



AERO PRECISION

SOLUS USER MANUAL

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I. INTRO & SUPPORT RESOURCES

The Aero Precision Solus Rifle works to provide shooting enthusiasts with a custom shooting experience. The Solus line was designed and built around the core belief that equipment should not be the marksman's limiting factor under any use case.

Within this manual are instructions for how to get the most out of your Solus rifle, including function, customization, maintenance, warranty information and more. **Some details are configuration dependent.**

For detailed videos, common questions, and other support resources, please visit aeroprecisionusa.com/learn/solus.

If you are in further need of support, our customer service department is available Monday – Friday.

Aero Precision Customer Support
<https://www.aeroprecisionusa.com/contact>
253-203-8188

II. SAFETY INFORMATION

⚠ WARNING READ ALL SAFETY INSTRUCTIONS AND WARNINGS CAREFULLY AND MAKE SURE YOU UNDERSTAND THEM BEFORE OPERATING YOUR FIREARM. FIREARMS ARE DANGEROUS AND FAILURE TO DO SO COULD RESULT IN PROPERTY DAMAGE, SEVERE BODILY INJURY OR DEATH TO YOU OR OTHERS.

⚠ WARNING ALWAYS MAKE SURE YOUR FIREARM IS UNLOADED AND CLEAR OF AMMUNITION BEFORE CLEANING, PERFORMING MAINTENANCE, CONDUCTING ADJUSTMENTS OR ANY OTHER ACTIVITY OTHER THAN PREPARING TO FIRE THE RIFLE. FAILURE TO UNLOAD YOUR FIREARM COULD RESULT IN AN ACCIDENTAL DISCHARGE, CAUSING PROPERTY DAMAGE, SEVERE BODILY INJURY OR DEATH TO YOU OR OTHERS.

II. SAFETY INFORMATION CONT.

When using a firearm, always adhere to the 4 rules of firearms safety.

- 1: Treat every firearm as if it is loaded.
- 2: Always keep your firearm pointed in a safe direction.
- 3: Keep your finger off the trigger until you are ready to shoot.
- 4: Be aware of your target and what's beyond it.

Important aspects of safe firearms ownership and use.

Learn the mechanical & handling characteristics of the rifle you are using.

Always use proper Ammunition (defined in section V).

Be sure the barrel is clear of obstructions before loading and shooting.

If your rifle fails to fire when the trigger is pulled, hold your shooting position for 1 minute; then with the muzzle pointed in a safe direction, carefully unload the rifle.

Don't rely on the rifle's safety to keep it from firing.



III. RIFLE OVERVIEW

(Solus Competition Rifle pictured)

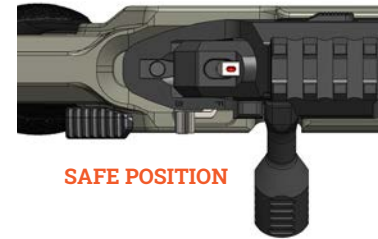


III. RIFLE OVERVIEW CONT.

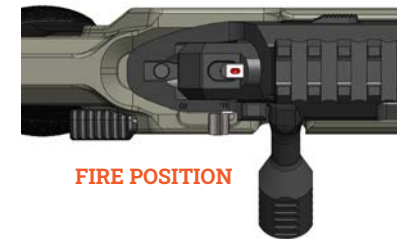
Every Solus rifle is test fired in our state-of-the art range for function and accuracy prior to leaving the facility. Rifles may show evidence of this firing. Due to post firing cleaning, some component's protective finish may appear dry or uneven. Applying a light coat of oil will correct the appearance.

Safety Controls

The safety lever for the Solus is located on the right-hand side of the rifle, directly behind the bolt handle. The safety lever when rearward is in the "S" (Safe) position and when forward is in the "F" (Fire) Position.



SAFE POSITION



FIRE POSITION

Always place the rifle in "Safe" before handling, loading, unloading, and when not in use. Only when on target and ready to fire should the safety lever be removed from safe and placed in the forward "F" (Fire) position.

Do not touch the trigger while manipulating the safety. Fingers and other objects must be kept outside the trigger guard area, away from the trigger, at all times until ready to fire the rifle.

