

INSTRUCTION MANUAL

FOR MAGNUM RESEARCH'S BFR



Big Frame Revolver

STAINLESS STEEL SINGLE ACTION REVOLVER



READ THE INSTRUCTIONS AND WARNINGS IN THIS MANUAL CAREFULLY BEFORE USING THIS FIREARM. THIS INSTRUCTION BOOK SHOULD ALWAYS ACCOMPANY THIS FIREARM WHEN ON LOAN OR WITH CHANGE OF OWNERSHIP.

IMPORTANT SAFETY INFORMATION:

- 1. READ ALL INSTRUCTIONS AND WARNINGS CAREFULLY. BE SURE YOU UNDERSTAND THE INSTRUCTIONS AND WARNINGS BEFORE USING THIS FIREARM. FAILURE TO READ AND FOLLOW THESE INSTRUCTIONS AND WARNINGS MAY RESULT IN SERIOUS INJURY OR DEATH TO YOU AND OTHERS.**
- 2. ALWAYS WEAR PROTECTIVE SHOOTING GLASSES AND EAR PROTECTION WHEN SHOOTING. ESPECIALLY ON A RANGE, WITHOUT EAR PROTECTION THE NOISE OF FIRING CAN LEAD TO CUMULATIVE LONG TERM AND PERMANENT HEARING LOSS.**
- 3. NEVER DRINK ALCOHOLIC BEVERAGES OR TAKE DRUGS BEFORE OR DURING SHOOTING AS YOUR VISION AND JUDGMENT CAN BE SERIOUSLY IMPAIRED, MAKING YOUR GUN HANDLING UNSAFE.**
- 4. THIS MANUAL REFERS TO THE USE OF THE REVOLVER BY CIVILIAN USERS. INSTRUCTIONS FOR LAW ENFORCEMENT USE MAY DIFFER FROM WHAT IS DESCRIBED IN THIS MANUAL. THROUGHOUT THIS INSTRUCTION MANUAL, POSITION DESIGNATIONS SUCH AS “LEFT,” “RIGHT,” “FORWARD,” “REAR” AND SO ON, ARE REFERENCED TO THE FIREARM HELD IN THE NORMAL FIRING POSITION. IN OTHER WORDS, POINTED AWAY FROM THE SHOOTER, BARREL IN A GENERALLY HORIZONTAL DIRECTION AND POINTING DOWNWARDS.**
- 5. EXPLANATIONS IN THIS MANUAL ARE BASED ON RIGHT-HAND OPERATION. LEFT-HANDED USERS SHOULD OPERATE VICE VERSA.**

DISCLAIMER OF LIABILITY

The first concern when handling any firearm is safety. The failure to handle any firearm in a safe manner may result in property damage, serious bodily injury or even death. MAGNUM RESEARCH specifically disclaims any and all liability arising out of the use of this firearm and its accessories. Under no circumstance shall MAGNUM RESEARCH be responsible for incidental or consequential damages with respect to economic loss or injury to person or property due to negligence, improper use, failure to follow instructions in this manual, unsafe handling, failure to maintain the firearm, unauthorized replacement of parts, disregard of statutory rules or laws or any other modification to the firearm.



This SAFETY & INSTRUCTION MANUAL should always accompany this firearm and be transferred with it upon change of ownership or when presented to another person.

Table of Contents

State by State Warnings	4
1. Firearm Safety and Your Responsibility	5
2.1 Lead Warnings	8
2.2 Safe Storage and Transportation.	8
3. Introduction	9
4. Nomenclatures	10
5. Ammunition	10
6. Ammunition Warnings	11
7. Handling Warning	11
8. Firing Warnings	12
9. Uncocking the BFR Revolver.	13
10. Unloading or Ejecting Cartridge Cases.	13
11. Disassembly and Reassembly Warning	14
12. Cylinder Removal and Installation	14
13. Scope Mounting	15
14. Sight Adjustments.	15
15. Lubrication Warning	16
16. Care and Cleaning.	16
16.1 Care of Stainless Steel Firearms.	16
17. Shooting your .500 S&W Magnum BFR.	17
18. Parts List and Exploded View	18-19
19. Service and Shipping	20
20. Alteration Warning	21
21. Installation of the Gun Lock	21
Limited One-Year Warranty.	22
Custom BFR's Availability and Ordering.	22

State by State Warnings

CALIFORNIA:

WARNING: Children are attracted to and can operate firearms that can cause severe injuries or death. Prevent child access by always keeping guns locked away and unloaded when not in use. If you keep a loaded firearm where a child obtains and improperly uses it, you may be fined or sent to prison.

CONNECTICUT:

“UNLAWFUL STORAGE OF A LOADED FIREARM MAY RESULT IN IMPRISONMENT OR FINE.”

FLORIDA:

“IT IS UNLAWFUL, AND PUNISHABLE BY IMPRISONMENT AND FINE, FOR ANY ADULT TO STORE OR LEAVE A FIREARM IN ANY PLACE WITHIN THE REACH OR EASY ACCESS OF A MINOR UNDER 18 YEARS OF AGE OR TO KNOWINGLY SELL OR OTHERWISE TRANSFER OWNERSHIP OR POSSESSION OF A FIREARM TO A MINOR OR A PERSON OF UNSOUND MIND.”

MAINE:

“ENDANGERING THE WELFARE OF A CHILD IS A CRIME. IF YOU LEAVE A FIREARM AND AMMUNITION WITHIN EASY ACCESS OF A CHILD, YOU MAY BE SUBJECT TO FINE, IMPRISONMENT OR BOTH. KEEP FIREARMS AND AMMUNITION SEPARATE. KEEP FIREARMS AND AMMUNITION LOCKED UP. USE TRIGGER LOCKS.”

MARYLAND:

“WARNING: CHILDREN CAN OPERATE FIREARMS WHICH MAY CAUSE DEATH OR SERIOUS INJURY. IT IS A CRIME TO STORE OR LEAVE A LOADED FIREARM IN ANY LOCATION WHERE AN INDIVIDUAL KNEW OR SHOULD HAVE KNOWN THAT AN UNSUPERVISED MINOR WOULD GAIN ACCESS TO THE FIREARM. STORE YOUR FIREARM RESPONSIBLY!”

MASSACHUSETTS:

“WARNING FROM THE MASSACHUSETTS ATTORNEY GENERAL: This handgun is not equipped with a device that fully blocks use by unauthorized users. More than 200,000 firearms like this one are stolen from their owners every year in the United States. In addition, there are more than a thousand suicides each year by younger children and teenagers who get access to firearms. Hundreds more die from accidental discharge. It is likely that many more children sustain serious wounds, or inflict such wounds accidentally on others. In order to limit the chance of such misuse, it is imperative that you keep this weapon locked in a secure place and take other steps necessary to limit the possibility of theft or accident. Failure to take reasonable preventive steps may result in innocent lives being lost, and in some circumstances may result in your liability for these deaths.”

“IT IS UNLAWFUL TO STORE OR KEEP A FIREARM, RIFLE, SHOTGUN OR MACHINE GUN IN ANY PLACE UNLESS THAT WEAPON IS EQUIPPED WITH A TAMPER-RESISTANT SAFETY DEVICE OR IS STORED OR KEPT IN A SECURELY LOCKED CONTAINER.”

NEW JERSEY:

“IT IS A CRIMINAL OFFENSE TO LEAVE A LOADED FIREARM WITHIN EASY ACCESS OF A MINOR.”

