

SIG SAUER[®]
when it counts[®]



SIG50

OWNERS MANUAL: HANDLING & SAFETY INSTRUCTIONS

**READ THE INSTRUCTIONS AND WARNINGS IN THIS MANUAL CAREFULLY
BEFORE USING THIS FIREARM; DO NOT DISCARD THIS MANUAL.**

This instruction manual should always accompany this firearm and be transferred with it upon ownership, or when the firearm is loaned or presented to another person.

State-By-State Warnings

Certain states require, by law, that their own specified warning notices, in larger-than-normal type be conspicuously included by the manufacturer, distributor, or retail dealer with firearms sold in that state. SIG SAUER® sells its products in compliance with applicable laws and regulations. Because our products may be sold in these states, we include the following:

CALIFORNIA:

"With the exception of certain law enforcement agencies, the State of California has restricted the possession of .50 BMG rifles. Possession of an unregistered .50 BMG rifle in California is a felony. Other jurisdictions are considering similar restrictions. You are responsible for understanding and complying with restrictions imposed on .50 BMG rifles."

WARNING

"Children are attracted to and can operate firearms that can cause severe injuries or death. Prevent child access by always keeping firearms locked away and unloaded when not in use. If you keep a loaded firearm where a child obtains and improperly uses it, you may be fined or sent to prison."

ADVERTENCIA

"A los niños atraen las armas de fuego y las pueden hacer funcionar. Ellos pueden causarse lesiones graves y la muerte. Evite que los niños tengan acceso a las armas de fuego guardándolas siempre con llave y descargadas cuando no las esté utilizando. Si usted tiene una arma de fuego cargada en un lugar en que un niño tiene acceso a ella y la usa indebidamente, le pueden dar una multa o enviarlo a la cárcel."

CONNECTICUT:

"UNLAWFUL STORAGE OF A LOADED FIREARM MAY RESULT IN IMPRISONMENT OR FINE."

FLORIDA:

"IT IS UNLAWFUL, AND PUNISHABLE BY IMPRISONMENT AND FINE, FOR ANY ADULT TO STORE OR LEAVE A FIREARM IN ANY PLACE WITHIN THE REACH OR EASY ACCESS OF A MINOR UNDER 18 YEARS OF AGE OR TO KNOWINGLY SELL OR OTHERWISE TRANSFER OWNERSHIP OR POSSESSION OF A FIREARM TO A MINOR OR A PERSON OF UNSOUND MIND."

MAINE:

"ENDANGERING THE WELFARE OF A CHILD IS A CRIME. IF YOU LEAVE A FIREARM AND AMMUNITION WITHIN EASY ACCESS OF A CHILD, YOU MAY BE SUBJECT TO FINE, IMPRISONMENT OR BOTH. KEEP FIREARMS AND AMMUNITION SEPARATE. KEEP FIREARMS AND AMMUNITION LOCKED UP. USE TRIGGER LOCKS."

MARYLAND:

"WARNING: Children can operate firearms which may cause death or serious injury. It is a crime to store or leave a loaded firearm in any location where an individual knew or should have known that an unsupervised minor would gain access to the firearm. Store your firearm responsibly!"

MASSACHUSETTS:

“WARNING FROM THE MASSACHUSETTS ATTORNEY GENERAL: This handgun is not equipped with a device that fully blocks use by unauthorized users. More than 200,000 firearms like this one are stolen from their owners every year in the United States. In addition, there are more than a thousand suicides each year by younger children and teenagers who get access to firearms. Hundreds more die from accidental discharge. It is likely that many more children sustain serious wounds, or inflict such wounds accidentally on others. In order to limit the chance of such misuse, it is imperative that you keep this weapon locked in a secure place and take other steps necessary to limit the possibility of theft or accident. Failure to take reasonable preventative steps may result in innocent lives being lost, and in some circumstances may result in your liability for these deaths.”

“IT IS UNLAWFUL TO STORE OR KEEP A FIREARM, RIFLE, SHOTGUN OR MACHINE GUN IN ANY PLACE UNLESS THAT WEAPON IS EQUIPPED WITH A TAMPER RESISTANT SAFETY DEVICE OR IS STORED OR KEPT IN A SECURELY LOCKED CONTAINER.”

NEW JERSEY:

“IT IS A CRIMINAL OFFENSE TO LEAVE A LOADED FIREARM WITHIN EASY ACCESS OF A MINOR.”

NEW YORK CITY, NY:

“THE USE OF A LOCKING DEVICE OR SAFETY LOCK IS ONLY ONE ASPECT OF RESPONSIBLE FIREARMS STORAGE. FOR INCREASED SAFETY, FIREARMS SHOULD BE STORED UNLOADED AND LOCKED IN A LOCATION THAT IS BOTH SEPARATE FROM THEIR AMMUNITION AND INACCESSIBLE TO CHILDREN AND OTHER UNAUTHORIZED PERSONS.”

NORTH CAROLINA:

Any person who resides in the same premises as a minor, owns or possesses a firearm, and stores or leaves the firearm (i) in a condition that the firearm can be discharged and (ii) in a manner that the person knew or should have known that an unsupervised minor would be able to gain access to the firearm, is guilty of a Class 1 misdemeanor if a minor gains access to the firearm without the lawful permission of the minor's parents or a person having charge of the minor and the minor: (1) Possesses it in violation of G.S. 14-269.2(b) (2) Exhibits it in a public place in a careless, angry, or threatening manner; (3) Causes personal injury or death with it not in self defense; or (4) Uses it in the commission of a crime.

TEXAS:

"IT IS UNLAWFUL TO STORE, TRANSPORT, OR ABANDON AN UNSECURED FIREARM IN A PLACE WHERE CHILDREN ARE LIKELY TO BE AND CAN OBTAIN ACCESS TO THE FIREARM."

WISCONSIN:

"IF YOU LEAVE A LOADED FIREARM WITHIN THE REACH OR EASY ACCESS OF A CHILD YOU MAY BE FINED OR IMPRISONED OR BOTH IF THE CHILD IMPROPERLY DISCHARGES, POSSESSES, OR EXHIBITS THE FIREARM."

Please check with your licensed retailer, state police, or local police for additional warnings, which may be required by local law or regulation. Such regulations change constantly, and local authorities are in the best position to advise you on such legal matters.



WARNING - LOCKING DEVICES



This firearm was originally sold with a key- operated locking device. While it can help provide secure storage for your unloaded firearm, any locking device can fail. All firearms are designed to fire if they are loaded and the trigger is pulled. Therefore, never install the locking device inside the trigger guard or in any way that makes it possible to pull the trigger! Do not leave the keys in the lock.

