any action that constitutes a violation of any applicable laws or regulations. KelTec will not be responsible for injuries or damages resulting from careless handling, unauthorized or unsafe adjustments or modifications, the use of non-standard, defective, or improper ammunition, the use of incompatible or improperly installed accessories, corrosion, neglect, fire damage, water damage, theft, abuse, ordinary wear and tear, or unreasonable use of the firearm. Under no circumstances shall KelTec be responsible for incidental or consequential damages with respect to economic loss or injury or property damage, whether as a result of breach of express or implied warranty, negligence or otherwise.

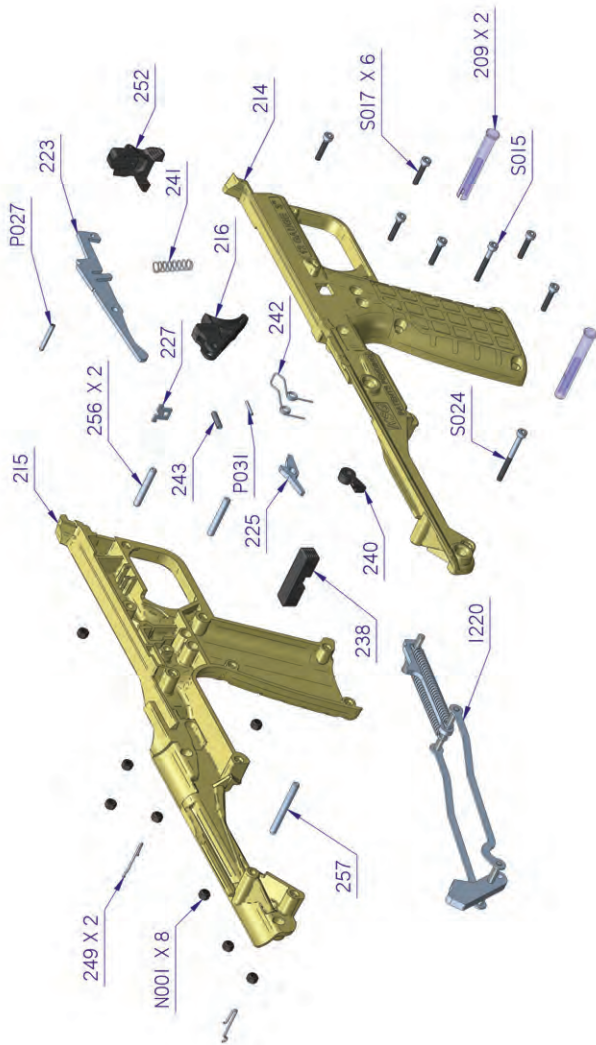
KSG BARREL PARTS LIST



118	BARREL	1	142	PICATINNY RAIL	1	219	LEFT FOREND	1
135	BARREL EXTENSION	1	146	MAG BOLT	2	228	MAG STOP ACTUATOR	1
136	BARREL NUT	1	148	WAVY WASHER	2	N001	M3 NYLOCK	6
137	BARREL RING	3	154	RETAINER CLIP	2	S008	M4 X 6 BHS	4
138	SIGHT BASE	1	173	HEAT SHIELD	1	S017	M3 X 16 SHS	6
139	PUMP BUFFER	1	185	BOLT CARRIER	1	S023	M4 X 12 BHS	2
140	MUZZLE PLATE	1	218	BOLT CARRIER	1	S031	M3 X 20 SHS	1

KSG GRIP PARTS LIST

NOTE: USED IN KSG, KSG25,
KSG COMPACT, KSG TACTICAL



NOTE: THIS ASSEMBLY INCLUDES
THE FRAME PIN ASSEMBLY

1220	HAMMER ASSEMBLY	1	225	SEAR	1	243	SEAR SPRING	1	P027	3/32 X 3/4 CSP	1
209	FRAME PIN	2	227	SEAR CATCH	1	249	CAPTOR SPRING	2	P031	1/16 X 7/16 DP	1
214	GRIP RIGHT	1	238	SAFETY	1	252	LOCK BUTTON	1	S015	M3 X 25 SHS	1
215	GRIP LEFT	1	240	SAFETY SNAP	1	256	TRIGGER AXIS	2	S017	M3 X 16 SHS	6
216	TRIGGER	1	241	ACTION BAR SPRING	1	257	HAMMER AXIS	1	S024	M3 X 35 SHS	1
223	ACTION LOCK	1	242	TRIGGER SPRING	1	N001	M3 NYLOCK	8			

