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**sub**  
*advanced diving  
technology*

# X-FIRE

Fucile ad elastico  
Arbalete spearguns  
Arbaletes a Sandow  
Fusiles Elasticos de buceo  
Λαστιχοβόλο ψαροντούφεκο



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## Introduction

*Congratulations for having chosen the quality and reliability of a SEAC Diving Pro product. The equipment you have purchased was made with selected and tested materials. Development and constant research allow us to evolve continually. Innovative manufacturing processes, constant controls and testing, as well as testing under real conditions guarantee the reliability that all SEAC Diving Pro products are known for.*

### ► **Attention!**

**Read this entire manual before using this equipment!**

**This manual must be retained for as long as you own the product!**

## General warnings

- ▶ Before using the underwater gun you must be familiar with all the safety regulations. Follow the indications in the instruction manual carefully and obey pertinent national and local laws; those concerning the minimum age limit for using this product, proper conduct during its use and transport, the areas where it is allowed, and warning devices, etc. The improper use of diving equipment by unlicensed persons, and in particular, the use of the spear gun, can be dangerous and may cause serious or fatal injuries to the diver and his companions.
- ▶ During the assembly and finishing of the Arbalete spear gun, all possible provisions were made to supply a highly reliable, long-lasting product. Such provisions may become ineffective if the user does not use the Arbalete spear gun correctly and does not maintain it adequately. SEAC Diving Pro s.r.l. denies

any responsibility for any problem resulting from a lack of observation of the recommendations made in this manual.

- ▶ For any other eventuality, please contact your authorized SEAC Diving Pro dealer or SEAC Diving Pro directly. In order to guarantee maximum safety, every repair or maintenance intervention must be carried out only by authorized SEAC Diving Pro workshops.
- ▶ SEAC Diving Pro Arbalete spear guns are a result of research conducted in close collaboration with numerous professional diving operators. The innovative characteristics guarantee a reliability that remains unchanged over time. At the same time, the mechanical and functional aspects allow an extremely simple maintenance regime.
- ▶ If you are not expert in the use of this apparatus, we advise you to study how it functions during trial dives in shallow depths and under favorable conditions.

## Technical characteristics

The X-FIRE arbalete spear gun is the result of years of research on the technical/construction characteristics of various materials like lightweight alloys, synthetic resins, and natural rubber. Thanks to the collaboration of various experts in this sector, like air-sea technicians, ballistic experts, applied ergonomists, and professional underwater hunters, we have developed a high quality product appropriate for both recreational and competitive use. Each individual component has been studied in detail to offer unique features in this field. We have taken great care and consideration in developing each feature and component in order to guarantee a product that will impress you with its manageability, precision, reliability, and durability.

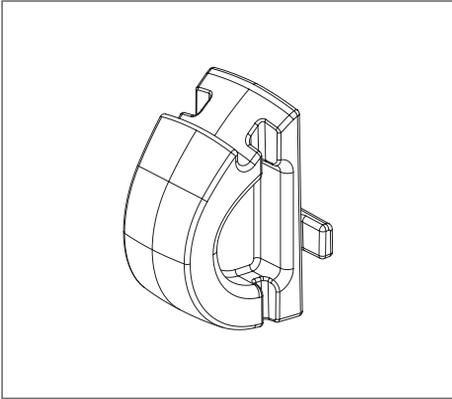
## CHARACTERISTICS OF THE ARBALETE X-FIRE SPEAR GUN

RECREATIONAL/PROFESSIONAL ARBALETE SPEAR GUN	
<b>DEFINITION</b>	Recreational/professional Arbalete spear gun
<b>SIZES AVAILABLE</b>	50    60    75    85    95    105    115 * the total length of the barrel is measured from the muzzle to the beginning of the stainless steel handle
<b>SPEAR SHAFT LENGTH</b>	50    60    75    85    95    105    115 cm 65   cm 75   cm 105   cm 115   cm 125   cm 135   cm 145
<b>TYPE OF SPEAR</b>	<ul style="list-style-type: none"> <li>• Sandvik non-reflecting, tempered stainless steel</li> <li>• Diameter 6,25 mm</li> <li>• Tensile strength equal to 2100 Newton / mm<sup>2</sup></li> <li>• Hardness 52RcH</li> <li>• Built-in 7.4 cm barb, inserted downwards</li> <li>• O-ring to hold barb</li> <li>• 3 eyelets to connect to monofilament or line</li> <li>• Universal notch</li> </ul> <p>n.b. The X-FIRE 50/60 versions are assembled with a 6.5 mm / 7 thread spear with the same technical characteristics as above.</p>
<b>BAND LENGTH</b>	50    60    75    85    95    105    115 cm 32   cm 36   cm 46   cm 50   cm 54   cm 58   cm 62
<b>TYPE OF ELASTIC BAND</b>	17.5 mm diameter circular elastic of "Premium quality latex rubber" with special black coating for increased resistance to abrasion and UV rays
<b>TYPE OF SPEARHEAD FOR ELASTIC</b>	Articulated, jointed, with protective plastic on arms
<b>MUZZLE</b>	Minimized, open for quick loading of the spear shaft
<b>BARREL</b>	In lightweight alloy with stringing system
<b>HANDLE</b>	Ergonomic with open line of sight
<b>HANDLE AND TRIGGERING MECHANISM</b>	Triggering mechanism in stainless steel with laser system and incorporated into the one-piece handle
<b>SUPPLIED WITH</b>	<ul style="list-style-type: none"> <li>• Package of dual-strength 140 nylon monofilament (300 lb test) with closure sleeves</li> <li>• Carrying bag in PU-coated nylon with drawstring casing closure</li> <li>• Threaded shaft and 5-point gaff for the X-FIRE 50/60 version</li> <li>• Single-flopper Tahitian shaft for the X-FIRE 75/85/95/105/115 versions</li> </ul>
<b>REEL</b>	Yes - optional