The ultimate responsibility for secure storage of any firearm must depend upon its owner and his or her individual circumstances. Firearms should be stored unloaded, in a secure location, separate from their ammunition.

NEVER INSTALL THE LOCKING DEVICE INSIDE THE TRIGGER GUARD



To maximize effectiveness and reduce the chances of malfunction or damage to a firearm, ALWAYS refer to the locking device's manufacturer directions for installation and removal of the device.

FIREARMS SAFETY IS YOUR RESPONSIBILITY

This owner's manual is designed to assist you in learning how to use and care for your SIG SAUER® firearm properly.

Only when you are certain that you fully understand this manual and can properly carry out its instructions, should you practice loading and firing your firearm with live ammunition. Having a gun in your possession is a full-time job; you cannot guess and you cannot forget. You must know how to use your firearm safely.

If you have any doubts about your ability to handle or use this firearm safely, you should seek supervised instruction. The Sig Sauer Academy™ provides all levels of firearms safety and skill training, from beginner to expert.

For more information contact:



www.sigsaueracademy.com • (603) 679-2003

Main campus: Epping, New Hampshire

Satellite Facilities: Range 82, Midland, VA
NRA Whittington Center, Raton, NM

**SAFETY MUST BE THE FIRST AND CONSTANT CONSIDERATION OF
EVERY PERSON WHO HANDLES FIREARMS AND AMMUNITION.**

For more information about safety, responsible firearms ownership, and shooting sports, contact: National Rifle Association (NRA) of America, 11250 Waples Mill Road, Fairfax, VA 22030-7400 • 1-800-672-3888 • www.nra.com

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ARE FOUND WITHIN THIS MANUAL**

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OTHER CAUTIONS AND WARNINGS APPEAR THROUGHOUT THE MANUAL

FIREARMS ARE DANGEROUS WEAPONS**READ THE INSTRUCTIONS AND WARNINGS IN THIS MANUAL
THOROUGHLY AND CAREFULLY BEFORE USING.**



WARNING - ALTERATIONS



This product was designed to function properly in its original condition. Alterations can make it unsafe. Do not alter any part or add or substitute any parts or accessories not manufactured by SIG SAUER Inc.

DO NOT ALTER ANY FIREARM

THE BASIC RULES OF SAFE FIREARMS HANDLING

1. ALWAYS treat every firearm as if it were loaded.
2. ALWAYS be sure the barrel is clear of any obstruction.
3. ALWAYS be sure of your backstop, what lies beyond, and the safety of bystanders before you shoot.
4. ALWAYS use clean, dry, original factory-made ammunition of the proper type and caliber for your firearm.
5. ALWAYS wear ear protection and safety glasses when shooting.
6. ALWAYS carry your firearm so that you can control the direction of the muzzle if you fall or stumble.
7. NEVER shoot at a flat surface or water.
8. DO NOT leave an unattended firearm loaded. Firearms and ammunition should be stored separately, locked if possible, beyond the reach of children, careless adults, and unauthorized users.
9. NEVER allow your firearm to be used by anyone who has not read and understood this operator's manual.
10. DO NOT point any firearm, loaded or unloaded, at any undesired target.
11. NEVER fire your rifle near an animal unless it is trained to accept the noise: an animal's startled reaction could injure it or cause an accident.
12. NEVER drink alcoholic beverages or take drugs before or during shooting, as your vision and judgment could be seriously impaired, making your firearm handling unsafe.

GENERAL SAFETY INFORMATION AND MECHANICAL CHARACTERISTICS

1.0 Safety Information

The safety warnings in this manual are important. By understanding the dangers inherent in the use of any firearm, and by taking the precautions described herein, you can enjoy complete safety in the use of your rifle. Failure to heed any of these warnings may result in serious injury to you or others, as well as severe damage to the firearm or other property. SIG SAUER Inc. shall not be responsible in any manner whatsoever for malfunctioning of the firearm, physical injury or property damage resulting in whole or in part from:

- 1) criminal or negligent discharge;
- 2) improper or careless handling;
- 3) unauthorized modifications;
- 4) defective, improper, hand-loaded, or reloaded ammunition;
- 5) corrosion;
- 6) neglect; or
- 7) other influences beyond our direct and immediate control.

This limitation applies regardless of whether liability is asserted on the basis of contract, negligence, or strict liability (including any failure to warn). Under no circumstance shall SIG SAUER Inc. be liable for incidental or consequential damages, such as loss of use of property, commercial loss, and loss of earnings or profits.

1.1 Protect Your Eyes And Ears

Always wear safety glasses and ear plugs or “ earmuff ” type protectors whenever you are shooting. Always make certain that persons close to you are similarly protected. Unprotected eyes may be injured by powder, gas, carbon residue, lubricant, metallic particles, or similar debris which may emanate occasionally from any firearm in normal use. Without ear protection, repeated exposure to shooting noise may lead to cumulative, permanent hearing loss.

1.2. Ammunition

1. Use only high quality, original, factory-manufactured ammunition. Do not use cartridges that are dirty, wet, corroded, bent, or damaged. Do not use oil cartridges. Do not spray aerosol-type lubricants, preservative, or cleaners directly onto cartridges or where excess spray may flow into contact with cartridges. Lubricant or other foreign matter on cartridges can cause potentially dangerous ammunition malfunctions. Use only ammunition of the caliber for which your firearm is chambered. The proper caliber is permanently engraved on your firearm; never attempt to use ammunition of any other caliber.
2. The use of reloaded, “remanufactured” hand-loaded, or other non-standard ammunition voids all warranties. Reloading is a science and improperly loaded ammunition can be extremely dangerous. Severe damage to the firearm and serious injury to the shooter or to others may result. Always use ammunition that complies with the industry performance standards established by the Sporting Arms and Ammunition Manufacturers’ Institute, Inc. of the United States (SAAMI) or ammunition manufactured to military specifications.



WARNING – AMMUNITION (CARTRIDGE) NOTICE

SIG SAUER Inc. SPECIFICALLY DISCLAIMS RESPONSIBILITY FOR ANY DAMAGE OR INJURY WHATSOEVER OCCURRING IN CONNECTION WITH, OR AS A RESULT OF, THE USE IN ANY SIG SAUER FIREARM OF FAULTY, NON-STANDARD, “REMANUFACTURED” HAND LOADED (RELOADED) AMMUNITION, OR CARTRIDGES OTHER THAN THOSE FOR WHICH THE FIREARM WAS ORIGINALLY CHAMBERED.