Please note - the mechanical safety, when properly engaged and in working order, provides a degree of protection from unintentional and accidental discharge. The safety mechanism is not a substitute for following the rules of safe firearms handling and should not be relied upon exclusively for safety and accident prevention.

IV. INITIAL ASSEMBLY & CLEANING

Installing the Bolt into the Action

Your Solus rifle is shipped from the factory with the bolt removed from the action. The following steps will outline how to install the bolt in your action. Please read and understand all steps fully prior to starting.

- 1: Prior to installing the bolt, verify the magazine is removed and rifle/barreled action is free of ammunition.
- 2: To install the bolt assembly into the action, place the Adjustable Comb Riser to the highest position (depending on configuration).
- 3: Grasp the bolt assembly by the bolt handle, position the bolt head of the bolt assembly into the bore of the action and slide approximately halfway in.
- 4: Align the bolt handle with the action's Bolt Handle Raceway channel by either lifting or lowering the bolt handle.
- 5: When aligned, the bolt stop will automatically engage the Bolt Stop Guide Channel of the bolt assembly. Once the bolt stop has engaged the bolt assembly, the bolt assembly can be pushed fully forward, and the bolt handle can be rotated downward to close the action.



IV. INITIAL ASSEMBLY & CLEANING CONT.

Removing the Bolt from the Action

You may need to remove the bolt from your action for cleaning and maintenance purposes. The following steps will outline how to remove the bolt. Please read and understand all steps fully prior to starting.

Ensure the firearm safety is in the "S" (Safe) position, that the magazine is removed, and that the firearm is unloaded and clear of ammunition.

- 1: Lift the bolt handle to unlock the action and retract the bolt assembly rearward approximately 2/3 of the bolt assembly's travel.
- 2: Slide the Bolt Release button forward (towards muzzle) and depress the raised portion of release button.
- 3: With the button depressed, the bolt assembly can be fully retracted and removed from the action.

*Note - The stock's adjustable comb may need to be fully raised to allow bolt assembly removal.



IV. INITIAL ASSEMBLY & CLEANING

Initial Cleaning

Solus rifles ship from the factory with preservative oil on all surfaces, including the bore. Wipe down all surfaces with a clean lint free cloth. The bore and chamber of the barrel must also be cleaned to remove any lubricants, failure to do so may result in an increase in bore and chamber pressure which may cause firearm damage, personal injury, or death.

Barrel Break-In Procedure

⚠️ WARNING Before loading any ammunition, make sure your safety lever is in the “S” (Safe) position and that the rifle is pointed in a safe direction.

- 1: Ensure the bore is free of any obstructions, oils or solvents. If unsure, insert a cleaning rod with jag and patch. Run the cleaning rod back and forth approximately 20 times or until clean, replacing patches as necessary.
- 2: Obtain a rough zero for safety. The process for this depends on what optic you are using. Refer to the optic manual for instructions.
- 3: Shoot approximately 50-60 rounds through your rifle in groups of 5 shots.
- 4: Once you have shot 50-60 rounds through the barrel, follow the cleaning steps in section VIII “Bore Cleaning - Carbon Deposits”
- 5: Zero your rifle and regularly track rounds fired and general accuracy achieved after break-in. Tracking can help you understand when maintenance needs to be performed. Replace barrel when accuracy starts to see permanent degradation.

V. AMMUNITION

The ammunition to be used in your rifle must match the caliber inscribed on the barrel. Use only new production high-quality factory loaded ammunition, manufactured in conformance with SAAMI (Sporting Arms and Ammunition Manufacturers’ Institute, Inc)/ANSI (American National Standards Institute) specification. **Do not use remanufactured, handloads, or non-standard ammunition. Use of such ammo will void all warranties and may result in damage to the firearm, severe bodily injury or death to the shooter or bystanders.**

Before loading, ensure the primer of each cartridge is seated flush or below the surface of the cartridge case base. **A protruding primer may be ignited upon closing of the bolt which could result in severe injury to the shooter or bystanders.**

If a cartridge does not readily chamber, do not force it. Remove the magazine from the rifle and retract the bolt. Examine the bore and chamber for damage, foreign debris, or a lodged bullet. Confirm the ammunition is the correct caliber for the rifle. If you cannot determine why the cartridge will not fit the chamber, contact Aero Precision Customer Support or a qualified gunsmith.