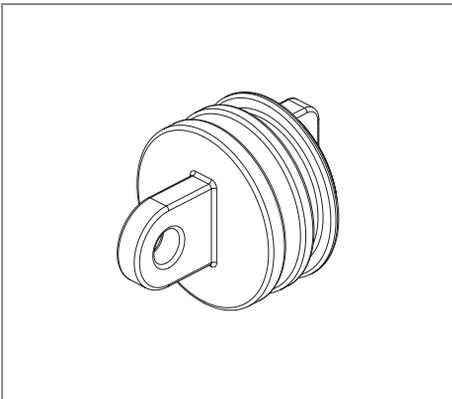
## X-FIRE Elastic Spear gun

### MUZZLE

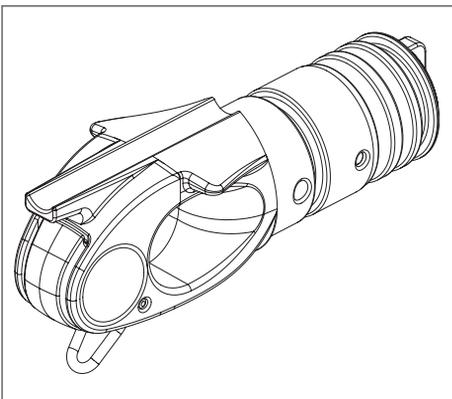
- ▶ The muzzle has been designed for the least possible minimal hydrodynamic resistance. Normally, guns with pairs of elastics have a much larger muzzle that is also located higher on the barrel, which opposes resistance to maneuvering the gun, both vertically and horizontally. These guns have a less manageable lever arm, so consequentially, at the tip, it is very difficult to move the weapon or hold it still while fishing in an undertow or backwash.
- ▶ The “all-open” muzzle on the X-FIRE allows a better sight than traditional muzzles because the line of sight directly follows the spear shaft. This allows the use of shorter shafts with an increase in speed and improved traversing. The traditional muzzle unfortunately does not allow linear vision and forces the hunter to use longer shafts in order to see the tip of the shaft and aim. The traditional muzzle also results in a correction factor because the eye’s line of site and that of the spear shaft are never parallel.
- ▶ Moreover, our type of “all-open” muzzle offers an indirect improvement of traversing. By being able to use shorter spear shafts (our studies suggest making them 10 cm shorter than standard) we have actually shortened the overall length of the gun, which is very useful in fishing in undertow or backwash or in an ambush while still maintaining the technical/functional characteristics and offering increased power. For example, our X-FIRE 85, which uses a 115 cm spear shaft has the same bulk as a corresponding classic 75 (which always uses a standard 115 spear shaft), but shoots the spear at a much higher speed. Therefore, with the same overall length (gun plus spear), our X-FIRE has higher power and better traversing.
- ▶ Our muzzle also has a rubber insert that serves to block the monofilament. For true professionals, this feature is highly useful. Once the spear shaft has been placed on its guide, it must be blocked immediately with the monofilament and then hooked to the line guide. In traditional guns with the muzzle open or semi-open, this operation is not possible and it may happen that while the gun is turned to attach the monofilament to the line release mechanism, it is impossible to hold it taut due to the movement of the spear shaft, resulting in a loss of time. In difficult underwater conditions, this problem can become more serious.
- ▶ Another important advantage over the double-elastic muzzles is that the spear shaft need not move inside the muzzle bore but is always locked in the same point even in lateral shots, downward shots, or upside down (as often happens in dens or holes); therefore always guaranteeing optimal precision and silence.
- ▶ A double o-ring seal is inserted on the muzzle, one of which is assembled on a horizontally-hinged part anchored onto the muzzle itself. Any movement of the muzzle during the drawing of the elastics does not affect the o-ring seals and therefore the o-ring remains fixed in the same point, guaranteeing a better seal than other systems do. Inside the muzzle there is a small cavity where it is possible to insert weights to balance the gun (in case longer lengths are too light).



*Insertion of monofilament lock*



*Horizontal Hinge*



*Muzzle*

- ▶ Our muzzle does not allow a second elastic to be mounted. This was a part of the design intended to avoid penalizing the weight and the traversing of this gun, which is in any case more powerful than a double-band gun of equal length. In order to upgrade the already excellent performance of the X-FIRE spear gun, you may use 19.5 mm circular bands with the same technical characteristics of those supplied with the gun, but with greater power. Our gun was designed to be more precise and for optimal traversing. It is a spear gun that guarantees excellent overall performance.
- ▶ The spear shaft continues to be guided along the muzzle thanks to a special groove that ends in a protruding lip form. The lip itself can be used as a spear anchor if you should want to fix it with a small o-ring.
- ▶ A stainless steel eyelet on the lower part of the muzzle allows the connection of the monofilament. If a reel is used, this eyelet can function as a line guide.

## BARREL

- ▶ The barrel assembled on the X-FIRE gun has a unique characteristic in that it is extruded and drawn with a one-piece integrated spear guide and 1 mm walls.
- ▶ The innovative/technological characteristic is the barrel with the 28 mm integrated spear guide which guarantees it to be lightweight and strong but with minimal resistance to traversing. Up until today, the market offered forms with thick walls and therefore 30 mm barrels, making the gun heavy and not adapted for traversing (as well as with traditional muzzles).
- ▶ To increase the quality and durability against external chemical agents we carry out hard anodizing surface treatments, ensuring unique and long-lasting resistance and compactness.

- ▶ Another important characteristic is that of having created, together with the integrated guide, a support along the barrel that functions as a beam to eliminate almost any bending of the barrel.
- ▶ The integrated guide is mandatory and indispensable on guns with circular bands. In fact, circular bands always tend to slightly push the spear against the barrel. On our X-FIRE, the band is positioned in such a way that this pressure is present but minimal, allowing the spear to slide with practically no friction. Moreover, the spear lies on a layer of water that forms between the integrated guide and the spear itself. Even after having carried out hundreds of shots, you will not notice any scratches on the guide. The gun always shoots the spear along the guide and, therefore, straight. This also allows us to modify the characteristics of the elastic and the spearhead without significant variations in performance.
- ▶ Using a circular band with no integrated guide can lead to problems of precision during shooting. In fact, because the spear is attached over the barrel it is strongly affected by the band, which tends to push down on the end of it. Not finding a guide, the shank tends to be crushed against the barrel and the spear tends to rear up onto the guide groove or on the muzzle, which are obviously higher than the barrel itself. In these cases the spear rears up or, in some cases, may waver, resulting in serious inaccuracy. Changing band and spearhead will not change things. In fact, the spearheads tend to more or less crush the shaft, preventing absolute precision. Furthermore, the bands may also cause a slight deviation leftwards or rightwards that, if not compensated by an integrated guide, may also further deviate the aim.
- ▶ Another very important point for those who fish while in ambush or waiting in undertow or backwash, is that the integrated guide holds the spear steady in the groove and does not allow the passage of water between the spear shaft and the barrel in order to totally eliminate turbulence and bending of the spear during lateral traversing.
- ▶ In guns with parallel bands and no spear guides, once the spear has left the handle and rests on only a few mm at the head, both the length of the right and left bands (which generally do not have a length with millimetric precision) and the type of spear will determine if it will shoot upwards, downwards, or straight. A few millimeters of initial shifting at four meters distance will make the gun imprecise by a few centimeters.
- ▶ Another unique and innovative feature is the special notch on the stock. The stock is inserted in the barrel together with the triggering mechanism. The triggering package results as being pinned directly onto the lightweight alloy barrel with a pin at the middle of the barrel. This unique solution allows the release of all the tension from the bands directly onto the barrel pin, thus eliminating any possibility of bending. In the traditional solution, the barrel was free from the stock, so that the force of the bands was released directly onto the triggering mechanism and on the stock which, being made of plastic and never being perfectly fixed to the barrel, tended to bend and cause imprecise aim.
- ▶ The minimum height between the barrel and the spear (about 4/5 mm less than on traditional guns), the elastics placed beside the barrel and the total lack of turbulence make this the gun particularly adapted for traversing in any possible situation.
- ▶ In traditional guns with a muzzle for double bands, we often find problems in maneuvering the gun. In fact, because