NEW YORK CITY:

“THE USE OF A LOCKING DEVICE OR SAFETY LOCK IS ONLY ONE ASPECT OF RESPONSIBLE FIREARM STORAGE. FOR INCREASED SAFETY, FIREARMS SHOULD BE STORED UNLOADED AND LOCKED IN A LOCATION THAT IS BOTH SEPARATE FROM THEIR AMMUNITION AND INACCESSIBLE TO CHILDREN AND OTHER UNAUTHORIZED PERSONS.”

NORTH CAROLINA:

“IT IS UNLAWFUL TO STORE OR LEAVE A FIREARM THAT CAN BE DISCHARGED IN A MANNER THAT A REASONABLE PERSON SHOULD KNOW IS ACCESSIBLE TO A MINOR.”

TEXAS:

“IT IS UNLAWFUL TO STORE, TRANSPORT, OR ABANDON AN UNSECURED FIREARM IN A PLACE WHERE CHILDREN ARE LIKELY TO BE AND CAN OBTAIN ACCESS TO THE FIREARM.”

WISCONSIN:

“IF YOU LEAVE A LOADED FIREARM WITHIN THE REACH OR EASY ACCESS OF A CHILD YOU MAY BE FINED OR IMPRISONED OR BOTH IF THE CHILD IMPROPERLY DISCHARGES, POSSESSES, OR EXHIBITS THE FIREARM.”

PLEASE CHECK WITH YOUR FIREARMS RETAILER OR STATE POLICE FOR ADDITIONAL REQUIREMENTS UNDER STATE OR LOCAL LAWS OR REGULATIONS. SUCH LAWS AND REGULATIONS CHANGE CONSTANTLY, AND LOCAL AUTHORITIES ARE IN THE BEST POSITION TO ADVISE ON SUCH CHANGES.

1. FIREARM SAFETY AND YOUR RESPONSIBILITY

Safety must be the first and constant consideration of every person who handles firearms and ammunition. This Instruction Manual is designed to assist you in learning how to use and care for your revolver properly. Only when you are certain you fully understand the Manual and can properly carry out its instructions should you practice loading, unloading, etc. with live ammunition. If you have any doubts about your ability to handle or use a particular type of gun safely, then you should seek supervised instruction. Such instruction is often available from gun dealers, gun clubs, or police departments. If none of these sources can help you write to the National Rifle Association, Washington, D.C. 20036, they will assist you.

The person with a gun in their possession has a fulltime job; they cannot guess; they cannot forget. They must know how to use their firearm safely. Do not use any firearm without having a complete understanding of its particular characteristics and safe use.

Your Safety Responsibilities

SAFETY IS YOUR NUMBER ONE RESPONSIBILITY!!!!

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. If you feel uncertain about any operational aspects of this firearm, please contact Magnum Research Customer Service Department at 218-746-3459, Monday ~ Friday 9:00 am ~ 4:30 pm Central Time before proceeding with its operation.



WARNING: YOU MUST FOLLOW ALL OF THESE SAFETY RULES TO ENSURE THE SAFE USE OF YOUR FIREARM. THE FAILURE TO FOLLOW THESE BASIC FIREARM SAFETY RULES MAY RESULT IN AN UNINTENDED DISCHARGE WHICH COULD CAUSE SERIOUS PERSONAL INJURY OR DEATH TO YOU OR OTHERS.

● **ALWAYS KEEP YOUR FIREARM POINTED IN A SAFE DIRECTION.** Never point a firearm at anyone or anything you do not intend to shoot, whether or not it is loaded. This is particularly important when loading, unloading, or field stripping the gun. ALWAYS control the direction of the firearms muzzle.

● **ALWAYS TREAT EVERY FIREARM AS IF IT IS LOADED AND WILL FIRE IF THE TRIGGER IS PULLED.** Do not take anyone's word that the firearm is unloaded—always check for yourself. Never pass your firearm to another person until the cylinder or action is open and you visually check that it is unloaded. Keep your firearm unloaded and safely stored when not in use.

● **NEVER PLACE YOUR FINGER INSIDE THE TRIGGER GUARD OR ON THE TRIGGER UNLESS YOU INTEND TO FIRE.**

Ensure that other objects do not touch the trigger.

● **ALWAYS BE SURE OF YOUR TARGET AND WHAT IS BEYOND IT.**

Always be sure of where the bullet will strike and shoot only where there is a safe back stop free of obstructions, water or other surfaces which can cause ricochets. Do not fire into the sky.

● **NEVER CROSS OBSTACLES SUCH AS FENCES OR STREAMS WITH A LOADED FIREARM.**

● **SAFE GUN HANDLING IS YOUR PERSONAL RESPONSIBILITY** at all times.

Firearms are dangerous and can cause serious injury or death if they are misused or used inappropriately. Safety must be the prime consideration of anyone who owns or handles firearms.

Accidents are the result of violating the rules of safe gun handling and common sense. Firearm safety training is available. Contact your dealer, law enforcement agency, local sportsman's club, etc. for availability of appropriate training.

● **YOU ARE RESPONSIBLE FOR THE FIREARM AT ALL TIMES.**

In owning a firearm, you must undertake full-time responsibility for your firearm's safety and security. You must protect yourself and all others against injury or death from misuse of the firearm 24 hours a day.

● **FIREARM SECURITY IS YOUR RESPONSIBILITY.**

You must secure firearms safely from children and/or unauthorized users. Your firearm should always be kept unloaded and locked when not in use. A lock has been provided for this purpose. Never assume that the use of this lock is sufficient to safely secure your firearm. You must always evaluate your personal situation and employ the security system(s) that meet your needs and prevents children and unauthorized users from gaining access to your firearm.

● **APPROPRIATE USE FOR YOUR FIREARM MEANS USING YOUR FIREARM FOR LEGAL PURPOSES.**

For example - target shooting and lawful resistance of deadly criminal force. It is your responsibility to ensure that you are in compliance with all applicable laws and ordinances regarding the use and storage of your firearm.

- **NEVER RELY ON MECHANICAL FEATURES ALONE.**

Only your safe gun handling habits will ensure the safe use of your firearm. This is your responsibility.

- **ALWAYS SAFELY STORE AND SECURE YOUR FIREARM.** Safe and secure storage of your firearm is one of your most important responsibilities. It is a full-time responsibility. You must always secure your firearm and ammunition separately so that they are not accessible to children and/or other unauthorized persons.

- **NEVER KEEP AMMUNITION IN THE SAME LOCATION AS THE FIREARM.** Store each in a separate and secure place.



WARNING: ALWAYS WEAR EYE AND EAR PROTECTION THAT ARE SPECIFIED FOR FIREARM USE EVERY TIME YOU DISCHARGE YOUR FIREARM. MAKE SURE OTHERS IN THE VICINITY OF WHERE YOU WILL BE SHOOTING DO SO ALSO.

- **NEVER USE ALCOHOL OR DRUGS BEFORE OR WHILE SHOOTING.** Do not use your firearm if you are on any medication which impairs, even slightly, your mental or physical ability.

- **ALWAYS HAVE ADEQUATE VENTILATION.** 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, and other serious physical injury. Review the warnings and labels for all ammunition and cleaning products carefully. Wash hands thoroughly after exposure.

- **BEFORE HANDLING ANY FIREARM, UNDERSTAND ITS OPERATION.** Not all firearms are the same. Familiarize yourself with the mechanical features of any firearm you intend to use. If you feel uncertain about any operational aspects of your firearm, please contact MAGNUM RESEARCH at 218-746-3459 before proceeding with its operation.