⚠️ WARNING If a cartridge fails to fire (misfires) when the trigger is depressed, keep the rifle pointed in a safe direction and wait 1 minute before attempting to open the rifle’s action. After time has elapsed, with the rifle pointed in a safe direction, unload the defective cartridge from the chamber. Inspect chamber and bore for lodged bullets and other debris. Dispose of the defective cartridge in accordance with local rules and regulations. A misfire is still considered a loaded firearm and should be treated as such.

Should the report of the shot fired sound softer, louder, or irregular in any way, keep the rifle pointed in a safe direction; unload the rifle and check the chamber and bore for a lodged bullet through the entire barrel. A cleaning rod can be utilized to ensure the bore is free of a stuck bullet. If a bullet is found stuck in the bore, take the firearm to a qualified

V. AMMUNITION CONT.

gunsmith, or contact Aero Precision Customer Support. Never attempt to remove a stuck bullet by firing a subsequent cartridge to push the bullet out of the bore. Doing so may result in damage to the rifle and severe injury or death to the shooter or bystanders.

Do not apply any lubrication to ammunition and avoid lubrication to the firing chamber and bore. Lubrication between the chamber walls and cartridge results in an increase of load and stresses applied onto the locking lugs of the bolt and receiver.

When it comes to accuracy, every rifle will have an ammunition preference over others. It is recommended small quantities of different ammunition types are tested to obtain the best accuracy potential of your rifle.



VI. LOADING & UNLOADING MAGAZINES

Solus rifles are compatible with both Accuracy International (AI) AICS and AW pattern detachable magazines.

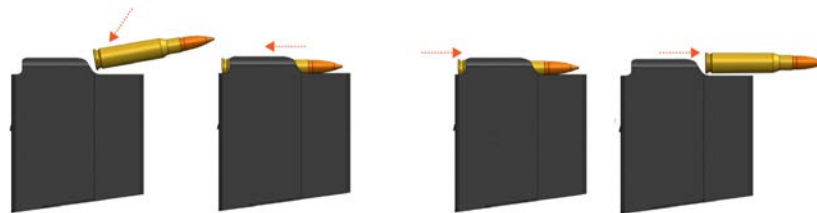
Loading Magazines

To load the magazine, press the base of the cartridge down on the front of the magazine follower and slide backwards under the feed lips until the cartridge base contacts the rear of the magazine. Each successive round will load in a similar manner on top of the preceding cartridge. Repeat until the magazine's capacity is reached or until you have loaded the desired number of rounds.

Do not load the magazine beyond its capacity. Doing so will damage the magazine, require additional force to lock the magazine into the rifle's magazine well, make feeding the first round difficult, and may cause damage to the ammunition cartridge resulting in negative effects on first shot accuracy.

Unloading Magazines

To unload the magazine, grasp the magazine in one hand, with your opposite hand place your thumb between the two feed-lips and the base of the top cartridge. Push the cartridge forward and out of the magazine. Repeat until all cartridges have been removed.



Loading Magazines

Unloading Magazines

VI. LOADING & UNLOADING MAGAZINES CONT.

Seating a Magazine into the Rifle

- 1: Start by ensuring the rifle's safety is in the "S" (Safe) position.
- 2: Grip the magazine by its base and insert it into the magazine well located forward of the trigger guard of the rifle.
- 3: Apply upward pressure on the magazine base to fully seat it onto the magazine catch within the magazine well. An audible click will be heard.
- 4: To ensure the magazine is locked into place, pull down on the magazine. A properly seated magazine will remain in place.

Removing a Magazine from the Rifle

- 1: Start by ensuring the rifle's safety is in the "S" (Safe) position and that the chamber is clear of ammunition.
- 2: Place one hand on the bottom of the magazine, and with the opposite hand depress the magazine release latch.

*Note - The latch is ambidextrous and can be released from either side of the trigger guard.



VII. CYCLE OF OPERATION

Function Check

The following steps outline how to function check the firing of your rifle.