they are mounted over the barrel, they offer both resistance to traversing and a continuous passage of water with the relative vibrations and turbulence that make traversing difficult.



*Detail of Barrel*

## HANDLE

- ▶ The handle offers maximum ergonomic comfort and practicality. Our technicians carried out extensive studies on the stocks of pistols and then applied many of the same fundamental concepts to this gun.
  - ▶ Made in nylon loaded with glass microspheres, the handle was designed with an inclination of 40° in relation to the perpendicular axis of the barrel.
  - ▶ The inclination used allows the recoil to be discharged onto the wrist, which is already aligned with the arm. The recoil in fact develops along the middle of the barrel, discharges on the curvature of the stock, and from here is directly in line with the area between the thumb and the index finger, and therefore on the wrist. In traditional guns, the stock is turned more downwards, an apparently more comfortable position, but that does not allow a perfect support of the thumb/index area and holds the wrist lower and
- less inclined in relation to the barrel. This is as a result of the recoil, which tends to turn the gun on a lower fulcrum than its middle point, making the gun recoil. Furthermore, because the wrist is not aligned with the arm, it tends to turn more easily, resulting in a less precise aim, which becomes more accentuated as the power of the band increases.
  - ▶ The length of the lower part allows maximum support of the palm, which reduces the force that the muscles of the man must exert in order to rotate the stock. The more this part is reduced, the more the hand must work to rotate the spear gun.
  - ▶ The hilt of the trigger was made slightly longer in order to improve the support of the index finger when extended, both to rest it and to help vertical movement of the spear gun.
  - ▶ The handle also has two supports aligned diagonally to lighten pressure on the sternum while loading the band. The support surface is in fact the sum of the stock plus the lower part of the handle, which together stabilize (hold still) the gun during loading.
  - ▶ Another unique and significant innovation is the complete freedom of the line of fire. A deep, v-shaped, sight notch allows total view of the spear, aligning it perfectly with the target, and therefore maximum precision and the possibility of using shorter spears.
  - ▶ The seal on the stock is also guaranteed by a horizontal hinge (with o-ring) anchored in the handle (the same system as the muzzle). Even the slightest movement of the handle during the drawing of the elastics does not affect the o-ring seals and therefore the o-ring remains fixed in the same point, guaranteeing a perfect seal.



Open sight notch



Side view of the handle

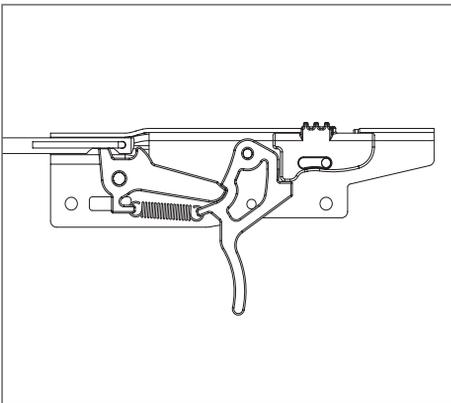


Diagram of the triggering mechanism system

## TRIGGERING MECHANISM

- ▶ Entirely in stainless steel, this is an extremely simple system. The mechanism includes only two elements (catch and trigger) cut by laser and 5 mm thick, fastened to the stainless steel handle with stainless steel pins. Maximum simplicity, maximum reliability, will function with any power band without compromising sensitivity and ease in shooting. The two elements are polished individually to eliminate any snags during shooting.
- ▶ The special polishing of the parts in contact with the slide and the large reduction (unique in this application to underwater spear guns) allow the diver to hook the spear with extreme simplicity and without have to develop excessive pressure. This also guarantees sensitivity in triggering which facilitates accurate aim.
- ▶ In special lateral line release mechanism (also in stainless steel) allows the dive to always keep the line against the barrel (in contrast to spear guns that use the lower one), acting orthogonally to the catch on the lower part creates no slowdown or friction, facilitating the release.
- ▶ One final important characteristic is that the front part of the handle entrance is squeezed and widened. This facilitates the use of spears with larger shanks or thicker monofilaments (160 or even 180). The rear part is left thinner in order to keep the triggering mechanism closer, while the upper part has a practical and efficient safety system.

## ELASTIC BANDS

The elastic bands are made of premium quality pure latex (99.9%). Their elongation coefficient is 850%. These elastic bands have a diameter of 17.5 mm and are made of selected rubber. The amber colored elastic is covered with a special black coating that

guarantees better resistance to ultraviolet rays and therefore to cracking, as well as increased resistance to cuts and abrasions. In this way, the lifespan of an elastic is prolonged with added value in terms of its characteristics over time, and therefore earning in economic terms for increased durability. The use of a circular band in place of a classic double band notably increases the power, while the loading force remains unchanged, saving them from deterioration and improving their resistance to abrasion. There are also circular bands available (optional) in the 19.5 mm version in lengths that range from 42 cm to 72 cm.

## SPEARS

- ▶ The spear included with the X-FIRE spear gun is a Sandvik AISI 301 with a 6.25 mm diameter. This type of steel is particularly hard and not easy to work, obtained by cold-work hardening in order to increase the hardness and tensile strength, and subsequently treated with tempering at a medium temperature to obtain tensile strength of 1800 N/ mm<sup>2</sup> and a hardness of 48 Rch.
- ▶ In order to make this type of spear unique in this field, we have added a thermal treatment at 400° for 2 hours in order to reach a tensile strength of 2100 N/ mm<sup>2</sup> and a hardness of 52 Rch.
- ▶ This extra operation, in addition to guaranteeing unique characteristics, gives the spear a dark, non-reflecting appearance that can be useful in different fishing situations.
- ▶ The barb is 7.4 cm long and positioned at 6 cm from the point of the mono-barb and at 5 cm from the point of the double-barb version (optional). It is built into the spear in order to reduce shooting resistance.
- ▶ The position of the barb is deliberately lower than the body of the spear in order

to counterbalance the natural drop following shooting. The connection bores to connect the line (3) have a diameter of 2.5 mm and are positioned as follows:

1. 1 bore on the shank
2. 1 bore following the first notch
3. 1 bore following the second notch
4. 1 bore of the same diameter for the barb pin.

