OPERATING INSTRUCTIONS

MCMILLAN TACTICAL SNIPER RIFLE

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PART 1 – EQUIPMENT INTRODUCTION

Purpose

1. The McMillan Tactical Sniper Rifle System with Accessories provides especially trained personnel with the capability to effectively perform the tasks of a sniper, for combat and internal security operations. The rifle system can also be used in both advanced regional and national sniper competitions.

Description

The McMillan Tactical Sniper Rifle System is a heavy barrel, manually operated, bolt action. It is fitted with a McMillan Fiberglass Stock, butt spacer system, and adjustable cheekpiece.

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The system utilizes a Remington type trigger set to 3.0 lbs. The barrel is match grade stainless steel. All metal parts are finished with a Matte Black Corrosion Resistant Polymer Finish, with a nickel / teflon or black oxidized finish on the bolt and internal parts.

The McMillan Tactical Sniper System is capable of 1/2 MOA in the hands of qualified snipers with applicable match ammunition.

Identification

Model ..... MCRT Repeater
Manufacturer ..... McMillan Bros Rifle Co.
Manufacturer Part No. MCRT-300

PART 2 – PREPERATION FOR USE

SAFETY RULES

WARNING

Read These Basic Safety Rules

Learn how to handle your rifle safely. Failure to follow these rules can result in serious personal injuries. Only you can prevent accidents.

Know Your Firearm

To use it correctly and safely, read and follow the instructions in this manual.

1. Treat ALL firearms as if they are loaded.

2. Never point your firearm at anything you are not willing to destroy.

3. Keep your finger off the trigger until your sights are on target and you are ready to fire.

4. Be sure of your target! Know what is in front and behind the target.

5. Never make changes to/or alter any parts in your rifle, especially the trigger sear and sear notch. Use only original McMillan rifle parts for this system.

6. Make yourself safe at all times by wearing eye protection, such as shooting glasses or impact resistant sunglasses, when shooting. Wear ear protection, such as ear plugs and/or earmuffs, if not both. Repeated exposure to shooting noise can cause permanent hearing loss.

7. Take care of your rifle system and keep the barrel clean and free of obstructions. Clean and have the rifle checked periodically to make sure it functions properly. Worn, damaged, or missing parts may be dangerous.

8. Only use ammunition that exactly matches the caliber or gauge markings on your firearm. Handloads can be dangerous. McMillan is not responsible for accidents or damage caused by improperly loaded handloads.

9. Never load a firearm until you are in a location where it is safe to fire, and you are ready to shoot.

10. Know the range of your firearms! **Remember**, center fire bullets can travel out to 5.5 miles.

11. If a firearm fails to fire, keep it pointed in a safe direction, carefully unload, avoiding exposure to the breech. If the firearm discharges, but the report or recoil seems weak, unload and ensure there are no barrel obstructions.

12. Unload your firearm whenever you are not shooting. Never carry or store a loaded firearm in a building or vehicle. Unload your firearm before climbing up or over a fallen obstacle, fence, or slippery area.

13. Store your firearm and ammunition safely, especially away from children. Lock unloaded firearms and ammunition securely in separate locations.

Caution: Never drink alcoholic beverages before or during shooting.

PART 2 – PREPERATION FOR USE

NEW RIFLE BREAK-IN PROCEDURES

For the best results and long life of your rifle barrel, we suggest the following break-in procedure.

14. Thoroughly clean the barrel before starting to shoot. We recommend a good quality brass brush, a coated cleaning rod, bore guide, brass jag, and soft clean patches. For solvents we recommend products like SWEET'S 7.62 SOLVENT, SHOOTERS CHOICE, MP7, etc.

15. Always clean the barrel from the chamber end, using a bore guide, brass brush, and plenty of solvent. When the above procedure has been completed and the patch comes out clean, proceed with the first shot. Make sure the barrel is dry internally.

16. Fire one round, and follow the above procedure for a total of ten (10) rounds, thoroughly cleaning the barrel between each shot.

17. When you have completed this initial single shot sequence, you may proceed to the next step, shoot two (2) shots and clean, for a total of twenty (20) rounds. At no time should the barrel be allowed to get so hot that you cannot hold it comfortably in your hands.