KSG RECEIVER PARTS LIST

KSG25 RECEIVER:
KSG-525 REPLACES KSG-325
KSG-500 REPLACES KSG-300B

KSG COMPACT AND TACTICAL RECEIVERS:
KSG-300TAC REPLACES KSG-300B



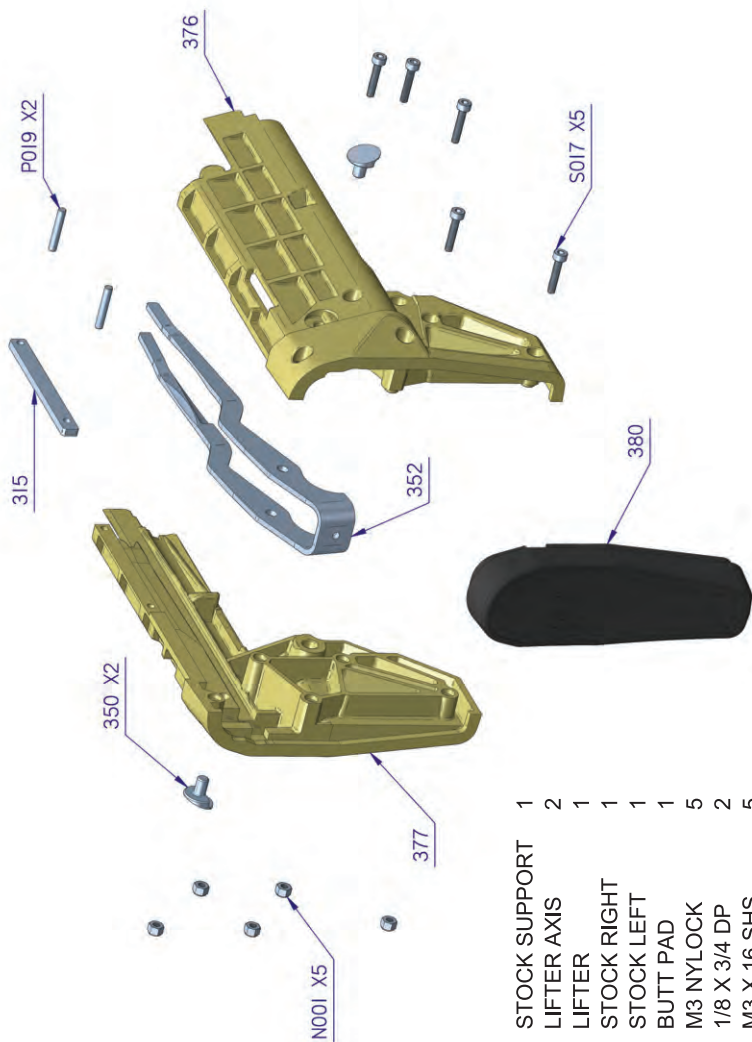
300B	RECEIVER	1	323	CTG PIN	1	333	SELECTOR	1
310	MAG PLUG	2	325	MAG SPRING	2	334	ACTUATOR	1
311	FOLLOWER	2	328	DETENT SPRING	1	336	ACTUATOR SPRING	1
320	SELECTOR WASHER	1	330	CTG CATCH	1	338	CTG SPRING	1
322	DETENT	1	331	CTG OUTER	2	S007	M3 X 10 SHS	1