- **NEVER ALLOW A FIREARM TO BE USED BY INDIVIDUALS WHO DO NOT UNDERSTAND ITS SAFE OPERATION OR HAVE NOT READ THESE FIREARM SAFETY RULES.**

- **ALWAYS USE THE CORRECT AMMUNITION FOR YOUR PARTICULAR FIREARM** as indicated by the marking on the barrel. Never use non-standard, reloaded, or “handloaded” ammunition which has not been subjected to internal ballistic pressure testing.

- **BE SURE ALL ACCESSORIES, SUCH AS HOLSTERS AND GRIPS, ARE COMPATIBLE** with the firearm and that the accessories do not interfere with safe operation.

- **NEVER DISASSEMBLE YOUR FIREARM** beyond the field stripping procedure outlined in this manual. Improper disassembly or reassembly of your firearm may be dangerous and can lead to serious injury or death.

- **NEVER MANIPULATE, ADJUST OR CHANGE ANY OF THE INTERNAL COMPONENTS OF YOUR FIREARM** including the firing pin, sear, or hammer. Improper manipulation or altering of any internal component may affect the safety and reliability of your firearm and may cause serious injury or death.

- **NEVER ALLOW ANY ALTERATION OR REPLACEMENT OF PARTS IN YOUR MAGNUM RESEARCH FIREARM UNLESS PERFORMED BY A QUALIFIED GUNSMITH** using genuine MAGNUM RESEARCH parts. If you do otherwise, improper functioning of your firearm may occur and serious injury or death may result.



WARNING: SAFE USE OF A FIREARM IS YOUR PERSONAL RESPONSIBILITY AND THE FAILURE TO FOLLOW ALL OF THESE BASIC SAFETY RULES MAY RESULT IN SEVERE PERSONAL INJURY OR DEATH TO YOU OR OTHERS. YOU ARE THE MOST IMPORTANT SAFETY DEVICE WHEN IT COMES TO THE USE OF YOUR FIREARM AND MAGNUM RESEARCH WILL NOT BE RESPONSIBLE FOR ANY PERSONAL INJURY, DEATH OR PROPERTY DAMAGE THAT RESULTS FROM:

- (1) THE CRIMINAL OR NEGLIGENT USE OF THIS FIREARM;**
- (2) A DISREGARD OF THESE SAFETY INSTRUCTIONS AND WARNINGS;**
- (3) IMPROPER OR CARELESS HANDLING OF THIS FIREARM;**
- (4) THE USE OF NON-STANDARD, DEFECTIVE, IMPROPER OR RELOADED AMMUNITION; OR**
- (5) IMPROPER OR NEGLIGENT MODIFICATIONS OR REPAIRS TO THE FIREARM.**

2.1 Lead Warnings

WARNING - LEAD EXPOSURE

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

FIRING OR CLEANING HAND GUNS MAY EXPOSE YOU TO LEAD.

2.2 Safe Storage and Transportation



WARNING: FIREARMS ARE DANGEROUS WHEN USED AND STORED IMPROPERLY THEY POSE A RISK OF SERIOUS OR FATAL INJURIES. FIREARMS CAN BE ESPECIALLY DANGEROUS TO CHILDREN WHEN THEY ARE STORED IN AN IRRESPONSIBLE AND UNSAFE MANNER. FOR YOUR SAFETY AND THE SAFETY OF OTHERS, IT IS IMPERATIVE THAT YOU KEEP YOUR FIREARM LOCKED AND UNLOADED IN A SECURE PLACE. THE AMMUNITION SHOULD BE STORED IN A SEPARATE, SECURE LOCATION WHEN IT IS NOT IN USE. SAFE AND SECURE STORAGE OF YOUR FIREARM IS ONE OF THE MOST IMPORTANT RULES OF FIREARM SAFETY. YOUR FAILURE TO FOLLOW THESE RULES MAY RESULT IN SERIOUS INJURY OR DEATH TO YOU OR OTHERS.

- **ALWAYS SECURE YOUR FIREARM IN A MANNER THAT WILL PREVENT UNAUTHORIZED ACCESS.**

Whenever your firearm is not in use, keep it unloaded and locked. Your safety and the safety of others requires that you always secure and store your firearm in a manner that will prevent unauthorized access. Never leave a firearm unattended unless it is locked, unloaded, and secured.

- **ALWAYS USE THE LOCK PROVIDED BY MAGNUM RESEARCH TO SECURE YOUR FIREARM.** Please read and follow the instructions packaged separately for the use of this lock. A lock, when properly used, can be an effective tool in preventing unauthorized access to your firearm. There are other alternative locks and safe storage containers available in the marketplace which may also be appropriate for your particular needs. Consult your local gun shop, hardware store, or local police department for guidance on the variety of other safe storage devices or practices which may be appropriate for your particular needs. By purchasing this firearm you have accepted the responsibility of safely securing the firearm at all times and preventing its unauthorized use. Never

assume that the use of this lock alone is sufficient to safely secure your firearm. It is your personal responsibility to select and use whatever measures or practices that will enable you to be absolutely certain that your firearm is secure at all times.



WARNING: NEVER LOCK A LOADED FIREARM AND NEVER LOAD A LOCKED FIREARM!!

● **ALWAYS STORE YOUR FIREARM AND AMMUNITION SEPARATELY** so that they are not accessible to children or other unauthorized persons. Safe and secure storage of your firearm and ammunition are your responsibility. It is a full-time responsibility.

● **NEVER ASSUME THAT A “HIDING” PLACE IS A SECURE STORAGE METHOD.**

Others may be aware of your storage location or come upon it by chance. It is your personal responsibility to use common sense when storing your firearm and ammunition and to always make sure they are not accessible to children or other unauthorized persons.

● **NEVER TRANSPORT A LOADED FIREARM.**

When transporting your firearm, be sure it is unloaded and locked. Safe and secure transportation of your firearm is your responsibility.

● **ALWAYS FOLLOW THE LAW!**

Many jurisdictions have laws that make it a crime to keep a firearm unlocked and in an area accessible to children or others. Keeping a firearm locked and unloaded when not in use is not only common sense safety practice... IT IS THE LAW. You must be familiar with all local, state, and federal laws regarding the safe storage and transportation of your firearm. Failure to know and follow the law may result in unauthorized access or use of your firearm by another. Obey all laws relating to the storage and transportation of firearms. Your local police department or gun shop can furnish you with available information on storing and/or transporting a firearm safely and legally.

● **YOUR FIREARM IS YOUR RESPONSIBILITY.**

You must prevent your firearm from being stolen or from being used by untrained or unqualified individuals. Keep it locked, unloaded and secured when not in use.

FIREARMS ARE DANGEROUS - READ THE INSTRUCTIONS AND WARNINGS IN THIS MANUAL THOROUGHLY AND CAREFULLY BEFORE USING THIS FIREARM.

3. INTRODUCTION

The mechanism of Magnum's BFR differs significantly from that of most single action revolvers. The information and instructions which follow apply ONLY to the BFR model revolver. A careful reading of this manual will help you to understand the logic of the revolvers mechanism and to make full use of the advantages which it provides.

