



McMILLAN®

OWNER'S MANUAL



MCMILLAN® TAC-SERIES G30 TACTICAL RIFLE

S H O O T T O W I N®



Congratulations. You are now the owner of the finest firearm that technology, craftsmanship and art can build. Please take a few minutes and get acquainted with the proper operation of your new firearm.



Shoot to win.®

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PART 1 – EQUIPMENT INTRODUCTION

PURPOSE

The McMillan® TAC™-Series Rifle System provide professionally trained personnel with the capability to effectively perform the tasks of a tactical marksman for combat and internal security operations. The rifle system can also be used in both advanced regional and national marksmanship competitions.

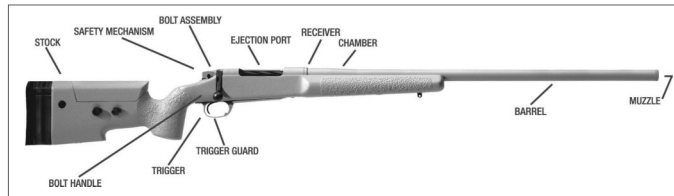
DESCRIPTION

The McMillan TAC-Series Rifle System is a heavy barrel, manually operated, bolt action rifle. It is fitted with a McMillan tactical fiberglass stock.

The system utilizes a Remington type trigger set to 3 lbs. The barrel is match grade stainless steel. All metal parts are finished with a matte corrosion resistant polymer finish, with a nickel/Teflon* finish on the bolt and internal parts.

The McMillan Tactical System is capable of shooting 1/2 MOA or better in the hands of qualified marksmen with match ammunition.

**Teflon is a Dupont trade name. PTFE is generic.*



PART 2 – PREPARATION 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 or death. Only you can prevent accidents.

KNOW YOUR FIREARM

To use your firearm 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 of and behind the target.
5. Never make changes to, or alter any parts in your rifle, especially the trigger. Use only original McMillan rifle parts.
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 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 (and muzzle brake if present) clean and free of obstruction. Keep the rifle clean and have it checked periodically to verify and maintain proper function. Any worn, missing, or damaged parts may cause an unsafe condition resulting in possible injury or death.
8. Use only ammunition that matches the type marked on your firearm. McMillan is not responsible for any accidents or damage caused by handloads or improperly loaded ammunition. If for any reason the bolt closes or opens with difficulty or increased effort, discard the ammunition and replace it with suitable ammunition. Failure to do so may cause damage to the rifle and possible injury or death.
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, centerfire bullets can travel out to 5.5 miles.
11. If a firearm fails to fire, keep it pointed in a safe direction, wait one minute and 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.

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 shooting. We recommend a good quality bronze brush (NEVER use stainless steel brushes as they can damage the bore), coated cleaning rod, bore guide, brass jag, and soft clean patches. Ammonia type copper removers may be used, but are caustic and can cause damage if left on surfaces. Never leave any ammonia type copper remover in a barrel for over five (5) minutes. Follow all warning labels on any solvent or cleaners used.
15. Always clean the barrel from the chamber end towards the muzzle. With the bolt removed and the bore guide in place, start by pushing a solvent wet patch through the bore, followed by 20 strokes of a solvent soaked bronze brush. Dry patch the barrel until patches come out clean and dry. Remove the bore guide and run a final dry patch through chamber and bore. Install the bolt. The rifle is now ready for the first shot.
16. Fire one round and reclean the bore as stated in step 15. In order to break in the barrel correctly it is critical to remove all traces of fouling. After the initial bore cleaning has been completed, run several patches soaked in the copper remover completely through the barrel. Dry patch after each wet patch. Once there is no trace

of copper in the bore and the patches come out clean and dry, fire the next round. Repeat this procedure for the first 10-12 rounds.

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.

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

18. To continue to get the best accuracy and longest life from your custom barrel, we recommend that you clean the barrel every 30-40 rounds.

