

# VR80 MAG FED SHOTGUN

**RIA**  
IMPORTS

## USERS MANUAL



WARNING: READ THE INSTRUCTIONS AND  
SAFETY PRECAUTIONS IN THIS MANUAL  
CAREFULLY BEFORE USING THE FIREARM.

# ROCK ISLAND ARMORY

## USERS MANUAL VR80 MAG FED SHOTGUN SAFETY, INSTRUCTION AND PARTS MANUAL



As a responsible owner of this firearm, you must read the instructions and warnings in this manual carefully. Before using this firearm, make sure you understand thoroughly the contents of this manual.

This manual must always be in the firearms carrying case whenever the owner/user brings it or when it transfers ownership. A copy of this manual is available upon request from:



### *RIA Recommendation For Semi Auto Shotgun Break In Procedures*

- *Quality shotshells only*
- *Minimum 2 <sup>3/4</sup>, 3 dram shotshell to be used*
- *Minimum velocity 1250 fps*
- *Minimum 1 <sup>1/8</sup> oz of shot*
- *Expect some malfunctions in first 25-50 rounds*
- *Minimum of 250 rounds before trying lighter load*
- *Avoid light recoil or reduced recoil loads*
- *Due to variation in ammo and firearms some gun may work with lighter loads and some may not*
- *Please complete break in period of 100 rounds with recommended loads before sending warranty claim for cycling issues*
- *YouTube has several videos on customization for lighter loads however custom work may void warranty*

### **ARMSCOR PRECISION INTERNATIONAL**

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## MAINTENANCE



## 01 | STATEMENT OF LIABILITY

### STATEMENT OF LIABILITY

This shotgun is classified as a firearm or dangerous weapon. It is expressly understood that we assume no liability for its resale or unsafe handling under local laws and regulations. Armscor assumes no responsibility for physical injury or property damage resulting from either intentional or accidental discharge, or for the function of the firearm subjected to influence beyond their control. Armscor will honor no claims which may result from careless handling, unauthorized adjustments, defective or improper ammunition, corrosion or neglect. Examine your firearm carefully at the time of purchase. It should be forwarded immediately to the factory or its sales agent if any adjustment of any kind is required.

### State-By-State Warnings



#### CALIFORNIA STATE WARNING

*CHILDREN ARE ATTRACTED TO AND CAN OPERATE FIREARMS THAT CAN CAUSE SEVERE INJURIES OR DEATH. PREVENT CHILD ACCESS BY ALWAYS KEEPING FIREARMS 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. IT IS UNLAWFUL TO USE A MAGAZINE WITH A CAPACITY OVER 10 ROUNDS.*



#### MASSACHUSETTS STATE WARNING

*IT IS UNLAWFUL TO CARRY ANY MAGAZINE OR BELT WHICH HOLDS MORE THAN TEN ROUNDS, UNLESS AUTHORITY IS GRANTED BY THE BOSTON POLICE COMMISSIONER. 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 YORK STATE WARNING

*IT IS UNLAWFUL TO CARRY ANY MAGAZINE OR BELT WHICH HOLDS MORE THAN SEVEN ROUNDS, UNLESS AUTHORITY IS GRANTED BY THE STATE OF NEW YORK. THE USE OF A LOCKING DEVICE OR SAFETY LOCK IS ONLY ONE ASPECT OF RESPONSIBLE FIREARMS STORAGE FOR INCREASED SAFETY, FIREARMS SHOULD BE STORED UNLOADED AND LOCKED IN A LOCATION THAT IS BOTH SEPARATED FROM THEIR AMMUNITION AND INACCESSIBLE TO CHILDREN AND OTHER UNAUTHORIZED PERSONS.*

## 02 | SAFETY PRECAUTIONS

Safety must be the first and constant consideration of every person who handles firearms and ammunition. The person with a firearm in his possession has an important responsibility. He/She must know how to use his/her firearm safely:

