



Owners Manual
MAX-11A1/15 Upper Receiver
U.S. Patent 10,794,647 B2



LAGE Manufacturing, L.L.C. 170 S. William Dillard Dr. #102, Gilbert AZ 85233
CM11A115-300

NFA Warning

This upper receiver is designed to be used with the M-11A1 .380 ACP submachine gun. NFA (National Firearms Act, Title 26, United States Code) rules apply to its use and possession.

It is the owner's/user's responsibility to comply with all local, State and Federal laws and regulations in the use of this product.

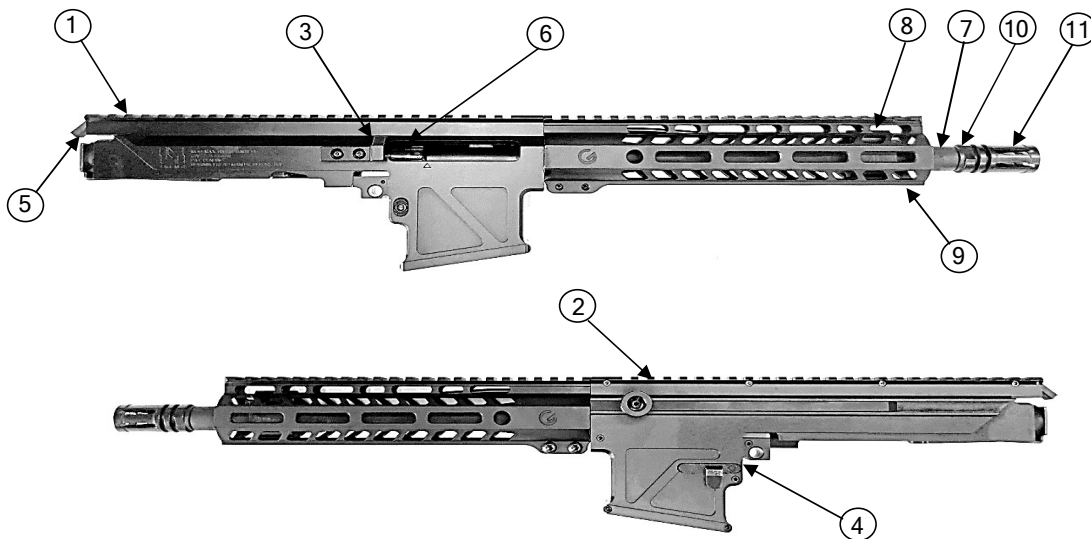
WARNING:

**READ THIS MANUAL COMPLETELY BEFORE ASSEMBLING OR OPERATING THIS UPPER RECEIVER,
TO PREVENT DAMAGE TO YOUR GUN, YOURSELF OR OTHERS.**

Description/Features

Features:

- | | |
|--|---|
| 1) Scope/Optics rail 19-3/4" | 7) 10-1/2 inch barrel (threaded 1/2-28) |
| 2) Charging Handle (non-reciprocating) | 8) Adjustable Gas Block |
| 3) Shell Deflector | 9) Handguard |
| 4) Ambidextrous Mag' Release | 10) Crush Washer |
| 5) Rear Gas Seal | 11) Flash Suppressor |
| 6) Bolt Carrier Group | |



Upper Receiver

Length: 22-1/2"
Width: 3"
Height: 4-1/2"

Overall Length When Installed on Firearm

with 9-1/2" Folding Stock Extended: 32-1/2"
with 9-1/2" Folding Stock Folded: 23-3/4"
with AR Stock Collapsed: 31-3/8"

Weight:

Upper Receiver with Internal Recoil Mechanism installed: 4 lbs, 15 oz.

Complete gun with Internal Recoil Mechanism and 9-1/2" Folding Stock installed
Unloaded: 7 lbs, 1 oz.
Loaded (30 Round Magazine): 8 lbs, 2.1 oz.

The MAX-11A1/15 is a rifle caliber upper receiver for the M-11A1 Sub Machinegun. It is chambered in 5.56 x 45mm but it is also compatible with .223 Remington ammunition.

The MAX-11A1/15 is designed to use standard AR-15 magazines.