3. Firearms may be severely damaged and serious injury to the shooter or to others may result from any condition causing excessive pressure inside the chamber or barrel during firing. Excessive pressure can be caused by obstructions in the barrel, propellant powder overloads, the use of incorrect cartridges or defectively assembled cartridges. In addition, the use of a dirty, corroded, or damaged cartridge can lead to a burst cartridge case and consequent damage to the firearm and personal injury from the sudden escape of high-pressure propellant gas within the firearm’s mechanism.
4. Immediately stop shooting and check the barrel for a possible obstruction whenever:
- You have difficulty in, or feel unusual resistance in, chambering a cartridge;
 - A cartridge misfires (does not go off);
 - The mechanism fails to extract a fired cartridge case;
 - Unburned grains of propellant powder are discovered spilled in the mechanism;
 - A shot sounds weak or abnormal. In such cases it is possible that a bullet is lodged part way down the barrel.
 - Firing a subsequent bullet into the obstructed barrel can wreck the firearm and cause serious injury to the shooter or to bystanders.

5. Bullets can become lodged in the barrel:

- If the cartridge has been improperly loaded without propellant powder, or if the powder fails to ignite (ignition of the cartridge primer alone will push the bullet out of the cartridge case, but usually does not generate sufficient energy to expel the bullet completely from the barrel);
- If the bullet is not properly seated in the cartridge case. When such a cartridge is extracted from the chamber without being fired, the bullet may be left behind in the bore at the point where the rifling begins. Subsequent chambering of another cartridge may push the first bullet further into the bore.

6. If there is any reason to suspect that a bullet is obstructing the barrel, immediately unload the firearm and look through the bore. It is not sufficient to merely look in the chamber. A bullet may be lodged some distance down the barrel where it cannot easily be seen.

IF A BULLET IS IN THE BORE, DO NOT ATTEMPT TO SHOOT IT OUT BY USING ANOTHER CARTRIDGE OR BY BLOWING IT OUT WITH A BLANK OR ONE FROM WHICH THE BULLET HAS BEEN REMOVED. SUCH TECHNIQUES CAN GENERATE EXCESSIVE PRESSURE, WRECK THE FIREARM, AND CAUSE SERIOUS PERSONAL INJURY.

If the bullet can be removed with a cleaning rod, clean any unburned powder grains from the bore, chamber, and mechanism before resuming shooting. If the bullet cannot be dislodged by tapping it with a cleaning rod, take the firearm to a gunsmith.

7. Dirt, corrosion, or other foreign matter on a cartridge can impede complete chambering and may cause the cartridge case to burst upon firing. The same is true of cartridges which are damaged or deformed.

8. Do not oil cartridges, and be sure to wipe the chamber clean of any oil or preservative before commencing to shoot. Oil interferes with the friction between cartridge case and chamber wall that is necessary for safe functioning, and subjects the firearm to stress similar to that imposed by excessive pressure.

9. Use lubricants sparingly on the moving parts of your firearm. Avoid excessive spraying of any aerosol gun care product, especially where it may get on ammunition. All lubricants and aerosol spray lubricants in particular can penetrate cartridge primers and cause misfires. Some highly penetrative lubricants can also migrate inside cartridge cases and cause deterioration of the propellant powder; on firing, the powder may not ignite. If only the primer ignites, there is danger that the bullet may become lodged in the barrel.

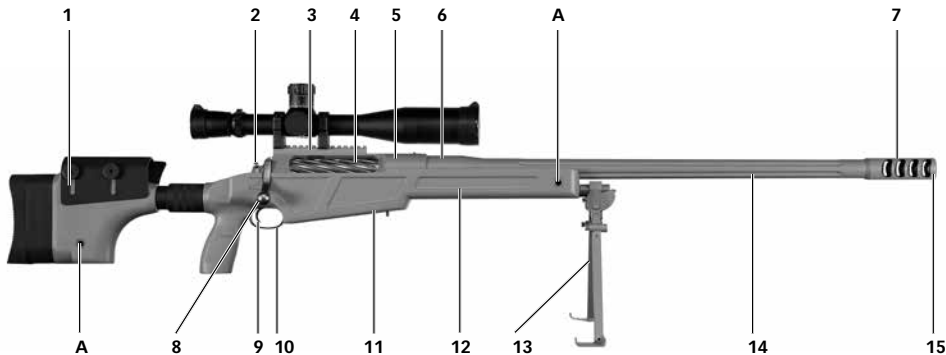
**WARNING - AMMUNITION**

Death, serious injury, and damage can result from the use of wrong ammunition, bore obstructions, powder overloads, or incorrect cartridge components. Always wear shooting glasses and hearing protectors.

IMPROPER AMMUNITION DESTROYS FIREARM**WARNING - LEAD EXPOSURE**

Discharging firearms in poorly ventilated areas, cleaning firearms, or handling ammunition may result in exposure to lead and other substances known to the state of California to cause birth defects, reproductive harm, and other serious physical injury. Maintain adequate ventilation at all times. Wash hands thoroughly after exposure.

SHOOTING OR CLEANING GUNS MAY EXPOSE YOU TO LEAD



- | | | |
|--------------------|----------------------------|------------------------------|
| 1 Cheek Rest | 7 Muzzle Brake | 13 Bipod |
| 2 Safety Mechanism | 8 Bolt Handle | 14 Barrel |
| 3 Bolt Assembly | 9 Trigger | 15 Muzzle |
| 4 Ejector Port | 10 Trigger Guard | A QD Sling Attachment Points |
| 5 Receiver | 11 Detachable Box Magazine | |
| 6 Chamber | 12 Stock | |

2.0. Mechanical Characteristics and Rifle Theory

2.1 Rifle Description

2.1.1 General

The SIG50 rifle is a heavy barrel, rotary bolt action, push feed, large caliber precision rifle with detachable box magazine system with five shot capacity. The rifle is chambered in .50 BMG and is capable of shooting sub-MOA in the hands of qualified marksmen with applicable match ammunition.

2.1.2 Bolt and Locking Mechanism

The bolt is constructed from 9310 steel. It is equipped with a claw type extractor. The body of the bolt is fluted for operation in adverse environmental conditions. The bolt is finished in Robar Companies NP3 process. A locking mechanism is located on the left rear side of the receiver which allows the bolt to be removed when depressed. The bolt handle has added length to clear optics. It is in right handed configuration.

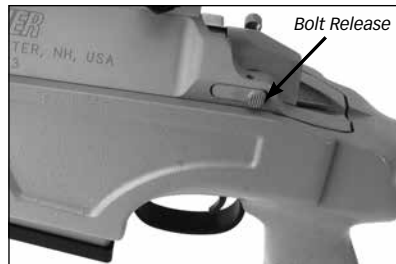


FIGURE 1: BOLT AND LOCKING MECHANISM

2.1.3. Safety Mechanism

The safety lever which is located on the right side of the receiver locks the trigger from being pressed to the rear when it is engaged. When pressed forward, the trigger is unlocked. The safety lever provides protection against accidental or unintentional discharge under normal usage when properly engaged.

