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KELTECWEAPONS.COM

**SUB2000™
SUB CQB™**

**SAFETY,
INSTRUCTION
& PARTS MANUAL**



 **WARNING:** Read this manual carefully before loading or using the SUB2000s.







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A. SAFETY INFORMATION AND WARNINGS


Please read this manual and carefully review the warnings contained herein before loading or using the SUB2000. This comprehensive guide provides essential information on the function and safe handling of the SUB2000, highlighting potential dangers, including the risk of death or serious personal injury, resulting from its improper use. It is imperative that this manual accompanies the SUB2000 at all times and is transferred with the firearm if it is ever sold or loaned to another individual.


Even if you possess experience as a shooter, it is paramount that you READ THIS ENTIRE MANUAL THOROUGHLY before loading or firing the SUB2000. The manual contains fundamental instructions on the proper handling and operation of the firearm. The safety of yourself and others relies on your strict adherence to the instructions and warnings outlined here, as well as the consistent practice of safe firearms procedures. If you are unfamiliar with firearms, we strongly recommend enrolling in a course on safe firearm handling, led by a qualified firearms instructor, your local gun club, or a similarly accredited organization.

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


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


 **WARNING** The SUB2000 is designed to function reliably with proper care and knowledgeable use. Do not use your SUB2000 unless you fully understand how to safely operate it.

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

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

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

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

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

⚠ WARNING

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

⚠ WARNING

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

⚠ WARNING

Always make sure the SUB2000 is unloaded, on SAFE and the action is open before handing it to another person.

⚠ WARNING

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

⚠ WARNING

Never alter or modify the SUB2000 because this could cause it to malfunction and create a dangerous condition.

⚠ WARNING

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

⚠ WARNING

If the SUB2000 is dropped or forcefully struck, it could be damaged and may not function properly. Have it inspected by Kel-Tec CNC Industries, Inc. before continuing to use it.

⚠ WARNING

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

⚠ WARNING

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

⚠ WARNING

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

⚠ CAUTION

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

NOTICE

Some variants of this weapon may be controlled under the National Firearms Act (NFA) for suppressors, typically the CQB model.

NOTICE

Suppressors, and hunting with suppressors, are not legal in some states or jurisdictions.

NOTICE Firearm laws and regulations may change overtime, which may inadvertently affect ownership or use of the weapon; it is your responsibility to understand your local and federal laws and how they apply to the possession and use of this firearm.

Before it left the factory, the SUB2000 was tested, carefully inspected and packaged. Kel-Tec CNC Industries, Inc. cannot control what happens to the SUB2000 after it leaves the factory; therefore, carefully examine the SUB2000 when you acquire it to ensure that it is unloaded and undamaged. If you do not understand any of the warnings and instructions in this manual, have any problems operating the SUB2000, or need another copy of this manual, contact Kel-Tec CNC Industries, Inc. at:

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

www.keltecweapons.com/resources/downloads

B. OVERVIEW

Description

NOTICE This manual pertains exclusively to the third generation SUB2000 rifle. If you happen to possess a previous generation SUB2000, please note that this manual does not apply. For copies of earlier manuals, please visit: support.keltecweapons.com/owners-manuals.

The SUB2000 is a highly versatile semi-automatic rifle designed for use with the 9mm Luger cartridge. Various versions of the SUB2000 rifle are compatible with most double-stack handgun magazines, such as those from Glock, SIG, or Beretta. With a simple rotation of the barrel, the SUB2000 rifle can rapidly fold to a size of just 16.15 x 6.6 inches.

Dubbed a "sub-rifle" due to its compact dimensions, light weight, and utilization of a pistol cartridge, the SUB2000 is intended to complement a handgun with the full interchangeability of ammunition and magazines.

Nomenclature

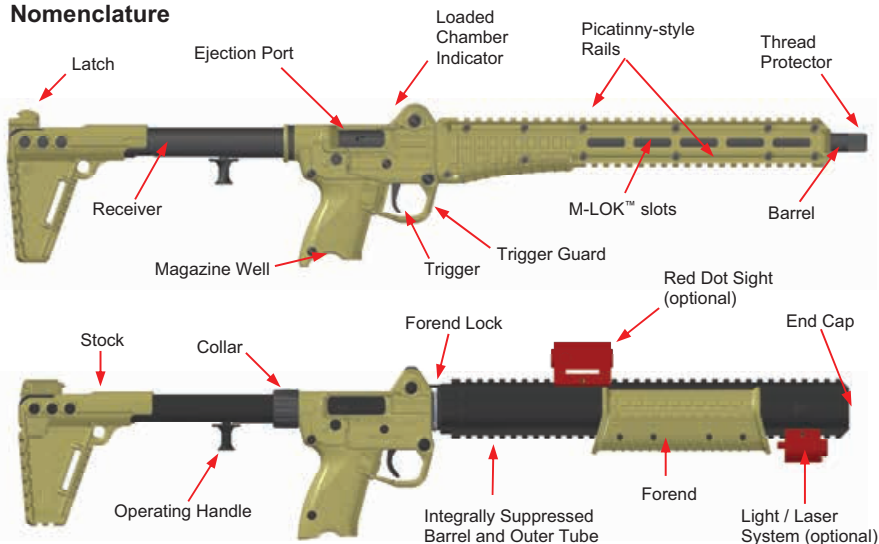


Figure B-1: Side View of SUB2000 and SUB2000 CQB (with optional accessories)

The barrel of the SUB2000 features a spring-loaded lock nut to ensure a precise lock to the grip, which is composed of impact-modified, glass-reinforced Zytel. The polymer forend comes with two integrated Picatinny-style rails for mounting compatible accessories, along with five M-LOK™ mounting slots on each side to accommodate various accessories. During storage, the forend can rotate around the bore axis, allowing the sighting system to move out of the way. Always ensure accessories are compatible, securely attached, and do not interfere with the firearm's function.

The hinge block at the front end houses the barrel and forend assembly, securely locked in place by a rotating trigger guard. The grip rigidly attaches to the receiver through multiple lugs and houses the firing mechanism. Depending on the SUB2000 variant, the grip

accepts specific handgun magazines. The tubular steel receiver contains the bolt assembly and terminates with the polymer stock.

The stock is adjustable to three positions for the shooter's comfort, with each position adding approximately 5/8 of an inch to the overall length, extending up to 1.25 inches in the furthest rearward position. It includes a single point sling loop attachment and a slot for adding a 1.25-inch wide nylon sling loop. The stock can be adjusted by following the field stripping instructions on page 14.

The heavy two-piece machined steel bolt houses the firing pin, extractor, and operating handle. A captive recoil spring with buffer actuates the bolt.

The firing mechanism follows a conventional single-action type, featuring a positive disconnecter and a push-bolt safety. The hardened steel ejector is internal for added durability.