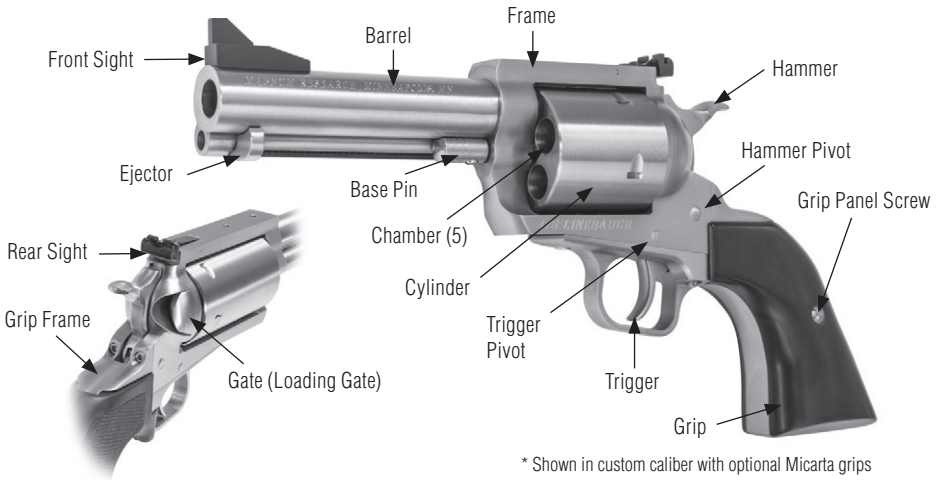
Unlike the earlier single action revolvers that had four hammer positions, the BFR has only TWO hammer positions, cocked and all the way forward (uncocked).

The revolvers mechanism incorporates a transfer bar. The transfer bar; which is raised into firing position as the trigger is pulled to the rear, transmits the energy of the hammer blow to the firing pin. This transfer bar mechanism makes a “safety” notch unnecessary.

The gate (loading gate) can be opened only when the hammer and trigger are fully forward. Opening the gate immobilizes the trigger, hammer, and transfer bar.

When the gate is opened, the cylinder is unlatched and can be turned by the hand for loading or ejection. When the gate is closed, the cylinder latch functions in the normal manner. The loading notch is therefore unnecessary in the revolver's design.

4. NOMENCLATURES



5. AMMUNITION

STANDARD MODELS:

CALIBER/MODEL

.30/30 Winchester
 .444 Marlin
 .44 Magnum
 .45LC/410
 .45/70 Gov't
 .454 Casull
 .460 S&W
 .500 S&W

AMMUNITION

.30/30 Winchester
 .444 Marlin
 .44 Magnum
 .45 Colt/.410 Shotshells (up to 3")
 .45/70 Gov't
 .454 Casull
 .460 S&W
 .500 S&W

CUSTOM MODELS:

The below custom calibers are available by special order only. For ordering information please contact our customer service personnel at 218-746-3459, 9:00 am to 4:30 pm M~F Central Time. For additional information on custom models, see pages 24 ~ 25 of this manual.

CALIBER/ MODEL

.30 Carbine
 .300 AAC Blackout
 .375 JDJ
 .375 Winchester
 .38/55 Winchester
 .445 Super Mag
 .45 ACP
 .45 Long Colt
 .45/90 Winchester
 .450 Bushmaster
 .450 Marlin
 .475 Wildey
 .480 Ruger/.475 Linebaugh
 .499 LWR
 .50 Beowulf
 .50 G.I.
 .500 JRH

AMMUNITION

.30 Carbine
 .300 AAC Blackout
 .375 JDJ
 .375 Winchester
 .38/55 Winchester
 .445 Super Mag
 .45 ACP
 .45 Long Colt
 .45/90 Winchester
 .450 Bushmaster
 .450 Marlin
 .475 Wildey
 .480 Ruger/.475 Linebaugh
 .499 LWR
 .50 Beowulf
 .50 G.I.
 .500 JRH

6. AMMUNITION WARNINGS

It is extremely dangerous to use a cartridge whose pressure is greater than that developed by cartridges loaded to Industry standards. Even the strongest firearm can be damaged as a result of excessive pressure.

- **BFR 45LC/410 CHOKE:** Remove choke when firing .45 Long Colt bullets or .410 slugs. Chokes are to be used only when firing shot shells.
- **BFR 500S&W:** If deciding to reload at your own personal risk it is very critical that the correct primer is used. Do not use pistol primers in casings with rifle primer pockets and vice versa.

DISCLAIMER:

MAGNUM RESEARCH SPECIFICALLY DISCLAIMS RESPONSIBILITY FOR ANY DAMAGE OR INJURY WHATSOEVER OCCURRING IN CONNECTION WITH, OR AS THE RESULT OF, THE USE IN BFR REVOLVERS OF FAULTY, OR NON-STANDARD, OR REMANUFACTURED OR HAND LOADED (RELOADED) AMMUNITION, OR OF CARTRIDGES OTHER THAN THOSE FOR WHICH THIS FIREARM WAS ORIGINALLY CHAMBERED.

NOTE: THE USE OF HAND LOADED (RELOADED) AMMUNITION WILL VOID THE PRODUCT WARRANTY.

CARRYING:

The MAGNUM RESEARCH BFR may be carried with all chambers loaded. When the hammer and trigger are fully forward at the same time, the transfer bar is lowered out of firing position and the hammer rests directly on the frame, not on the firing pin. See Handling Warning.

7. HANDLING WARNING

Do not load the revolver until you are ready to use it.

NEVER CARRY ANY REVOLVER WITH THE HAMMER COCKED OR WITH THE TRIGGER HELD TO THE REAR.

If the trigger is held to the rear, the gun can fire if the hammer strikes the transfer bar. Note that it need not be a deliberate effort to pull the trigger. Any situation where the trigger attains its rearward position and permits the transfer bar to be interposed between the hammer and the firing pin can cause the cartridge under the firing pin to discharge if the hammer falls or is struck. **NEVER DROP OR STRIKE ANY REVOLVER, COCKED OR UNCOCKED, OR CARRY OR HANDLE A REVOLVER IN SUCH A MANNER THAT THE HAMMER WILL BE STRUCK.**

TO LOAD AND FIRE:

NOTE: The loading gate cannot be opened unless the hammer and trigger are fully forward.

1. Open the gate (see right photo).
2. Turn the cylinder clockwise or counter-clockwise, by hand, and insert cartridges into chambers.
3. Close the gate and rotate the cylinder until it locks. The revolver is now in its normal carrying condition - Hammer and trigger fully forward and the transfer bar automatically lowered out of firing position.
4. The revolver is now ready to be fired. Keep the muzzle pointed in a safe direction. To fire the revolver; the hammer must first be manually cocked and then the trigger must be squeezed. That sequence must take place to fire each shot.





WARNING: WHEN COCKING THE HAMMER; HAVE A FIRM HOLD ON THE GRIP WITH THE SHOOTING HAND. DO NOT TOUCH THE TRIGGER WHILE COCKING THE HAMMER. TOUCH THE TRIGGER ONLY WHEN YOU ARE READY TO FIRE.

CAUTION: “ALWAYS” KEEP THE MUZZLE POINTED IN A SAFE DIRECTION WHEN HANDLING ANY FIREARM.

COCKING: With the fore portion of the thumb firmly on the hammer spur; draw the hammer fully to the rear until it stops. Then permit the hammer to move forward until the trigger engages in the hammer at full cock. Do not speed cycle the hammer. Damage to the cylinder will result. This damage is not covered by the warranty.