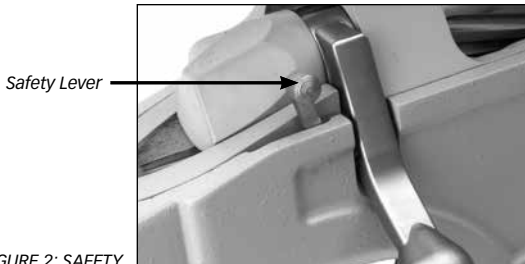


FIGURE 2: SAFETY

Always move the safety lever to the rear (SAFE) position before handling, loading, or unloading the rifle. When you are ready to fire the rifle, move the safety lever to the forward (FIRE) position. Avoid touching the trigger when moving the safety lever.

KNOW HOW TO USE THE SAFETY

2.1.4 Trigger Mechanism

The trigger mechanism is a mechanical type adjustable single stage trigger. The adjustment range is from 3.5 to 4.5 lbs. It is pre-set at 3.5 lbs from the factory.



FIGURE 3: TRIGGER

2.1.5 Barrel

The SIG50 barrel is a match grade, heavy fluted, free floating barrel.

Barrel Inspection Procedure:

- The inside of the barrel must be clean and free of obstructions.
- Point the rifle in a safe direction.
- Move the safety lever to the rear (SAFE) position.
- Raise the bolt handle.
- Pull the bolt all the way to the rear.
- Remove any ammunition from the chamber and/or magazine.
- Remove the bolt.
- Look through the barrel from the chamber end to the muzzle.

To Remove an Obstruction from Inside the Barrel:

- Use the correct size cleaning rod.
- Push the cleaning rod from the chamber end all the way through the barrel until the rod comes out of the muzzle.
- Verify the muzzle brake is free of patches and other debris.
- If an object cannot be easily pushed out of the barrel with a cleaning rod, return the rifle to SIG SAUER®.

WARNING: NEVER TRY TO REMOVE AN OBJECT FROM THE BARREL BY LOADING ANOTHER CARTRIDGE AND FIRING.

2.1.6 Receiver

The receiver is CNC machined from bar stock.

2.1.7 Stock

The buttstock is removable from the SIG50 rifle by unscrewing the knurled collar clockwise (left hand thread). To re-install the buttstock, insert the buttstock back into the stock until it indexes into place. You should not be able to rotate it prior to tightening the collar. Turn the knurled collar counter-clockwise to tighten the buttstock to the stock. Hand tight is sufficient.

2.1.8. Scope Mount

A Mil-Std M1913 rail on the upper receiver allows for mounting of any iron sights, scopes, or electronic optics with an M1913 mounting base. An optional rail system continues forward of the upper receiver for mounting of laser aiming devices and night vision scopes. There are rails positioned at 3 and 9 o'clock for attachment of laser aiming or range finding devices.



FIGURE 4: STOCK



FIGURE 5: SCOPE MOUNT

2.1.9 Magazine

The SIG50 ships with one five (5) round high reliability metal magazine. It is compatible with most .50 caliber NATO ammunition. The receiver has a machined in feature that allows the operator to hand load a single round into the action with the box magazine in place.



FIGURE 6: MAGAZINE

2.1.10 Bipod

The SIG 50 has an adjustable four-position bipod which folds for transport.

To attach bipod to rifle, loosen the 3/8" bipod clamp bolt so the bipod clamp will slip over the bipod spigot, then tighten the bipod clamp bolt. The bipod should not come off the spigot and should tilt from side to side.



FIGURE 7: BIPOD

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2.2 Technical Specifications

CALIBER	.50 BMG
O.A.L. W/ BUTT STOCK ATTACHED	57.0"
O.A.L. W/ BUTT STOCK REMOVED	46.125"
BUTT STOCK LENGTH	11.625"
WEIGHT	23.5 lbs
FEEDING DEVICE/CAPACITY	Detachable Magazine, 5 rounds
BARREL	
BARREL LENGTH	29.0"
BARREL WEIGHT	9.5 lbs
NUMBER OF GROOVES	7
BARREL TYPE	Fluted Match Grade
RATE OF TWIST	1:15"
DIRECTION OF TWIST	Right Hand
VELOCITY (750 GR AMAX)	2700 fps
HEADSPACE (MAXIMUM)	3.1392 inch.

All specifications are approximate. Specifications subject to change without notice.

HEADSPACE (MINIMUM)	3.1332 inch.
FIRING PIN PROTRUSION (MAXIMUM)	0.080 inch.
FIRING PIN PROTRUSION (MINIMUM)	0.075 inch.
MUZZLE THREAD PITCH	1x14 TPI
TRIGGER	
TYPE	Single Stage
ADJUSTABLE	Yes
RANGE OF ADJUSTMENT	3.5 to 4.5 lbs
FACTORY SETTING	3.5 lbs
STOCK	
CONSTRUCTION	Fiberglass
CHEEK PIECE	Adjustable
BUTT STOCK (MINIMUM LENGTH)	13.5"
BUTT STOCK (MAXIMUM LENGTH)	15.0"
BUTT STOCK SPACERS	2 @ 0.5" Thick/2 @ 0.25" Thick

3.0 Handling

3.1 Important Instructions

- Before manipulating the weapon, ensure the safety lever is in the SAFE position.
- Use only factory-new ammunition which corresponds to the caliber of the weapon.
- During all manipulations of the rifle, point the weapon in a safe direction.
- Do not place your finger on the trigger until the target has been verified and you intend to shoot.
- Do not load the weapon until immediately before use.
- Unload weapon immediately after shooting is finished.
- Remove the bolt and magazine from the weapon prior to transportation.



WARNING - HANDLING:

Never carry the rifle loaded with the safety lever in the FIRE position. If dropped or struck with the safety off, the rifle may fire. Such a discharge can occur with or without the trigger being directly struck or touched. Never rest a loaded rifle against any object (wall, tree, fence, vehicle, etc.) because there is always the possibility that the rifle will be jarred or slide from its position and fall with sufficient force to discharge. Keep the safety lever on SAFE unless actually firing.

ANY FIREARM MAY FIRE IF DROPPED

3.2.1 Loading the magazine.

- Point the rifle in a safe direction.
- Move the safety lever to the rear (SAFE) position.
- Raise the bolt handle.
- Pull the bolt all the way to the rear.
- Insert the required number of cartridges into the magazine.
- Insert one cartridge into the chamber.
- Using your finger, depress the cartridges in the magazine, and slowly slide the bolt forward so the bolt rides over the top cartridge in the magazine.
- Finish closing the bolt on the cartridge inserted into the chamber.