Rate of fire is approximately 730 to 815 RPM, depending on ammunition used and the gas setting of the adjustable gas block.

The upper features a side charging, non-reciprocating, spring return charging handle on the left side.

A plastic shell deflector is fitted to provide comfortable shooting when operating left handed. Being plastic, it also minimizes deformation of the ejected brass.

Full length Picatinny rail on the top is the same height as an AR-15 flat top upper so standard AR foregrips with a rail on top are compatible.

Barrel mounting is AR compatible so different AR handguard mounts can be used, including the original AR delta ring and barrel nut.

An ambidextrous magazine release is provided to allow easy magazine changes with your left hand.

The upper receiver does not include removeable sights, scope or optics.

Barrel length is 10-1/2" and is 1:7 twist.

The MAX-11A1/15 Upper Receiver is available only with the Internal Recoil Mechanism.

Internal Recoil Mechanism (IRM)

The Internal Recoil Mechanism (IRM) consists of a Custom Bolt Assembly, Recoil Spring and Buffer and does not require drilling the rear sight plate. If a Lage Manufacturing Internal Gas Block is installed in the lower receiver, it must be removed.

NOTE: The IRM version does not include an AR Stock Assembly, as it does not require it for operation. The IRM can use any stock that will attach to the M-11A1 Lower Receiver. If you desire the AR Stock Assembly, it can be purchase seperately.

Upper Receiver

Made from 7075 aluminum and finished in Type III Black Anodize.

Charging Handle

The charging handle is a side charging, non-reciprocating, spring return design.

Shell Deflector

Deflects shells away from the shooter, especially helpful for left handed shooters. Being plastic, it also minimizes deformation of the ejected brass.

Magazine Release

The magazine release is a Troy Industries ambidextrous release. This makes magazine release with the left hand easier by just grabbing the magazine and using your thumb to swipe the magazine release lever on the left side of the gun. A standard magazine release button is located on the right side.

Rear gas seal

The upper is fitted with a rubber gas seal at the top rear to prevent smoke and debris from being directed towards the shooter's face when firing with a sound suppressor.

Piston Compatible

The upper is designed to be compatible with Adams Arms Piston kits, and possibly others. The upper receiver will accept the pressed in steel bushing.

Bolt Carrier Group

The bolt head is manufactured from Carpenter 158 steel and is Magnetic Particle Inspected (MPI). The finish is black nitride.

Barrel

Barrel is 10-1/2" long with a phosphate finish and chambered for 5.56 x 45mm ammunition. It is also compatible with .223 Remington ammunition. Rifling twist is 1:7.

Adjustable Gas Block

An Odin Works adjustable gas block is installed on the barrel. This allows the gas system to be tuned to your specific ammunition to allow softer recoil and a lower rate of fire.

Handguard

Handguard is aluminum and features M-LOK mounting points and a steel barrel nut for durability. With extensive use, the handguard can get uncomfortably hot. We recommend you install M-LOK™, TYPE 2 Rail Covers to insulate your hand from the heat transmitted from the hand guard.

Flash Hider

The flash hider is an M16-A1 style with slots around its full diameter. It is installed with a crush washer to protect the barrel shoulder and allow a non-marred surface to attach a sound suppressor. The barrel muzzle is threaded 1/2-28.

Installation

WARNING:

You **MUST** inspect your safety prior to using this upper receiver.

When using the MAX-11A1/15 upper receiver with an M-11A1 SMG that has an extended safety or aftermarket safety installed, make sure the safety positively engages in the "FIRE" and "SAFE" positions. If the safety wobbles or is easily disengaged, it may move to the "SAFE" position while firing, causing the gun to jam with bolt partially opened.

An extra strength safety spring is included for you to install. One end is larger than the other and must be twisted into the hole in the safety slide.