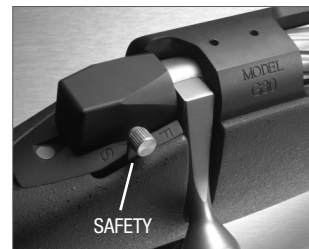
PART 3 – ASSEMBLY OF THE MCMILLAN RIFLE RIFLE SYSTEM

1. Your McMillan Tactical Rifle System can be broken down into two major components: the stock assembly and the action/barrel assembly.
2. Remove the stock and make sure there is no grit, dust, or any foreign matter in 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 hex 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 55-65 inch-pounds. Always tighten the front screw first (the screw 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. Ensure 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.



REMOVAL OF THE BOLT ASSEMBLY

6. Point the rifle in a safe direction.
7. Move the safety lever to the rear (SAFE) position.
8. Avoid touching the trigger while moving the safety lever.
9. Raise the bolt handle.
10. Pull the bolt all the way to the rear.
11. Depress the bolt stop release.
12. As you depress the bolt stop release, slide the bolt from the rifle.



BOLT ASSEMBLY

INSTALLATION OF THE BOLT ASSEMBLY

13. Point the rifle in a safe direction.
14. Move the safety lever to the rear (SAFE) position.
15. Align the lugs on the bolt assembly with the receiver.
16. Slide the bolt assembly into the receiver and push the bolt all the way forward.
17. To lock the bolt assembly into position, push the bolt handle down.

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 AN 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 McMillan.

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. Remove bolt and magazine if equipped.
2. Ensure the muzzle is lower than the action.
3. Roll one cotton patch all the way around the brass jag. Wet the patch with solvent. Roll the cleaning rod with the wet patch in the chamber and neck area. Push wet patch through bore.
4. Install bore guide.
5. Replace the jag with a phosphor bronze brush, wet it with bore solvent (not copper remover) and run it through the barrel. After it exits the muzzle, draw it back through the barrel and out the chamber. This is one stroke. Repeat this for a total of ten (10) times. Apply more solvent to the brush and perform another ten (10) times. Apply more solvent to the brush and perform another ten (10) strokes.

NOTE: NEVER reverse brush while inside the bore.

6. Replace the bronze brush with the brass jag. Roll a clean patch onto jag and dry patch bore. Dry patch bore until patches come out clean and dry.

7. Roll a new patch onto the jag and wet it with the copper fouling remover and push it through the bore and out the muzzle. Repeat once more and clean up with a dry patch. The wet patches can be worked back and forth with short 4"-6" strokes to increase effectiveness. Repeat this process until all copper fouling is removed. Once all fouling has been removed from the barrel, remove the bore guide and dry patch the chamber, neck, and bore until clean and dry.

NOTE: Copper remover may be applied to a nylon brush for heavily fouled barrels. Never add any type of copper fouling remover to a bronze brush. It will attack the brush in the same fashion as fouling.

WARNING: Ammonia-based copper removers should never be left in the barrel for more than 5 minutes, as they could permanently etch the barrel.

8. Wrap a new patch around the jag and wet with solvent (not copper remover). Run the patch through the barrel, followed by one or two dry patches. Copper fouling removers will leave the bore dry and stripped of any oil. It is good practice to run a patch wet with bore solvent down the bore, followed by a dry patch. Many bore cleaners/solvents have some trace of oil that will stay in the bore.

NOTE: For barrels using moly coated bullets, additional cleaning may need to be done to remove the moly fouling.

9. Once all bore cleaning has been completed through step 8, if moly fouling is present, additional cleaning may be necessary. Wrap a dry patch around a jag and apply bore paste to the patch. Work the patch through the bore in the same manner as the copper remover.
10. Repeat steps 3, 5, and 6 to remove any residue paste from the bore. Use the bore paste only as a last resort. Improper or excessive use of abrasives can damage the barrel and shorten its service life.