1. Always keep the muzzle pointed at a safe direction. Watch the muzzle at all times. Never point a gun, accidentally or intentionally, at any person or anything you do not intend to shoot. Identify the target before shooting; do not shoot at sounds.
2. Always treat a gun as if it is loaded – it may be!
3. Keep your finger off the trigger while operating the action and at all other times until you are ready to shoot.
4. Keep the safety “on” or in the “safe” position at all times until you are ready to fire. Do not rely on your gun’s safety, the safety on any gun is a mechanical device and is not intended as a substitute for common sense or safe gun handling.
5. Learn how your gun functions and handles. If you do not thoroughly understand the proper use and care of your gun, seek the advice of someone who is knowledgeable.
6. Do not alter or modify any part of the firearm.
7. Store guns unloaded, separate from any ammunition, and out of the reach of children.
8. Be sure the barrels is clear of any obstructions before loading. Make it a habit to check the barrel every time before loading.
9. Be sure you have and use the proper ammunition.
10. Wear protective shooting glasses and adequate ear protection when shooting.
11. Never climb or jump over anything, such as a tree, fence, or ditch, with a loaded gun. Open the barrel, remove the shells and hand the gun to someone else or place it on the ground on the other side of the obstacle before crossing it yourself. Do not lean a gun against a tree or other object; it could fall and possibly discharge.

12. Do not shoot at a hard surface or at water. Bullet and shot can ricochet or bounce off and travel in unpredictable directions with great velocity.

13. Never transport a loaded gun. Do not place a loaded gun into a vehicle. The gun should be unloaded and placed into a case when not in use.

14. Never consume intoxicating beverages and/or drugs before.

### WARNING

DO NOT ATTEMPT TO USE ANY FIREARM WITHOUT HAVING A COMPLETE UNDERSTANDING OF ITS PARTICULAR CHARACTERISTICS AND SAFE USE. READ AND UNDERSTAND THIS MANUAL CAREFULLY BEFORE USAGE OF YOUR SHOTGUN.

### WARNING

YOU SHOULD NEVER DEPEND ON A SAFETY MECHANISM OR ANY OTHER MECHANICAL DEVICE TO JUSTIFY CARELESS AND IMPROPER HANDLING.

### WARNING

THIS FIREARM WAS MANUFACTURED TO PERFORM PROPERLY WITH THE ORIGINAL PARTS AS DESIGNED. PLEASE MAKE SURE ANY PARTS YOU BUY ARE INSTALLED CORRECTLY AND THAT NEITHER REPLACEMENTS NOR ORIGINALS ARE ALTERED OR CHANGED. PUTTING A FIREARM TOGETHER INCORRECTLY OR WITH MODIFIED PARTS CAN RESULT IN DAMAGED FIREARM, DANGER, AND INJURY OR DEATH. ANY MODIFICATIONS TO FIREARM WILL VOID FACTORY WARRANTY.

## 03 | SAFETY PRECAUTIONS

### WARNING

CHILDREN ARE ATTRACTED TO FIREARMS, AND MIGHT BE ABLE TO OPERATE THEM, THEY CAN CAUSE SEVERE INJURIES AND EVEN DEATH, TO THEMSELVES OR OTHERS. PREVENT CHILDREN FROM ACCESS, ALWAYS KEEP YOUR FIREARMS LOCKED AWAY, UNLOADED AND OUT OF REACH OF CHILDREN WHEN NOT IN USE AT ANY TIME.

### WARNING

THE FIREARM SHOULD BE STORED IN ROOMS WITH A DRY ATMOSPHERE AND MINIMUM HUMIDITY. IT SHOULD NOT BE STORED ENCASED IN LEATHER OR ANYTHING THAT WILL ATTRACT AND HOLD MOISTURE, CAUSING IT TO RUST.

### WARNING

DO ALL PROCEDURES (DISASSEMBLY, CLEANING AND OTHER MAINTENANCE) ONLY WHEN THE FIREARM IS UNLOADED. BE SURE THAT THE MAGAZINE TUBE, RECEIVER AND CHAMBER ARE EMPTY WHILE YOU ARE PROCEEDING. CHECK EJECTION PORT, LOADING PORT AND CHAMBER VISUALLY.

### WARNING

ALL PRODUCTS HAVE 3" (76MM) CHAMBERS (EXCEPT OTHERWISE STATED). YOU CAN SEE MARKS ABOUT GAUGES AND CHAMBER LENGTH ON THE GUN. EVERY SHOTGUN HAS PASSED DURABILITY TEST WITH SPECIAL HIGH PRESSURE CARTRIDGES.

### WARNING

WHEN STORING THE GUN FOR A PROLONGED PERIOD OF TIME, IT IS NECESSARY TO OIL IT HEAVILY WITH AN ACID-FREE LUBRICANT. THE EXTERNAL PARTS MUST BE COATED WITH AN ANTI-RUST OIL OR GREACE TO PREVENT MOISTURE CAUSING THE PARTS TO RUST AND MALFUNCTION. BEFORE USAGE, THE SHOTGUN MUST BE CLEANED AND WIPED DRY AGAIN.