18. **CAUTION:** Do not use any kind of abrasive cleaner in the bore of your rifle.

20. To continue to get the best accuracy and long life from your custom barrel, we recommend that you clean the barrel on a "regular" basis (should not exceed 30 rounds)

PART 3 – ASSEMBLY OF THE McMILLAN RIFLE

RIFLE SYSTEM

1. Your McMillan Tactical Rifle System is broken down into 2 major components: the stock assembly and the action/barrel assembly.

2. Remove the stock and make absolutely sure that there is no grit, dust, or any foreign matter on the recoil lug recess or bedding (action) area. This is absolutely critical to achieve accuracy.

3. Carefully inspect the action/barrel assembly and check that it is clean and free of any foreign matter.

4. Gently place the action/barrel assembly into the stock. Be careful not to damage or chip the bedding material in the recoil lug area.

5. Use the ¼ x 28 Allen head screws supplied to fasten the action/barrel to the stock assembly**.**

6. With the action/barrel assembly in place, use a torque wrench to tighten the screws to 65 inch-pounds. Always tighten the front screw first (NOTE: the "front" screw being the one closest to the muzzle). This is accomplished when the handle "clicks", indicating the torque setting has been reached.

7. Insert the complete bolt assembly into the rear of the action. Insure that the lugs are in alignment before trying to insert the bolt.

PART 4 – DESCRIPTION OF RIFLE SYSTEM CONTROLS

SAFETY LEVER

1. The safety lever provides protection against accidental or unintentional discharge under normal usage when properly engaged.

2. To engage the safety, move the safety lever to the rear (SAFE) position

3. Always move the safety lever to the rear (SAFE) position before handling, loading, or unloading the rifle.

4. When you are ready to fire the rifle, move the safety lever to the forward (FIRE) position.

5. Avoid touching the trigger when moving the safety lever.

BOLT ASSEMBLY

Installation of the Bolt Assembly

6. Point the rifle in a safe direction.

7. Move the safety lever to the rear (SAFE) position.

8. Align the lugs on the bolt assembly with the receiver.

9. Slide the bolt assembly into the receiver and push the bolt all the way forward.

10. To lock the bolt assembly into position, push the bolt handle down.

Removal of the Bolt Assembly

11. Point the rifle in a safe direction.

12. Move the safety lever to the rear (SAFE) position.

13. Avoid touching the trigger while moving the safety lever.

14. Raise the bolt handle.

15. Pull the bolt all the way to the rear.

16. Depress the bolt stop release.

17. As you depress the bolt stop release, slide the bolt from the rifle.

PART 5 – BARREL GROUP

The Inside of the barrel must be clean and free of obstructions

Barrel Inspection Procedure

1. Point the rifle in a safe direction.
2. Move the safety lever to the rear (SAFE) position.
3. Raise the bolt handle.
4. Pull the bolt all the way to the rear.
5. Remove any ammunition from the chamber and/or magazine.
6. Remove the bolt.
7. Look through the barrel from the chamber end to the muzzle.

To Remove Any Obstruction from Inside the Barrel

8. Use the correct size cleaning rod.
9. Push the cleaning rod from the chamber end, all the way through the barrel, until the rod comes out of the muzzle.
10. If an object cannot be easily pushed out of the barrel with a cleaning rod, return the rifle to the unit maintenance section for service.

NEVER try to remove an object from the barrel by loading another cartridge and firing.

PART 6 – CLEANING OF THE RIFLE BARREL

Moly Coated or Copper Jacketed Bullets

Clean the rifle after 30 to 40 rounds in order to maintain "benchrest accuracy"

Cleaning Procedure

1. **Ensure** the rifle is **unloaded.**..

2. Ensure that the muzzle is **lower** than the action.

3. Roll one (cotton) patch all the way around the brass jag. Wet the patch with MP7 Cleaner. Roll the cleaning rod with the wet patch in the chamber and neck area.

4. Repeat Step 3

5. Replace the brass jag with a phosphor bronze brush, wet it with MP7 Solvent and run it through the barrel, then again wet the brush with MP7 Solvent after it exits the muzzle, then draw it back down the barrel. Run the brush through the barrel 10 times (up and back is one time). Then once again wet the brush at the muzzle, and run the brush through the barrel an additional 4 times.