Design Features	SUB2000	SUB2000 CQB
Operating System	Blowback	
Caliber	9mm Luger	9mm Luger
Capacity	Varies by magazine	
Barrel Length (Standard / Export)	16.15" (410 mm) / 18.52" (470.5 mm)	OAL 16.2" (412 mm), Rifled 4.25" (108 mm)
Barrel Twist Rate	1:10"	1:10"
Barrel Threads	1/2"-28	N/A
Trigger Pull	~ 5 pounds (~ 22 N)	
Accessory Mount (Top / Bottom)	Rotating Forend with Picatinny-style Rail	
Accessory Mount (Sides)	M-LOK™ (Forend)	N/A

Dimensions and Weight		
Length (Stock Extended / Collapsed)	Approximately 30.45" (774 mm) / 29.2" (742 mm)	
Folded length (Storage Mode)	16.15" (410 mm) by 6.6" (167 mm), no sights GLK 19 grip	
Length of Pull (Stock to Trigger)	14.5" (368 mm) / 13.25" (337 mm)	
Max Width	At Grip 1.25" (32 mm)	At Handguard 2.35" (60mm)
Max Height	5.5" (141 mm), no sights	~ 8" (203mm) with red dot; ~6" (152.5mm) w/o red dot
Weight (Unloaded, No Magazine)	4.20 lbs (1.9kg)	5.15 lbs (2.34kg) (no aftermarket accessories)

C. OPERATION INSTRUCTIONS

Safety

The SUB2000 comes equipped with a push-bolt safety positioned behind the trigger on the grip assembly. To engage the safety, the hammer must be cocked. When the safety is engaged, the push-bolt safety obstructs the sear, preventing it from releasing and disengages the trigger bar.

For right-handed users, activating the safety typically involves pressing it with the right thumb until a distinct "click" is heard, and the red o-ring becomes visible on the safety, as demonstrated in the following examples.



Figure C-1: Pressed to the left, SAFE configuration; pressed to the right, Red for FIRE

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

Storage Mode / Rotating Forend

The SUB2000 is designed to reduce its size to a compact 16.15 x 6.6 inches without the need to remove an attached sighting system. To fold the SUB2000:

1. Ensure the weapon is unloaded, with no magazine or ammunition inside.
2. Place the weapon on SAFE.
3. Rotate the trigger guard away from the trigger (1), allowing the barrel to rotate around the hinge axis (2).

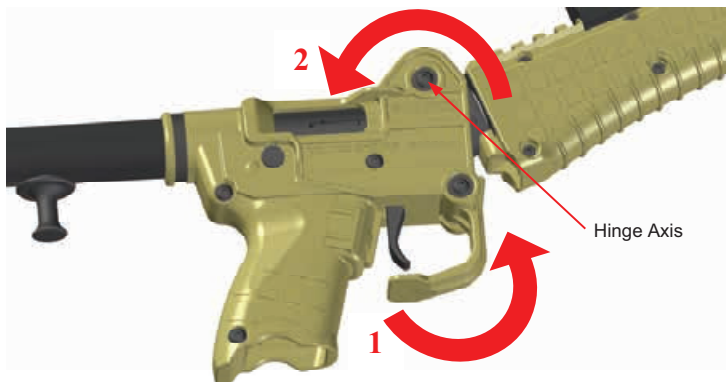


Figure C-2: Folding the barrel assembly

After releasing the barrel assembly from the trigger guard and grip, the forend gains the ability to rotate around the bore axis (3) in either direction. The provided example demonstrates the forend rotating in one of these directions.



Figure C-3: Rotate the forend assembly

The latch securely fastens to the M-LOK slot on both sides of the barrel assembly. By pressing in the latch, you can easily secure the barrel assembly to the receiver (4).

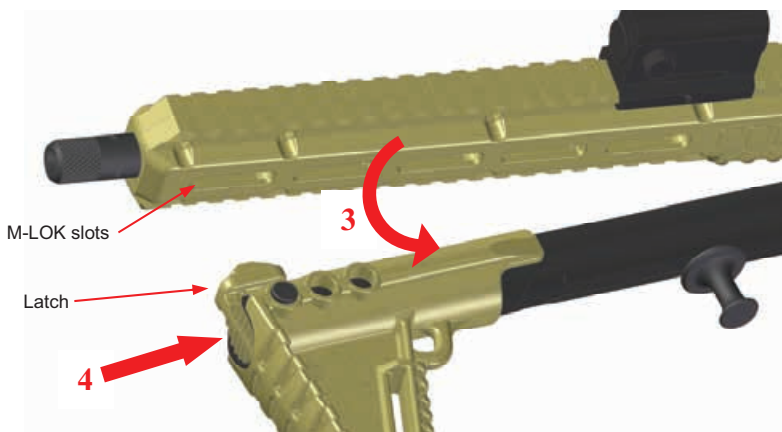




Figure C-4: Area of engagement for the latch

⚠ CAUTION

Avoid releasing the bolt assembly from the notched, or locked back, position in the receiver tube when the barrel assembly is in storage mode. Such action could potentially cause damage to the receiver tube or hammer.

NOTICE

The latch's purpose is to support the barrel assembly in staying closed during storage mode for transportation. However, it's essential to note that the latch is not intended as a lock or safety mechanism.

To exit storage mode, press the latch forward (towards the grip) to release the barrel assembly (1). Once released, the barrel assembly is free to rotate to the forward position (2).

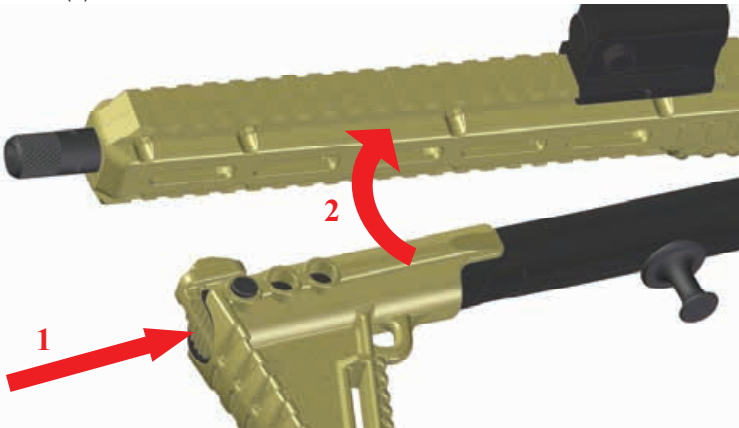


Figure C-5: Unfolding the barrel assembly

As you rotate the barrel assembly forward, also rotate the forend to ensure the sighting system is upright (C-6).