## 04 | TECH SPECS

Model	<b>VR80</b>
Caliber	12 Gauge
Chamber	2 <sup>3</sup> / <sub>4</sub> / 3"
Action	Semi Automatic
Capacity	5 Rounds
Choke	Full, Modified and Improved Cylinder
Barrel	Contoured
Barrel Length	500mm / 20"
Overall Length	990mm / 39"
Overall Width	40mm / 1.6"
Overall Height	230mm / 9"
Rear Sight	Serration On Receiver
Weight, Empty	3.35 kg / 7.39 lbs
Weight, Loaded	3.85 kg / 8.49 lbs
Finish	Black Chrome
Stock	Polymer Buttstock With Rubber Buttpad

### CALIBER



## 05 | BASIC PARTS

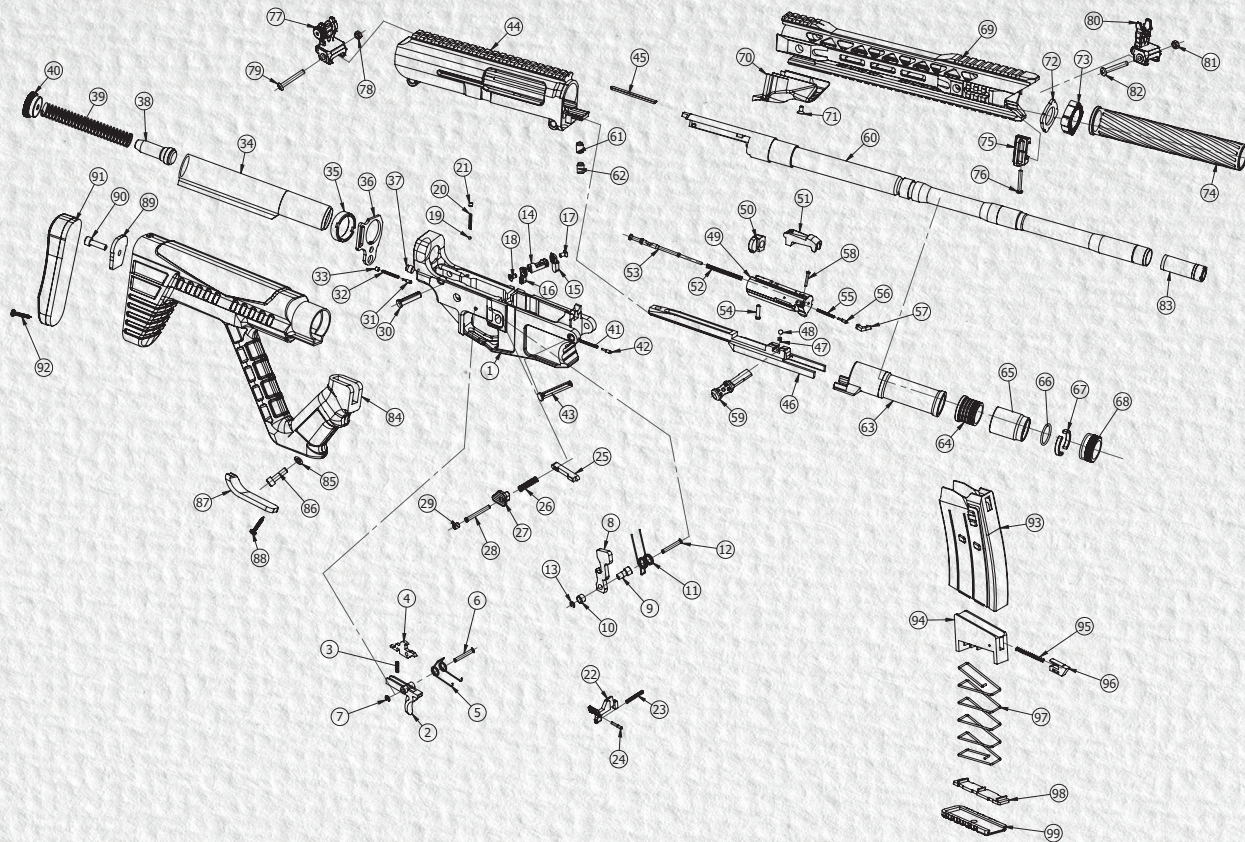
P.NO	PART NAME
1	Lower Receiver
2	Trigger
3	Disconnecter Spring
4	Disconnecter
5	Trigger Spring
6	Trigger Pin
7	Crescent washer
8	Hammer
9	Hammer Pin Sleeve, Male
10	Hammer Pin Sleeve, Female
11	Hammer Spring
12	Hammer Pin
13	Crescent washer (Optional)
14	Safety
15	Safety Lever
16	Safety Lever
17	Safety Retaining Screw
18	Safety Retaining Screw
19	Safety Detent
20	Safety Spring
21	M4 Screw
22	Bolt Catch
23	Bolt Catch Spring
24	Bolt Catch Pin
25	Magazine Catch
26	Magazine Catch Spring
27	Magazine Catch Button
28	Magazine Catch Screw
29	M6 Screw
30	Takedown Pin
31	Extractor Spring Pin
32	Extractor Spring
33	M4 Screw
34	Stock Support
35	Pivot Nut
36	Sling Plate
37	Detent Ball
38	Bolt Buffer