NOTE: USED IN KSG, KSG25,
KSG COMPACT, KSG TACTICAL



KSG STOCK PARTS LIST

NOTE: USED IN KSG, KSG25,
KSG COMPACT, KSG TACTICAL

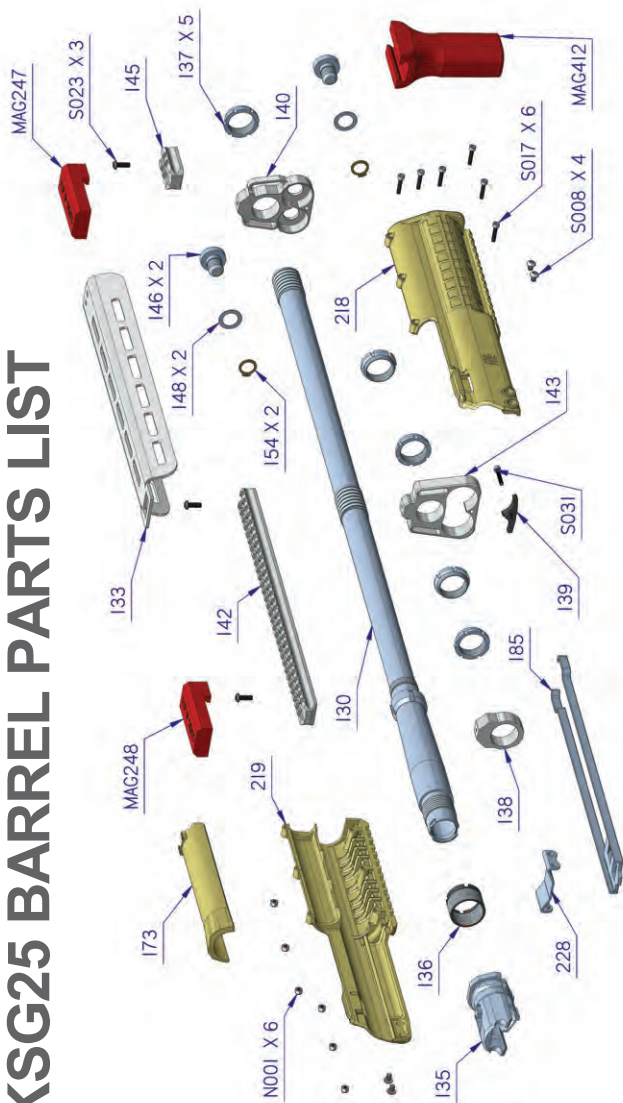


315	1	STOCK SUPPORT
350	2	LIFTER AXIS
352	1	LIFTER
376	1	STOCK RIGHT
377	1	STOCK LEFT
380	1	BUTT PAD
N001	5	M3 NYLOCK
P019	2	1/8 X 3/4 DP
S017	5	M3 X 16 SHS

**KSG TACTICAL BARREL ASSEMBLY:
KSG-114 REPLACES KSG-119T**



KSG25 BARREL PARTS LIST



130	BARREL LONG	1	143	SLEEVE PLATE	1	228	MAG STOP ACTUATOR 1	1
133	FRONT HEAT SHIELD	1	145	PIC RAIL SHORT	1	1	MAG247 MAGPUL FRONT MBUS	1
135	BARREL EXTENSION	1	146	MAG BOLT	2	2	MAG248 MAGPUL REAR MBUS	1
136	BARREL NUT	1	148	WAVY WASHER	2	2	MAG412 MAGPUL RVG	1
137	BARREL RING	5	154	RETAINER CLIP	2	2	N001 M3 NYLOCK	6
138	SIGHT BASE	1	173	HEAT SHIELD	1	1	S008 M4 X 6 BHS	4
139	PUMP BUFFER	1	185	BOLT CARRIER	1	1	S017 M3 X 16 SHS	6
140	MUZZLE PLATE	1	218	RIGHT FOREND	1	1	S023 M4 X 12 BHS	3
142	PICATINNY RAIL	1	219	LEFT FOREND	1	1	S031 M3 X 20 SHS	1