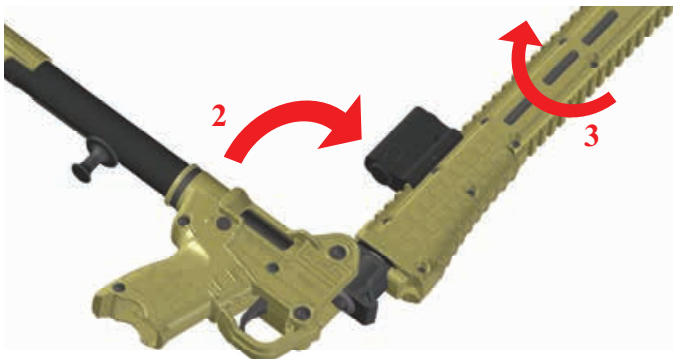


Figure C-6: Unfolding the barrel assembly

CAUTION During the process of rotating the barrel assembly forward, it is crucial to manually orient the forend's sighting system to an "upright" position. This step ensures proper engagement between the barrel assembly and the grip assembly. Neglecting to do so could result in potential damage to the barrel or forend assembly.

Once you rotate the barrel assembly forward, make certain that it positively engages into the trigger guard. You may hear an auditory "snap" as the trigger guard re-engages the barrel assembly.



Figure C-7: Re-engage the barrel assembly into the trigger guard

CQB FOREND. To rotate the forend on the CQB, lift the forend lock upward and away from the locking surface on the forend. This action permits the forend to rotate about the bore axis, effectively moving any sighting system out of the way.



Figure C-8: Lift the forend lock to rotate forend

NOTICE The rotating forend features a latching area built into the handguard, designed to function similarly to the second-generation SUB2000. However, if the rail placement of the handguard is altered or the rotating forend is not positioned correctly against the forend nut, the handguard may not latch properly.



Figure C-9: Rotating Forend latching into the latch tab

Loading the Magazine(s)

To load the magazine, press a cartridge downward onto the forward portion of the magazine, then slide the cartridge back into place.

Repeat these steps for the desired number of cartridges, up to the magazine capacity. Avoid loading the magazine with more cartridges than specified, as doing so may result in feeding malfunctions.

Chambering a Cartridge

Hold the rifle in one hand, ensuring the muzzle is pointed in a safe direction, and keep your finger off the trigger and outside the trigger guard. Insert the loaded magazine into the grip until it locks in place securely. Verify that the magazine is properly secured.

Using your free hand, firmly grasp the operating handle, and fully cycle the bolt back (away from the muzzle) and release it. If the bolt is already locked back, pull the operating handle back slightly, rotate it from the slot, and release it, allowing the bolt to close with the recoil spring. This action will strip a cartridge from the magazine and seat it in the barrel chamber.

WARNING Under no circumstances should you load cartridges directly into the chamber. Always keep the rifle pointed in a safe direction and ensure your finger remains

off the trigger and outside the trigger guard until you are prepared to fire. Safety should be your top priority at all times.

Loaded Chamber Indicator

The chamber indicator window is positioned on the top side of the rifle, rearward of the hinge. It allows for a visual check to determine if the rifle is chambered with a round.

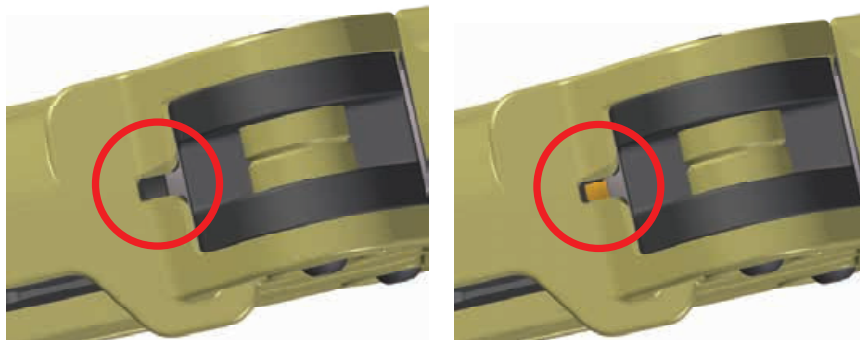


Figure C-10: Left image, no round in chamber; Right image, round in chamber.

Firing

Ensure the muzzle is pointed in a safe direction, and keep your finger outside the trigger guard as you aim at a safe target. Disengage the safety and squeeze the trigger until the cartridge is fired. Fully release the trigger. Squeeze the trigger again to fire another round.

Upon firing, the bolt moves backwards, extracting and ejecting the fired cartridge. It then returns forward, automatically feeding another cartridge into the chamber. This process can be repeated until the last cartridge is fired.

Please note that the SUB2000 lacks an automatic bolt stop. However, you can lock the bolt in the rear position by pulling back the operating handle and rotating it into the slot.

Unloading

To unload the SUB2000, follow these steps: Press in the magazine catch, and remove the magazine. Pull the bolt back firmly to extract the round from the chamber. Ensure not to obstruct the ejection port and keep fingers away from the trigger and muzzle. Lock the bolt in the back position and conduct a visual and physical inspection to verify the chamber is empty.

To unload the magazine, push the remaining cartridges in the magazine forward and out. Always exercise caution and adhere to safety practices while handling the firearm.

WARNING Prior to firing the SUB2000, clean the barrel by running a clean patch through it from the chamber end, utilizing a cleaning rod. Repeat this process until the patch emerges from the barrel without any traces of gun oil or cleaner-lubricant-preservative (CLP) on it. It is crucial to avoid any obstructions in the barrel, as they could hinder the proper firing of the SUB2000 and lead to severe consequences, including death, serious personal injury, and/or damage to the firearm. Safety is paramount, so ensure the barrel is clear before use.

⚠ WARNING Prior to firing, always ensure that the barrel is clear of any obstructions. To do so, open the action and clear the firearm of all ammunition before checking the barrel of the unloaded firearm. The presence of any obstruction in the barrel may hinder the proper firing of the SUB2000, leading to severe consequences, including death, serious personal injury, and/or damage to the firearm. Safety is of utmost importance, so ensure the barrel is free of any obstructions before proceeding.

⚠ WARNING Should a failure to fire occur, maintain the SUB2000 pointed towards the target for a minimum of 30 seconds. If a hang-fire (slow ignition) happens, the bullet should fire within approximately 30 seconds. If the bullet does not fire, cycle the operating handle to its rearmost position, remove the unfired cartridge from the chamber, and ensure the SUB2000 remains pointed in a safe direction while engaging the safety. (Note: Dispose of misfired cartridges following the ammunition manufacturer's instructions). Safety must be a top priority throughout this process.

⚠ WARNING Never use the SUB2000 if it fails to function properly, and never force the bolt forward on a jammed casing because it could cause the casing to explode or damage the SUB2000.

⚠ WARNING Never pull the trigger if the bolt does not fully close to prevent a possible out of battery firing. If this happens, unload the SUB2000 as described in this manual, examine the casing that was in the chamber, and check the chamber to ensure that there are no obstructions or debris in it.