THE RIFLE IS NOW LOADED

3.2.2 Loading single cartridge only

- Point the rifle in a safe direction.
- Move the safety lever to the rear (SAFE) position.
- Raise the bolt handle.
- Pull the bolt all the way to the rear.
- Insert one cartridge through the loading/ejection port and into the magazine.
- Push the bolt forward and chamber the cartridge. Lock the bolt closed.
- If you choose to insert the round directly into the chamber, the magazine follower must be depressed to allow the bolt to move forward. Once depressed the bolt may be closed over the chambered round.

WARNING: Always check the cartridge for the correct headstamp which matches the rifle caliber.
NEVER force the bolt closed on a cartridge.

If extra effort is ever needed to close the bolt, stop. Open the bolt, remove and discard the round. Failure to do so may result in damage to the firearm and injury or death to the shooter.

THE RIFLE IS NOW LOADED

3.3 Loading the Rifle

1. Ensure the safety lever is in the SAFE position;
2. Insert the loaded magazine by inserting it into the mag well with the rear of the magazine slightly higher than the front. The rear lug catches first, then raise the front of the magazine until it is caught by the mag catch.
3. Ensure the bolt is closed with a cartridge inserted into the chamber.

4.0 Cycle of Operation

Ready to Fire Condition

The SIG50 “Ready to Fire” condition is described as a loaded magazine properly seated into the magazine well, a live cartridge loaded into the chamber, the fire control selector placed on “SAFE”.

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

THE RIFLE IS READY TO FIRE

4.1. Firing

Rotate the safety lever from the “SAFE” position to the “FIRE” position.

Pressing the trigger rearward releases the striker, causing it to strike the firing pin, impacting the cartridge primer.

4.2 Over Pressure Firing

The SIG 50 has a mechanism in place to vent extreme gases in cases of head separation or pierced primers. Overpressure gases are diverted through three (3) vent holes in the side of the bolt and not directly rearward through the firing pin hole which could result internal stress to the bolt assembly, failure of the bolt and possible injury to the shooter.



FIGURE 8: MAGAZINE BEING INSERTED

5.0. Unloading

ALWAYS MAKE SURE THE MUZZLE IS POINTED IN A SAFE DIRECTION!

1. Point the rifle in a safe direction.
2. Move the safety lever to the rear (SAFE) position.
3. Depress the magazine release latch and remove the magazine from the rifle.
4. Raise the bolt handle.
5. Put one hand over the top of the ejection port.
6. Slowly pull the bolt to the rear with your other hand to remove the cartridge from the chamber.
7. Take hold of the cartridge and remove it from the rifle.
8. Visually and physically inspect the chamber to verify it is empty.

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 and repeat steps 1 through 8.

**WARNING:**

Removing cartridges from the magazine does not prevent the rifle from being fired! When there is a cartridge in the chamber and the safety lever is in the FIRE position, the cartridge will discharge if the trigger is pulled. It is absolutely essential for the user to know how to completely unload the rifle. "Completely" means emptying the magazine and removing a chambered cartridge. The safety lever should always be in the SAFE position when the rifle is being unloaded.

THE RIFLE WILL FIRE EVEN IF THE MAGAZINE IS EMPTY OR REMOVED

Remember to clear the chamber after the magazine is removed.

Never assume that any firearm is unloaded until it has been visually and physically inspected. After every range session make sure the firearm is unloaded before leaving the range.

6.0. Procedures In Case of a Stoppage

A “Stoppage” is an interruption in the cycle of operation as depicted in Section 4.0. A stoppage can normally be repaired by the operator by performing one of the following immediate actions described.

6.1. Failure to Fire (Cold Rifle) Trigger is pressed, firing pin releases, rifle does not fire.

1. Ensure the magazine is properly seated in the magazine well by applying upward pressure and then pulling down on the magazine.
2. Retract the bolt all the way back and observe the ejection of the expended case or a live cartridge; and
3. Visually inspect the chamber for any obstructions, if the chamber shows to be clear, slide bolt forward to feed a new cartridge.
4. Attempt to fire the rifle again.

6.2. Failure to Fire (Hot Rifle) Trigger is pressed, striker releases, the rifle does not fire.

1. Keep the muzzle pointed down range, place the rifle on SAFE, remove the magazine, if you cannot extract the loaded cartridge within ten (10) seconds you must wait a minimum of 15 minutes before handling the rifle.
2. Upon completion of the 15 minutes, retract the bolt all the way back and observe the ejection of the cartridge; and
3. Visually inspect the chamber for any obstructions, if the chamber shows to be clear, slide bolt forward to feed a new cartridge.
4. Attempt to fire the rifle again.

6.3 Recovery from Failure to Fire

If the rifle does not fire after completing 6.1 or 6.2:

1. Unload, and clear the rifle;
2. Insert a fresh magazine;
3. Slide bolt forward to chamber a round; and
4. Attempt to fire the rifle.

IF THE RIFLE FAILS TO FIRE AFTER ATTEMPTING ALL OF THE ABOVE, THE RIFLE SHOULD BE RETURNED TO SIG SAUER, INC. FOR EVALUATION BY A FACTORY TRAINED TECHNICIAN.

7.0. Field Strip Disassembly

1. Unload and clear the rifle per section 5.0.
2. Point the rifle in a safe direction.
3. Move the safety lever to the rear (SAFE) position.
4. Avoid touching the trigger while moving the safety lever.
5. Raise the bolt handle.
6. Pull the bolt all the way to the rear.
7. Depress the bolt stop release.
8. As bolt stop release is depressed, slide the bolt from the rifle. The butt stock must be removed to remove the bolt.

8.0. Cleaning

Clean the rifle after 30 to 40 rounds in order to maintain “benchrest accuracy.”

8.1 Removing and Installing the Muzzle Brake

1. The rifle can be cleaned with the muzzle brake on or off.
2. To remove the muzzle brake, use a 12-inch or 300mm adjustable wrench with two layers of masking tape on the jaws. Clamp barrel in padded vise just behind the brake. You may have to use a wood mallet and/or nylon hammer, and give a sharp rap on the end of the wrench to break it loose. The brake is installed with standard right-hand threads.
3. To reinstall the muzzle brake, put 2 or 3 drops of gun oil on the barrel threads. For the last 1/4 turn, use the adjustable wrench and give it a fast turn to properly tighten the muzzle brake. For “Pinch Clamp” muzzle brakes, screw brake on to barrel until it stops. Back brake off until level and tighten cross-bolt to 80-85 inch-pounds. (Check the muzzle brake for looseness every 50 rounds, then tighten as necessary.)