WARNING:

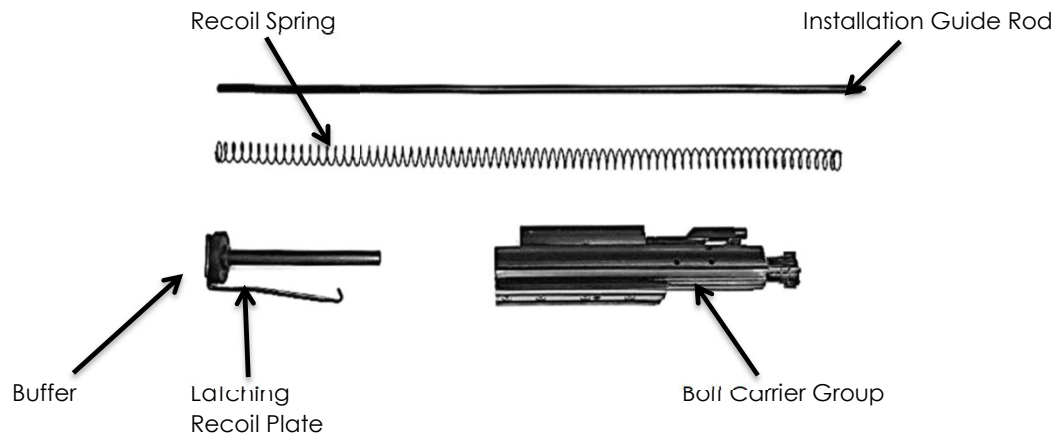
Always remember that this system works with an open bolt and fixed firing pin. Pushing the bolt into a bullet or pushing the bullet into the bolt can cause the bullet to fire.

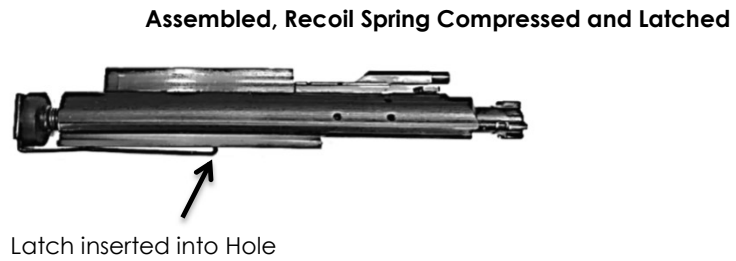
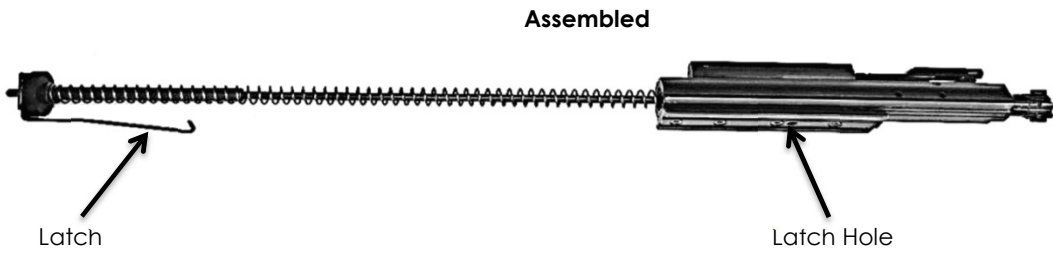
The MAX-11A1/15 Upper Receiver is available only with the Internal Recoil Mechanism.

Internal Recoil Mechanism

The Internal Recoil Mechanism (IRM) consists of a Bolt Assembly, Recoil Spring, Latching Recoil Plate and Buffer. The Buffer is preloaded onto the Recoil Plate. An Installation Guide Rod is used to install the IRM.

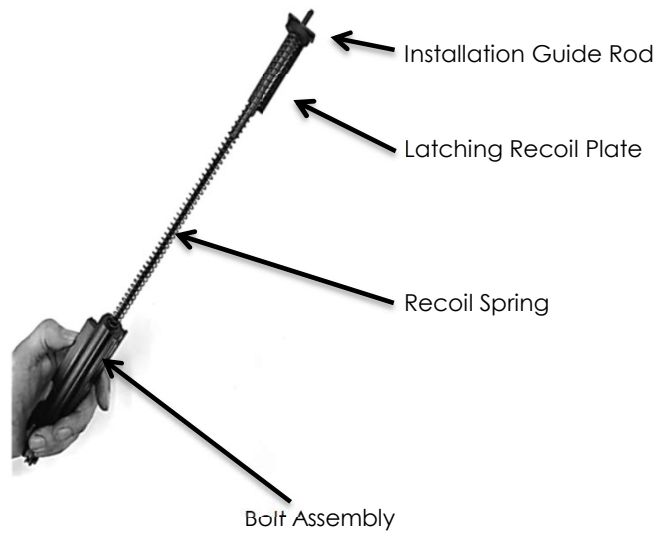
Components





To install the Internal Recoil Mechanism:

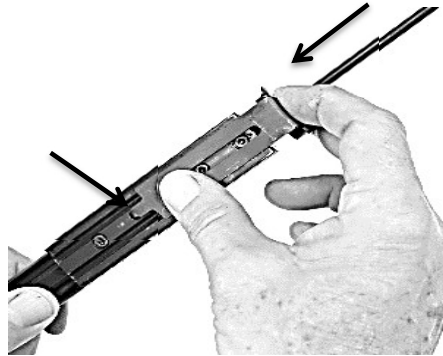
- 1) Place the bolt end of the bolt assembly against a bench or your waist.
- 2) Place the 3/16" (.187") diameter guide rod into the hole through the center of the back of the bolt assembly.
- 3) Slide the recoil spring over the rod and into the back of the bolt assembly.
- 4) Slide the recoil plate tube onto the rod with the square end opposite of the bolt assembly.



- 8) Place the bolt against a bench or your hip and align the latch on the recoil plate with the bottom of the bolt assembly and slide the recoil plate down the rod, compressing the spring.



- 9) Align the latch on the recoil plate with the bottom of the bolt assembly and slide the recoil plate down the rod, compressing the spring.



- 10) Align the hook on the latch with the corresponding hole on the bottom of the sear plate and press it into place. This will hold the recoil plate in place with the spring compressed.



11) Remove the guide rod.



12) Extend the bolt head on the bolt assembly and insert it into the rear of the upper receiver. When fully seated, the rear rectangular plate of the recoil plate will be flush with the back of the upper receiver and the rubber buffer will be inside.

13) Install the upper receiver to the lower receiver, shown in "Installation-Assembly of the upper receiver to the lower receiver" section of manual.

14) The bolt will remain in the rearward position and the trigger will not release the bolt. Fully cock the bolt back to release the bolt.

15) Perform function test shown under "Function Test" section of manual.

Removing the IRM:

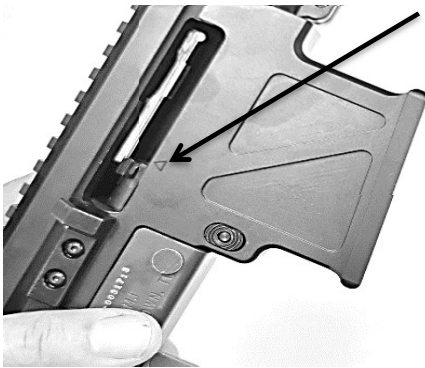
If you remove the upper receiver from the lower receiver, the recoil spring will pop free once they are separated. To make disassembly easier and prevent damage to the spring, the recoil spring can be compressed and latched in place before removing the upper from the lower receiver by doing the following:

1) Make sure magazine is empty and removed and the chamber is clear of any ammunition.

2) Pull the charging handle back until the sear catches the bolt in the rear position.

3) Insert an un-loaded M-11A1 magazine into the hand grip magazine housing of the M-11A1 Lower Receiver, but do not latch it in.

- 4) Pull the charging handle back while looking into the ejection port and align the face of the bolt with the arrow engraved on the side of the upper receiver, below the ejection port. Do not pull the charging handle back to the point that the sear catches and holds the bolt back. While holding the bolt in this position, slowly insert the magazine until the latch hooks into the hole in the bottom of the bolt assembly. You may have to position the bolt slightly in front of or behind the arrow to get it to line up properly. To test to see if the hook is engaged, release the charging handle and pull the trigger. The bolt should not release. If it does, repeat the latching process until it locks the bolt rearward.