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

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

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

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

⚠ WARNING Always carry the SUB2000 unloaded with the action open while on a range until preparing to fire. Always keep the SUB2000 pointed towards the backstop when loading, firing, and unloading it.

⚠ WARNING After firing several cartridges, the exterior metal parts of the SUB2000 get very hot and can cause severe burns if touched.

Thread Protector (if applicable)

Certain versions of the SUB2000 feature a threaded barrel accompanied by a thread protector. The barrel thread is 1/2"-28 for the 9mm Luger barrel.

To utilize these threads, turn the thread protector counter-clockwise to loosen and remove it. Once removed, you can attach a compatible accessory designed for the specific caliber thread.

NOTICE Maximum torque on barrel is 10 ft-lbs. Do **NOT** tighten accessories onto barrel beyond this torque; doing so may damage the firearm.



Figure C-11: Thread protector

NOTICE If using a vise, do **NOT** clamp directly onto the polymer components as they may become damaged or loose.

D. FIELD STRIP

Performing regular maintenance on the SUB2000 requires a thorough understanding of field stripping the rifle (disassembly). Follow the provided sections in sequential order and continue as needed, depending on the maintenance requirements. Familiarity with this process is crucial to ensure the proper functioning and longevity of the firearm.

WARNING If the SUB2000 has been fired, wait a sufficient amount of time for the components to cool before attempting field stripping; failure to do so may result in burns.

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

WARNING Never alter or modify the SUB2000 because this could cause it to malfunction and create a dangerous condition.

WARNING Always wear safety glasses when disassembling the SUB2000 to protect your eyes from components that are under pressure, such as springs.

NOTICE The stock pin is **NOT** held captive in the stock once it is removed. **DO NOT LOSE THE STOCK PIN.**

Ensure the barrel assembly is rotated into the forward position (if it was folded), and verify that the SUB2000 rifle is unloaded. Confirm that the bolt assembly is in the forward (closed) position, the hammer is cocked, and the push-bolt safety is engaged.

Press the latch in towards the front of the weapon. The latch will move approximately 3/32" forward before bottoming out on the stock pin (1). Slightly release tension on the latch (away from the front of the weapon) to enable the removal of the stock pin (2). This step is necessary since the stock pin is held captive by the latch.



Figure D-1: Press latch in

Using a cartridge or another pointed object, apply pressure to the stock pin from either side until the stock pin is successfully removed.



The latch is under tension from the recoil spring. Maintain positive contact with the latch while removing the stock pin, as some parts may become loose.



Figure D-2: Removal of stock pin

Place the stock pin in a safe location. Remove latch and place it in a safe location.



Certain SUB2000 models are equipped with an internal recoil buffer, positioned between the latch and the bolt assembly. If your SUB2000 is equipped with this buffer, it is crucial not to fire the weapon without it, as doing so may result in damage to the firearm. Please ensure the buffer is in place before using the weapon to maintain its proper functioning and integrity.

To disassemble the SUB2000, begin by pulling the bolt assembly back using the operating handle. Next, remove the buffer and recoil spring from the assembly. Proceed by pulling the operating handle downward to detach it, enabling the bolt assembly to slide out of the rear of the receiver tube. You can further separate the bolt assembly by lifting the bolt head

off of the bolt. At this stage, you can also remove or adjust the stock once the stock pin has been taken out.

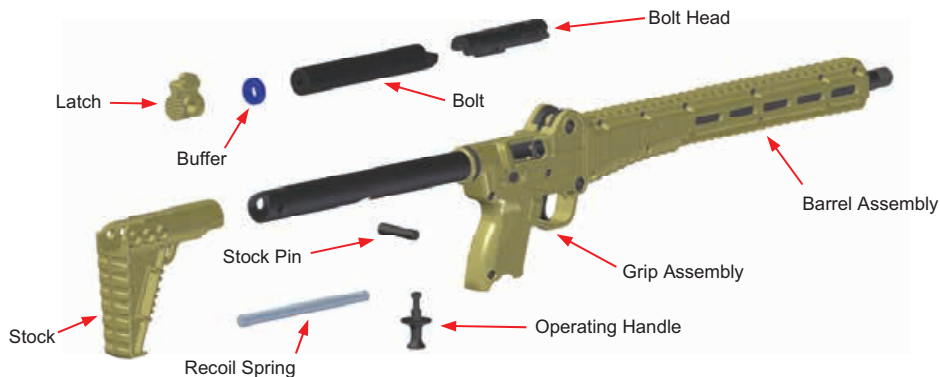


Figure D-3: SUB2000 general field strip

At this stage, you have the option to rotate the barrel assembly up for cleaning or inspection. No further field stripping is necessary for normal operation.

NOTICE Do not release the hammer with the bolt assembly removed, as doing so will render the SUB2000 rifle inoperable.

NOTICE We strongly advise against unscrewing the barrel. These parts are assembled using special tools and compounds, and improper removal may result in damage.

Disassembly of Integrally Suppressed Barrel (CQB ONLY)

WARNING The baffles for the suppressor must be disassembled and re-assembled as described below. Failure to do so may result in serious personal injury or damage to the SUB2000.

Using the supplied wrench or a flat tool, rotate the end cap counter-clockwise to loosen and remove the end cap from the barrel tube.

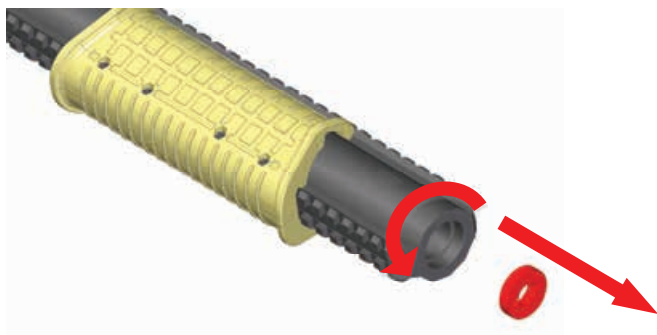


Figure D-4: Removal of end cap

Carefully remove the first set of baffles from the suppressor. These baffles are aluminum and are longer in length and lighter overall.



CAUTION Do **NOT** submerge the weapon system into any ultrasonic cleaner.



The baffles may be snug or a tight fit in the barrel tube; adding some cleaner-lubricant-protectant to the baffles may assist in loosening them from any carbon build-up.



The parts list for the CQB weapon has the part count for the total number of baffles in the assembly.

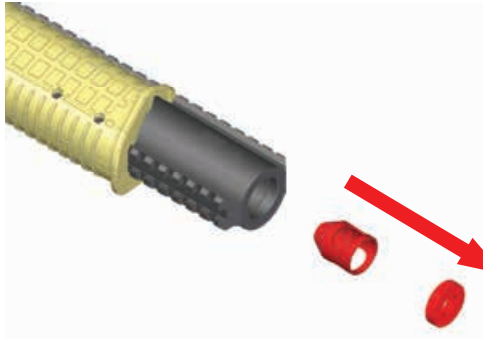


Figure D-5: Removal of aluminum baffles

Carefully remove the second set of baffles from the suppressor. These baffles are steel and are shorter in length and heavier than the aluminum baffles.