8.2 Cleaning Procedure

1. Ensure the rifle is unloaded.
2. Remove the magazine, buttstock, and bolt from the rifle.
3. Ensure the muzzle is lower than the action.
4. Roll one patch all the way around the brass jag. The cotton patch should be 4”x6” for maximum effect. Wet the patch with solvent. Roll the cleaning rod with the wet patch in the chamber and neck area.
5. Unroll approximately 2” of the wet patch, leaving the other 2/3rds on the jag. Push the remaining wet patch through the bore and remove it at the muzzle.

6. Install the bore guide in the receiver. Replace the brass jag with the phosphor bronze brush, wet it with solvent and run it through the barrel and out the muzzle. Once the brush is forward of the muzzle, pull the brush back through the bore and out of the chamber. Do this a total of ten (10) times. After the tenth time, reapply the bore solvent and run the brush back through another ten (10) times.(Up and back is one time.)

NOTE: NEVER reverse the brush while inside the bore.

7. Replace the bronze brush with the brass jag and roll a 4"x4" patch on to the jag. Dry patch the bore until the patches come out clean and dry.

8. Roll a 4"x4" patch onto the jag. Wet the patch with copper fouling remover and push it through the bore and out the muzzle. Remove the old patch. Repeat once more and clean up with 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.

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

NOTE: Do not ever use any type of copper fouling remover on bronze brushes. It will attack them the same as fouling in the bore. Copper remover may be used with a nylon brush for heavily fouled barrels.

9. Wrap a 4" square patch around the jag. Wet the patch with bore solvent (not copper remover) and run it through the bore, followed by one or two dry patches. Copper fouling removers will leave the bore dry and totally stripped of any oil. Many standard bore cleaners/solvents have some traces of oil that will stay in the bore.

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

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

11. To remove moly fouling, wrap the brass jag with a dry patch. Install bore guide into receiver. Apply a bore paste to the patch and work the patch down the bore in the same manner as the copper remover. Repeat as necessary but do not over do. Once all moly fouling is removed, dry patch bore until patches come out clean. Excessive or improper use of abrasives can shorten service life and/or cause loss of accuracy.

12. Repeat steps 4 through 7 twice to remove any residue paste from the chamber and barrel.

NOTE: To perform step 11 the muzzle brake must be removed. 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 14.

8.3 Cleaning the Magazine

Magazines should be cleaned whenever the rifle is cleaned as preventive maintenance.

1. Use a brush to clean inside the body.
2. Clean with a rag and CLP then wipe dry.
3. Clean follower and dry completely.

The magazine body should be kept dry. Any oil or solvent left behind will attract dirt and debris causing undue wear and possibly feeding issues.

8.4 Cleaning the Receiver and Trigger Assembly

1. Move the safety lever to the rear (SAFE) position.
2. Remove the bolt assembly.
3. Turn the rifle upside down.
4. Remove the two action screws.
5. 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 surfaces any longer than necessary.

6. 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.

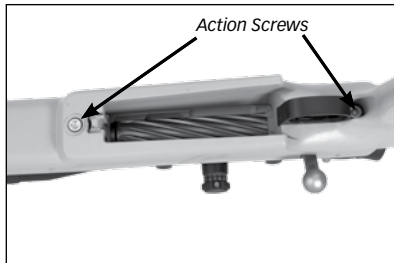
7. Before replacing the bolt, make sure the barrel is free from obstructions. Grease bolt as per Section 8.5 Step 2.

8. 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 SIG SAUER.

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



8.5 Cleaning the Bolt Assembly

1. Remove the bolt assembly from the rifle.
2. Use a good quality solvent and a rag to wipe down the bolt body. Ensure that all fouling and residue are removed.
3. With a good quality bristle brush and solvent scrub the bolt face and remove all fouling and loose brass from the bolt face.
4. Lift the extractor upward and clean under the extractor notch with the brush and solvent.
5. Dry thoroughly and lubricate bolt body with a small amount of gun oil.
6. Activate the ejector and the extractor and ensure they move freely without sticking.
7. If the ejector or the extractor sticks, return the rifle to SIG SAUER®.
8. 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:

- ONLY USE CLEANING AND LUBRICATION PRODUCTS THAT ARE SPECIFICALLY DESIGNED FOR USE ON FIREARMS.
- READ ALL WARNING LABELS AND OBTAIN MSDS ON ANY CLEANING, LUBRICATION, AND PROTECTIVE CHEMICALS USED.
- CLEANER, LUBRICANT, PROTECTANT IS COMMONLY REFERRED TO AS "CLP"
- SOME BORE CLEANERS ARE NOT MEANT TO BE LEFT IN THE BORE FOR EXTENDED PERIOD OF TIME.
- FOLLOW ALL MANUFACTURER'S INSTRUCTIONS AND CAUTIONS WHEN USING CLEANING OR LUBRICATION PRODUCTS ON FIREARMS.
- SOLVENT IS A GENERIC TERM AND WILL BE USED TO DESCRIBE A GENERAL BORE CLEANING SOLUTION.

8.6 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.
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 both locking tabs 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 tabs with the notches in the bolt body. When aligning the tabs, 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 clockwise.
7. You will feel the firing pin assembly lock in place.
8. Grease the locking lugs and cocking cam of the bolt. Install bolt in receiver making certain the bolt stop/guide has "clicked" into its track in the bolt body.



9.0 Full Reassembly

Your SIG SAUER SIG50 Precision Rifle can be broken down into two major components: the stock assembly and the action/barrel assembly.

1. Inspect 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 5/16 x 24 hex head screws supplied to fasten the action/barrel to the stock assembly.

NOTE: The screws are marked on the end with a letter ("F" for front, "R" for rear).

6. With the action/barrel assembly in place, use a torque wrench to tighten the screws to 80-85 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.

NOTE: Action screws must be re-torqued every 30 rounds.

7. Insert the complete bolt assembly into the rear of the action. Ensure that the bolt stop clicks into the guide track in the bolt body.
8. Once the bolt is past the bolt release, you will have to depress the magazine follower to allow the bolt to go into battery.

9.1 Field Strip Reassembly / Function Check

1. Point the rifle in a safe direction.
2. Move the safety lever to the rear (SAFE) position.
3. Align the lugs on the bolt at 12 and 6 o'clock.
NOTE: The magazine follower must be depressed to allow the bolt to enter the receiver.
4. Slide the bolt assembly into the receiver approximately halfway and rotate it until the bolt stop/guide clicks into its track.
5. To lock the bolt assembly into position, push the bolt handle down.
6. Engage safety by moving safety lever to the rear.
7. Press the trigger. Firing pin should not fall.
8. Disengage safety lever by pressing it forward.
9. Press trigger.
10. Firing pin should release.