Engraved
Arrow



- 5) Remove the retaining pin and remove the upper from the lower receiver.
- 6) Grab the recoil plate and pull the bolt assembly from the rear of the upper receiver.

To release the recoil spring from the IRM:

- 1) Insert the guide rod through the rear of the recoil plate, making sure the rod seats inside the bolt assembly.
- 2) Place the bolt end of the bolt assembly against a bench or your waist.
- 3) Maintain pressure on the guide rod and compress the rear of the recoil plate towards the front of the bolt assembly. The hook on the latch should release. If it does not, pull the hook out of the hole with your finger.
- 4) Maintain pressure on the guide rod and slowly slide the recoil plate away from the bolt assembly until the spring tension is released.
- 5) Slide the recoil plate off of the guide rod, then remove the spring and guide rod.

For long term storage, it is recommended that the IRM be stored with the recoil spring released in its extended state.

Installation- Assembly of the upper receiver to the lower receiver.

- 1) ensure firearm is unloaded. Point in a safe direction. Remove magazine and pull bolt to the rear to ensure chamber is empty.



- 2) While holding cocking knob, pull trigger and ease bolt forward



- 3) Remove retaining pin and detach upper receiver from lower receiver.



4) Rotate rubber gas block at rear top of upper receiver so that it is near horizontal.



5) Slide the upper receiver into the back of the lower receiver.



6) The rubber gas block will rotate into a vertical position when it hits the rear sight. This will keep it in position.



7) Align the retaining pin holes of the upper and lower receiver and insert retaining pin.

8) Fully retract the charging handle to release the bolt from the latch. Retract the charging handle on the left hand side of the upper receiver a couple of times to ensure the bolt is not binding.

Function Test

With the firearm **UNLOADED**, perform a function test of the fire control parts.

- 1) Rotate selector to the "SMG" or "AUTO" position.
- 2) Retract the charging handle until the bolt is held rearward with the sear.
- 3) Slide the safety rearward to the "SAFE" position.
- 4) Pull the trigger and ensure the bolt is not released.
- 5) Slide the safety forward to the "FIRE" position.
- 6) Pull the trigger and verify the bolt is released.
- 7) Retract the charging handle again until the bolt is held rearward with the sear.
- 8) Rotate selector to the "SEMI" position.
- 9) Pull the trigger and HOLD IT TO THE REAR. When the bolt slides forward, CONTINUE HOLDING THE TRIGGER TO THE REAR and retract the charging handle. WITH THE TRIGGER STILL BEING HELD BACK, the bolt should stay in the rearward position being held by the sear.

Loading and Firing

Use quality ammunition of recent manufacture. For best performance, use 5.56x45mm M193 ammunition,

DO NOT USE Laquer coated steel case ammunition. If you are unsure of the coating on your ammunition, do not use it. Through testing, we have found that this ammunition when fired can become stuck in the chamber. This can cause excessive wear on the extractor and cause it to break. Use of laquer coated steel case ammunition will void the Warranty.

When loading polymer magazines, make sure you do not overload the magazines. Many polymer magazines will allow an extra round to be loaded. This requires extra stripping force and may cause the first round of the magazine to not completely feed or fire once chambered.

The MAX-11A1/15 fires from an Open Bolt. When you cock the bolt back, it will stay back until the trigger is pulled. Unlike a standard AR-15 rifle, It will not chamber a round until it is being fired.

- 1) Rotate selector to the "SEMI" or "AUTO" position.
- 2) Cock the bolt back before inserting a loaded magazine.
- 3) Keep gun pointed in a safe direction and insert a loaded magazine.
- 4) Slide the safety forward to the "FIRE" position.
- 5) Aim at target and fire.
- 6) When finished firing, cock the bolt back and slide the safety to the rearward "SAFE" position.

Adjustable gas block

The MAX-11A1/15 upper receiver features an Odin Works Adjustable Gas Block.

It is pre-set at the factory at 11 clicks from fully closed. With this setting, the MAX-11A1/15 should run most ammunition without a problem, but you should adjust the gas system to its lowest setting for the ammo you are using. This will provide the lowest rate of fire, make the gun more controllable and reduce wear and tear on your lower receiver. If you change the ammunition that you have the gas block adjusted to, you may have to readjust the gas setting.