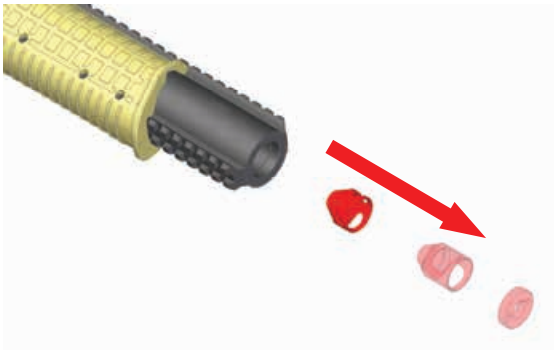


Figure D-6: Removal of steel and aluminum baffles

Loosen the outer tube by unscrewing it until it can be slid forward, revealing the blast chamber on the barrel tube. To confirm that all baffles are removed from the barrel tube, look through the slots.



Figure D-7: View through the slots to ensure baffles are removed

E. ASSEMBLY

Rotate the barrel assembly into the forward position (if the barrel assembly was folded). Slide the bolt and bolt head together by aligning the machined slots in the parts.

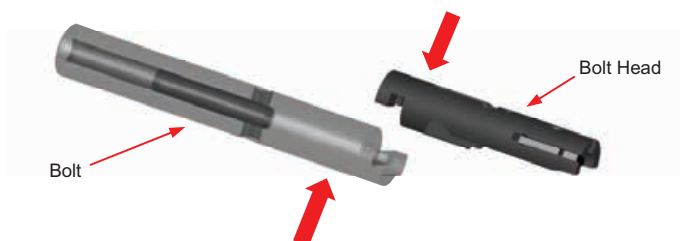


Figure E-1: Assembly of the bolt and bolt head

Insert the combined bolt and bolt head into the receiver. Line up the operating handle hole with the operating handle slot below and then fully insert the operating handle (1). Put the recoil spring into the bolt (2), buffer (if applicable), then slide the bolt assembly forward (3).



Figure E-2: Bolt assembly in receiver with recoil spring

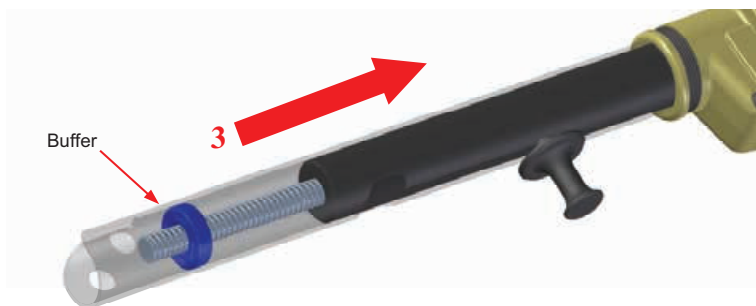


Figure E-3: Sliding bolt assembly forward

Add the stock to the receiver and set the stock position. Position 1 is the shortest overall length of the weapon. Position 2 adds 5/8" to the overall length and position 3 adds 1.25" to the overall length.



Figure E-4: Attaching the stock

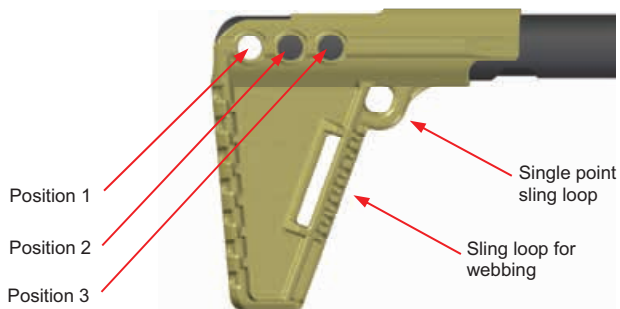


Figure E-5: Explanation of stock

Figure E-5 shows the stock in Position 1. After aligning the stock to the desired position, add the latch.

NOTICE The bolt assembly may need to be pressed towards the rear of the weapon slightly to make certain that the recoil spring and buffer (if applicable) are aligned when inserting the latch. After doing so, press the latch assembly towards the front of the weapon.

CAUTION The latch is under tension from the recoil spring.

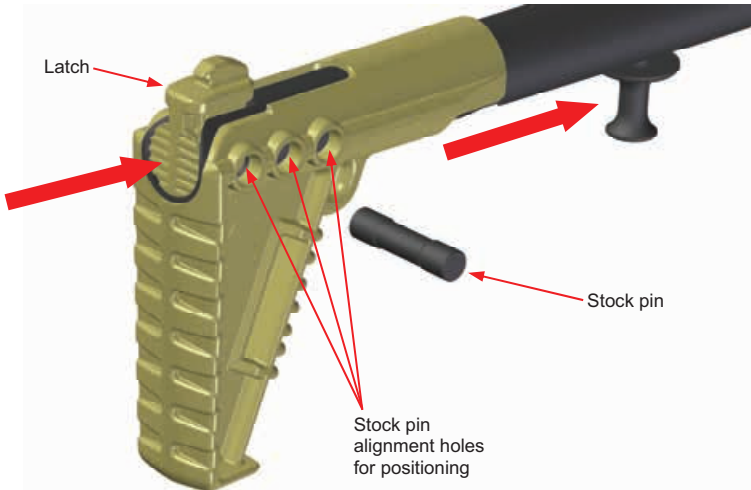


Figure E-6: Insert the stock pin into the assembly

Line up the slot in the latch with the desired stock position and receiver. Push the stock pin completely in, which may take some adjusting for complete alignment (1). After the stock pin is pressed in, release the tension on the latch (2) and cycle the bolt assembly a few times to ensure the action functions properly (3).

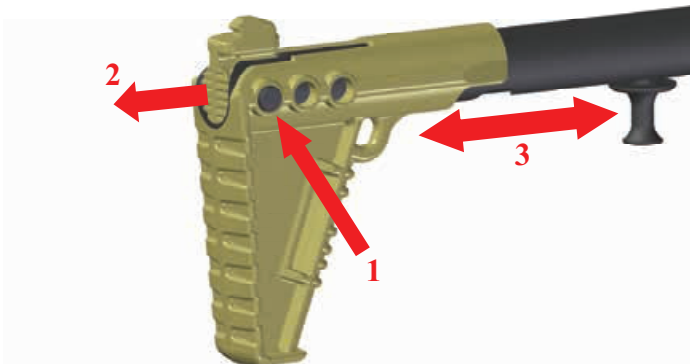


Figure E-7: Testing function of weapon

Assembly of Integrally Suppressed Barrel (CQB ONLY)

CAUTION The baffles are only designed to assemble in one direction, with the cone of the baffle facing towards the chamber end of the barrel in order to stack properly.