- ▶ The excellent quality of Sandvik steel allows us to have more bores on the spear without altering its resistance.
- ▶ In the X-FIRE 50 and X-FIRE 60 versions, the spear provided is a Sandvik threaded spear with a 6.5 mm diameter/ 7 thread with the same technical characteristics as Tahitian ones.
- ▶ An optional spear has a 6.5 mm diameter in the mono-barb and double-barb versions.

## WISHBONE

- ▶ The wishbone provided with the X-FIRE spear gun is articulated with a special plastic covering on the arms to protect the barrel during the return of the wishbone after shooting and to improve silencing. Each single arm is in stainless steel and has a diameter of 5 mm, which makes it robust and reliable over time. The connection to the threaded plastic bushings is ensured by two self-locking nuts in stainless steel.

## MONOFILAMENT

- ▶ The special Nylon monofilament used is 140. It is softer and therefore has higher resistance to tangling than traditional monofilaments. It also is more resistant to abrasion and has a breaking point that is nearly double that of traditional monofilaments. Our 140 monofilament has a breaking point of 300 lbs. - equal to or

slightly superior than a traditional 180 lb monofilament and almost double a traditional 140. The line anchors are guaranteed by rustproof aluminum sleeves. The gun is supplied with 5 mt of monofilament and n. 3 sleeves.

## MISCELLANEOUS

- ▶ The X-FIRE will surprise you for its high number of featured technical characteristics. It is possible to truly aim by aligning the sight notch and spear in difficult long-distant shots. In use, it has an unsurpassable traversing, especially in undertows or backwash.
- ▶ The ease of inserting the spear (even with gloves on) together with the extreme naturalness of the loading due to the quality of the power bands will make you appreciate the X-FIRE spear gun during all phases of its use.
- ▶ All of these characteristics allow the diver to carry out prolonged hunts without fatigue.

## Instructions for the correct use of the X-FIRE spear gun

### ▶ Attention!

***Read the following instructions carefully. Your safety and the continual efficiency of your equipment depend on your having read these instructions.***

The X-FIRE spear gun must always be transported with care in bags and backpacks specially designed to contain underwater spear guns and avoid contact with a heavy or sharp components.

### ▶ Attention!

***Each time you transport or do not use your X-FIRE spear gun, remember to protect the tip of the spear with a protection tube.***

## Instructions for the correct assembly of the X-FIRE spear gun

The X-FIRE spear gun is supplied with the monofilament kit to be assembled.

In order to carry out this operation, it is first necessary to insert the connection sleeve on the monofilament, after which the monofilament must be inserted in the bore located on the shank of the spear (Drawing 1). Ascertain that the loop that forms remains outside the triggering mechanism (Drawing 2) and immediately afterwards, proceed with the closure of the loop, using pliers on the sleeve (Drawing 3).

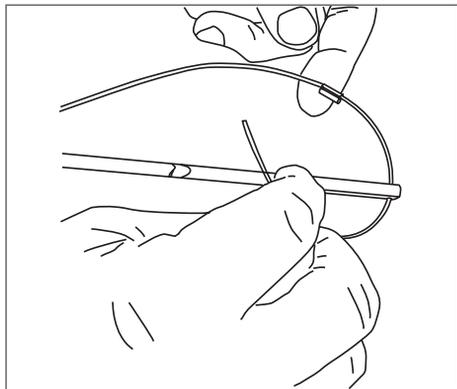
At this point, it is advisable to run the monofilament along the spear until it reaches the muzzle, passing the monofilament itself under the barb to the left or right of the muzzle (Drawing 4) and inserting it in the space left especially at the tip of the head (Drawing 5), the monofilament in this case blocks the shaft.

### ▶ Attention!

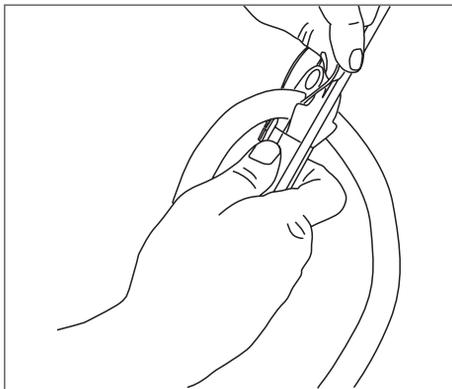
***It is advisable to familiarize yourself with these movements in order to be able to carry them out easily whenever it is necessary to load the spear.***

Continue with the running of the monofilament until it reaches the line release, after which, you must return towards the head (Drawing 6) and create another loop by passing the line inside the special stainless steel bridge anchored on the muzzle (Drawing 7). Control the tension of the line so that it is close to the spear gun and firmly anchored to the line release. Finally, proceed with the locking of the second sleeve (Drawing 8).

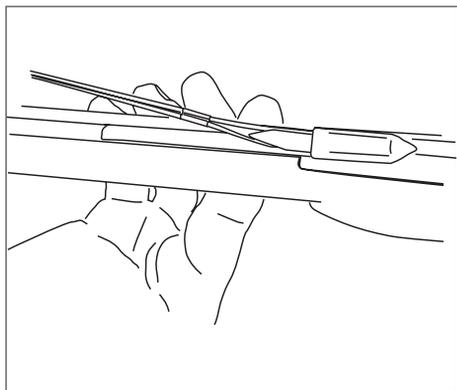
The spear gun is now ready for use.