To adjust the gas system:

- 1) Slide the safety to the "FIRE" setting, rotate the selector to "Semi" and cock the bolt back.
- 2) Insert a magazine loaded with three rounds of ammunition. Fire one round and verify the bolt locks back after the first shot.

If it fires one round:

- 1) Remove the magazine and pull the charging handle back to ensure there is not a round in the chamber or receiver.
- 2) Use the provided 7/64" (.109") Allen Wrench to adjust the gas block by rotating the adjusting screw one click clockwise (when viewed from the muzzle end). When adjusting the screw, make sure the muzzle is pointed in a safe direction.
- 3) Reload three rounds in the magazine and shoot the gun again, verifying it shoots only one round. Repeat the process above if it does.
- 4) When you have adjusted it so that it will fire more than one shot or the bolt short strokes and does not pick up another round, rotate the adjusting screw two clicks counter clockwise.
- 5) When finished adjusting, load 30 rounds in a magazine and fire all 30 rounds in sem-automatic mode to make sure that it only fires one shot, as intended.
- 6) Continue to adjust the gas block if it does not.

If it fires more than one round or short strokes the bolt and has a feed jam:

- 1) Remove the magazine and pull the charging handle back to ensure there is not a round in the chamber or receiver.
- 2) Use the provided 7/64" (.109") Allen Wrench to adjust the gas block by rotating the adjusting screw one click counter clockwise (when viewed from the muzzle end). When adjusting the screw, make sure the muzzle is pointed in a safe direction.
- 3) Reload three rounds in the magazine and shoot the gun again, verifying it shoots only one round. Repeat the process above, if it does not. When you have adjusted it so that it will only fire one shot, rotate the adjusting screw one more click counter clockwise.
- 4) When finished adjusting, load 30 rounds in a magazine and fire all 30 rounds in semi-automatic mode to make sure that it only fires one shot, as intended.
- 5) Continue to adjust the gas block if it does not.

For reference, here are some starting points for different ammo.

Standard Spring (Bronze .455" Dia.)						
Ammo	Wolf					
	Federal M193		Military Classic		Wolf Performance	
	Clicks	ROF	Clicks	ROF	Clicks	ROF
	7	731	10	794	10	813

Optional Heavy Spring (Black .440" Dia.)						
Ammo	Wolf					
	Federal M193		Military Classic		Wolf Performance	
	Clicks	ROF	Clicks	ROF	Clicks	ROF
	7	884	10	917	10	925

Rate Of fire (ROF) is approximate. Clicks are measured from the fully screwed in or closed position.

With extensive use, the gas adjusting screw may become carbon fouled, stuck or stripped. Odin Works sells an inexpensive rebuild kit to solve this problem.

WARNING:

If the bolt is ever jammed shut, it is safest to assume that there is a live round and not an empty shell in the chamber. Furthermore, do not insert a cleaning rod or other rod down the barrel and attempt to hammer out the round or empty shell. With a live round in the chamber, hammering it out will cause the fixed firing pin to impact the primer causing the round to discharge along with what ever rod or device you inserted.

If the bolt ever jams shut or partially extracts with a stuck shell, wait a couple of minutes to ensure the round is not a "hang fire". Then, point the gun in a safe direction and carefully remove the upper from the lower receiver by removing the retaining pin and pulling the upper forward and up from the lower receiver.

If the gun jams with the bolt partially rearward and the safety has slid to the forward "Safe" position, point the firearm in a safe direction and use a punch to drive out the retaining pin so the upper can be removed from the lower receiver. Once the upper is removed, the bolt will freely move and eject the round.

Do not try to "Mortar" the bolt back to unjam it. The bolt is wedged between the sear and internal safety slide underneath it. This creates a wedge which is only increased when the bolt is forced back. Do not slam the muzzle down onto a surface or hammer it to create inertia to move the bolt forward. If there is a live round in the chamber, you risk igniting the round.

This type of jam is caused by a weak safety spring or use of an aftermarket or extended safety. Replace safety spring with the one provided with the upper receiver.