PART 7 – OPERATING PROCEDURES

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

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. On DBM (Detachable Box Magazine) models, insert loaded magazine until locked in mag well. For hinged floorplate models, load required number of cartridges into the internal 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

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

THE RIFLE IS READY TO FIRE

LOADING SINGLE CARTRIDGE ONLY

10. Point the rifle in a safe direction.
11. Move the safety lever to the rear (SAFE) position.
12. Raise the bolt handle.
13. Pull the bolt all the way to the rear.
14. Insert one cartridge into the chamber. Push bolt forward and close over round.

THE RIFLE IS NOW LOADED

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

THE RIFLE IS READY TO FIRE

UNLOADING UNFIRED ROUNDS FROM THE RIFLE

16. Point the rifle in a safe direction.
17. Move the safety lever to the rear (SAFE) position.
18. Raise the bolt handle.

19. Put one hand over the top of the ejection port.
20. Slowly pull the bolt to the rear with your other hand to remove the cartridge from the chamber.
21. Take hold of the cartridge and remove it from the rifle, leaving the bolt in the open position.
22. For hinged floorplate models, depress the floorplate latch, open floorplate and remove all cartridges. Once magazine is empty, close floorplate until locked close. To unload DBM models, simply push magazine release lever and remove magazine from rifle.



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 16 through 21.

PART 8 – CARE AND CLEANING PROCEDURES

LUBRICATION

1. Wipe the rifle down with a clean soft cloth. A thin coat of light oil may be applied to all steel surfaces. Apply gun grease (non melting grease, not heavy oil), at the rear of the locking lugs located at the front of the bolt, and the cocking cam at the rear-underside. Keep grease and oils from getting into the trigger as this may create an unsafe condition. Do not over lube.

2. When the rifle is to be stored, it should be carefully cleaned and thoroughly oiled. A soft 1" paint brush may be used to clean dust and dirt from hard to reach areas. The bore should be coated with a very light layer of oil. Avoid over oiling the bore as it will work its way down into the action.
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: Never use WD-40 on any part of the rifle. WD-40 is a water displacing oil and will dry out, leaving a sticky varnish behind.

CLEANING THE RECEIVER AND TRIGGER ASSEMBLY

4. Move the safety lever to the rear (SAFE) position. Make certain the rifle is unloaded.
5. Remove the bolt assembly.
6. Turn the rifle upside down.
7. Remove both guard screws.
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. Do not leave any degreaser on coated surface any longer than necessary.

9. Wipe the receiver down 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. Grease bolt per step 1.
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 5 times.

WARNING: If the firing pin does not remain cocked when the bolt is closed smartly, return the rifle to McMillan 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.
14. Use a good quality solvent and a clean rag to wipe down the bolt body. Ensure that all fouling and residue are removed.
15. With a good quality bristle brush and solvent, scrub the bolt face and remove all fouling and loose brass from the bolt face.
16. Lift the extractor upward and clean under the extractor notch with the brush and solvent.
17. Dry thoroughly and lubricate bolt body with a small amount of gun oil.
18. Activate the ejector and the extractor and ensure they move freely without sticking.

19. If the ejector or the extractor sticks, return the rifle to McMillan for service.
20. A light film of grease should be applied behind the bolt locking lugs. DO NOT OVER GREASE. This will facilitate smooth bolt movement and less grease will be needed as the rifle is broken in.

NOTE: Refer to Part 3: Assembly Of The McMillan Rifle on page 8 for correct barreled action to stock reassembly.



PART 9 - TRIGGER ADJUSTMENTS AND BOLT MAINTENANCE PROCEDURES

TRIGGER ADJUSTMENTS

The McMillan Tactical Rifle comes supplied with an adjustable trigger assembly. It can be adjusted and maintained safely only by McMillan.

BOLT MAINTENANCE

1. Remove the bolt from the receiver.
2. 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.
3. 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 (clockwise). This unlocks the firing pin assembly from the bolt.