P.NO	PART NAME
39	Bolt Return Spring
40	Lock Ring
41	Extractor Spring
42	Extractor Pin
43	Pivot Pin
44	Upper Receiver
45	Pin
46	Slide Carrier
47	Ball Spring
48	5 Ø ball
49	Bolt
50	Buffer Bolt System
51	Lock
52	Firing Pin Return Spring
53	Firing Pin
54	Firing Pin Retaining Pin
55	Extractor Spring
56	Extractor Spring Pin
57	Extractor
58	Extractor Spring Pin
59	Cocking Handle
60	Barrel with Barrel Extension
61	M8 screw
62	M8 screw
63	Slide with Slide Extension
64	Gas Piston
65	Gas Block
66	Gas Block O-Ring
67	Gas Block screw
68	Gas System Retaining Nut
69	Fore End
70	Handguard
71	Handguard Retaining Screw
72	Handguard Pivot Nut
73	Handguard Pivot Polymer Nut
74	Barrel Shroud
75	Sling Swivel
76	Sling Swivel Screw

P.NO	PART NAME
77	Flip-up Assembly (Rear)
78	Flip-up Nut (Rear)
79	Flip-up Screw (Rear)
80	Flip-up Assembly (Front)
81	Flip-up Nut (Front)
82	Flip-up Screw (Front)
83	Mobile Choke
84	Pistol Grip + Fixed Buttstock
85	Washer
86	M6 screw
87	Pistol Grip Cap
88	Pistol Grip Cap Screw
89	Custom Washer
90	M6 screw
91	Recoil Pad
92	Recoil Pad Screw
93	Magazine
94	Magazine Follower
95	Magazine Follower Extractor Spring
96	Magazine Follower Extractor
97	Magazine Spring
98	Magazine Base Plate Retainer
99	Magazine Base Plate



## 06 | EXPLODED VIEWS



## 07 | OPERATING INSTRUCTIONS

### DISASSEMBLY OF THE FIREARM

1) Remove the magazine.

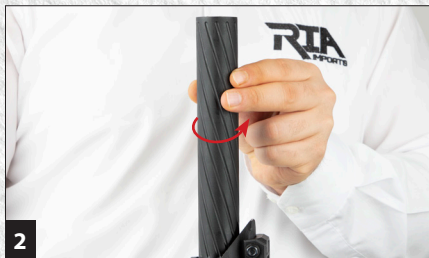
2) Unscrew the barrel shroud by turning in arrow direction.

3) Pull the forend in arrow direction.

4) Push the detaching pin and pull from the other side until it sets.

5) Push the other detaching pin and pull from the other side until it sets.

6) Detach upper from lower.

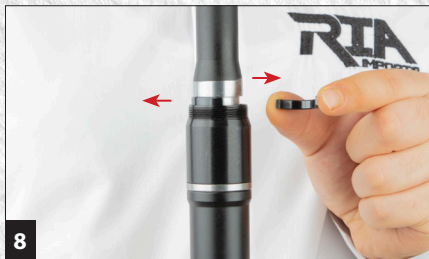


## 08 | OPERATING INSTRUCTIONS

### DISASSEMBLY OF THE FIREARM

**7)** Unscrew the gas system retaining nut by turning in arrow direction.

**8)** Remove the split rings.



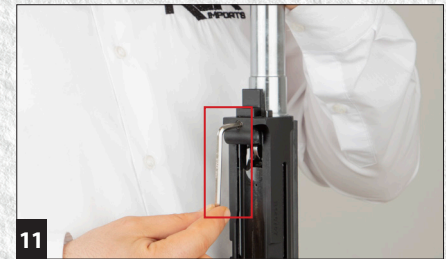
**9)** Remove the piston, slide and has block by pulling in arrow direction.