For assembly, ensure the outer tube is threaded onto the forend nut until it nearly bottoms out on the forend nut's threads (1). The steel baffles are installed first into the barrel tube (2), followed by the aluminum baffles (3).

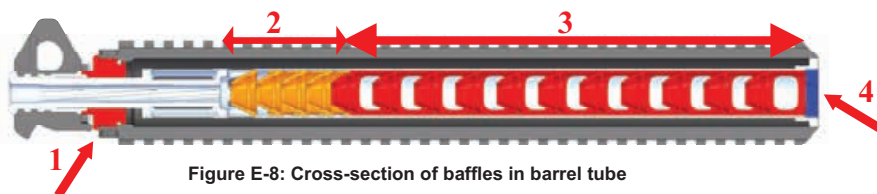


Figure E-8: Cross-section of baffles in barrel tube

Once the baffles are properly installed into the barrel tube, thread the end cap onto the barrel tube (4). Ensure the end cap is hand tight with the supplied wrench or tool.

Fold the weapon and visually inspect the bore line from the barrel's chamber end to ensure there are no obstructions in the barrel or suppressor.

WARNING Ensure the end cap on the CQB is properly secured to the threads in the barrel tube and is hand-tight.

F. CLEANING AND MAINTENANCE

Maintenance

WARNING Remove the magazine, verify that the chamber is unloaded, and remove all live ammunition from the area before working on the SUB2000 to reduce the chance of a negligent discharge.

WARNING Always wear safety glasses when cleaning the SUB2000 to protect your eyes from cleaning materials.

WARNING Always make sure that no ammunition is located in the area where you clean the SUB2000. Cleaning solvents can affect the primer and powder in ammunition and cause it to malfunction. This could result in a bullet being pushed into the barrel of the SUB2000 and getting stuck. Firing another cartridge with a bullet stuck in the barrel could cause the barrel to burst and result in death or serious personal injury and/or damage to the SUB2000.

WARNING If the SUB2000 has been fired, wait a sufficient amount of time for the components to cool before attempting disassembly, failure to do so may result in burns.

Your SUB2000 is a precision instrument and will provide a lifetime of faithful service if it is properly cleaned and maintained. It is recommended that you clean your SUB2000 after every shooting session or more frequently if needed. Be sure to unload your SUB2000 before performing any cleaning or maintenance procedures.

NOTICE Cleaning the suppressor and components should be completed every 500 – 1000 rounds, or as needed.

NOTICE

Only use commercially available gun solvent and gun oil or a CLP. Use of improper cleaning fluids could damage the SUB2000 and void your warranty.

Lubrication

After cleaning the entire gun, use a cloth to apply a light coating of high-quality gun oil to all internal and external metal surfaces and wipe clean.

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

⚠ WARNING

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

Troubleshooting

The optimal performance of your SUB2000 is contingent on maintenance, care, and the ammunition you use. Here are some of the more common types of malfunctions that may occur:

Misfire: A misfire refers to the failure of the cartridge to ignite when the hammer falls. If this occurs, it's essential to keep the firearm pointed in a safe direction and wait for 30 seconds to avoid potential hang-fires. To address the misfire, remove the magazine from the weapon by pressing the magazine release and ensuring it ejects properly. Then, manually cycle the bolt assembly to eject the cartridge. Afterward, place the weapon in the SAFE configuration, fold the barrel assembly, and inspect the barrel for any obstructions. Faulty ammunition is the most common cause of misfires, so using reliable and quality ammunition is crucial to prevent such malfunctions.

Failure to Feed: Failure to feed happens when a cartridge has been fed from a magazine but not fully chambered. If this occurs, ensure the firearm is pointed in a safe direction. Remove the magazine and the cartridge from the ejection port of the weapon. Thoroughly inspect both the cartridge and the magazine for any issues. If necessary, consider changing the magazine. The most common causes of this malfunction are dirt or foreign objects obstructing the magazine follower, as well as improperly crimped cartridges.

Failure to Eject or Extract: When a fired cartridge is not fully extracted from the chamber or ejected from the rifle, ensure the firearm remains pointed in a safe direction. Remove the magazine and the cartridge from the ejection port of the weapon. If needed, consider changing the magazine. The most common causes of this issue are a damaged extractor, ejector ammunition. Improperly loaded or sized cartridges can also be contributing factors. Addressing these potential causes will help resolve the problem.

If any of the previously mentioned problems persist even after cleaning or using different brands of ammunition, it is crucial to cease firing. Safely unload the weapon and promptly return it to our service department for further evaluation and assistance. Your safety and the proper functioning of the firearm are our utmost priority, and we will gladly address any concerns to ensure its reliable performance.

G. SERVICE, REPAIR, AND WARRANTY



Always make sure the SUB2000 is unloaded before sending it in for service.



For the SUB2000 CQB, DO NOT ship the item without first contacting KelTec's service department. Furthermore, DO NOT ship without a copy of the approved BATF form.

If your SUB2000 ever requires adjustment, refinishing or repair, it should be returned to Kel-Tec CNC Industries, Inc.'s service department. The unloaded firearm should be sent with prepaid shipping to:

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

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

To ensure prompt service and handling, include a brief letter including your name, address, telephone number, the serial number of your SUB2000, and what you would like to be done with it, or the issue that you would like to be addressed. No return authorization number is required. Once your firearm has been received, we will provide a quotation of all charges (unless the repairs are covered by the warranty) and will not begin work until we receive your approval. Charges for adjustments, refinishing, and repairs are payable by Master Card, Visa, and American Express. No COD or personal checks are accepted.

LIMITED LIFETIME WARRANTY

Subject to the terms, conditions and limitations outlined below, Kel-Tec CNC Industries, Inc. guarantees your SUB2000 against defects in materials and workmanship for the lifetime of the original consumer purchaser.

To make a claim under this warranty, return your SUB2000 pursuant to the instructions above and include a copy of a bill of sale in your name, or a copy of the 4473 form, showing that you are the original consumer purchaser. For repairs that are covered by the warranty, Kel-Tec CNC Industries, Inc. will pay the transportation and insurance charges to return your SUB2000.

LIMITATIONS OF WARRANTY

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

- (1) the instructions in the Instruction Manual are not followed;
- (2) the SUB2000 or any of its parts are altered or modified from their original state;
- (3) damage is caused by misuse, abuse or improper maintenance; or
- (4) the SUB2000 is disassembled beyond the instructions in the Instruction Manual.

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

The sole and exclusive remedy pursuant to this warranty is the repair or replacement of the SUB2000, at the sole discretion of Kel-Tec CNC Industries, Inc.