6. Replace the bronze brush with the brass jag and roll one patch onto the jag. Then roll the cleaning rod in the chamber and neck. After removing the rod, unroll the patch, then run 3 dry patches through the barrel.

7. Repeat steps 3 through 6, **except** using **Sweets 7.62 Solvent** on a NYLON brush. (**Note**: there is no need to clean the chamber)

   WARNING: Sweets should never be left in the barrel for more than 10 minutes, as it could permanently etch the barrel.

8. Roll a patch on the jag, wet with **Sweets Solvent**, and run the patch through the barrel in short back and forth strokes, approximately 4" at a time. **DO NOT** push the patch out of the end of the barrel. (go on to steps 5 and 6, using the nylon brush)

   Note: Remember to keep the nylon and phosphor bronze brushes separated, as the **Sweets Solvent** will erode the bronze bristles.

9. Replace the nylon brush with a jag, roll a patch onto the jag and wet with MP7 Solvent. Then run the wet patch through the barrel and remove it, followed by a dry patch to remove any excess MP7 Solvent from the barrel. Finally, roll one full patch

on the jag, roll the cleaning rod in the chamber and neck to remove any excess MP7 Solvent.

10. The barrel should now be clean and the rifle ready to fire or store.

    Note: Some barrels may need Step 7 repeated, as some barrels will foul more than others.

11. For barrels using **Moly Coated Bullets** only: follow Steps 3 through 19 after firing 100 rounds of ammo. Roll a patch onto the jag, and apply **USP Bore Paste** onto the patch.

12. Run the patch through the barrel using short back and forth strokes approx. 4" at a time. Do not push the patch out of the end of the barrel, and repeat four more times.

13. Repeat steps 3 and 5 three times to remove any residue paste from the chamber and barrel.

    Note: Moly will build up on the rifling and will not come out with normal cleaning. It will prevent a rifle from firing at its peak, thus the reason to perform Step 11.

PART 7 – OPERATING PROCEDURES

Loading

1. Point the rifle in a safe direction.

2. Move the safety lever to the rear (SAFE) position.

3. Raise the bolt handle.

4. Pull the bolt all the way to the rear.

5. Insert the required number of cartridges into the magazine.

6. Insert one cartridge into the chamber.

7. Using your finger, depress the cartridges in the magazine, and slowly slide the bolt forward, so the bolt slides over the top cartridge in the magazine.

8. Finish closing the bolt on the cartridge you inserted into the chamber.

THE RIFLE IS NOW LOADED

8. To fire the rifle, move the safety lever to the forward (FIRE) position.

THE RIFLE IS READY TO FIRE

Loading Single Cartridge Only

9. Point the rifle in a safe direction.

10. Move the safety lever to the rear (SAFE) position.

11. Raise the bolt handle.

12. Pull the bolt all the way to the rear.

13. Insert one cartridge into the magazine or insert one cartridge into the chamber.

14. Using your finger, depress the cartridge in the magazine, and slowly slide the bolt forward, so the bolt slides over the top cartridge in the magazine, continue to close the bolt, locking the cartridge into the chamber.

15. If you choose to insert the round directly into the chamber, slide the bolt all the way forward, closing the bolt, and locking the cartridge into the chamber.

THE RIFLE IS NOW LOADED

16. To fire the rifle, move the safety lever to the forward (FIRE) position.

THE RIFLE IS READY TO FIRE

WARNING

Always check the cartridge for the correct caliber
before loading your rifle.

Unloading Unfired Rounds from the Magazine

17. Point the rifle in a safe direction.

18. Move the safety lever to the rear (SAFE) position.

19. Raise the bolt handle.

20. Put one hand over the top of the ejection port.

21. Slowly pull the bolt to the rear with your other hand to remove the cartridge from the chamber.

22. Take hold of the cartridge and remove it from the rifle.

23. Depress the floorplate latch to allow the floorplate (with magazine follower and spring) to drop open and drop the rounds in the magazine box into your hand.

NOTE: If the cartridge you are trying to remove, slides into the chamber, normally the cartridge will slide back out by elevating the muzzle. If the cartridge remains in the chamber, push the bolt all the way forward and depress the bolt handle, locking the cartridge into the chamber. Then repeat Steps 18 through 22.