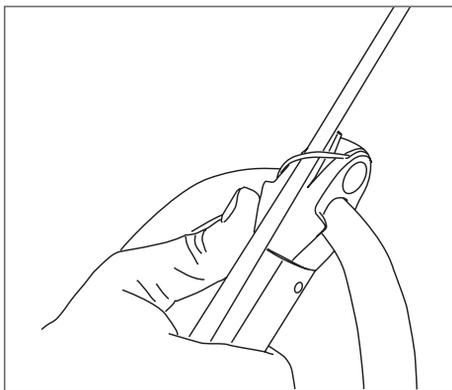
**Drawing 1** *Insertion of the monofilament in the spear shank*



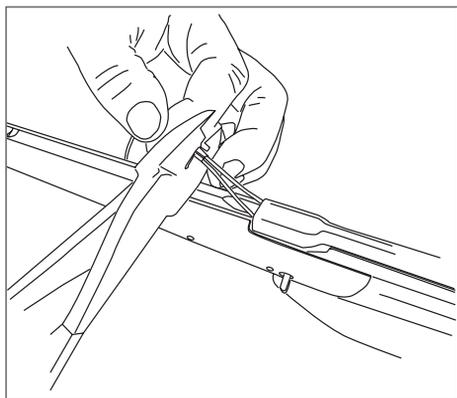
**Drawing 4** *Passing the monofilament on the muzzle*



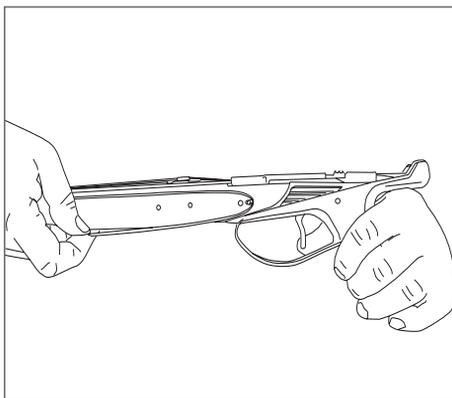
**Drawing 2** *Closing the loop outside of the triggering mechanism*



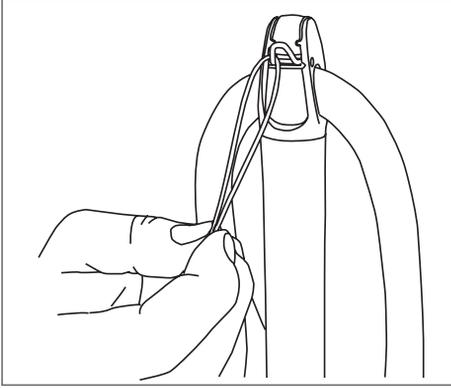
**Drawing 5** *Blocking the spear onto on the muzzle*



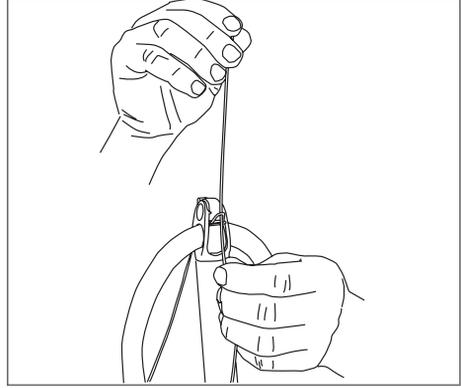
**Drawing 3** *Blocking the sleeve onto the monofilament*



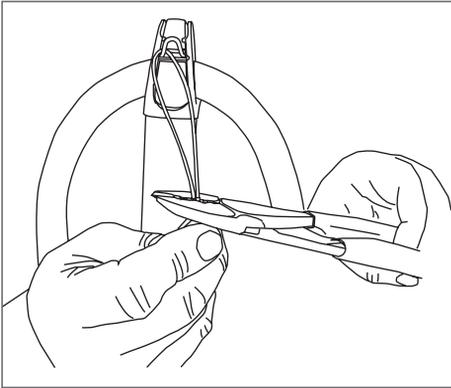
**Drawing 6** *Passing the monofilament on the catch*



**Drawing 7** *Passing the monofilament inside the stainless steel bridge*



**Drawing 9** *The functioning of the bridge while using the reel*



**Drawing 8** *Blocking the sleeve on the monofilament*

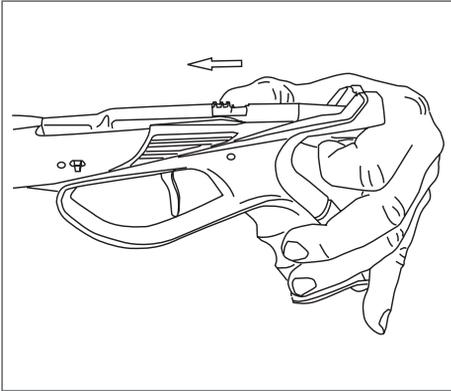
► **Attention!**

***If a reel is used, the stainless steel bridge on the muzzle is used only as a line guide (Drawing 9). It is always necessary to carry out a complete circuit with the line between the head and the line release mechanism before connecting it to the spear.***

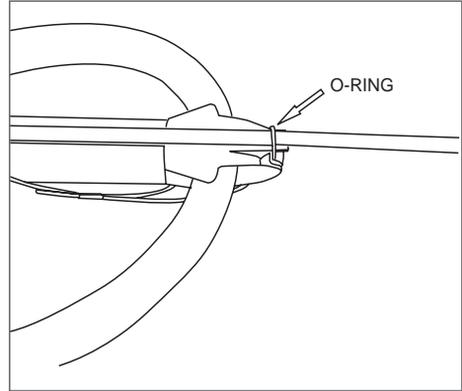
## Instructions for the correct use of the X-FIRE spear gun

### Loading the spear

- ▶ Always check that the loaded spear is fixed firmly. The classic “click” tells you that the operation is complete, however as a safety precaution it is advisable to subsequently pull the spear with your hands to be sure that it is properly in place.
- ▶ Activate the safety catch by shifting the system ahead in relation to the position of the handle (Drawing 10), after which control that the trigger is blocked.



Drawing 10 Inserting the safety catch



Drawing 11 Inserting the o-ring to block the spear onto the muzzle

## Correct assembly of the monofilament on the muzzle and on the catch

- ▶ Run the monofilament along the spear until it reaches the muzzle. By passing the monofilament itself under the barb to the left or right of the muzzle, insert it into the space left especially at the tip of the head (Drawing 4). The monofilament in this case blocks the spear (Drawing 5). Continue with the running of the monofilament until it reaches the line release, after which, insert the monofilament around the line release, pulling it slightly. The spear gun now has the monofilament taut (in fact, the other end of the monofilament is anchored at the muzzle by the stainless steel bridge) and is ready to be loaded.