Cleaning and Maintenance

Recommended cleaning interval is every 500 rounds.

- 1) Remove the Bolt Carrier Group and clean and lubricate it.
- 2) Clean the inside of the upper receiver and Charging Handle slot. You can clean the charging handle slot by using solvent and compressed air or an aerosol cleaner (automotive brake cleaner works well). Add a couple of drops of gun oil into the Charging Handle Slot and Spring inside the upper receiver.
- 3) Clean and lubricate the barrel and chamber area.
- 4) Clean and lightly lubricate the recoil spring.

We recommend replacing the AR Bolt Assembly (bolt head, gas rings, cam pin and extractor, extractor spring, extractor o-ring and extractor pin) every 5,000 rounds.

The upper receiver is a two piece design with left and right sides that are secured with screws. The halves do not need to be disassembled for routine maintenance.

The Charging Handle Assembly is secured within the left half of the upper receiver and does not need to be removed for cleaning.

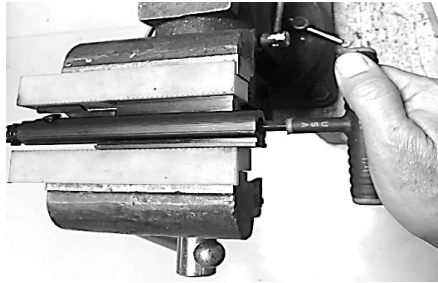
The Barrel assembles into the upper receiver in the normal manner that an AR-15 barrel is installed except the barrel nut requires a 30 mm wrench to remove or install it.

The IRM Latch may become deformed with use or with improper installation or removal. If you have trouble getting the IRM Latch to engage or release, use the attached MAX-11A1/15 IRM Latch Template as a guide for reforming the shape of the latch so it works correctly.

IRM Bolt Carrier Group (BCG) Disassembly

To disassemble the BCG for cleaning or maintenance:

- 1) Place the BCG in a smooth faced vise, laying the BCG on it side so you can clamp onto the top and bottom of the BCG.
- 2) Using the provided 1/4" T-Handle Driver, insert it into the rear of the Bolt Carrier and into the Firing Pin Set Screw. Loosen the Firing Pin Set Screw by turning counter-clockwise. If the screw does not come all of the way out, tap the back of the BCG on a hard piece of wood to shake it out.



- 3) Once the Firing Pin Set Screw is removed, the Firing Pin, Bolt Cam and Bolt can be removed. These parts remove and install the same as any AR-15 BCG parts.

NOTE: Do not disassemble the sear plate from the bottom or the bolt weight from the top. They do not need to be removed for maintenance and are secured by Rockset thread locker.

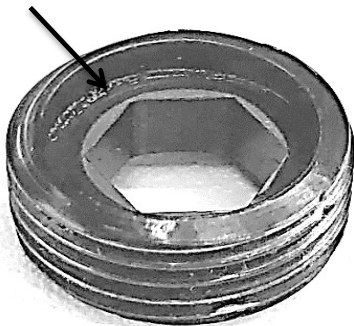
To reassemble the BCG:

- 1) Re-install the Bolt and Cam Pin.
- 2) Insert the Firing Pin and then the Firing Pin Set Screw. Make sure the end of the Firing Pin Set Screw that has the counterbore is facing forward.