PART 8 – CARE AND CLEANING PROCEDURES

Lubrication

1. Over-lubrication should be avoided at all times. A thin coat of oil externally is all that is needed.

2. When the rifle is to be stored, it should be carefully cleaned and thoroughly oiled. The exterior surfaces should be wiped with a light coat of oil on a regular basis.

3. When the rifle is to be reused, all excess lubrication must be removed. The chamber and the bore must be thoroughly cleaned and wiped dry.

Note: A light film of grease should be applied to the guide slot and the external surface of the bolt. **DO NOT OVER GREASE**. This will facilitate smooth bolt movement and less grease will be needed as the rifle is broken in.

Cleaning the Receiver and Trigger Assembly

4. Move the safety lever to the rear (SAFE) position.

5. Remove the bolt assembly.

6. Turn the rifle upside down.

7. Remove the screws from the trigger guard.

8. Carefully lift the stock away from the receiver and trigger assembly.

NOTE: Clean the receiver and trigger assembly as a unit with a degreaser such as M.E.K. (Methyl Ethel Ketone) or "Gun Scrubber".

9. Spray the receiver and the trigger assembly with a light coat of oil. Let stand for 15 minutes, then wipe or blow off all excess lubricant with a clean rag or air.

10. Before replacing the bolt, make sure the barrel is free from obstructions.

11. After cleaning the trigger assembly, check to be sure there are no cartridges in the rifle, close the bolt, move the safety lever to the forward (FIRE) position, and pull the trigger. The firing pin must fall. Repeat at least 10 times.
    WARNING: If the firing pin does not remain cocked, when the bolt is closed smartly, return the rifle to the unit maintenance unit for service.

12. Cleaning should also be performed after long term storage, or after being subjected to rain/sleet/dust/snow/sand/mud or saltwater.

Cleaning the Bolt Assembly

13. Remove the bolt assembly from the rifle.

8. Use a good quality solvent and a rag to wipe down the bolt body. Ensure that all fouling and residue are removed.

9. With a good quality bristle brush and solvent scrub the bolt face and remove all fouling and loose brass from the bolt face.

10. Lift the extractor upward and clean under the extractor notch with the brush and solvent.

11. Dry thoroughly and lubricate bolt body with a small amount of gun oil.

12. Activate the ejector and the extractor and ensure they move freely without sticking.

13. If the ejector or the extractor sticks, return the rifle to McMillan for service.

14. A light film of grease should be applied behind the bolt recoil lugs. DO NOT OVER GREASE. This will facilitate smooth bolt movement and less grease will be needed as the rifle is broken in.

PART 9 - TRIGGER ADJUSTMENTS AND MAINTENANCE PROCEDURES

General

1. The McMillan Tactical Sniper Rifle comes supplied with a Remington style trigger assembly. The trigger adjustment screws are located as shown in Figure 1.

   #1 is the OVERTRAVEL or BACKLASH adjustment set screw

   #2 is the SPRING TENSION set screw

   #3 is the SEAR ENGAGEMENT set screw

   These screws have all been preset during the manufacture of the rifle, however with use, the engagement surfaces and spring tension will wear and/or weaken and will need to be adjusted.