### ▶ Attention!

*It is advisable to familiarize yourself with these movements in order to be able to carry them out easily whenever it is necessary to load the spear.*

## IMPORTANT

*If the diver does not wish to use this system to lock the spear, it is possible to fix it by inserting an o-ring between the circumference of the spear and the lip of the muzzle (Drawing 11).*

### ▶ Attention!

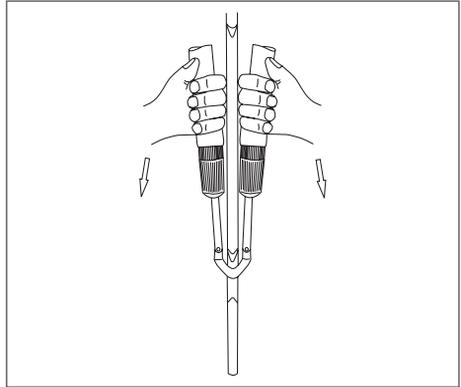
*If a reel is used, the stainless steel bridge on the muzzle is used only as a line guide (Drawing 9). It is always necessary to carry out a complete circuit with the line between the head and the line release mechanism before connecting it to the spear.*

### ▶ Danger!

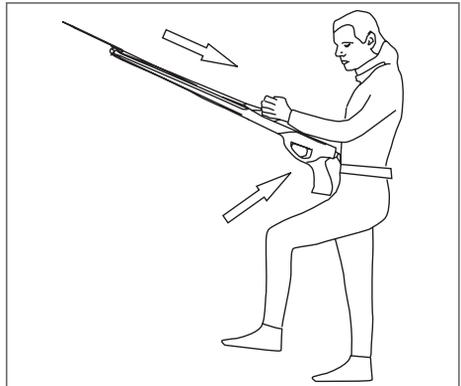
*Do not fasten the reel line directly to the spear without first having completed at least one complete round with the monofilament between the muzzle and the line release mechanism!!*

### Use of the circular band and the wishbone for loading

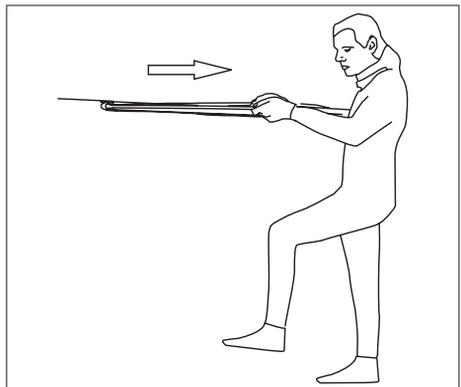
- ▶ It is advisable to always use gloves when loading your X-FIRE spear gun.
- ▶ Hold the rubbers in front of the wishbone, holding them between your fingers while pulling the elastics (Drawing 12).
- ▶ It is advisable to rest the handle, which has been specially designed, on your stomach or, more precisely, on the buckle of your weight belt in such a way as to have a firm and steady support during loading (Drawing 13).
- ▶ In some cases, depending on the person or on the length of the spear gun, an extra support may be needed for the handle on the central part of the sternum, in order to facilitate the insertion of the wishbone in the last notch. This operation is necessary to exploit the maximum firing power (Drawing 14).
- ▶ The correct positioning of the wishbone in the notch of the spear must be carefully controlled and followed by a slow release of the rubbers once loading has been completed (Drawing 15).



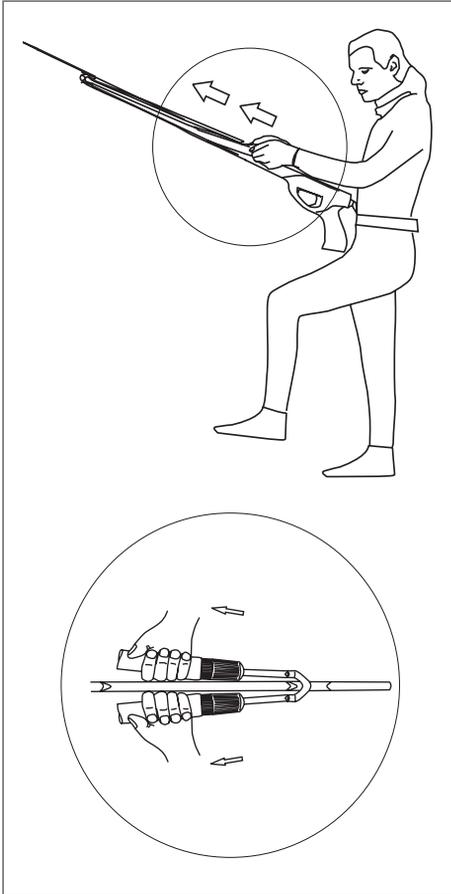
Drawing 12 *How to hold the elastic while loading*



Drawing 13 *Position of the handle for loading at belt level*



Drawing 14 *Position of the handle for loading at chest level*



Drawing 15 *Releasing the elastics slowly following loading*

► **Attention!**

*It is advisable to always use original spare parts in that each individual component has been specifically studied to optimize the performance of the product and to guarantee high safety margins. It is also advisable to refer to the length of the elastics and spears as indicated in the table entitled "Technical characteristics of the X-FIRE spear gun" above.*

## Shooting the X-FIRE spear gun

- Now the X-FIRE spear gun is ready to be used, and as a final step, you must remove the safety catch that was previously inserted in order to be able to pull the trigger. It is advisable to always use extreme caution in using the underwater spear gun as it is considered, for all effects and purposes, a weapon.

► **Attention!**

*At the end of a day of fishing, we advise unloading the spear gun before returning to land. To do this correctly, first insert the safety catch, and then hold the elastic band with both hands just above the spearhead, being very careful to release the wishbone from the spear by accompanying the elastics to the muzzle.*

## Eleven important useful recommendations to prevent risk and injury while using the elastic spear gun

1. Follow national and local laws concerning the use and transport of underwater spear guns.
2. Do not load or attempt to load the underwater spear gun in crowded places like beaches, along public coastlines, and marinas.
3. Always load the underwater spear gun in water, keeping other persons at a safe distance.
4. Never, for any reason, aim the spear gun at people, even if the safety is inserted.
5. Always consider the safety catch as an extra precaution and not as a foolproof safety system.
6. Control the position of the spear gun correctly before beginning the loading operation.

7. Mark your presence in the water with internationally and locally recognized signal buoys.
  8. Follow local laws concerning minimum age limits for use.
  9. Do not use the underwater spear gun if it shows signs of wear on the components like spears, elastic bands, barbs, and triggering mechanism. In case of doubt, do not use and immediately contact an authorized SEAC Diving Pro center for maintenance and assistance.
  10. Never use the underwater spear gun outdoors in that, given its power, it could be seriously damaged or become potentially dangerous for people, things, and animals.
  11. Never, for any reason, transport or keep the spear gun loaded except for underwater use.
5. If you believe you will not be using the spear gun for more than a month, it is advisable to rinse every part carefully and let it dry thoroughly in the shade. Keep it perfectly dry in a cool, aerated place.
  6. At the end of a particularly intense season, or at least following a long period of inactivity, it is sound practice to leave the spear gun with an authorized laboratory for a complete check. We recommend that you contact your regular retail store that will be able to give you better information concerning faster and safe systems to carry out annual revisions.
  7. We also suggest a periodic control of the wear of each component, like the muzzles, elastic bands, spears, barbs, triggering mechanism, and relative pins.