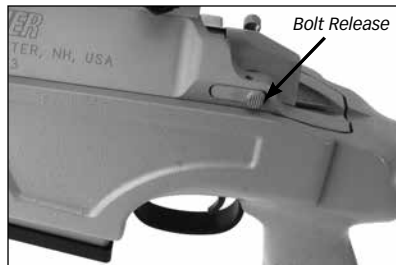


FIGURE 10: BOLT STOP RELEASE

ALWAYS PERFORM A FUNCTION CHECK OF THE RIFLE ANYTIME YOU FIELD STRIP IT FOR CLEANING OR MAINTENANCE. FOLLOW THE STEPS ABOVE. SHOULD THE RIFLE NOT PASS THESE SIMPLE STEPS DO NOT ATTEMPT TO FIRE THE RIFLE, AND CONTACT SIG SAUER® OR AN AUTHORIZED SERVICE TECHNICIAN.

10.0 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 located at the rear-underside. Keep grease 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.

11.0 Transportation and Storage

When transporting your firearm to and from shooting activities, keep it unloaded for your safety and for the safety of others. When storing your firearm, keep it separated from ammunition, under lock and key if possible, and out of the reach of children and other inexperienced or unauthorized persons.



WARNING - STORAGE:

Never place or store any firearm in such a manner that it may be dislodged. Firearms should always be stored securely and unloaded, away from children and other unauthorized users. Use the locking device originally supplied with this firearm for storage. The use of a locking device or safety lock is only one aspect of responsible firearms storage. For increased safety, firearms should be stored unloaded and locked in a location that is both separate from their ammunition and inaccessible to children and any other unauthorized person.

STORE SECURELY & UNLOADED

12.0. Service and Replacement Parts Policy

Parts Policy

Our Service Department maintains a full complement of replacement parts. Even though most gunsmiths have the knowledge, training, and the ability to make necessary repairs to your firearm, the skill and workmanship of any particular gunsmith is totally beyond our control.

Should your firearm ever require service, we strongly recommend that you return it to SIG SAUER Inc. A firearm is a precision instrument and some replacement parts will require individual fitting to ensure correct operation. A wrong part, improper fitting, or incorrect mechanical adjustment may result in an unsafe condition or dangerous malfunction, damage to the firearm, or cause possible serious injury to the shooter or others.

IF ANY PART IS ORDERED WITHOUT RETURNING THE FIREARM TO SIG SAUER Inc., the customer bears full responsibility for ensuring that the part supplied is correct for their particular firearm and is properly installed and fitted by a qualified gunsmith.

SIG SAUER Inc. CANNOT BE RESPONSIBLE FOR THE FUNCTIONING OF ANY FIREARM IN WHICH REPLACEMENT PARTS ARE INSTALLED BY OTHERS.

Service Policy

If you have questions concerning the performance or servicing of your rifle, please write or call:

SIG SAUER Inc.

Attention: Customer Service

72 Pease Boulevard, Newington, NH 03801

Phone: (603) 610-3000 ext. 3

Fax: (603) 766-7002

IF YOU DO NOT UNDERSTAND THE INSTRUCTIONS FOR OPERATING YOUR RIFLE, IT IS YOUR RESPONSIBILITY TO CALL OUR CUSTOMER SERVICE DEPARTMENT AT (603) 610-3000 EXT. 3 BEFORE USING YOUR RIFLE.

13.0 Shipping Firearms for Repair

Returning Your Firearm For Service In the event you need to return your rifle to the SIG SAUER Service Department, here's what to do:

1. The first step is to contact Customer Service at (603) 610-3000 ext. 3 for an RMA number. This number allows SIG SAUER to track the status of your return from its receipt at SIG SAUER through its return to you. Please do not send your firearm until you obtain an RMA number.
2. Make sure that the chamber and magazine(s) are unloaded and that no ammunition is included with your returned firearm.

3. Package the firearm securely to prevent damage. Enclose a letter which includes your name, street address, daytime phone number, model and serial number, and a detailed description of the problem you have experienced or the work you want performed. With the exception of extra magazines, do not include scopes, mounts, or other accessories.
4. Generally, an individual may ship firearms to the manufacturer for repair or service. Some states and localities, however, prohibit this. If you live in such an area, the firearms must be shipped by and returned to a Federally Licensed Firearms Dealer.
5. Federal law prohibits persons who do not possess a Federal Firearms License from shipping a firearm via the U.S. Postal Service. (Note: any shipment of firearms outside U.S. borders is subject to the export laws of the United States and to the valid laws of the specific country, which you must strictly follow; prior to exporting any firearm you should seek legal counsel.)
6. SIG SAUER is not responsible for any firearm until it is received, nor for damage incurred during shipment.
7. Ship your firearms insured and prepaid (we do not accept collect shipments) to:

SIG SAUER Inc.
Attention: Service Department
18 Industrial Drive Exeter, NH 03833

This instruction manual should always accompany this rifle and be transferred with it upon change of ownership.

WARNING: BEFORE SHIPPING ANY FIREARM, BE ABSOLUTELY CERTAIN THAT THE FIREARM AND ITS MAGAZINE ARE UNLOADED. DO NOT SHIP AMMUNITION WITH A FIREARM.

ORDERING PARTS

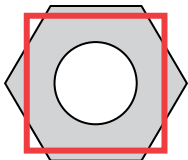
In the event you want to order parts for your SIG50, contact Customer Service at (603) 610-3000 ext. 3.

Have available the serial number of your rifle and the part diagram number for the part(s) you wish to order. A parts list and diagram of the rifle is provided in sections 14.0 and 14.1.

Please refer to the Service & Parts Policy on pages 49 and 50.



WARNING - PARTS PURCHASE:



It is the purchaser's responsibility to be absolutely certain that any parts ordered from the factory are correctly fitted and installed. Firearms are complicated mechanisms and **IMPROPER FITTING OF PARTS MAY RESULT IN A DANGEROUS MALFUNCTION, DAMAGE TO THE FIREARM, AND SERIOUS INJURY TO THE SHOOTER AND OTHER PERSONS.** The purchaser and installer of parts must accept full responsibility for the correct adjustment and functioning of the rifle after such installation.