- 1: With the magazine removed, physically and visually inspect the chamber to confirm no ammunition is present.
- 2: Pointing the rifle's muzzle in a safe direction, close the action.
- 3: With the safety in the "S" (Safe) position, squeeze the trigger. The firing pin should not fall.
- 4: Place the safety to the "F" (Fire) position, squeeze the trigger, the firing pin should fall.
- 5: If the firearm does not function properly, immediately discontinue its use and contact Aero Precision Customer Support for assistance.

Chambering

- 1: Ensure the action is closed, bolt handle is down, safety is in "S" (Safe) position, and the muzzle is pointed in a safe direction.
- 2: Lift the bolt handle until rotation stops, then retract the bolt assembly as far rearward as possible.
- 3: Seat loaded magazine into the rifle.
- 4: Push bolt forward in one continuous motion to strip the ammunition cartridge from the magazine & feed it into the chamber.
- 5: Once the bolt is fully forward, rotate the bolt handle downward to close the action.

VII. CYCLE OF OPERATION CONT.

Firing

- 1: With the safety lever in the “S” (Safe) position, acquire your target with your sight.
- 2: When you are ready to fire, obtain a firm grip of the rifle and draw the rifle tightly against your shoulder.
- 3: Move the safety lever to the “F” (Fire) position
- 4: Press the trigger slowly until the shot is fired.

*Note - The safety cannot be returned to “S” (Safe) after the rifle has been fired. Lift the bolt handle to reset the firing pin onto the sear, then place the safety lever to “S” (Safe).

⚠ WARNING The rifle will fire with or without a magazine seated in the rifle.

Extraction/Ejection

- 1: Lift the bolt handle until rotation stops, then retract the bolt assembly rearward in one continuous motion.
- 2: Once the front of the spent cartridge case clears the front of the ejection port, the bolt’s ejectors will throw the spent case out of the action.
- 3: To chamber a new cartridge, repeat the chambering operation.



VII. CYCLE OF OPERATION CONT.

Unloading

- 1: To unload the Solus rifle, verify the safety is in the “S” (Safe) position, and muzzle is pointed in a safe direction.
- 2: Remove the magazine from the rifle.
- 3: With one hand over the ejection port, your fingers away from the trigger and out of the trigger guard, slowly pull the bolt rearward to extract and eject the cartridge out of the chamber into your hand.
- 4: With the action open, look and physically feel with a finger to ensure the chamber is clear of all ammunition. Do not assume. The action can now be closed, or the bolt assembly removed.



VIII. CLEANING & MAINTENANCE

⚠️ WARNING Before cleaning, make sure your firearm is completely unloaded (chamber clear and the magazine removed) and the safety lever placed in "S" (Safe) position. Failure to follow these instructions may lead to property damage, personal injury and/or death.

⚠️ WARNING After each use, follow the lubrication and maintenance directions in this Owner's Manual.

General Cleaning

After each use of your Solus rifle, thoroughly clean and lubricate it. Handling leaves fingerprints of moisture that can result in the formation of rust. Always wipe receiver, bolt assembly, and barrel with an oiled cloth after handling. All exterior metal surfaces should get a light coat of oil or rust preventative. Any good quality gun lube/CLP should work.

Abrupt temperature changes will cause the formation of condensation and moisture; special care to interior metal parts is needed to prevent rusting. Do not store the rifle overnight in the trunk of a vehicle. Long term storage should be done in a dehumidified gun vault or safe.

Before firing any firearm, be sure to remove all excess lubrication. The chamber and bore must be clean and free of all oils and lubricants.



VIII. CLEANING & MAINTENANCE CONT.

Bore Cleaning – Carbon Deposits

- 1: Insert bore guide to ensure the barrel is free of obstructions.
- 2: Attach a nylon brush to the cleaning rod & apply carbon solvent.
- 3: Run the cleaning rod back and forth through the bore approximately 50 times replacing solvent as needed.
- 4: Replace the nylon brush with a jag and patch to remove the buildup in the bore.
- 5: Continue using patches with carbon remover until patches are no longer dirty. This will vary depending on the amount of carbon in the system.