FIRING: Once the hammer has been cocked, a light pressure on the trigger will disengage the trigger from the hammer. The hammer will fall forward and the revolver will fire.

CAUTION: Recoil of any center fire caliber causes the muzzle of the gun to flip upward with substantial force. You must maintain a ‘firm’ grip on the BFR at all times when firing.



“PROPER WAY TO HOLD A BFR”

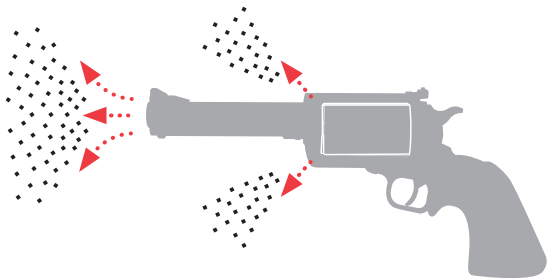
Improper way to hold the revolver is likely to result in serious personal injury from the firing gases and particles.

8. FIRING WARNINGS



WARNING: HOT HIGH PRESSURE GASES AND GUNPOWDER PARTICALS EXIT THE BARREL AND CYLINDER GAP WHEN ANY REVOLVER IS FIRED TO AVOID SERIOUS INJURY:

When firing any revolver, be sure all persons are at a safe distance to the rear of the shooter. When fired, all revolvers discharge gas and particles through the clearance gap between the cylinder and rear of the barrel. When firing any revolver always be certain that nothing (including your hands) is in the path of the hot gas and particles which discharge from the front and sides of the cylinder. Keep both hands behind the front of the trigger guard.



CAUTION: WHEN SHOOTING, ADEQUATE EYE PROTECTION IS ESSENTIAL. SHOOTERS AND BYSTANDERS MUST WEAR SAFETY GLASSES AND HEARING PROTECTION. EXPOSURE TO SHOOTING NOISE CAN DAMAGE HEARING.

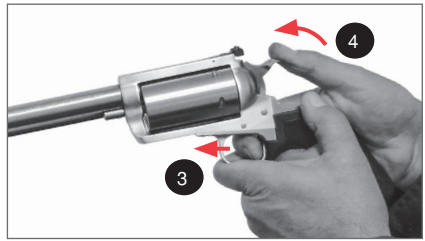
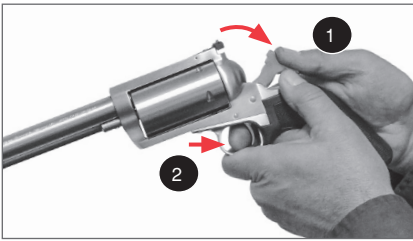


9. UNCOCKING THE BFR REVOLVER

If the revolver is cocked and you wish to let the hammer down to its forward position (against the frame) proceed as follows:

USE EXTREME CARE WHEN ATTEMPTING TO DECOCK THE REVOLVER AS THE THUMB SLIPPING DURING THIS PROCESS MAY RESULT IN AN ACCIDENTAL DISCHARGE IF THE TRIGGER IS HELD TO THE REAR.

1. Point the revolver in a safe direction and make sure both hands are dry and not impeded in anyway.
2. Grasp the revolver, if right handed, so that the thumb and forefinger of your left hand are firmly holding the frame; forward of the trigger guard. Your left hand is in full control of the revolver.
3. With your right thumb securely in control of the hammer squeeze the trigger only enough to permit the hammer to “break free” of the trigger. **IMMEDIATELY RELEASE THE TRIGGER-SLOWLY PERMITTING THE HAMMER TO SLOWLY MOVE FULLY FORWARD AND THE TRANSFER BAR TO DROP OUT OF POSITION.** The trigger and hammer will move towards their rest positions.



- A. With the thumb controlling the hammer as shown above (1), squeeze trigger slowly and just enough to permit the hammer to “break free” (2).
- B. When hammer is free, IMMEDIATELY release trigger (3). Then lower the hammer slowly to its resting position completely down against frame (4).

10. UNLOADING OR EJECTING CARTRIDGE CASES

1. If the hammer is cocked, it must be decocked.
2. Open the gate.
3. Turn the cylinder in either direction by hand to align a chamber with the ejector rod. Push the ejector rod rearward using the thumb-piece on the rod toward the fired casing. Repeat until all chambers are empty. Do not eject unfired cartridges onto any surface where the cartridge primer might strike a solid object discharge.
4. Re-Check all cylinder chambers to make sure they are empty.

11. DISASSEMBLY AND REASSEMBLY WARNING

Never clean, lubricate, disassemble or work on a revolver while it is loaded. Never install or remove a loaded cylinder. A loaded cylinder can discharge if dropped or struck.

CAUTION: The user of a revolver should contact Magnum Research Customer Service at 218-746-3459 BEFORE attempting to take the gun apart beyond cylinder removal for normal cleaning. It is essential that the disassembly and reassembly operations be carried out with knowledge and care.

12. CYLINDER REMOVAL AND INSTALLATION



WARNING: NEVER ATTEMPT TO REMOVE OR REPLACE A LOADED CYLINDER.

1. Ensure all cylinder chambers are empty.
2. Open gate (make sure hammer is not cocked).
3. Unscrew cylinder-pin screw 4 turns and withdraw the cylinder-pin.
4. Remove cylinder from loading gate side of frame.
5. To reinstall the cylinder - simply reverse the above procedure. Holding the gun with the barrel pointed away from you and in a safe direction, rotate the cylinder one-fourth turn in a clockwise direction to ensure that the pawl is correctly positioned on the cylinder ratchet. Cylinder pin (base pin) should be replaced with no binding.
6. Be sure the set screw in the cylinder pin is FLUSH when installed. If NOT installed correctly revolver will not function properly.

DRY-FIRING: THIS REVOLVER SHOULD NOT BE DRY FIRED.

FANNING: NEVER fan the revolver. Fanning is an unsafe way to fire a gun and is abusive to the revolvers mechanism.



“PROPER” INSERTION OF THE BASE PIN

This photograph shows the base pin head fully seated against the frame and the base pin screw fully seated into the barrel indent. (Barrel indent can be easily seen when the base pin is removed.)



“IMPROPER” INSERTION OF THE BASE PIN

This photograph shows a gap between the base pin head and the frame. At the same time the base pin screw, though tight, is not seating into the barrel indent. This will cause the gun to malfunction.

13. SCOPE MOUNTING

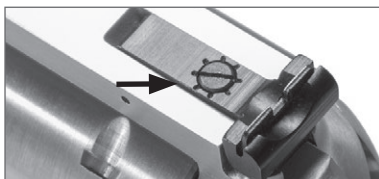
To install a scope on the BFR revolver:

1. Remove rear sight:
 - a. Drift out the 1/16th inch pin.
 - b. Loosen elevation screw until sight assembly comes off. *Be sure to remove slowly - there are two small springs under the sight which can be easily lost.
2. Remove plug screws.
3. Place scope base on the top of the frame. Screw holes will line up easily.
4. Place a drop of red Loctite 271® on each of the screws before installing to ensure the base will not loosen under recoil.
5. Tighten screws.