REMOVE

4. While still holding the bolt in your left hand, pull the firing pin assembly out to the right. Then lay the bolt body aside.
5. Remove all grease, dirt, powder residue, and solvents from the firing pin assembly and inside bolt body.
6. To reinstall the firing pin assembly, first apply grease at the locking tab located on the cocking piece housing. Grasp the bolt with your left hand with the back of the bolt facing to the right. Install the firing pin assembly into the back of the bolt while aligning housing tab with the notch in the bolt body. When aligning the tab, the cocking piece should be positioned to the right of the cocking cam and notch (LH models will be to the left). With the palm of your right hand, firmly press the firing pin assembly in until it bottoms out on the rear of the bolt. Once fully depressed, rotate the firing pin assembly counter clock-wise.
7. You will feel the firing pin assembly lock in place.
8. Grease the locking lugs and cocking cam of the bolt. Install bolt into the receiver.



INSTALL

PART 10 – HOW TO OBTAIN PARTS AND SERVICE FROM MCMILLAN FIREARMS MANUFACTURING TO ORDER PARTS

1. Fax completed order to 1-623-581-3825.
2. To order by phone call toll free: 1-877-365-6148.

Please have the following information ready before you call.

- Firearm model and serial number.
- Part description and quantity. Part descriptions can be found on the parts listing page in this manual.
- Your complete mailing address (P.O. Box and street address) including zip code, telephone number and e-mail address.
- Method of payment: MasterCard or Visa card number and expiration date. Prepayment may be made by check or money order. A quote may be made to you over the phone. (Sorry, no C.O.D.s.)

WARNING! USE ONLY MCMILLAN PARTS IN MCMILLAN FIREARMS.

REPAIR SERVICES

1. Contact McMillan Firearms Manufacturing if your firearm needs servicing. Please call our toll free number 1-877-365-6148, Mon-Fri., 7:00 a.m. to 4:00 p.m. Mountain Standard time, or you may e-mail us at info@mcmillanusa.com.
2. If shipment of your firearm is required, please:
 - Record the serial number of your firearm before sending it to us.
 - Remove all accessories from the firearm to prevent loss or damage.
 - Pack your firearm for safety and to prevent damage in shipping and handling in a firearms box or case.
 - Enclose a letter with the firearm detailing the model name or number of your firearm and serial number along with a full description of the problem. Be sure to include your full name and address (P.O. Box and Street Address), including zip code, daytime telephone number and e-mail address.
 - Ship your firearm by either United Parcel Service (UPS) or Parcel Post (US Post Office). McMILLAN is not responsible for damage or loss during shipment, so you may elect to purchase insurance from your carrier.

SHIP TO

McMillan Firearms Manufacturing
Attn: Rifle Service Division/Repairs
1638 W. Knudsen Dr.
Phoenix, Arizona 85027

WARNING! DO NOT SEND LIVE AMMUNITION IN YOUR FIREARM OR IN THE SAME BOX WITH THE FIREARM. THIS IS A VIOLATION OF FEDERAL LAW. IF YOU FEEL YOU MUST SEND AMMUNITION, PLEASE SEND THEM IN A SEPARATE PACKAGE AND INCLUDE NAME, ADDRESS (WITH ZIP CODE) TELEPHONE NUMBER, MODEL AND SERIAL NUMBER OF YOUR FIREARM.

PART 11 – PARTS LIST

| PART NUMBER | DESCRIPTION |
|-------------|-------------|
|-------------|-------------|

| | |
|----------|-------------------------------|
| G30-30XX | Barrel (Specify) |
| G30-32XX | Muzzle Brake (Specify) |
| G30-39XX | Thread Protector (Specify) |
| G30-100X | Receiver Stripped (Specify) |
| G30-2XXX | Bolt Stripped (Specify) |
| G30-251X | Firing Pin (Specify) |
| G30-255X | Firing Pin Spring (Specify) |
| G30-2570 | Firing Pin Locking Screw (x2) |
| G30-2600 | Cocking Piece |
| G30-2650 | Cocking Piece Housing |
| G30-2310 | Plunger Ejector |
| G30-2311 | Ejector Spring |
| G30-2312 | Ejector Retaining Pin |
| G30-241X | Extractor (Specify) |
| G30-2411 | Extractor Spring |
| G30-2412 | Extractor Actuating Pin |

