

INSTRUCTION & SAFETY MANUAL

# MODEL ULTRASTAR 40

CALIBER .40 S&W

READ CAREFULLY BEFORE USING  
YOUR FIREARM



## 10 COMMANDMENTS OF FIREARMS SAFETY

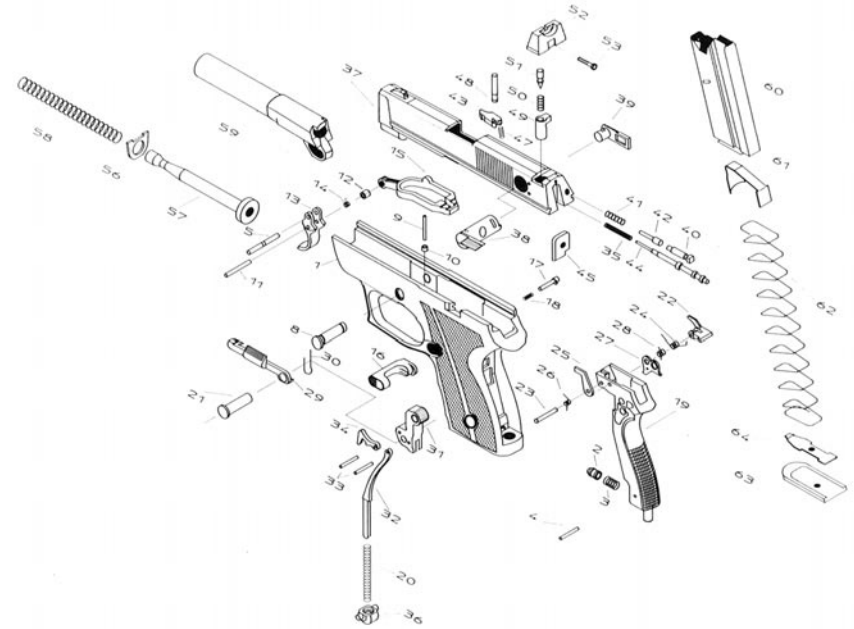
- 1 ALWAYS** treat every gun as if it were loaded.
- 2 ALWAYS** be sure the barrel is clear of any obstruction.
- 3 ALWAYS** be sure of your backstop, what lies beyond and the safety of bystanders before you shoot.
- 4 ALWAYS** use clean, dry, original factory-made ammunition of the proper type and caliber for your gun.
- 5 ALWAYS** wear shooting glasses and ear protection when shooting.
- 6 ALWAYS** carry your gun so that you can control the direction of the muzzle if you fall or stumble.
- 7 ALWAYS** leave the safety on until you intend to fire.
- 8 NEVER** leave an unattended gun loaded. Guns and ammunition should be stored separately, locked if possible, beyond the reach of children and carelèss adults.
- 9 NEVER** allow your firearm to be used by anyone who has not read this Instruction and Safety Manual.
- 10 NEVER, NEVER... EVER...** point any gun, loaded or unloaded, at anything you do not intend to shoot.

## TECHNICAL DESCRIPTION

<b>CONSTRUCTION</b> .....	Polymer Frame
<b>OPERATING</b>	
Operating principle.....	Semi-automatic with short recoil of barrel.
Firing mechanism.....	Self-cocking with selective Double Action
Caliber.....	.40 S&W
<b>DIMENSIONS AND WEIGHT</b>	
Overall length.....	176 mm. = 6.93 in
Height.....	126 mm. = 4.96 in
Width.....	29.5 mm. = 1.16 in
Barrel length.....	89 mm. = 3.50 in
Sighting line.....	134 mm. = 5.27 in
Front sight width.....	3.25 mm. = .128 in
Rear sight notch width.....	3.5 mm. = .138 in
Weight of pistol with empty magazine.....	737 grs. = 26 oz
Magazine capacity.....	8 rounds