**For any other information, please contact our technical office by e-mail at:**

**[info@seacsub.com](mailto:info@seacsub.com)**

## Care and maintenance of the X-FIRE spear gun

In order to maintain your X-FIRE spear gun perfectly efficient, you must follow the precautions below.

1. Following each dive, including those in fresh water like lakes or rivers, the X-FIRE spear gun must be rinsed outside with fresh running water. The use of de-mineralized water is recommended. First of all, ensure that all eventual water residues that have entered during the dive are removed from the triggering mechanism. Finally, let it dry without exposing it extensively to direct sunlight.
2. Periodically lubricate the triggering mechanism with silicone oil.
3. Never leave the X-FIRE spear gun with other equipment that can in some way cause cuts or breakage due to heavy objects (for example, weight belts).
4. Avoid contact with oils, solvents, or gasoline.

## Certificate of Warranty

Seac Diving Pro s.r.l guarantees the correct functioning of the product to which this document is attached.

This guarantee has a duration of two (2) years in accordance with current European regulations.

The warranty herein can be enacted according to the conditions and limits expressly indicated below:

1. The warranty will have a duration of 2 (two) years, beginning from the moment the product is acquired from an authorized SEAC Diving Pro dealer and does not require any preventive formality or subsequent validation.

2. This warranty is valid only for the first purchaser of the product from an authorized SEAC Diving Pro dealer.

Being a strictly nominative warranty, it is not transferable to third parties unless previously and explicitly authorized by SEAC Diving Pro.

3. This warranty covers all and any functional defects caused by:

- ▶ Intrinsic defects caused by the use of materials believed to be unsuitable.
- ▶ Evident errors in the design, manufacturing, or assembling of the product or its components.
- ▶ Incorrect or inadequate instructions and advice concerning its use.

4. This warranty will terminate automatically, and effective immediately, upon the repair, modification, transformation, adaptation, or general tampering carried out on the finished product or any of its parts that has not been previously authorized by SEAC Diving Pro or, in any case, carried out by unauthorized personnel.

5. This warranty guarantees the right to intervention and repair at no cost and as soon as possible, or the total substitution of the product (as incontestably decided by SEAC Diving Pro), or its parts at no cost, when and where SEAC Diving Pro acknowledges functional defects strictly regarding those of point 3 above.

6. This warranty may also be validated by shipment of the product believed to be defective to SEAC Diving Pro. The intermediary authorized to carry out the shipment must be the SEAC Diving Pro dealer where the product was purchased. If this should be impossible, any other SEAC Diving Pro dealer, subject to authorization, may be authorized to ship the defective product. In order for the

warranty to be valid, the product must be accompanied by a copy of the store receipt, invoice, or other similar proof of purchase documentation where the name of the authorized SEAC Diving Pro dealer and the date of purchase of the product are noted.

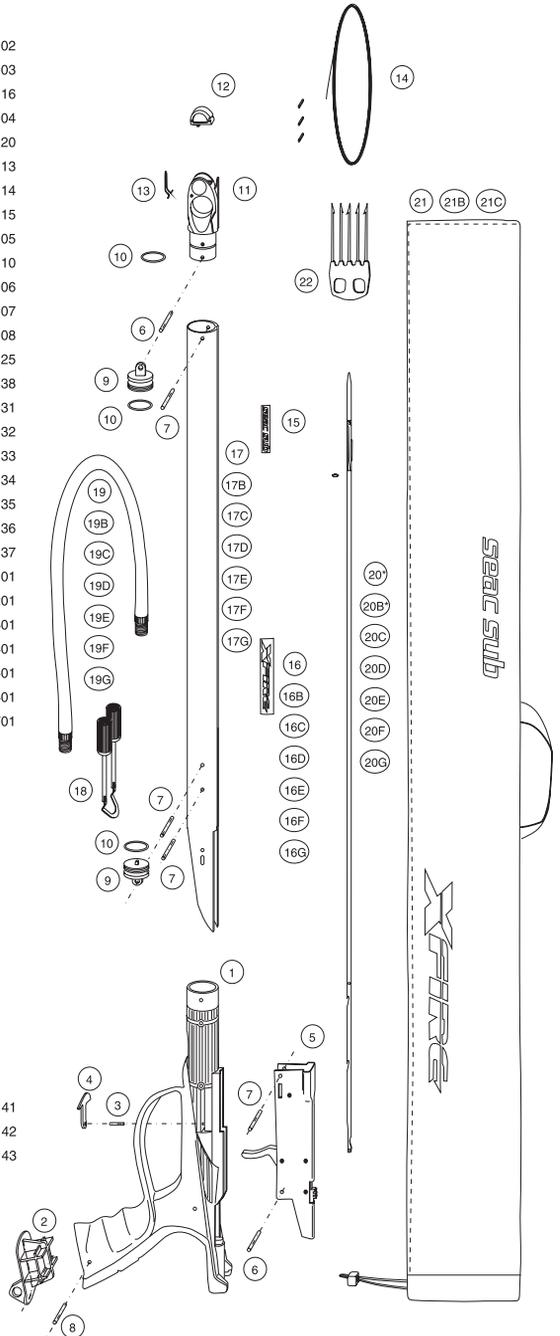
If SEAC Diving Pro receives a product that:

- ▶ is not accompanied by a proof of purchase document with the abovementioned characteristics
- ▶ has been subject to conditions that determine the extinction of the warranty according to point 4 above
- ▶ Presents defects due to causes that are external or other than those explicitly indicated in point 3 above
- ▶ has been used inappropriately and/or for purposes other than what the product was intentionally designed

absolutely no intervention shall be made on the product and the sender or the authorized dealer will be notified immediately. If ever the sender intends to have the intervention carried out, he/she will transmit to SEAC Diving Pro, within the following fifteen days, a request stating so in which he/she shall explicitly agree to sustain all costs relative to the intervention itself, labor, necessary replacement parts, shipping costs. Otherwise, SEAC Diving Pro will provide for the return of the product at the expense of the sender.