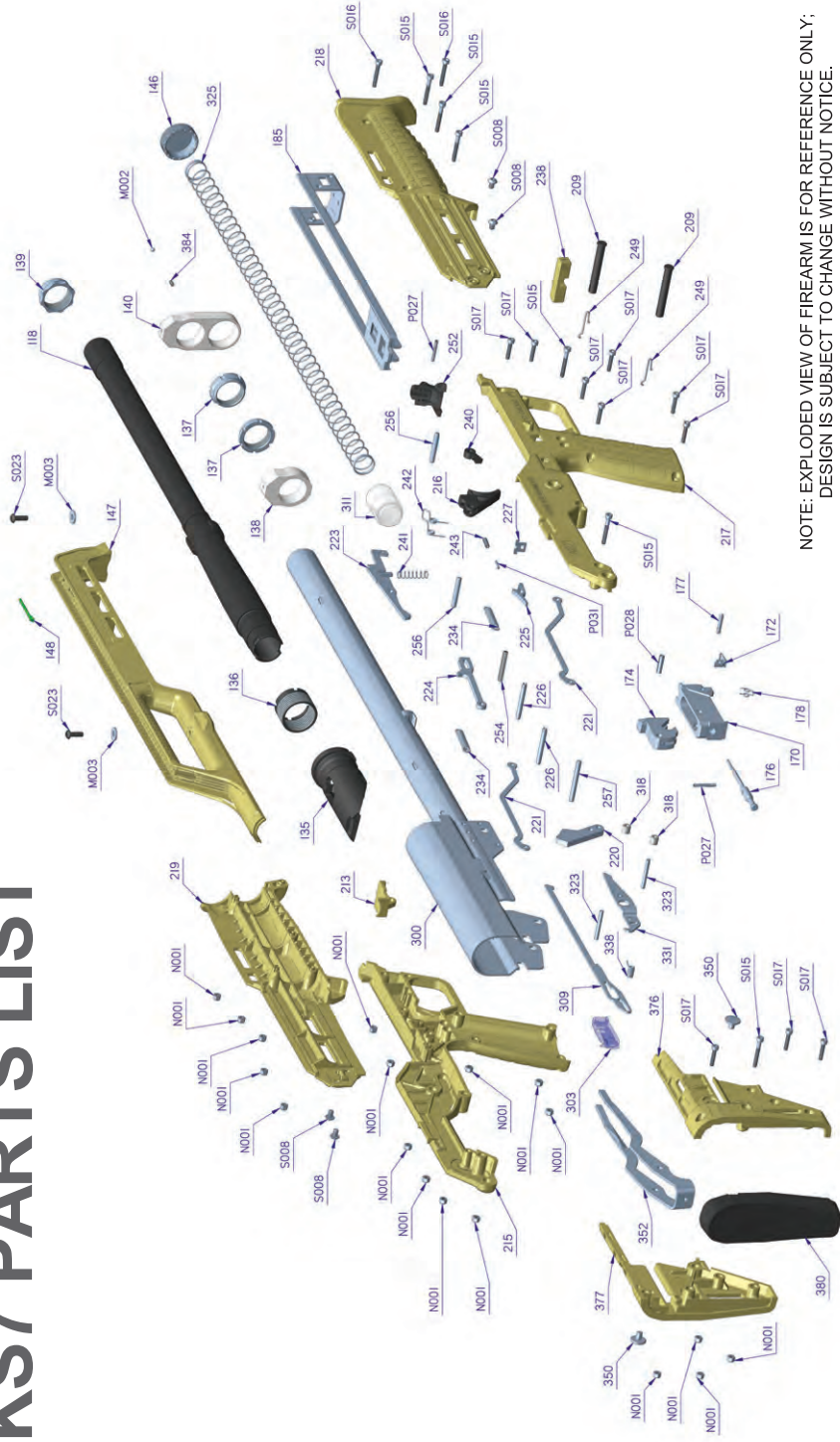
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KSG410 PARTS LIST

147	CARRY HANDLE	1	238	SAFETY	1	336	ACTUATOR SPRING	1
148	FIBER OPTIC	1	240	SAFETY SNAP	1	338	CTG STOP SPRING	1
176	FIRING PIN	1	241	ACTION SPRING	1	400	RECEIVER	1
209	FRAME PIN	2	242	TRIGGER SPRING`	1	409	MAG PLUG	2
216	TRIGGER	1	243	SEAR SPRING	1	411	MAG FOLLOWER	2
220	HAMMER	1	249	CAPTOR SPRING	2	414	GRIP RIGHT	1
221	HAMMER BAR	2	252	LOCK BUTTON	1	415	GRIP LEFT	1
223	ACTION LOCK	1	254	SEAR GUIDE PIN	1	418	BARREL	1
224	SEAR BAR	1	256	TRIGGER AXIS	2	419	FOREND RIGHT	1
225	SEAR	1	257	HAMMER AXIS	1	420	FOREND LEFT	1
226R	RIVET	2	322	SELECTOR SNAP	1	425	MAG SPRING	2
227	SEAR CATCH	1	328	SNAP SPRING	1	428	CTG ACTUATOR	1
234	HAMMER SPRING	2	331	CTG CATCH OUTER	2	430	CTG CATCH INNER	1