## ULTRASTAR PARTS LIST

1 Frame	23 Sear and ejector pin	43 Extractor
2 Backstrap retaining plunger	24 Sear spring	44 Firing pin
3 Backstrap retaining plunger spring	25 Ejector	45 Firing pin retainer
4 Backstrap retaining plunger pin	26 Ejector spring	47 Extractor spring
5 Trigger pin	27 Sear pusher	48 Extractor pin
8 Barrel pin	28 Sear pusher spring	49 Firing pin safety
9 Barrel pin spring	29 Slide stop lever	50 Firing pin safety spring
10 Barrel pin spring bushing	30 Slide stop spring	51 Firing pin safety spring pin
11 Trigger bar pin	31 Hammer body	52 Rear sight body
12 Trigger bar bushing	32 Hammer bar	53 Rear sight screw
13 Trigger body	33 Hammer bar and lock pins	56 Recoil Buffer
14 Trigger spring	34 Hammer lock	57 Recoil spring guide
15 Trigger bar	35 Firing pin spring	58 Recoil spring
16 Magazine catch body	36 Hammer Spring Support	59 Barrel
17 Magazine catch lock	37 Slide	60 Magazine tube
18 Magazine catch spring	38 Firing pin safety roller	61 Magazine follower
19 Backstrap	39 Thumb safety wing, right	62 Magazine follower spring
20 Hammer spring	40 Thum safety retaining plunger	63 Magazine floor plate
21 Hammer pin	41 Thumb safety spring	64 Magazine floor plate catch
22 Sear	42 Thumb safety positioning plunger	



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OPERATING AND DISASSEMBLY INSTRUCTIONS FOR STAR  
MOD. ULTRASTAR PISTOL IN CALIBER .40 S&W

**BASIC SAFETY PRECAUTIONS**

Always treat the pistol as if it were loaded.

Whenever first picking up the pistol, or before handing it to anyone else, carefully check to determine whether it is loaded. Inspect both the magazine and the chamber.

Never point the pistol -even if it is unloaded- at anything you do not wish to shoot.

Whenever handling the pistol, always keep the safety "ON" and your finger away from the trigger until you are ready to fire. Put the safety "ON" immediately after you cease firing, and leave it "ON" while transporting or storing the pistol.

Always keep the muzzle pointed in a safe direction until you are ready to fire. Do not allow any part of your body to get in front of the muzzle.

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(Fig. 1)

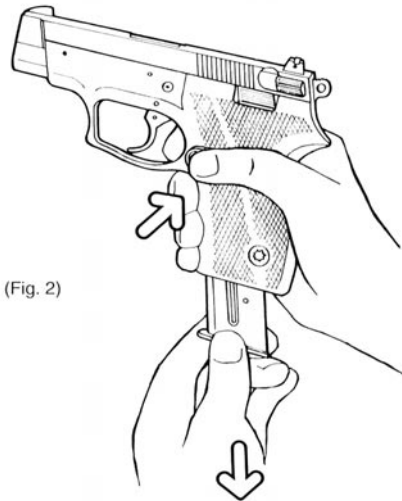
**TO OPERATE THE THUMB SAFETY / DECOCKING LEVER**

The manual safety is ambidextrous, and consists of two interconnected thumb levers, one on each side of the slide. The safety is "ON" (i.e., in the Safe position) when either lever is pushed upward to cover the red indicator dot on the left side of the slide and expose the white indicator dot. The safety is "OFF" (i.e., in the Fire position) when either lever is pushed down so that the white dot is covered and the red dot is exposed. Always point the muzzle in a safe direction when operating the safety lever.

Rotation of either lever to the "ON" position retracts the firing pin (44) into the slide (37) where it cannot be reached by the hammer (31). It also mechanically immobilizes the firing pin (44) in the retracted position.

The manual safety also functions as a selective decocking lever, allowing the shooter to lower the hammer from its full-cock position without pressing the trigger (13) and with the safety "ON". To use the decocking feature, keep the muzzle pointed in a safe direction and push either safety wing "ON". Continue pressing the lever upward further until the hammer (31) snaps down to the uncocked position. The safety is "ON" throughout, preventing the pistol from firing. When the wing is released, it automatically returns to the "ON" position.

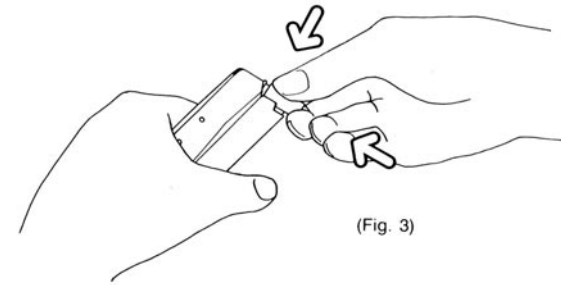
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(Fig. 2)

#### TO REMOVE THE MAGAZINE

With the safety "ON" and the muzzle pointed in a safe direction, depress the magazine catch bodis (16) on the frame behind the trigger guard and withdraw the magazine.