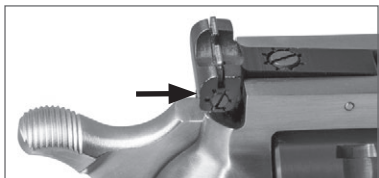


14. SIGHT ADJUSTMENTS

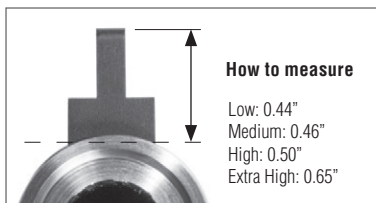
1. To raise point of impact, turn elevation screw on the rear sight counterclockwise.
2. To lower point of impact, turn elevation screw clockwise.
3. Move the rear sight the direction you want the bullet to go.
4. To move point of impact to the right, turn windage screw on the rear sight counterclockwise.
5. To move point of impact to the left, turn windage screw clockwise.



Elevation adjustment screw is located on the top of the rear sight.



Windage adjustment screw is located on the right side of the rear sight.



OPTIONAL SIGHT HEIGHTS: Various front sight heights are available for order from the Magnum Research. Email us at info@magnumresearch.com or contact our customer service department at 218-746-3459 for information, pricing and to place an order.

NOTE: IN ADDITION TO SIGHT ADJUSTMENTS, BARREL LENGTH, AMMUNITION, AND PERSONAL GRIP CONTROL WILL AFFECT THE POINT OF THE BULLET'S IMPACT.

15. LUBRICATION WARNING

Firing a revolver with oil, grease, or any material even partially obstructing the bore may result in damage to the revolver and injury to the shooter and those persons nearby.

DO NOT spray or apply lubricants directly on ammunition. If the powder charge of a cartridge is affected by the lubricant, it may not be ignited but the energy from the primer may be sufficient to push the bullet into the bore where it may lodge. Firing a subsequent bullet into the obstructed bore may damage the revolver and cause injury to the shooter or those nearby.

NOTICE: THE CHAMBERS IN THE CYLINDER MUST BE DRY FOR PROPER FUNCTION

USE LUBRICANTS PROPERLY. You are responsible for the proper care and maintenance of your firearm.

16. CARE AND CLEANING

ALWAYS BE CERTAIN THE REVOLVER IS UNLOADED BEFORE CLEANING.

The revolver's internal mechanism can be lubricated without disassembly. A few drops of oil, which is recommended as suitable for firearms, applied periodically about the various frame openings, will work its way into the mechanisms parts. The exterior of the revolver should be cleaned with a solvent and wiped with an oily patch, followed by a clean dry patch. **DO NOT APPLY EXCESS LUBRICATION. DO NOT PUT OIL ON THE GRIPS**

To clean the revolver after firing, remove the cylinder and clean the barrel from the muzzle by running a cleaning rod with a solvent coated patch through the bore several times until all metal fouling is removed. Then wipe the rod clean and using a dry patch swab the bore until it is clean. Repeat above procedure for all chambers in the cylinder.

16.1 Care of Stainless Steel Firearms

Firearms made of stainless steel are more resistant to corrosion than blued steel firearms. However, in the interest of proper operation and the long life of your FIREARM, please remember to inspect it frequently. You should clean, lubricate and apply an appropriate rust preventative as required. Stainless steel will rust if not cared for properly.

Contact with some types of holsters can cause stains or rusting. Rusting may also occur as a result of the handgun being exposed to moisture, humidity, salt or chemicals. Exposed surfaces on the firearm should be cleaned and wiped dry after exposure to adverse conditions. If a firearm is to be stored, coat with a light film of oil or preservative.

17. SHOOTING YOUR .500 S&W MAGNUM BFR

For those who purchase the new BFR in .500 S&W Magnum, it comes with two front sights. The factory installed “high” front blade will accommodate most shooting styles. Because of the wide variety of bullet weights available, individual shooting styles, and different shooting distances the extra-high front sight may be necessary when using the heavier bullet weights.

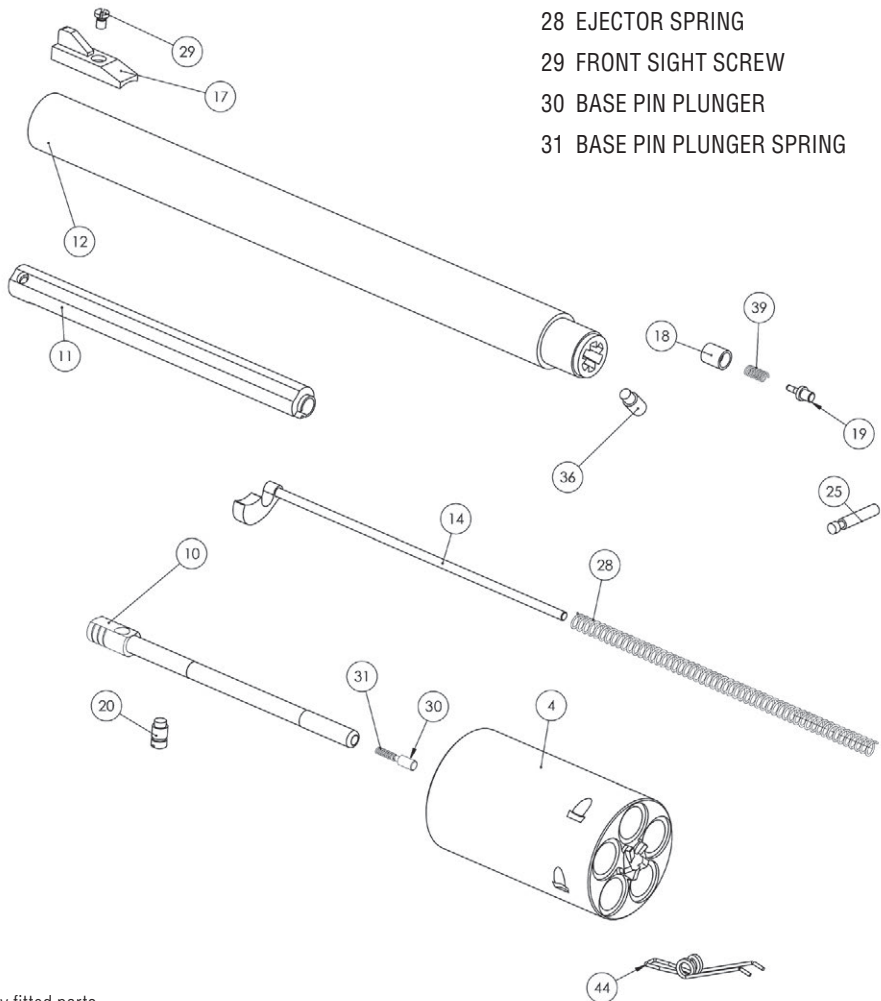
The basic rule in getting your BFR properly zeroed in is this – Move the rear sight the same direction you want the bullet to go. (The reverse of this rule applies to the front sight.)

After firing a preliminary group you can determine which way to move the rear sight. If your group is lower than your point of aim you need to move your rear sight up. If your group is higher than your point of aim you need to move your rear sight down. If you are unable to obtain a reasonable zero with one of the specific loads at your specific distance it may be necessary to replace the high sight on the BFR with the extra high front sight that came with your BFR. Our testing has shown that with the 440-grain load this may be necessary.

If you install the extra-high front sight and your gun is now shooting lower than you would like, simply file a small amount of metal from the top of the extra-high front sight. In this manner you can precisely adjust the sights for your individual shooting style as well as for the loads you wish to shoot.