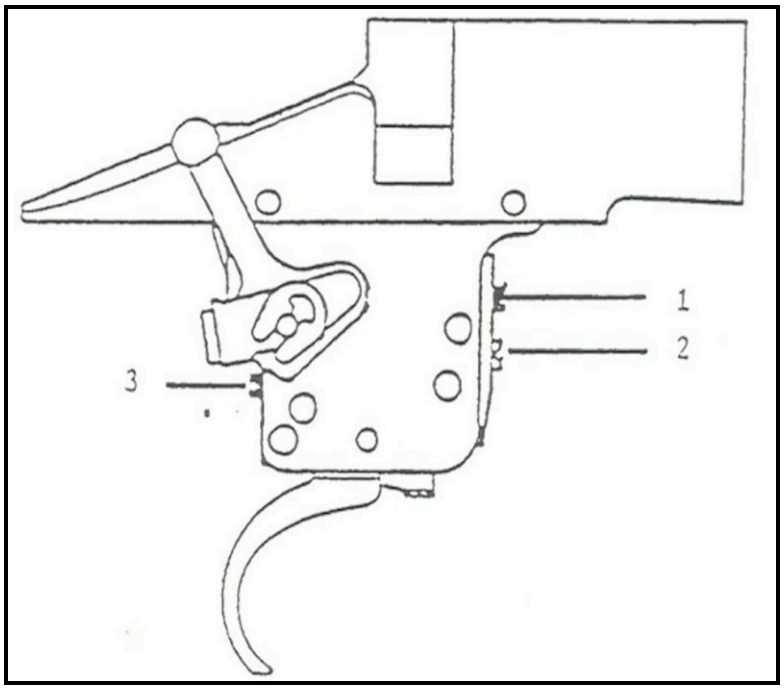

Figure 1

Backlash Adjustment

1. It is unlikely that this screw will need to be adjusted at all.

   Note: To adjust **do not remove the trigger mechanism from the action.**

2. Break the epoxy seal and turn the setscrew clockwise until the trigger **will not** fire.

3. Back out the setscrew until the trigger releases. Continue to back out the setscrew an additional 1/16 to 1/8 turn, and re-epoxy.

Spring Tension Adjustment

4. Break the epoxy seal and back the setscrew out counterclockwise until there is little or no spring tension on the trigger. **The bolt must be open at this time.**

5. Turn the setscrew in clockwise, part of the way, and close the bolt.

6. Check the trigger weight with a trigger pull gauge.

7. Turn the setscrew in clockwise to increase the weight of the trigger pull and counterclockwise to decrease the trigger pull weight.

8. Ideal trigger pull weight should be approximately 3.0 pounds.

9. **Do not** epoxy the setscrew if you are going to adjust the sear engagement, as some minor adjustment may be required.

10. **You must epoxy** the setscrew when the adjustment is finalized, before reassembling the rifle for firing.

Sear Engagement Adjustment

WARNING: Incorrect setting of the sear engagement can cause serious injury!

11. Open the bolt.

12. By looking through the hole in the side-plate (left side) of the trigger housing, you will be able to see the amount of the engagement (See Figure 2).

13. Turn the setscrew counterclockwise to increase the sear engagement and clockwise to decrease the engagement. Too little engagement can be dangerous and lead to a slamfire or decocking of the firing pin on closing the bolt.

14. This and all other trigger setting screws **must** be epoxied into position prior to reassembly and firing.

15. **Always** test the trigger prior to firing live ammunition.

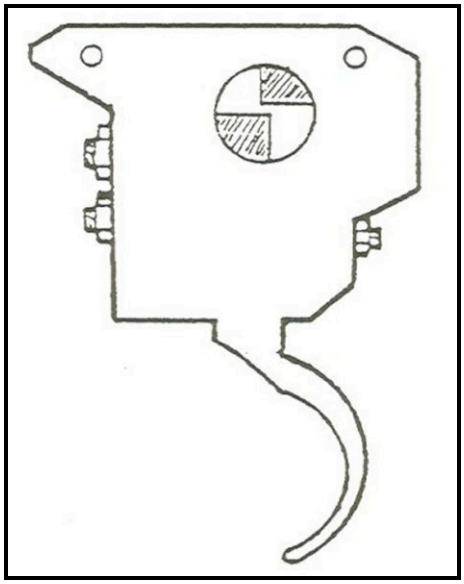

Figure 2

Replacement of Firing Pin

16. Remove the bolt from the receiver.

17. Hold the bolt in your left hand with the bolt handle towards you, bolt face to the left, cocking piece housing to the right, and with the cocking piece facing up.

18. Holding the bolt firmly in your left hand, grasp the cocking piece housing with your right hand, and give the cocking piece housing a 1/8 turn away from you. This unlocks the firing pin assembly from the bolt (See Figure 3).