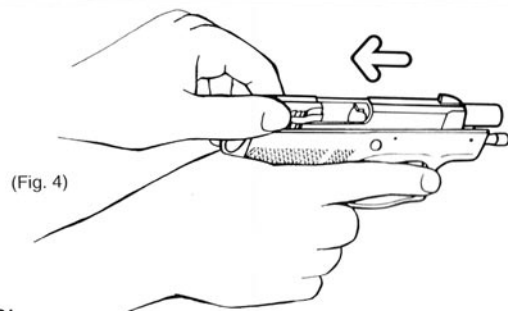


(Fig. 3)

#### TO LOAD THE MAGAZINE

Load the magazine by inserting each cartridge in two motions: first DOWN to compress the magazine follower spring (62), then REARWARD to slide the cartridge under the magazine lips. The magazine will hold up to 8 cartridges. Holes in both sides of the magazine allow visual confirmation of the number of cartridges inserted. To empty the magazine, push (do not pull) each cartridge forward until it is no longer held by the magazine lips.

**CAUTION:** take care not to bend, distort or pry the magazine lips when loading cartridges. Press down the column of cartridges until the top cartridge can be moved smoothly under the lips. **DO NOT USE EXCESSIVE FORCE;** damaged magazine lips will cause malfunctions.



#### TO LOAD AND FIRE THE PISTOL

Hold the pistol in a shooting grip with the muzzle pointed in a safe direction or at the target. Put the safety "ON". Insert the magazine into the pistol until it is held by the magazine catch (16). Grasp the serrated surfaces of the slide between thumb and index finger and pull the slide rearwards as far as it will go, then release it smartly. The compressed recoil spring (58) will snap the slide closed, stripping the topmost cartridge from the magazine and loading into the barrel chamber. (Do not "ride" the slide forward with your hand; impeding the slide's movement may cause a feeding jam.)

The pistol is now loaded, hammer cocked and safety "ON". The pistol is ready to fire as soon as the thumb safety is pushed to "OFF" (red indicator dot exposed). If you do not intend to immediately commence firing, decock the hammer. Use either safety wing, not the trigger, for this purpose.

This pistol features two trigger function modes: single-action and double-action. Double-action provides a capability of carrying the loaded pistol safely with the hammer uncocked, yet ready for instant firing simply by pushing the safety "OFF" and pulling the trigger. (If, after de-cocking the shooter desires to fire the first shot single-action, the hammer must first be manually recocked with the thumb.)

#### A) Single-action mode

The hammer is cocked. Push the safety "OFF". Take aim and lightly squeeze the trigger. The trigger operates in two stages: it first disengages a trigger-actuated firing pin block to permit forward travel of the firing pin. It then releases the hammer, causing it to fall and strike the firing pin. The firing pin (44) is driven forward to indent the cartridge primer and fire the pistol.

#### B) Double-action mode

The hammer is uncocked. Push the safety "OFF". Take aim and pull the trigger firmly through the full stroke of its travel. In a single motion this will cock the hammer, disengage the firing pin block and then release the hammer to fire the pistol.

After the first shot has been fired from either mode, the hammer will be automatically recocked by the recoil of the slide and all subsequent shots will be fired in single-action mode unless the shooter voluntarily decocks the hammer.



(Fig. 5)

#### FURTHER HANDLING OF THE PISTOL

When the last shot in the magazine has been fired, the slide will remain open. To resume firing: while keeping the pistol pointed at the target or in a safe direction, insert another loaded magazine and pull down the slide stop lever (29). The slide will snap closed, chambering the first cartridge. The pistol will once again be loaded, hammer cocked, and ready to fire.

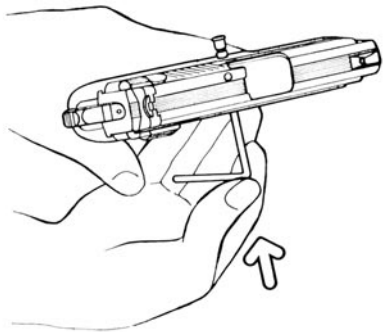
Do not turn away from the target without putting the safety "ON". If firing is discontinued while the pistol is still loaded, keep the muzzle pointed at the target or in a safe direction. Push the safety "ON". First remove the magazine, then pull back the slide smartly to eject the cartridge remaining in the chamber. Visually inspect the chamber to be sure it is empty and unload the magazine.