**10)** Remove the charging handle by pulling it.



**11)** Remove both barrel screws with an allen wrench one at a time.

**12)** Pull out the bolt assembly in arrow direction.



## 09 | MAINTENANCE

### DAXOS® (Dual Axis Operation Sistem) Ambidextrous Cocking Handle Operation

Pull the charging handle



Insert the charging handle from the other side



Make sure the handle is set



Specially developed system to avoid damages in the receiver caused by recoil. Patented by DERYA®



**BufferBolt® System**

Patented ThumbHole Design for great ergonomics and simple functionality.



**BufferTHS™**




**Light Loads Piston:** 2<sup>3/4</sup>" Shotshells  
**Heavy Loads Piston:** 3" Shotshells (Magnum)



## 10 | MAINTENANCE

### USAGE OF CHOKE TUBES

The choke is what controls the openness or tightness of the pattern of your shotgun. The chart below lists the choke available (from open to tight), and the corresponding marks that indicate the choke of your specific shotgun.

MARKING	USAGE OF CHOKE TUBES		NOTCHES
*	<b>FULL</b>	Suitable for longer ranges (DON'T USE SLUGS!)	
***	<b>MODIFIED</b>	Suitable for medium ranges (DON'T USE SLUGS!)	
*****	<b>CYLINDER</b>	Suitable for short ranges	

Never fire or gun cleaning tools through a barrel that uses choke tubes without having tube installed. The threads of the choke tube and the internal threads of the barrel should be cleaned after each use and before installation of the tube.

to install a tube, insert the tube into the barrel and tighten with your fingers. Once the tube is finger-tightened, tighten with the appropriate choke-tube wrench until the tube is snug. DO NOT over tighten or forcefully tighten with wrench.

ORDERING PARTS

Visit RIA website to browse, learn more about and purchase parts and ammunition for all of your Rock Island Armory products.



[www.advancedtactical.com](http://www.advancedtactical.com)



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### WARRANTY REGISTRATION

Armscor's warranty covers its firearms and parts. We offer limited lifetime warranty on our products for their intended purpose. As with any product, abuse, gunsmithing by an unqualified person and normal wear and tear are excluded. Additionally, if the firearm was modified and/or repaired by an unqualified gunsmith without permission from Armscor, then the warranty will be void. If warranty work should be required, return the firearm to the address listed below. There is no refund for the shipping cost. Gunsmithing services are available by registered Armscor Gunsmithers. Please email the address below.

To register your firearm, please go to [www.rockislandarmory.com/support-center/warranty/](http://www.rockislandarmory.com/support-center/warranty/) and complete online warranty form. In comments section, write warranty registration and press submit. You can also go to [www.rockislandarmory.com](http://www.rockislandarmory.com) and press warranty section at the bottom.

For more information on warranty, visit [www.rockislandarmory.com](http://www.rockislandarmory.com), or email [support@armscor.com](mailto:support@armscor.com)

**Armscor Precision International**  
**150 North Smart Way**  
**Pahrump, NV 89060**  
**Email: [support@armscor.com](mailto:support@armscor.com)**

### IMPORTANT WARRANTY INFORMATION

Our Rock Island Armory shotguns are warranted to function only with Factory Ammo and the Original Factory Magazine. Use of Handloads is not covered in Warranty of Repair for the function of the Firearm.

DUE TO THE FIT AND TIGHTNESS OF FIREARM, RIA RECOMMENDS A BREAK-IN PERIOD OF 500 ROUNDS.

#### **THIS IS HOW YOU VOID YOUR WARRANTY**

- \* Refinishing your RIA firearm
- \* Misuse, Mishandling, Dropping your RIA Firearm
- \* Firing Remanufactured or Reloaded Ammunition
- \* Not properly reassembling your RIA Firearm resulting in damage, ie reverse plugs!
- \* Any addition of after market parts
- \* Unauthorized repairs done by any other than Rock Island Armory

#### **LIMITS ON WARRANTY (will not cover)**

- \* Finish, Holster wear, Scratches, Chemical damage
- \* After Market Magazines
- \* Damage to Factory Magazines
- \* Sights not installed by Rock Island Armory
- \* Recoil Springs

WE RESERVE THE RIGHT TO CHARGE FOR LABOR, PARTS AND SHIPPING TO RETURN YOUR RIA FIREARM BACK TO FACTORY SPECIFICATIONS IF IT HAS BEEN ALTERED.

03/2020

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[WWW.ROCKISLANDARMORY.COM](http://WWW.ROCKISLANDARMORY.COM)