VIII. CLEANING & MAINTENANCE CONT.

Bore Cleaning – Copper Deposits

*Note - It is only necessary to copper clean your rifle if accuracy is starting to diminish and you are not near the barrel's lifespan or you are storing the rifle for a longer duration of time. You may experience a point of impact shift as well as degradation in accuracy after cleaning until the barrel has been refoiled by copper. This refoiling will occur once you shoot 10 - 15 rounds after cleaning.

- 1: Remove bolt using process outlined in section IV.
- 2: Insert bore guide to ensure the barrel is free of obstructions.
- 3: Attach a nylon brush to the cleaning rod and apply copper solvent. Make sure you only use a nylon brush that has been used for only copper cleaning.
- 4: Run the cleaning rod back and forth through the bore approximately 50 times replacing solvent as needed.
- 5: Replace the nylon brush with a jag and patch to remove the buildup in the bore.
- 6: Continue using patches with copper solvent until patches are clean with a light copper streak. This will vary depending on the amount of copper in the system.

⚠ WARNING After cleaning the bore, always check to see that no part of the cleaning rod or part of a patch remains inside the barrel as an obstruction.

Water Immersion

If the firearm is immersed in water, it must be thoroughly cleaned, dried, and lubricated as soon as possible.

VIII. CLEANING & MAINTENANCE CONT.

Maintenance

The Solus rifle should be checked periodically by a competent gunsmith to ensure proper function and replace any parts which are worn or damaged. Only genuine Aero Precision Solus replacement parts should be used. They are available directly from Aero Precision. **Any alterations, modifications, or the use of non-factory replacement parts will void your warranty and may lead to firearm malfunctions which could result in property damage, severe bodily injury, or death.**



IX. BOLT DISASSEMBLY & REASSEMBLY

Bolt Disassembly

The Solus bolt assembly can be readily disassembled without tools for cleaning and maintenance.

- 1: With the bolt assembly removed from the action, grasp the Bolt Body with one hand and the Firing Pin Shroud with the other.
- 2: Twist the Shroud approximately a ¼ turn clockwise. The Firing Pin assembly will snap free when the retention lugs enter their recesses.

3:

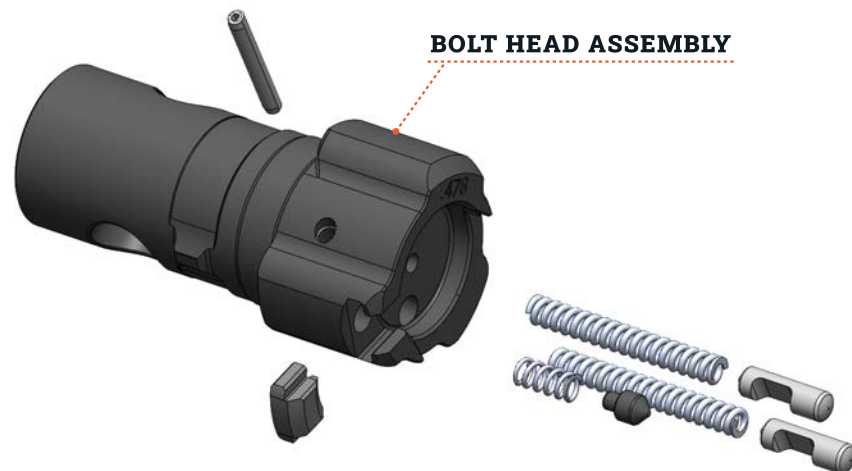


- 4: Once free, the Firing Pin Assembly can be removed from the bolt body.
- 5: With the Firing Pin Assembly removed, the Bolt Head Retaining Pin can be taken out. Slight resistance may be encountered when removing the pin. Applying light pressure to drive the bolt head into the bolt body will allow the retaining pin to drop free.
- 6: The bolt head can now be removed from the bolt body.

IX. BOLT DISASSEMBLY & REASSEMBLY CONT.



⚠ WARNING Use eye protection when working on the bolt head. If the bolt head needs to be disassembled for maintenance, the utmost care must be taken. Ejectors and Extractor are small and under great spring force. These items, if not properly contained during removal and installation, can become airborne projectiles.