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

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

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

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

Kel-Tec CNC Industries, Inc.'s liability for breach of warranty shall be limited to repair or replacement of the SUB2000, at the sole discretion of Kel-Tec CNC Industries, Inc.

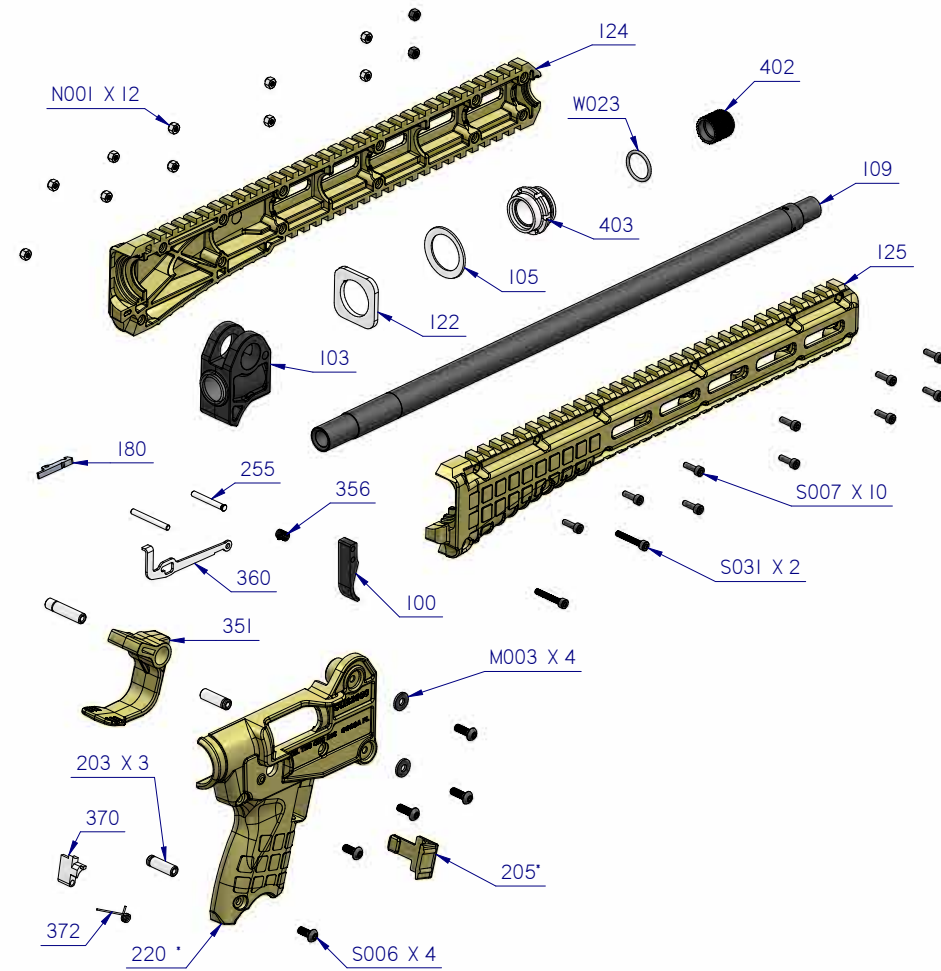
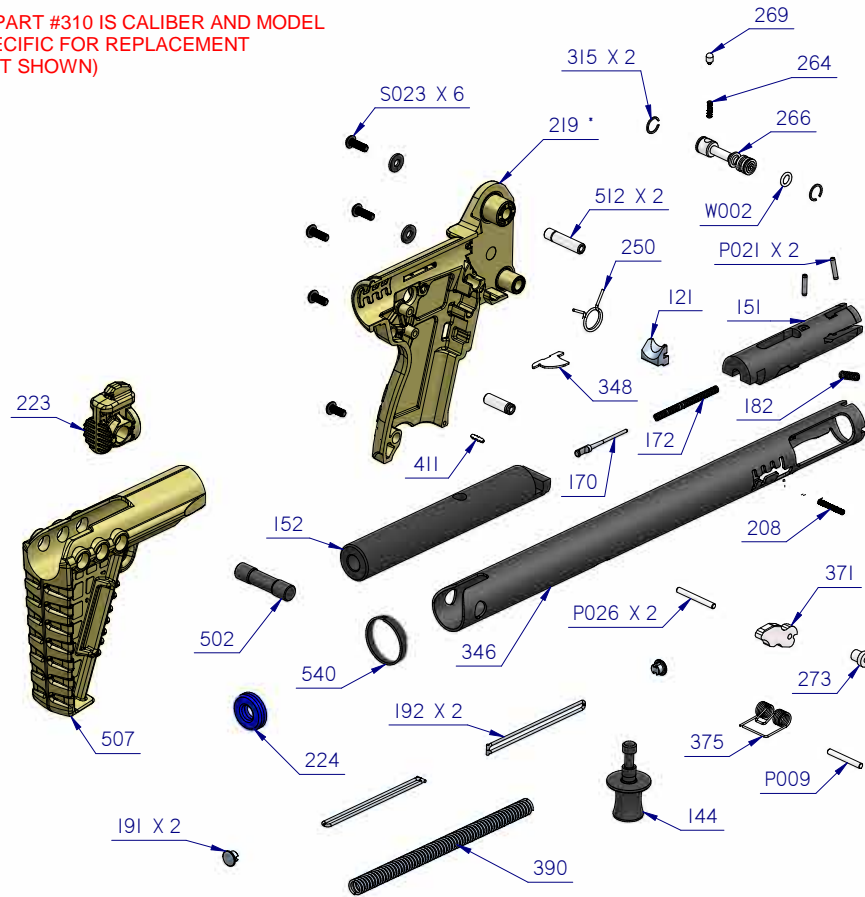
The SUB2000 is a dangerous weapon. The purchaser assumes all liability resulting from unsafe handling or any action that constitutes a violation of any applicable laws or regulations. KelTec will not be responsible for injuries or damages resulting from careless handling, unauthorized or unsafe adjustments or modifications, the use of non-standard, defective, or improper ammunition, the use of incompatible or improperly installed accessories, corrosion, neglect, fire damage, water damage, theft, abuse, ordinary wear and tear, or unreasonable use of the SUB2000. Under no circumstances shall KelTec be responsible for incidental or consequential damages with respect to economic loss or injury or property damage, whether as a result of breach of express or implied warranty, negligence or otherwise.



SUB2000® GLK MODEL

* PARTS #219, #220, AND #205 ARE REPLACED FOR THE MULTI MAG VARIANT

*** PART #310 IS CALIBER AND MODEL SPECIFIC FOR REPLACEMENT (NOT SHOWN)



NOTE:
Exploded view of weapon is for reference only.
Design is subject to change without notice.