431	SHOULDER BOLT	1	472	EXTRACTOR	1	P031	1/16 X 7/16 DP	1
433	SELECTOR	1	474	BOLT LOCK	1	S001	M3 X 12 SHS	3
434	ACTUATOR	1	476	STOCK RIGHT	1	S007	M3 X 10 SHS	1
435	BARREL EXTENSION	1	477	STOCK LEFT	1	S008	M4 X 6 BHS	4
436	BARREL NUT	1	480	BUTTPAD	1	S010	M3 X 18 SHS	2
438	SIGHT BASE	1	485	BOLT CARRIER	1	S016	M3 X 22 SHS	2
439	BARREL RING	3	494	EXTRACTOR SPRING	1	S017	M3 X 16 SHS	4
440	MUZZLE PLATE	1	M006	RETAINING CLIP	2	S023	M4 X 12 BHS	2
446	MAG BOLT	2	P008	1/16 X 7/16 SSP	1	S031	M3 X 20 SHS	4
450	LIFTER AXIS	2	P009	1/8 X 1 DP	1	S041	M3 X 30 SHS	1
452	LIFTER	1	P020	1/8 X 3/8 CSP	1	W022	WAVY WASHER	2
470	BOLT	1	P021	3/32 X 1/2 SSP	1			
471	EXTRACTOR AXIS	1	P027	3/32 X 3/4 CSP	1			

KS7 PARTS LIST



NOTE: EXPLODED VIEW OF FIREARM IS FOR REFERENCE ONLY;
DESIGN IS SUBJECT TO CHANGE WITHOUT NOTICE.

118	BARREL	1	174	BOLT LOCK	1	220	HAMMER	1
135	BARREL EXTENSION	1	176	FIRING PIN	1	221	HAMMER BAR	2
136	BARREL NUT	1	177	EXTRACTOR AXIS	1	223	ACTION LOCK	1
137	BARREL RING	2	178	EXTRACTOR SPRING	1	224	SEAR BAR	1
138	SIGHT BASE	1	185	BOLT CARRIER	1	225	SEAR	1
139	MUZZLE RING	1	209	FRAME PIN	2	226R	HAMMER BAR PIN	2
140	MUZZLE PLATE	1	213	GRIP FILLER	1	227	SEAR CATCH	1
146	MAG CAP	1	215	GRIP LEFT	1	234	HAMMER SPRING	2
147	CARRY HANDLE	1	216	TRIGGER	1	238	SAFETY	1
148	FIBER OPTIC	1	217	GRIP RIGHT	1	240	SAFETY SNAP	1
170	BOLT	1	218	FOREND RIGHT	1	241	ACTION BAR SPRING	1
172	EXTRACTOR	1	219	FOREND LEFT	1	242	TRIGGER SPRING	1

243	SEAR SPRING	1	325	MAG SPRING	1	P027	3/32 X 3/4 COIL PIN	2
249	CAPTOR SPRING	2	331	CTG OUTER	1	P028	5/32 X 5/8 COIL PIN	1
252	LOCK BUTTON	1	338	CTG SPRING	1	P031	1/16 X 7/16 PIN	1
254	SEAR GUIDE PIN	1	350	LIFTER AXIS	2	S008	M4 X 6 BHS	4
256	TRIGGER AXIS	2	352	LIFTER	1	S015	M3 X 25 SHS	6
257	HAMMER AXIS	1	376	STOCK RIGHT	1	S016	M3 X 22 SHS	2
300	RECEIVER	1	377	STOCK LEFT	1	S017	M3 X 16 SHS	10
303	CTG INNER	1	380	BUTT PAD	1	S023	M4 X 12 BHS	2
309	ACTUATOR BAR	1	384	DETENT SPRING	1			
311	MAG FOLLOWER	1	M002	DETENT BALL	1			
318	CTG BRACE	2	M003	WASHER	2			
323	CTG STOP PIN	2	N001	M3 NUT	18			

NOTES

[illegible]

KELTEC®



1505 Cox Rd Cocoa FL 32926
p: 800.515.9983 f: 321.631.1169
e: info@keltecweapons.com



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