18. Parts List and Exploded View

- | | | |
|-------------------|------------------------|----------------------------|
| 1 LONG RECEIVER * | 9 GATE * | 18 RECOIL PLATE * |
| 2 TRANSFER BAR * | 10 LONG BASE PIN | 19 FIRING PIN * |
| 3 CYLINDER LATCH | 11 EJECTOR ROD HOUSING | 20 BASE PIN SCREW |
| 4 LONG CYLINDER * | 12 BARREL | 21 MAIN SPRING |
| 5 TRIGGER * | 13 HAMMER STRUT | 22 REAR SIGHT ASSY |
| 6 HAMMER * | 14 EJECTOR ROD ASSY | 23 REAR SIGHT PIN |
| 7 PAWL | 15 MAIN SPRING SEAT | 24 HAMMER PIVOT PIN |
| 8 GRIP FRAME | 16 RUBBER GRIPS | 25 TRIGGER PIVOT PIN |
| | 17 SHORT FRONT SIGHT | 26 GATE SPRING |
| | | 28 EJECTOR SPRING |
| | | 29 FRONT SIGHT SCREW |
| | | 30 BASE PIN PLUNGER |
| | | 31 BASE PIN PLUNGER SPRING |



* Factory fitted parts

32 PAWL PLUNGER

33 TRIGGER SPRING RETAINING PIN

34 CYLINDER LATCH PLUNGER

35 TRIGGER SPRING PIVOT PIN

36 EJECTOR ROD HOUSING SCREW

37 GRIP FRAME SCREW BOTTOM (2)

38 GRIP FRAME SCREW FRONT (3)

39 FIRING PIN REBOUND SPRING *

40 CYLINDER LATCH SPRING

41 PAWL ROLL PIN *

42 GRIP PANEL DOWEL

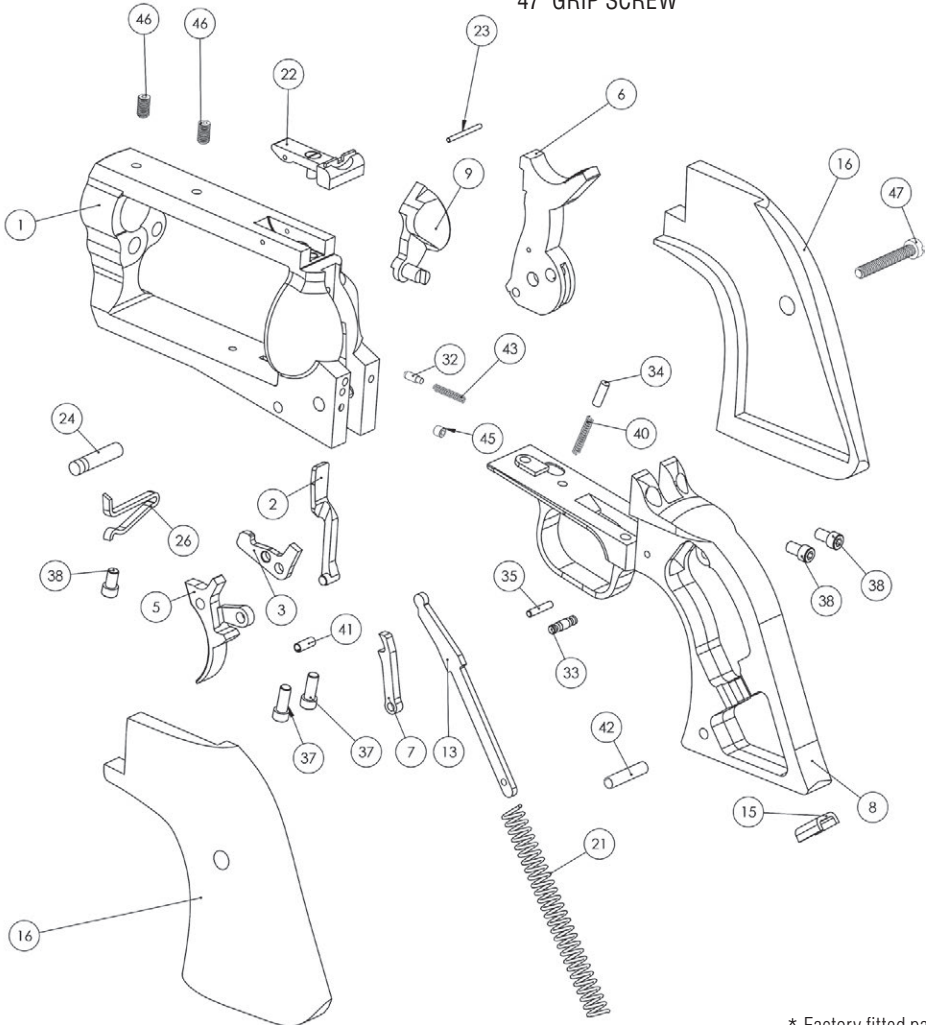
43 PAWL SPRING

44 TRIGGER RETURN SPRING

45 HAMMER PIN SET SCREW

46 SCOPE MOUNT PLUG SCREW (2)

47 GRIP SCREW



* Factory fitted parts

19. SERVICE AND SHIPPING

Before returning any products please contact:

Magnum Research®, Inc. (MRI)
Customer Service Department Phone: 218-746-3459 / Fax: 218-746-3097
12602 33rd Avenue SW, Pillager, MN 56473
E-mail: info@magnumresearch.com

Customer service personnel are available by phone Monday thru Friday (except holidays) from 9:00am to 4:30pm Central Time.

IF YOU NEED TO RETURN A FIREARM OR OTHER PRODUCT FOR SERVICE:

- Call or e-mail the Customer Service Dept. for a Return Authorization Number (RMA#) and shipping instructions. (An RMA# is required for ALL return shipments.)
- Ensure that the firearm is unloaded.
- DO NOT SHIP ANY AMMUNITION TOGETHER WITH THE FIREARM.
- Enclose a legible letter together with your firearm which includes:
 - A) Your RMA#
 - B) Full name and address (no P.O. Boxes, please)
 - C) Daytime telephone number & e-mail address
 - D) Serial number of the firearm
 - E) A clear explanation of the problem experienced or the type of work desired.
 - F) Include information about the ammunition used, to include the brand, bullet weight, type and lot number used when the problem occurred.
- Remember to make a record of the serial number before shipping, in case you wish to check on the repair status of your firearm prior to its return.
- Please remove all custom parts and accessories, such as special sights, or holsters from your firearm before returning it.
- Place the firearm in its original case or in a similarly secure container and pack securely.
- When returning a firearm you need to ensure that any loose items are wrapped and packed well so that they do not rub against or contact the firearm or each other during shipment. Magnum Research Inc. is not responsible for damage caused by customers improper packing or shipping.
- The package must NOT bear any markings which indicate the identity of the contents.
- It is most important that you comply with federal, state, and local laws and regulations. The following guidelines are meant to help, but you must seek assistance from the appropriate authorities if necessary.
- Do not attempt to ship a firearm via US Postal Service; only federally licensed dealers may ship a firearm by US Postal Service.
- If your firearm must be replaced, it may be necessary to ship the replacement to a dealer rather than directly to you. You will be requested to furnish a signed FFL (Federal Firearms License) from your dealer in such an instance.

- Non-Warranty work will be billed and payment received prior to return of the firearm. For estimates call our service dept at 218-746-3459. Customer service personnel are available by phone Monday thru Friday (except holidays) from 9:00 am to 4:30 pm Central Time.