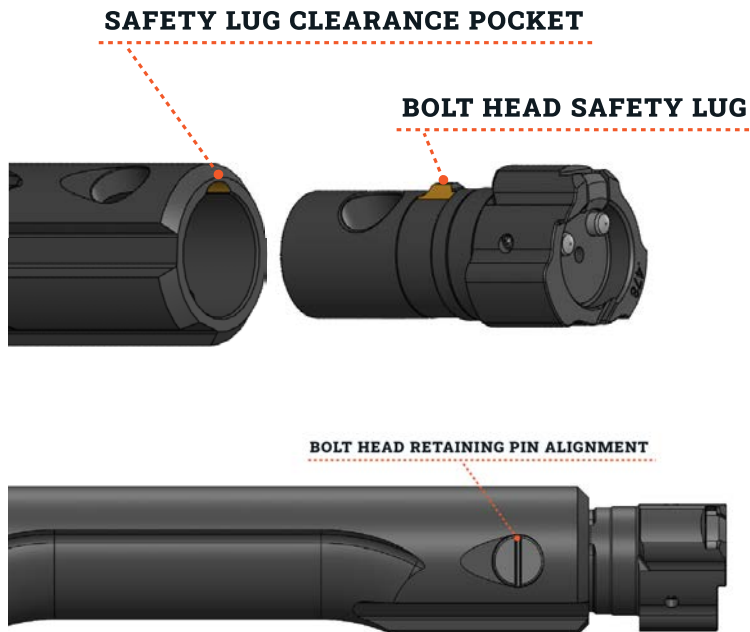
Please contact Aero Precision Customer Support if replacement parts are needed

IX. BOLT DISASSEMBLY & REASSEMBLY CONT.

Bolt Assembly and Reassembly

To reassemble the Bolt Assembly, follow the disassembly process in reverse order.

- When installing the Bolt Head into the Bolt Body, the Safety Lug needs to be aligned and seated within the mating/clearance pocket on the Bolt Body.
- When installing the Bolt Head Retaining Pin, ensure the through hole is in line parallel with the bolt body. This can be confirmed by the groove in the retaining pin head being perpendicular to the bolt.

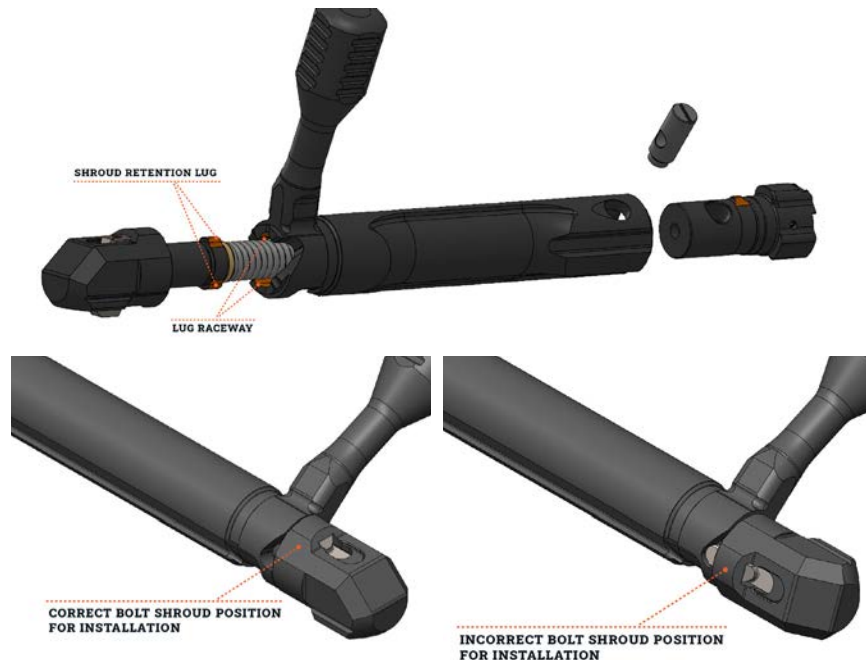


IX. BOLT DISASSEMBLY & REASSEMBLY CONT.

Installing the Firing Pin Assembly

- 1: Align the retention lugs to the appropriately sized recesses (Lugs are two sizes).
- 2: Once aligned, push the Firing Pin Assembly into the rear of the Bolt Body. **An increased amount of force is required to get the Firing Pin Assembly to fully seat.**
- 3: Once seated/compressed, rotate the shroud approximately $\frac{1}{4}$ turn counterclockwise until the detent is engaged.