**X-FIRE**

1)	Impugnatura X-FIRE	S311102
2)	Tappo per impugnatura X-FIRE	S311103
3)	Spina x sganciasagola X-FIRE 15 x 2	S311116
4)	Sganciasagola inox X-FIRE	S311104
5)	Meccanismo sgancio X-FIRE	S311120
6)	Spina X-FIRE 4 x 26	S311113
7)	Spina X-FIRE 4 x 28	S311114
8)	Spina X-FIRE 4 x 30	S311115
9)	Tappo canna X-FIRE	S311105
10)	O-Ring tappo X-FIRE 20 x 3	S311110
11)	Testata X-FIRE	S311106
12)	Frenasagola X-FIRE	S311107
13)	Guida sagola X-FIRE	S311108
14)	Confez. monofilo per X-FIRE	S311125
15)	Etichetta Seac Sub per X-FIRE	S311138
16)	Etichetta X-FIRE 50	S311131
16B)	Etichetta X-FIRE 60	S311132
16C)	Etichetta X-FIRE 75	S311133
16D)	Etichetta X-FIRE 86	S311134
16E)	Etichetta X-FIRE 95	S311135
16F)	Etichetta X-FIRE 105	S311136
16G)	Etichetta X-FIRE 115	S311137
17)	Canna X-FIRE 50	S311101
17B)	Canna X-FIRE 60	S311201
17C)	Canna X-FIRE 75	S311301
17D)	Canna X-FIRE 85	S311401
17E)	Canna X-FIRE 95	S311501
17F)	Canna X-FIRE 105	S311601
17G)	Canna X-FIRE 115	S311701
18)	Ogiva articolata universale	3585
19)	X-FIRE 50 - elastico nero x powerfull 17,5 x 32	3451
19B)	X-FIRE 60 - elastico nero x powerfull 17,5 x 36	3452
19C)	X-FIRE 75 - elastico nero x powerfull 17,5 x 46	3453
19D)	X-FIRE 85 - elastico nero x powerfull 17,5 x 50	3454
19E)	X-FIRE 95 - elastico nero x powerfull 17,5 x 54	3455
19F)	X-FIRE 105 - elastico nero x powerfull 17,5 x 58	3456
19G)	X-FIRE 115 - elastico nero x powerfull 17,5 x 62	3457
20)	X-FIRE 50 - asta filettata sandvik 6,5 x 650 mm	3348
20B)	X-FIRE 60 - asta filettata sandvik 6,5 x 750 mm	3349
20C)	X-FIRE 75 - asta tahitiana sandvik 6,25 x 1050 mm	3343
20D)	X-FIRE 85 - asta tahitiana sandvik 6,25 x 1150 mm	3344
20E)	X-FIRE 95 - asta tahitiana sandvik 6,25 x 1250 mm	3345
20F)	X-FIRE 105 - asta tahitiana sandvik 6,25 x 1350 mm	3346
20G)	X-FIRE 115 - asta tahitiana sandvik 6,25 x 1450 mm	3347
21)	Custodia X-FIRE 50/60 cm 85	C311141
21B)	Custodia X-FIRE 75/85/95 cm 125	C311142
21C)	Custodia X-FIRE 105/115 cm 145	C311143
22)	Fiocina nylon a 5 punte X-FIRE 50 / 60	110C



\* Le misure X-FIRE 50 e 60 sono assemblate con aste filettate.

## X-FIRE

1)	X-FIRE handgrip	S311102
2)	X-FIRE handgrip cover	S311103
3)	X-FIRE line releaser pin 15 x 2	S311116
4)	X-FIRE stainless steel line releaser	S311104
5)	Triggering mechanism	S311120
6)	X-FIRE pin 4 x 26	S311113
7)	X-FIRE pin 4 x 28	S311114
8)	X-FIRE pin 4 x 30	S311115
9)	X-FIRE barrel cup	S311105
10)	X-FIRE O-Ring cup 20 x 3	S311110
11)	X-FIRE muzzle	S311106
12)	X-FIRE plastic monofilament locking	S311107
13)	X-FIRE stainless steel monofilament slide	S311108
14)	X-FIRE nylon monofilament set	S311125
15)	Seac Sub X-FIRE sticker	S311138
16)	X-FIRE 50 sticker	S311131
16B)	X-FIRE 60 sticker	S311132
16C)	X-FIRE 75 sticker	S311133
16D)	X-FIRE 86 sticker	S311134
16E)	X-FIRE 95 sticker	S311135
16F)	X-FIRE 105 sticker	S311136
16G)	X-FIRE 115 sticker	S311137
17)	X-FIRE 50 barrel	S311101
17B)	X-FIRE 60 barrel	S311201
17C)	X-FIRE 75 barrel	S311301
17D)	X-FIRE 85 barrel	S311401
17E)	X-FIRE 95 barrel	S311501
17F)	X-FIRE 105 barrel	S311601
17G)	X-FIRE 115 barrel	S311701
18)	Universal articulate wishbone	3585
19)	X-FIRE 50 - latex tubing x powerfull 17,5 x 32	3451
19B)	X-FIRE 60 - latex tubing x powerfull 17,5 x 36	3452
19C)	X-FIRE 75 - latex tubing x powerfull 17,5 x 46	3453
19D)	X-FIRE 85 - latex tubing x powerfull 17,5 x 50	3454
19E)	X-FIRE 95 - latex tubing x powerfull 17,5 x 54	3455
19F)	X-FIRE 105 - latex tubing x powerfull 17,5 x 58	3456
19G)	X-FIRE 115 - latex tubing x powerfull 17,5 x 62	3457
20)	X-FIRE 50 - sandvik threaded shaft 6,5 x 650 mm	3348
20B)	X-FIRE 60 - sandvik threaded shaft 6,5 x 750 mm	3349
20C)	X-FIRE 75 - sandvik arbalete shaft 6,25 x 1050 mm	3343
20D)	X-FIRE 85 - sandvik arbalete shaft 6,25 x 1150 mm	3344
20E)	X-FIRE 95 - sandvik arbalete shaft 6,25 x 1250 mm	3345
20F)	X-FIRE 105 - sandvik arbalete shaft 6,25 x 1350 mm	3346
20G)	X-FIRE 115 - sandvik arbalete shaft 6,25 x 1450 mm	3347
21)	X-FIRE 50/60 nylon PU bag	C311141
21B)	X-FIRE 75/85/95 nylon PU bag	C311142
21C)	X-FIRE 105/115 nylon PU bag	C311143
22)	X-FIRE 50 / 60 5 pronged head	110C

\* The X-FIRE 50 and 60 are assembled with threaded shaft.