RETURNS SHOULD BE ADDRESSED TO:

M.R.I.
ATTN: Customer Service Dept.
12602 33rd Avenue SW, Pillager, MN 56473
Phone: 218-746-3459

IMPORTANT: If the firearm is returned for servicing, please do not send custom holsters, custom gun cases, scopes, etc. as we cannot accept responsibility for possible damage or loss caused in transit.

Correspondence must include serial number, contact name, RMA#, email address, daytime phone number and complete return shipping address along with as much detail as to why you are sending your product in. Please include brand of ammunition, bullet weight and style and lot number of the ammunition you were using.

Should you need further assistance please contact our Customer Service Department at 1-218-746-3459, Monday - Friday, 9:00 am - 4:30 pm Central Time.

20. ALTERATION WARNING



ACCESSORIES FOR YOUR MRI FIREARM ARE AVAILABLE EITHER FROM MAGNUM RESEARCH OR OUR WEBSITE. IF YOU ARE NOT COMFORTABLE WITH FITTING OR INSTALLING THESE ACCESSORIES PLEASE USE A QUALIFIED GUNSMITH OR RETURN YOUR FIREARM TO MRI. NEVER ATTEMPT TO MODIFY YOUR FIREARM OR INSTALL AFTER MARKET PARTS IN IT. ALWAYS USE MAGNUM RESEARCH GUNSMITHS EVEN IF THE REPAIR SEEMS TO BE SIMPLE. IF YOU HAVE ANY QUESTION, PLEASE CONTACT OUR SERVICE DEPARTMENT.

21. INSTALLATION OF GUN LOCK



WARNING: DO NOT LOCK A LOADED FIREARM.

1. Ensure the firearm is unloaded. (See this manual section “Unloading or Ejecting Cartridge Cases”)
2. With the gate open, insert the cable through the empty cylinder chamber near the base of the open gate. NOTE: This revolver will not fire when gate is open and locked in this manner.
3. To Lock: With the Key turned to the farthest clockwise position, insert the loose end of the cable into the padlock. Turn the key counter-clockwise and remove the key.
4. Check that the cable is securely fastened.
5. Store the key in safe place away from children and unauthorized users.



LIMITED ONE-YEAR WARRANTY

Magnum Research®, Inc. firearms are warranted to be free from defects in material and workmanship. Any such defect of which Magnum Research®, Inc. is given written notice as provided below within one year and ten days from the date of first purchase by customer will be remedied by Magnum Research®, Inc.

Warranty claims (in writing) and the firearm concerned should be shipped (freight prepaid), to the Customer Service Department, Magnum Research®, Inc., 12602 33rd Avenue SW, Pillager, MN 56473. Phone: 218-746-3459.

Warranty claim letters should state the model and serial number of the gun concerned, the Return Authorization Number (RMA#), a description of the difficulty experienced, the date of purchase, your name, billing address, a daytime phone number, and email address. It is recommended to use a delivery service able to track and insure your return item. Magnum Research®, Inc. cannot accept no responsibility for loss or damage in transit.

Return transportation and insurance charges will be paid by Magnum Research®, Inc. if the related claim is found to be covered by warranty.

Under no circumstances shall Magnum Research®, Inc. be responsible for incidental or consequential damages with respect to economic loss or injury to property, whether as a result of breach of express or implied warranty, negligence or otherwise. Some states do not allow the exclusion or limitation of incidental or consequential damages, so the above limitation may not apply to you. Magnum Research®, Inc. will not be responsible for result of careless handling, unauthorized adjustments, defective, low quality, reloaded or improper ammunition, corrosion, neglect, ordinary wear and tear, or unreasonable use. Furthermore, the liability of Magnum Research®, Inc. under this warranty shall be limited solely to the obligation to repair or replace the firearm and to pay the related transportation charge to the facility of Magnum Research®, Inc.

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

EXAMPLES OF WHAT IS “NOT” COVERED BY THIS WARRANTY

- Failure to provide proper care and maintenance
- Hand loaded, reloaded or improper ammunition
- Unauthorized adjustments, repairs or modifications
- Accidents, abuse or misuse
- Barrel obstruction
- Normal wear and tear

CUSTOM BFR’S and BFR CUSTOMIZATION Availability and Ordering

The famous BFR revolver is available in one of a kind unique calibers and/or configurations and two frame sizes. The discriminating shooter or collector can have the BFR “built to order” within a reasonable delivery time. Most guns ordered can be shipped in less than 6-weeks.

MRI’s Precision Center BFR 5 shot hunting revolvers start with our own super strong magnum frame and cylinder. Both are machined from 17-4 PH stainless steel, which is very tough and very corrosion resistant. BFR’s are made 100% in the USA with American steel. They are designed for accuracy and durability and feature button rifled stainless steel barrels.

The actions on the custom series are hand honed and polished for smoothness, feature deep cut caliber engraving on the frame, have .002" barrel-cylinder gap and have the cylinders precisely aligned and gauged with the barrel prior to barrel installation. They also sport a minimum creep 2.5 to 3 pound trigger pull.

In addition to custom calibers, the following custom options are available:

- Octagon barrels
- Fluted barrels
- Fluted cylinders
- Magnum Eagle logo on top strap
- Customers initials on the frame
- Custom two piece grips – Micarta
- Round and slim down grip frame (includes Micarta grip panels)
- Special barrel lengths under 10 inches

Additionally, the custom shop will consider/quote any job that doesn't damage the integrity or performance of the finished revolver.

AVAILABLE CUSTOM MODELS: (Available in long and short frame sizes)

CALIBER/ MODEL	AMMUNITION
.30 Carbine	.30 Carbine
.300 AAC Blackout	.300 AAC Blackout
.375 JDJ	.375 JDJ
.375 Winchester	.375 Winchester
.38/55 Winchester	.38/55 Winchester
.445 Super Mag	.445 Super Mag
.45 ACP	.45 ACP
.45 Long Colt	.45 Long Colt
.45/90 Winchester	.45/90 Winchester
.450 Bushmaster	.450 Bushmaster
.450 Marlin	.450 Marlin
.475 Wildey	.475 Wildey
.480 Ruger/.475 Linebaugh	.480 Ruger/.475 Linebaugh
.499 LWR	.499 LWR
.50 Beowulf	.50 Beowulf
.50 G.I.	.50 G.I.
.500 JRH	.500 JRH

The custom calibers are available by special order only. For ordering information please contact our customer service personnel at 218-746-3459, Monday - Friday, 9:00 am - 4:30 pm Central Time.

CUSTOM GUNS AND FEATURES

Back Cover Photo #1:

Caliber 30/30 Win
 Fluted 10" Barrel
 Ivory Polymer Grips
 Fluted Cylinder
 Custom engraving on the barrel and the side of the frame exclusive to the custom line of BFR's

Back Cover Photo #2:

Caliber .475 Linebaugh with 4-5/8"
 Custom Barrel
 Rounded Slimmed Black Micarta Grips
 11 Degree Target Crown

Back Cover Photo #3:

Caliber .50AE/.500JRH with 7.5" Barrel
 Black Micarta Grips
 Octagon Barrel
 Custom Dual Cylinder Revolver

CUSTOM GUNS AND FEATURES AVAILABLE (Refer to page 22-23)

Caliber 30/30 Win
Fluted 10" Barrel
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Caliber .475 Linebaugh with 4-5/8"
Custom Barrel
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11 Degree Target Crown



Caliber .50AE/500JRH with 7.5" Barrel
Black Micarta Grips
Octagon Barrel
Custom Dual Cylinder Revolver



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Website: www.MagnumResearch.com