#### TO DISASSEMBLE THE PISTOL FOR CLEANING

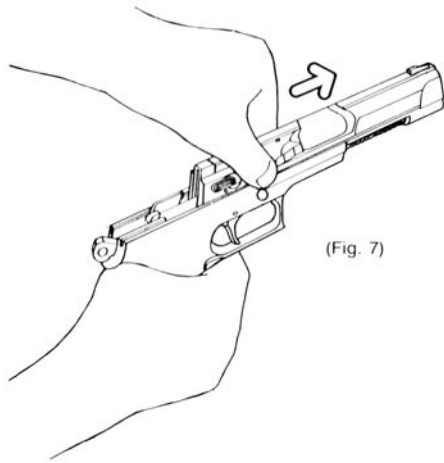
Put the thumb safety "ON" and make sure the firearms is unloaded. Remove the magazine, move the slide slowly backwards while gently depressing the right side of the barrel pin; this will eventually slide all the way from right to left by pushing from the right. The slide-barrel assembly can then be removed by sliding forward and out of the frame (see fig. 6 & 7).

The recoil spring assembly is removed from the slide by slightly compressing the spring and pulling the recoil guide head; the barrel can now be removed by pulling it a little forward and then back and out of the slide (see fig. 8 & 9).

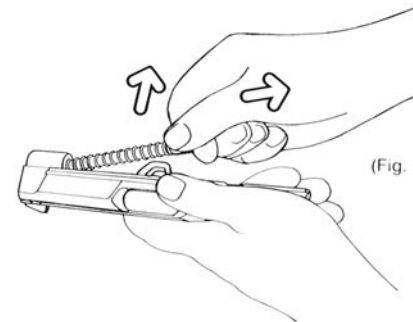
NO FURTHER DISMOUNTING IS NECESSARY TO PROPERLY CLEAN THE PISTOL.



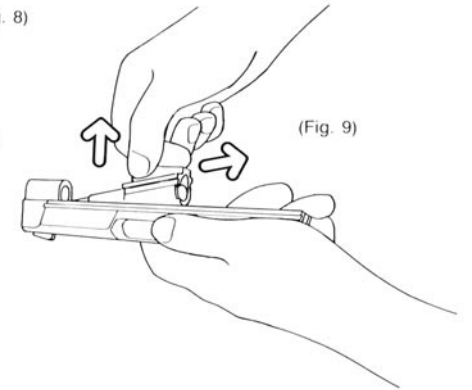
(Fig. 6)



(Fig. 7)



(Fig. 8)



(Fig. 9)



**STAR BONIFACIO ECHEVERRIA S.A.**

C/ TORREKUA, 3 - P.O. BOX 10  
TELF. (43) 10 73 40  
TELEX 38658 BEIA E - CABLE «STAR»  
FAX (43) 10 15 24  
**20600 EIBAR** (GUIPUZCOA) SPAIN

## SAFETY PRECAUTIONS

Here follow a few safety warnings which we strongly recommend you read and comprehend thoroughly before making first use of your firearm:

### AMMUNITION

**1** Use only high quality, original factory-manufactured ammunition. Do not use cartridges which are dirty, wet, corroded, bent, or damaged. Do not oil cartridges. Do not spray aerosol-type lubricants, preservatives, or cleaners directly onto cartridges or where excess spray may flow into contact with cartridges. Lubricant or other foreign matter on cartridges can cause potentially dangerous ammunition malfunctions. Use only ammunition of the caliber for which your pistol is chambered. The proper caliber is permanently engraved on your pistol; never attempt to use ammunition of any other caliber.

**2** The use of reloaded, 'remanufactured', hand-loaded, or other nonstandard ammunition voids all warranties. Reloading is a science and improperly loaded ammunition can be extremely dangerous. Severe damage to the firearm and serious injury to the shooter or to others may result. Always use ammunition that complies with the industry performance standards established by the Sporting Arms and

Ammunition Manufacturers' Institute, Inc. (SAAMI) of the United States.