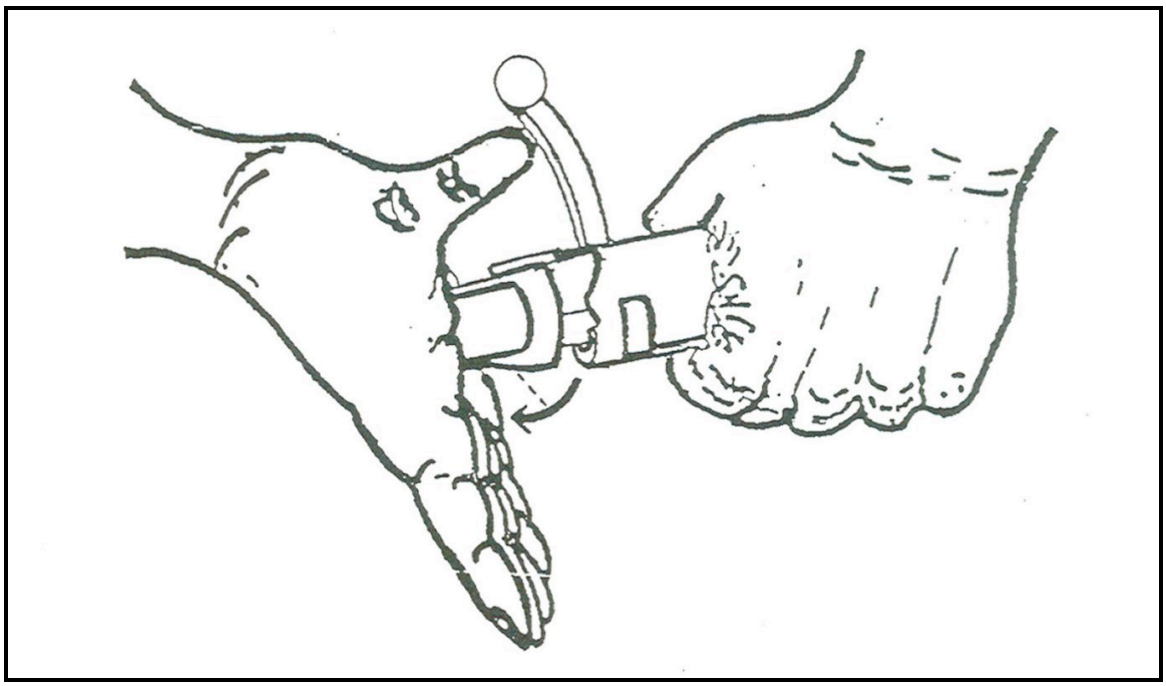

Figure 3

19. While still holding the bolt in your left hand, pull the firing pin assembly out to the right. Then lay the bolt aside.

20. Shift the firing pin assembly to your left hand. Keeping the cocking piece up and the firing pin pointing to the left.

21. Using an Allen wrench (.050), remove the two Allen head set screw from the hole on the cocking piece. **Be sure to put the screws somewhere safe so you can find them**.

22. Unscrew the cocking piece and cocking piece housing from the firing pin.

23. Remove the firing pin spring from the old firing pin.

24. Place the firing pin spring on the new firing pin.

25. Insert the firing pin and firing pin spring through the cocking piece housing, then screw the firing pin into the cocking piece.

26. Grasp the bolt with your left hand, open end to the right, and install the firing pin assembly. Press firmly and turn toward you.

27. You will feel the firing pin assembly lock in place.

28. Continue turning the cocking piece housing toward you until the cocking piece is at the bottom of the cocking cam in the bolt.

29. The firing pin will now be protruding from the face of the bolt. At this point the protrusion must be measured. The firing pin should extend.055 inches to .060 inches. If it falls within the acceptable range, replace the two Allen head setscrews, making sure the first one butts against the firing pin and the second against the first screw. Then turn the cocking piece housing back up to the cocked position.

30. If the protrusion is not acceptable, remove the firing pin assembly from the bolt once again.

31. If the protrusion is too long, screw the firing pin further into the cocking piece. If it is too short, screw the firing pin out.

32. Repeat steps 26, 27, 28, and 29 to test the adjustment. If the protrusion is acceptable go to step 33. If the protrusion is not acceptable repeat steps 30 and 31.