*Note – Do not over rotate the Firing Pin Assembly in to the “cocked” position. This will prevent you from being able to install the bolt back into the action. You must position the Firing Pin Assembly in to the “neutral” position (see following images).



X. LUBRICATION

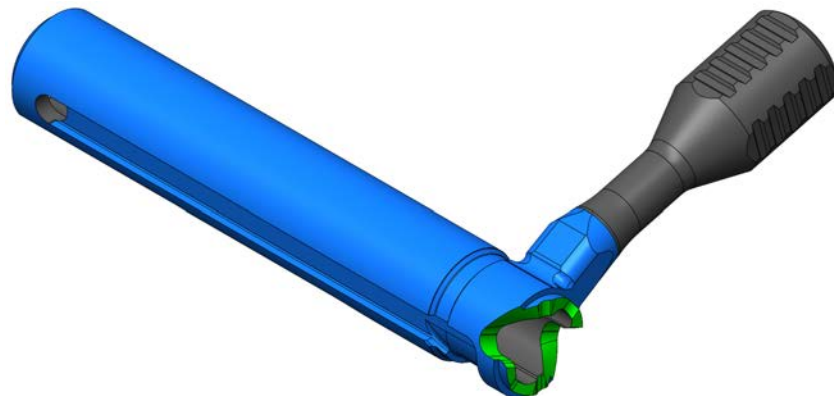
Parts are lubricated and greased from the factory. Callouts are for service and maintenance of the firearm as needed over time as lubrication wears off during use.

Lubricate all areas shown in blue with high-quality gun oil. Apply sparingly, but ample enough to provide an even film on the metal working surfaces.

Lubricate areas shown in green with high pressure grease.



X. LUBRICATION CONT.



XI. ADJUSTMENTS (DEPENDING ON CONFIGURATION)

The following instructions are specific to the Solus Competition Chassis. If your configuration features a different chassis or stock, please refer to the manufacturer's instructions.

⚠️ WARNING Prior to performing any work or adjustments to your Solus rifle, ensure that the magazine is removed, the rifle is free of all ammunition, and the safety lever in the "S" (Safe) position. Failure to follow these instructions could result in property damage, severe bodily injury or death to you or others.

Stock Adjustments

To adjust the Length of Pull of the stock, unscrew the knob until the knob no longer turns.



With the knob fully loosened, use one hand to depress and hold the spring-loaded knob. With the other hand, grasp the Length of Pull/Recoil Pad assembly and lengthen or shorten the stock's length of pull to suit your needs. The length is adjustable in seven $\frac{1}{4}$ " increments. The stock's spring-loaded locking mechanism will engage on each of the seven recesses.

XI. ADJUSTMENTS (DEPENDING ON CONFIGURATION)



Once the desired length has been obtained and the spring-loaded knob has engaged in a locked position, tighten the knob to complete the stock's length of pull adjustment.

XI. ADJUSTMENTS (DEPENDING ON CONFIGURATION)

Adjusting the Comb Riser is accomplished in a similar process using the forward upper knob. After the knob is loosened, the adjustable comb can be raised or lowered. Depressing the knob is not required for the Comb Riser once in the desired position. Tightening the knob secures the riser in place.



*Note - The adjustment knobs are reversible and can be placed on the opposite side of the stock if you choose. Simply remove the retaining set screw located behind the knob, uninstall the locking hardware, and reinstall from the opposite side in the same order it was removed.



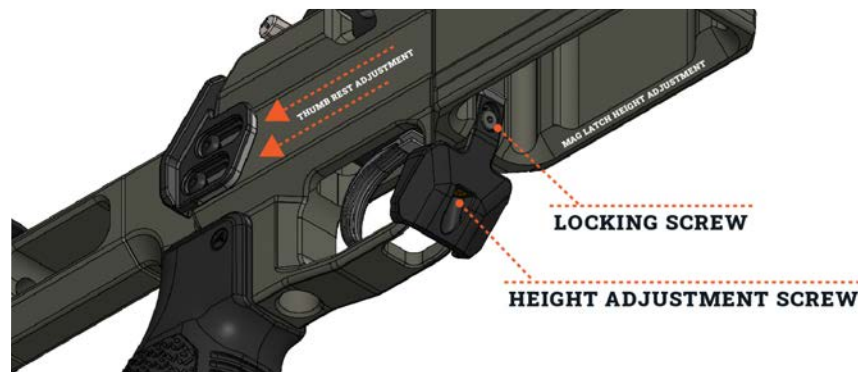
XI. ADJUSTMENTS (DEPENDING ON CONFIGURATION)