Counter Bore Side

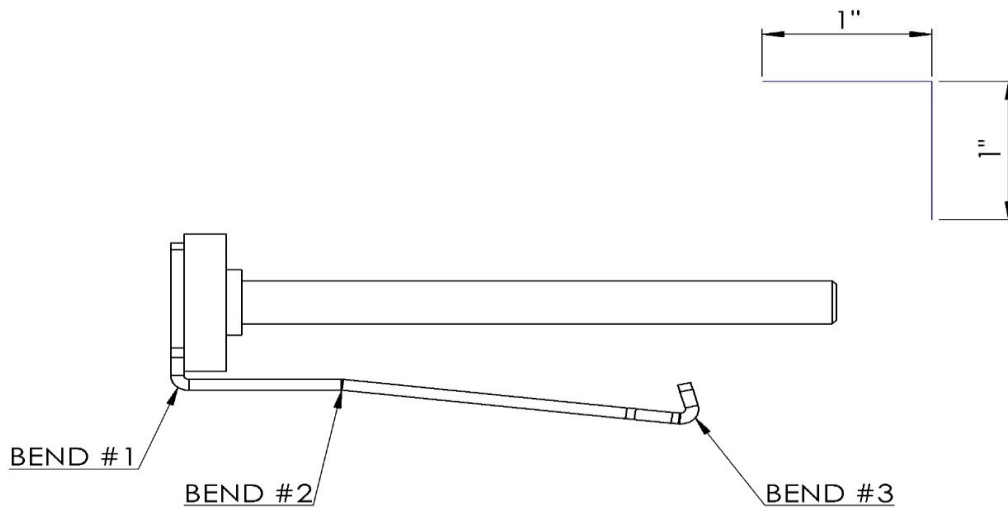
Wrench Side

Counter Bore



- 3) Place the BCG in a smooth faced vise, laying the BCG on it side so you can clamp onto the top and bottom of the BCG.
- 4) Insert the 1/4" T-Handle Driver into the Firing Pin Set screw and tighten it snug.

MAX-11A1/15 IRM LATCH TEMPLATE



THE IRM LATCH WILL VARY IN SHAPE WITH USE.

FOR PROPER FUNCTION, MAKE SURE THE BENDS IN THE IRM LATCH CLOSELY MATCH THE PROFILE ABOVE.

THERE SHOULD ONLY BE THREE BENDS IN THE LATCH.

LAGE MANUFACTURING, L.L.C.
04/07/22

Bolt Cam Pin Wear in Upper Receiver

With use, you may notice wear in the upper receiver from the Bolt Cam Pin. This is normal wear and will not affect the function of the upper receiver and is common in AR-15 rifles.



BATFE Notification letter:

PLEASE NOTE:

Upon assembly of the Lage Manufacturing, L.L.C. MAX-11A1/15 caliber conversion device to a machinegun frame, you must contact ATF, National Firearms Act Division (NFAD) with written notification of the change in caliber, barrel length and overall length.

Here is a sample letter format to use:

Mailing address:

ATF
National Firearms Act Division
244 Needy Road
Martinsburg, WV 25405

Dear Sirs,

I have a legally registered (insert manufacturer's name and model and serial number, eg: RPB M-11A1, S/N 0000001) machine gun in .380 ACP caliber.

I will be attaching a Lage Manufacturing, L.L.C. MAX-11A1/15 caliber conversion device to this machine gun. When the conversion device is attached, the caliber, barrel length and overall length will temporarily be changed to:

Caliber- 5.56 x 45mm

Change in Barrel length- 10-1/2"

Change in Overall Length- (enter your overall length from end of buttstock to end of barrel)

Sincerely yours,

(Sign your name)

Mail to:

ATF
National Firearms Act Division
244 Needy Road
Martinsburg, WV 25405

Warranty and Repair

WARRANTY

Note: Use of reloaded/remanufactured ammunition or laquer coated ammunition will void your warranty

The MAX-11A1/15 Upper Receiver has been manufactured in a manner to ensure it is defect free and durable. LAGE Manufacturing, L.L.C. warrants to the original purchaser that this product is free from defects in materials and workmanship for the period of One Year from the original date of purchase. This warranty does not apply to damage due directly or indirectly, to misuse, abuse, negligence or accidental, repairs or alterations outside our facilities or to lack of maintenance. We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special or consequential damages arising from the use of this product. The above limitation of exclusion may be subject to state law and may not apply to you.

To utilize this warranty, the MAX-11A1/15 Upper Receiver must be returned to us packaged in a manner to preclude damage during transit and with shipping charges prepaid. Proof of purchase date and a written description of the complaint must be included. If upon inspection, the complaint is verified, we will either repair or replace the product at our election or we may elect to refund the purchase price if we cannot readily and quickly provide a replacement. We will return the repaired product at our expense, but if we determine that there is no defect, or that the defect was a result of causes not within the scope of this warranty, then you must bear the cost of returning the product.

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