**3** If there is any reason to suspect that a bullet is obstructing the barrel, immediately unload the firearm and look **through** the bore. It is not sufficient to merely retract the slide and look in the chamber. A bullet may be lodged some distance down the barrel where it cannot easily be seen. If a bullet is in the bore, **do not attempt to shoot it out with another cartridge, or attempt to blow it out with a blank cartridge from which the bullet has been removed. Such techniques can generate excessive pressure, wreck the firearm, and cause serious personal injury.** If the bullet can be removed with a cleaning rod, clean any unburned powder grains from the bore, chamber, and mechanism before resuming shooting. If the bullet cannot be dislodged by tapping it with a cleaning rod, take the firearm to a gunsmith.

I

### USE OF THE SAFETY

**1** Risk of an accident is greatly increased when any semi-automatic pistol, no matter how safely designed, is carried with a cartridge in the chamber. This practice is not recommended and may be justified only in circumstances of clear and present danger, when the pistol may immediately have to be used in self-defense. By far the safest procedure when carrying a loaded pistol is to leave the chamber empty.

**2** If you **MUST** carry a semi-automatic pistol with a cartridge in the chamber, always lower the hammer to the uncocked position. If your pistol is equipped with a hammer-lowering lever, use the lever (NOT the trigger) to uncock the hammer. In addition, if your pistol is equipped with a manual safety, never carry the pistol with a cartridge in the chamber unless the safety is "on". Leave the safety "on" until you are ready to shoot and the firearm is pointed at the target!.

**3** When uncocking the hammer, always ease the hammer down, **NEVER LET IT SNAP DOWN, AS THIS MAY CAUSE THE PISTOL TO FIRE ACCIDENTALLY.**

**4** On some semi-automatic pistols it is possible to lower the hammer to a "half-cock" position. Do not use this feature as a safety! It is not designed or suitable for that purpose. The "half-cock" serves only to prevent unintended firing in case of internal breakage or malfunction or in case your thumb slips off the hammer during manual cocking. To prevent accidents, it is absolutely essential to use the manual safety (or, on some double-action pistols not equipped with a manual safety, you must use the hammer-lowering lever).

**5** Always point the muzzle in a safe direction when manually operating the slide to load the first cartridge from the magazine into the chamber. Malfunctions, which allow the pistol to fire without the trigger being pulled when the slide snaps closed, are rare but CAN happen. Always grip the slide so that your fingers, hand, elbow, and other parts of your body are **BEHIND** the pistol.

II

*Important Note: These are generic safety instructions for all Star pistols. Item number three dates from before decocker levers, and is referring to not pulling the trigger to drop the hammer. It is completely acceptable to "snap" the hammer down with a decocker lever, of course.*

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## LOADING AND UNLOADING

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- 1** Always keep the muzzle pointed in a safe direction.
- 2** Never attempt to load or unload any firearm inside a vehicle, building, or other confined space other than a properly constructed shooting range. Enclosed areas frequently offer no completely safe direction in which to point the firearm; if an accidental discharge occurs, there is great risk of injury or property damage.
- 3** Before loading, always clean all grease and oil from the bore and chamber, and check to be certain that no obstruction is in the barrel. Any foreign matter in the barrel could result in a 'bulged' or burst barrel or other damage to the firearm, and could cause serious injury to the shooter or to others.
- 4** Remember to unload the chamber after removing the magazine!
- 5** Never assume any gun is empty until you have checked it personally!
- 6** Always point the muzzle in a safe direction when manually operating the slide to load the first cartridge from the magazine into the chamber. Malfunctions which allow the pistol to fire without the trigger being pulled when the slide snaps closed are rare but CAN happen. Always grip the slide so that your fingers, hand, elbow, and other parts of your body are BEHIND the pistol.

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## AIMING

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- 1** Never point any firearm - loaded or unloaded - at anything you do not intend to shoot. Keep the muzzle pointed in a safe direction and keep your finger off the trigger until you are ready to fire.
- 2** Always make certain that your backstop is adequate to stop and contain your bullets. Remember, your bullet can carry for more than one mile. Never shoot at hard surfaces like rock or water; the bullet could ricochet and travel in any direction to strike you or a person or object you cannot see, causing serious injury or property damage.