| | |
|----------|-------------------------------------|
| G30-1110 | Bolt Stop |
| G30-1111 | Bolt Stop Spring |
| G30-1112 | Bolt Stop Pivot Pin |
| G30-1310 | WT Ejector |
| G30-1311 | WT Ejector Spring |
| G30-1312 | WT Ejector Pivot Pin |
| G30-120X | Trigger Assembly (Specify) |
| G30-1200 | Trigger Pin (x2) |
| G30-1050 | Recoil Lug |
| G30-1055 | Recoil Lug Pin |
| G30-5XXX | Stock Assembly (Specify) |
| G30-52X0 | Spacer Assembly (Specify) |
| G30-52X2 | 1/2" Spacer (Specify Stock) |
| G30-52X4 | 1/4" Spacer (Specify Stock) |
| G30-53XX | Recoil Pad-Pres., 1/2" (Specify) |
| G30-53XX | Recoil Pad-Decel., 1/2" (Specify) |
| G30-54X0 | Adjustable Cheek Assembly (Specify) |
| G30-5450 | Adjustable Cheek Lock Screw |

A WORD ON THE MAINTENANCE AND CARE OF YOUR MCMILLAN FIREARM

DON'T ALTER OR MODIFY YOUR RIFLE AND HAVE IT SERVICED REGULARLY.

Your firearm has been designed to operate according to certain factory specifications. You'll jeopardize your safety and that of others around you by attempting to alter its trigger, mechanical safety or other mechanisms. Never alter or modify your firearm in any way.

Like any mechanical device, a firearm is subject to wear. It must be maintained and periodically serviced to assure optimum safety and performance. Only McMillan Firearms Manufacturing should service, repair or modify your McMillan firearm. Consult your instruction book for instructions on how to send your firearm to McMillan. McMillan recommends that you have your firearm professionally serviced annually. You should also have your firearm professionally serviced after prolonged storage, or if there is ever any question pertaining to the proper functioning characteristics of your firearm.

Proper cleaning and lubrication are also important to firearm maintenance and are necessary to assure accuracy, safety and reliability. Before cleaning, always make sure that your gun is completely unloaded. And always clean the barrel from the chamber end to the muzzle when possible.

Contact: McMillan Firearms Manufacturing, LLC., 1638 W. Knudsen Dr., Phoenix, Arizona 85027 or phone 1.877.365.6148.

FIREARM OWNER'S RECORD

Model _____

Serial # _____

Date Purchased _____

Purchased From _____

Price Paid _____

Remember to complete and return the Firearm Warranty Registration Card in order to obtain full benefit of your limited warranty.

TO LEARN HOW MUCH CONFIDENCE A COMPANY HAS IN ITS PRODUCTS, READ ITS WARRANTY.

100% Guaranteed Satisfaction

Every McMillan rifle carries an "Unconditional Lifetime Warranty" against manufacturing defects. This does not include normal "wear and tear" of the firearm including barrel life, internal components and damages resulting in operator misuse. If a problem occurs with the firearm, which is covered under warranty, the defective item will be repaired or replaced.

OR

If for any reason you are not 100% satisfied with your McMillan rifle, return it within 30 days of purchase in good condition for a full refund or exchange.

Items that are purchased but are not manufactured by McMillan, such as scopes and cases, are not covered under the McMillan warranty.



Shoot to win.®

Visit our website at: www.mcmillanusa.com

McMillan Firearms Manufacturing, LLC. 1638 W. Knudsen Dr.
Phoenix, Arizona 85027 1.877.365.6148 phone 623.581.3825 fax
info@mcmillanusa.com