33. Install bolt in receiver.

Replacement of Extractor Assembly

34. Place the bolt in a padded vise, with the extractor up and the bolt face to the right.

35. Using a 1/16" punch or small screwdriver, push the extractor plunger to the rear, and at the same time, push down on the front edge of the extractor with your index finger or thumb, this will allow the ejector plunger to clear the extractor.

36. The extractor is now holding the extractor plunger and extractor spring to the rear. In this position a small screwdriver may be inserted under the extractor at the bolt face to lift the extractor from its recess.

    Caution: Removing the extractor, releases the extractor plunger and spring. Ensure that you retain them under control.

37. Prior to installing the new extractor, make sure the extractor spring is in its hole and the extractor plunger is in place with the flat side down.

38. To install the new extractor, place it in the extractor slot of the bolt and push to the rear and down.

39. Check to insure the flat side of the extractor plunger overlaps the extractor.

40. Remove the bolt from the vise.

Replacement of Ejector Assembly

40. Place the bolt in a padded vise with the extractor up and the bolt face to the right.

41. Place a **fired cartridge case** into the face of the bolt, making sure the case is hooked onto the extractor. This will compress the ejector spring as you push down on the cartridge case.

42. Using a 1/16" punch, drive the ejector retaining pin out. Care should be taken in removing the cartridge case from the face of the bolt, as the ejector is under spring tension and may shoot out and be lost.

43. After removing the ejector and spring, replace them with a new assembly.

44. Remove the bolt from the vise and rotate it 180 degrees so the extractor is facing down. Place the bolt back into the padded vise.

45. Insert the new ejector spring and ejector, making sure the retaining pin flat on the ejector aligns with the retaining pin hole in the bolt.

46. Place the cartridge case in the bolt face, depressing the ejector and install the ejector retaining pin. **Ensure** the pin is below the surface of the bolt.

47. Test the action of the ejector to insure free movement. Remove the cartridge case from the face of the bolt.

48. Remove the bolt from the vise.

PART 10 – SPARE PARTS LIST

ITEM NO	PART NUMBER	DESCRIPTION
1	300.1	Barreled Action Assembly
	300.1.1	Rifle Barrel
	300.1.2	MCRT Action Assembly
3	300.1.2.1	Bolt Assembly
4	300.1.2.1.1	Firing Pin Assembly
	300.1.2.1.1.1	Firing Pin
	300.1.2.1.1.2	Firing Pin Spring
	300.1.2.1.1.3	Cocking Piece
	300.1.2.1.1.4	Cocking Piece Housing
	300.1.2.1.1.5	Firing Pin Locking Set Screws
9	300.1.2.1.2	RT Ejector Assembly
	300.1.2.1.2.1	Ejector Pin
	300.1.2.1.2.2	Ejector Retaining Pin
	300.1.2.1.2.3	Ejector Spring
10	300.1.2.1.3	Extractor Assembly
	300.1.2.1.3.1	Extractor
	300.1.2.1.3.2	Extractor Actuating Pin
	300.1.2.1.3.3	Extractor Spring
12	300.1.2.2	Bolt Stop Assembly
	300.1.2.2.1	Bolt Stop
	300.1.2.2.2	Bolt Stop Pivot Pin
	300.1.2.2.3	Bolt Stop Spring
11	300.1.2.3	Wt Ejector Assembly
	300.1.2.3.1	Ejector Blade
	300.1.2.3.2	Ejector Pivot Pin
	300.1.2.3.3	Ejector Spring
6	300.1.2.4	Trigger/Safety Assembly
	300.1.2.4.1	Trigger
	300.1.2.4.2	Safety
8	300.1.3	Recoil Lug
2	300.2	Stock Assembly
	300.2.1	Butt Pad
	300.2.2	Butt Spacer Assembly
	300.2.2.1	1/2 Inch Spacer
	300.2.2.2	1/4 Inch Spacer
	300.2.2.3	Sling Swivel Studs
5	300.2.3	Bottom Metal Assembly
	300.2.3.1	Trigger Guard
	300.2.3.2	Floor Plate
	300.2.3.3	Magazine Box
	300.2.3.4	Magazine Spring
	300.2.3.5	Magazine Follower
7	300.2.4.6	Guard Screw Set
	300.2.4.6.1	Front
	300.2.4.6.2	Middle
	300.2.4.6.3	Rear