III

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## FIRING

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- 1** Never carry about or leave unattended any firearm which is cocked and ready to fire! Accidental firing could result if you fall or drop the firearm, or if the firearm is struck or disturbed by someone or something.
- 2** Never fire any pistol with your finger, hand, face, or other part of your body over or adjacent to the ejection port, or in any position where you may be struck by the reciprocating movement of the slide. Failure to heed this warning could result in bodily injury. Both the movement of the slide and the ejection of empty cartridge cases are part of the normal operating cycle of a pistol and pose no safety hazard to the shooter if the pistol is held in a normal grip and fired at arm's length, as intended by its design.
- 3** Never allow other persons to stand beside you where they might be struck by an ejected cartridge case. The case is hot and may be ejected with sufficient force to cause a burn or a cut or injure an unprotected eye. Make certain there is a clear, unobstructed path for safe ejection of the fired case. Remember, the case may bounce off a hard object nearby and strike you or another person.
- 4** While shooting, should your firearm develop a mechanical malfunction or binding, 'spits' powder gas, or if a cartridge primer is punctured, a cartridge case is bulged or ruptured, or if the report on firing does not sound quite right, **STOP SHOOTING IMMEDIATELY!** It may be dangerous to continue. **UNLOAD THE FIREARM — DO NOT TRY 'JUST ONE MORE SHOT'.** Take the firearm **and the ammunition** to a gunsmith for examination.
- 5** Do not assume that the pistol is empty merely because the slide remains open. A cartridge jammed between the slide and the barrel can also prevent the slide from closing. Always look in the chamber to make sure!
- 6** If a jam occurs, clear it as follows. While keeping the muzzle pointed in a safe direction remove the magazine. Pull back the slide and lock it to the rear by pushing up the slide release. The jammed cartridge or case can now be removed by shaking it out or by picking it out with your fingers.

IV

#### SHIPPING INSTRUCTIONS

1. Federal law permits you to ship your pistol, revolver, rifle, or shotgun to us via common carriers such as United Parcel Service (UPS). Rifles and shotguns may also be sent through the U.S. Mail, but only federally licensed dealers may mail pistols or revolvers. Because state and local laws vary greatly and may impose additional restrictions on your shipment or receipt of firearms, it is strongly recommended that any firearm returned to us be shipped through a federally licensed dealer.
2. Firearms must be sent to us with the shipping charge prepaid. **WE WILL NOT ACCEPT COLLECT SHIPMENTS.** Send to: Interarms, 10 Prince Street, P.O. Box 208, Alexandria, VA 22313. Upon receipt of your firearm, we will send you an acknowledgment.
3. Be sure to enclose a letter referencing the model and serial number of your firearm. Please describe the SPECIFIC nature of the difficulty experienced or work required ("Defective" or "Jams" or "Repair as needed" is not sufficient information). **IF THERE IS A FUNCTIONING PROBLEM, PLEASE IDENTIFY THE BRAND AND TYPE OF AMMUNITION BEING USED.** Enclose copies of any previous correspondence.
4. **FIREARMS MUST BE SHIPPED UNLOADED!** Please double-check that the chamber and magazine are empty before shipping.
5. **DO NOT** include telescopic or laser sights, custom grips, holsters, gun cases, or other accessories with any firearm shipped to us, as we cannot accept responsibility for possible damage caused in transit.
6. When the work is completed, your firearm will be returned via UPS, with the return shipping charge prepaid by us.

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### STAR LIFETIME PLUS\* FREE REPAIR PROTECTION

Without modifying or extending our normal Limited Warranty, Star Bonifacio Echeverria S.A. provides Lifetime Plus\* repair on any Star firearm bought new after May 1, 1995 for as long as it is owned by the original retail purchaser\*. If in normal service the firearm ever needs repair, it will be fixed free of charge.

The firearm must be returned with the shipping charge prepaid to Star's Authorized Warranty and Service Center, accompanied by a copy of the original purchase receipt showing the model, serial number and date of purchase. Descendants may be required to show proof of relationship.

Finish wear, damage caused by reloaded or improper ammunition or by abuse, corrosion or neglect, and problems resulting from unauthorized repairs or modifications are excluded. **THE LIMITATIONS AND EXCLUSIONS CONTAINED IN THE STAR LIMITED WARRANTY ARE ALSO INCORPORATED HERE.**

**\* OR ANY CHILD OR GRANDCHILD OF THE ORIGINAL PURCHASER.**