Magazine Latch Height Adjustment

The magazine latch height can be adjusted to ensure correct retention and presentation of the magazine. To adjust, simply loosen the Locking Screw two full turns (see following image). Insert your magazine into the magazine well. Tighten the Height Adjustment screw to minimize magazine movement. Test by releasing the magazine a few times through depressing the magazine release. No binding should occur. If binding does occur or the magazine will not drop free, slowly back off the Height Adjustment Screw. Once satisfied with your adjustment, secure the Locking Screw. Use Vibra-Tite VC-3 or Loctite 222 to prevent loosening of the fasteners. Apply no more than 4 in/lbs of torque to the Locking Screw.

Adjustable Thumb Rest Installation

The adjustable thumb rest comes installed on the chassis, to adjust it to your desired position loosen the two #6-32 adjustment screws until you can move the thumb rest back and forth. There is .380" of adjustment frontwards and back. Once the desired position is achieved tighten the top screw to hold the thumb rest in place and apply a light coat of Loctite 222 and torque to no more than 3.5 in/lbs. Repeat process on top screw.



XII. WARRANTY

We provide a lifetime warranty against manufacturing defects and damage caused by the normal use of our products. Aero Precision LLC will repair or replace any products that is has manufactured, sold, or distributed.

This warranty does not cover defects or damage that are not the result of “normal use,” as determined by Aero Precision LLC in its full discretion, including but are not limited to defects and damage resulting from modification of the product, neglect or abuse of the product, improper transportation of the product, improper maintenance of the product, use of defective or improper ammunition, failure to follow the instructions in the product manual, use of the product with incompatible components, and criminal activity. To make a warranty or repair inquiry, contact Aero Precision’s customer service team by visiting aeroprecisionusa.com/contact and submitting a form. DO NOT send or ship products to Aero Precision for repair or replacement without first receiving authorization from Aero Precision’s customer service team. Failure to follow these instructions may void this warranty at Aero Precision’s discretion.

THIS WARRANTY IS EXCLUSIVE AND IN LIEU OF ANY AND ALL OTHER WARRANTIES, CONDITIONS AND REPRESENTATIONS, WHETHER WRITTEN, ORAL, EXPRESS OR IMPLIED, INCLUDING WITHOUT LIMITATION ANY IMPLIED CONDITION, REPRESENTATION OR WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. THIS WARRANTY SHALL CONSTITUTE THE SOLE REMEDY OF THE PURCHASER OR USER OF THE PRODUCT, AND AERO PRECISION LLC SHALL NOT BE LIABLE FOR AN ALLEGEDLY DEFECTIVE OR DAMAGED PRODUCT EXCEPT TO REPAIR OR REPLACE IT IN ACCORDANCE WITH THIS WARRANTY. IN NO EVENT, TO THE EXTENT PERMITTED BY LAW, SHALL AERO PRECISION LLC BE LIABLE FOR CONSEQUENTIAL, CONTINGENT, INCIDENTAL, INDIRECT OR SPECIAL DAMAGES CAUSED OR ALLEGED TO BE CAUSED IN WHOLE OR IN PART BY THE NEGLIGENCE, TORT, STRICT LIABILITY, BREACH OF CONTRACT, BREACH OF WARRANTY, OR OTHER BREACH OF DUTY OF OR BY AERO PRECISION LLC.







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PRODUCT, OR REPLACEMENT PARTS**

OUR EXPERIENCED CUSTOMER SERVICE SPECIALISTS
CAN ANSWER ANY QUESTIONS YOU MAY HAVE ABOUT
PRODUCT RECOMMENDATIONS, OPERATION, OR ANY OTHER
TECHNICAL ISSUES. **PHONE:** (253) 272-8188

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