100	TRIGGER	191	RECOIL SPRING LUG	310	GENERIC MAGAZINE ***	502	STOCK PIN
103	HINGE	192	RECOIL SPRING GUIDE	315	E-CLIP	507	STOCK
105	WASHER	203	GRIP PIN SHORT	346	RECEIVER (EXCHANGE ONLY)	512	GRIP PIN LONG
109	BARREL (9MM)	205	MAG CATCH	348	EJECTOR	540	WIRE COLLAR
121	FEEDRAMP	208	MAG CATCH SPRING	351	TRIGGER GUARD	M003	WASHER
122	LOCKNUT WASHER	219	GRIP LEFT	356	TRIGGER SPRING	N001	M3 NUT
124	FOREND LEFT	220	GRIP RIGHT	360	TRIGGER BAR	P009	SEAR AXIS
125	FOREND RIGHT	223	LATCH	370	SEAR	P021	RETAINING PIN
144	OPERATING HANDLE	224	BUFFER	371	HAMMER	P026	TRIGGER / HAMMER AXIS
151	BOLT HEAD (9MM)	250	TRIGGER GUARD SPRING	372	SEAR SPRING	S006	M4 X 10 BHS
152	BOLT	255	TRIGGER BAR PIN	375	HAMMER SPRING	S007	M3 X 10 SHS
170	FIRING PIN	264	SAFETY SPRING	390	RECOIL SPRING	S023	M4 X 12 BHS
172	FIRING PIN SPRING	266	SAFETY	402	THREAD PROTECTOR	S031	M3 X 20 SHS
180	EXTRACTOR	269	SAFETY PIN	403	LOCKNUT	W002	RED O'RING
182	EXTRACTOR SPRING	273	HAMMER BUSHING	411	GRIP SNAP	W023	FOREND ORING

SUB2000® CQB

EXCLUSIVE PARTS

For any warranty issues or claims, DO NOT ship the item without first contacting KelTec's service department. Furthermore DO NOT ship without a copy of the approved BATF form.

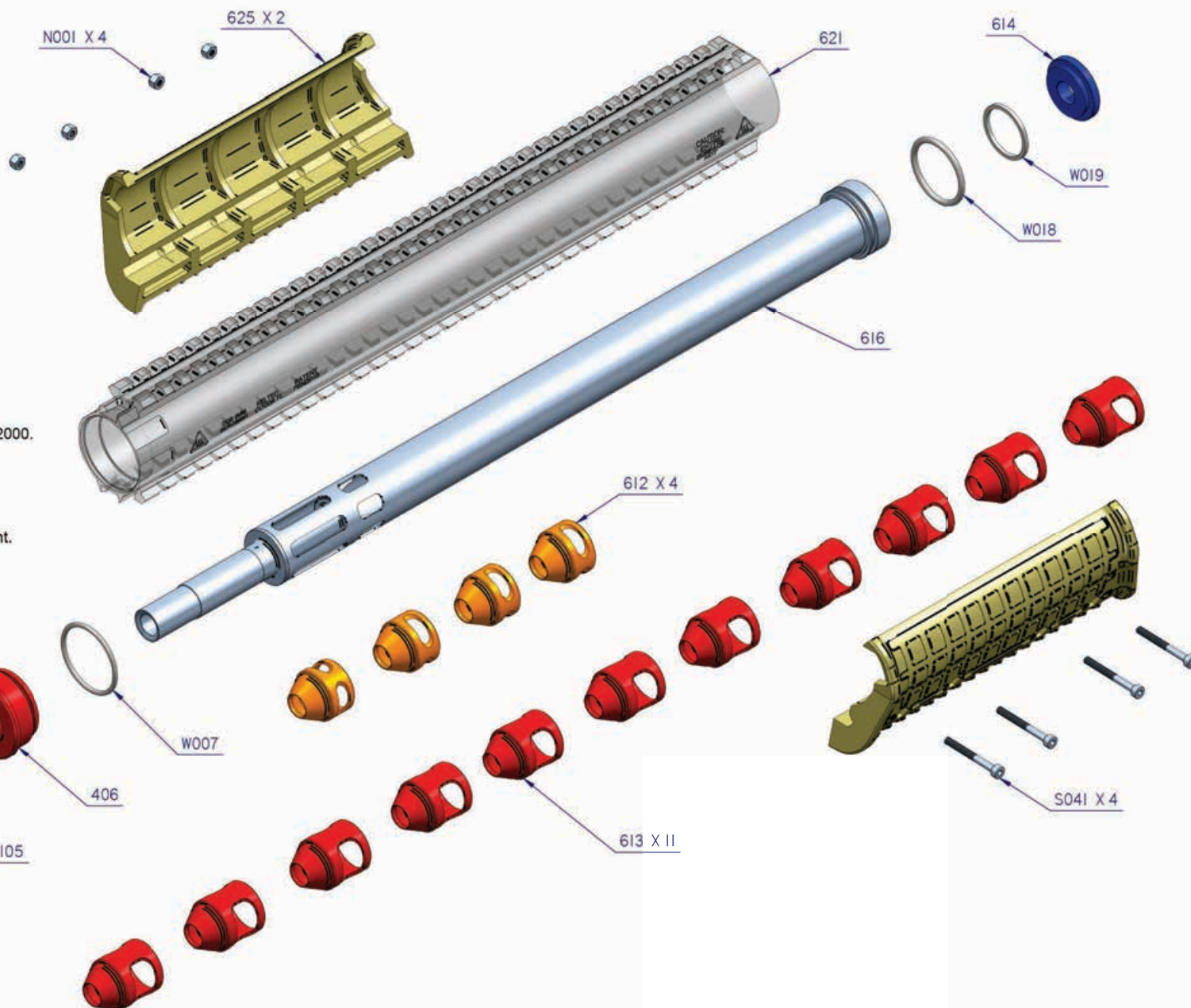
- 102 HINGE
- 105 WASHER
- 404 LOCKNUT WASHER
- 406 FOREND NUT
- 612 STEEL BAFFLES
- 613 ALUMINUM BAFFLES
- 614 END CAP
- 616 BARREL TUBE
- 617 FOREND LOCK (NOT SHOWN)
- 619 LOCK SPRING (NOT SHOWN)
- 621 OUTER TUBE (EXCHANGE ONLY)
- 625 HANDGUARD
- N001 M3 NUT
- S041 M3 X 30 SHS
- W007 2MM X 29.5MM ORING
- W018 1.25" ORING
- W019 1" SQUARE ORING

NOTE:
Parts shown are exclusive parts for the CQB model SUB2000.

Additional Part Change:

SUB2000-552 Brass Bolt replaces SUB2000-152-Bolt.

SUB2000-617 and 619 replaces SUB2000-158-Rear Sight.



NOTE:
Exploded view of weapon is for reference only.
Design is subject to change without notice.

REV 1123

NOTES

This image shows a single sheet of white paper with horizontal ruling lines. The lines are evenly spaced and run across the width of the page. There are no margins, text, or other markings on the paper.

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