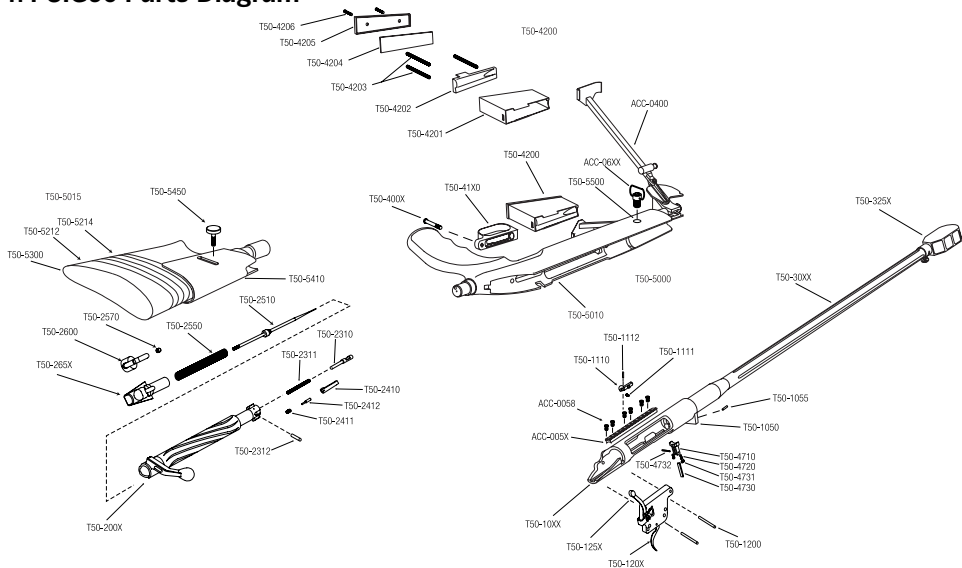
PARTS MUST FIT CORRECTLY

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14.0 SIG50 Parts List

T50-10XX Receiver - Stripped (Specify)	T50-4730 Magazine Latch Lever	T50-125X Trigger Safety Lever (Specify)
T50-200X Bolt - Stripped	T50-4731 Magazine Latch Lever Spring	T50-120X Trigger (Specify)
T50-2410 Extractor	T50-4732 Magazine Latch Lever Pivot Pin	T50-1200 Trigger Pin (x2)
T50-2411 Extractor Spring	T50-2510 Firing Pin	T50-325X Muzzle Brake
T50-2412 Extractor Actuating Pin	T50-2550 Firing Pin Spring	T50-30XX Barrel (Specify)
T50-2310 Ejector	T50-2570 Firing Pin Lock Screw (x2)	ACC-0400 McMillan M2 Bipod
T50-2311 Ejector Spring	T50-2600 Cocking Piece	T50-5000 TAC-50 Stock Complete
T50-2312 Ejector Retaining Pin	T50-265X Cocking Piece Housing (Specify)	T50-5010 TAC-50 Stock, Forend Assembly
T50-4200 Magazine Assembly	T50-1110 Bolt Stop	T50-5015 TAC-50 Stock, Butt Assembly
T50-4201 Magazine Box	T50-1111 Bolt Stop Spring	T50-5200 Spacer System Assembly
T50-4202 Magazine Follower	T50-1112 Bolt Stop Pivot Pin	T50-5212 Spacer 1/2"
T50-4203 Magazine Follower Spring (x3)	ACC-005X McMillan Steel Scope Base - Specify 0, 30, 45, or 60 MOA	T50-5214 Spacer 1/4"
T50-4204 Spring Retainer Plate	ACC-0058 Scope Base Screws (Set of 6)	T50-5300 Recoil Pad
T50-4205 Magazine Box Bottom Cover, Aluminum	T50-1050 Recoil Lug	T50-5410 Saddle Cheekpiece
T50-4206 Box Bottom Cover Screw (x2)	T50-1055 Recoil Lug Pin	T50-5450 Saddle Lock Screw
T50-4710 Magazine Latch Housing	T50-41X0 Trigger Guard (Specify)	T50-5500 Flush Mount Swivel Cup
T50-4720 Magazine Latch Housing Screw (x2)	T50-400X Action Screw (Fitted-Specify)	ACC-06XX Flush Cup Swivel

14.1 SIG50 Parts Diagram



Troubleshooting Guide

Malfunction	Cause	Correction
Feed		
No round fed into the chamber	Magazine not properly inserted or magazine is deformed or dirty	Insert magazine properly or change magazine
	Defective magazine	Replace magazine
Bolt does not close easily or completely	Rifle or cartridge is fouled (dirty) or rifle is too heavily lubricated	Clean and lubricate rifle and/or replace the ammunition
	Incorrect ammunition	Replace ammunition
Extraction/Ejection		
Cartridge fails to extract from chamber	Insufficient extractor tension due to fouling	Clean bolt and extractor
	Dirty chamber	Clean chamber and bore
	Broken/Damaged ejector	Return to SIG SAUER
Cartridge fails to eject from action	Ejector sticking	Clean and lube ejector

Malfunction	Cause	Correction
Ignition		
Firing pin strikes cartridge but round does not fire	Firing pin obstructed	Inspect, clean and lubricate the rifle
	Faulty ammunition	Manually cycle in next round
	Firing pin damaged or broken	Return to SIG SAUER

SIG SAUER® Limited Lifetime Firearms Warranty

SIG SAUER warrants that the enclosed firearm was originally manufactured free of defects in material, workmanship and mechanical function. For the lifetime of the original purchaser, SIG SAUER agrees to correct any defect in the firearm for the original purchaser by repair, adjustment or replacement, at SIG SAUER's option, with the same or comparable quality components (or by replacing the firearms at SIG SAUER's option); provided, however, that the firearm is returned unloaded and freight prepaid to SIG SAUER at 18 Industrial Drive, Exeter, NH 03833.

This limited warranty is null and void if the firearm has been misused, damaged (by accident or otherwise), fired with handloaded, reloaded or improper ammunition, fired with an obstruction in the barrel, damaged through failure to provide reasonable and necessary maintenance as described in the manual accompanying the firearm, or if unauthorized repair or any alteration, including of a cosmetic nature, has been performed on the firearm. This limited warranty does not apply to normal wear and tear of any parts.

Subject to the foregoing, this limited warranty confers the right to have the covered firearm or its parts repaired, adjusted or replaced exclusively upon the original purchaser, which right is not transferable to any other person. No implied warranties of any kind are made herein and this warranty does not apply to any accessory items attached or appurtenant to the firearm. In no event shall SIG SAUER be liable for any incidental or consequential damages arising from or in connection with this limited warranty.

SIGSAUER[®]
when it counts[®]

www.sigsauer.com

**FOR PRODUCT SERVICE ON THIS MODEL,
PLEASE CALL (603) 610-3000 EXT. 3**

72 Pease Boulevard, Newington, NH 03801 USA