

SIGSAUER[®]
when it counts[®]



TACTICAL 2

OWNER'S 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: WARNING

"Children are attracted to and can operate firearms that can cause severe injuries or death. Prevent child access by always keeping guns 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 guns 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® pistol 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) 610-3400

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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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 GUN

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.

THE BASIC RULES OF SAFE FIREARMS HANDLING

1. ALWAYS treat every gun as if it were loaded.
2. ALWAYS be sure the barrel is clear of any obstruction.
3. ALWAYS be sure of your backstop, what lies beyond, and the safety of bystanders before you shoot.
4. ALWAYS use clean, dry, original factory-made ammunition of the proper type and caliber for your gun.
5. ALWAYS wear ear protection and safety glasses when shooting.
6. ALWAYS carry your gun 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 gun loaded. Guns 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 gun, 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 gun handling unsafe.

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 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 GUNS



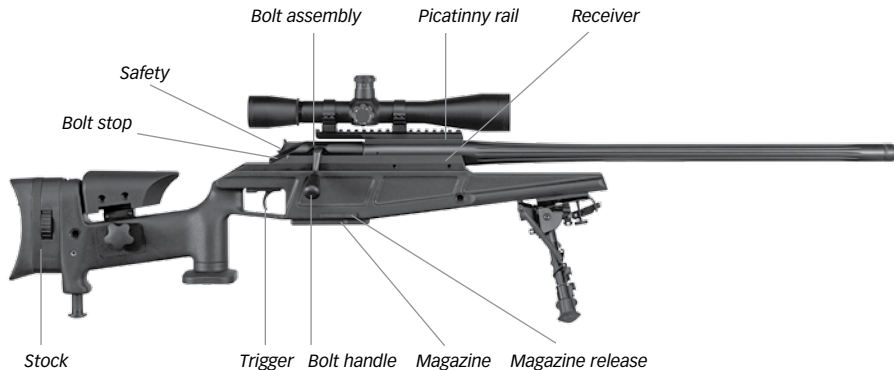
WARNING - LEAD EXPOSURE



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

2.0 Main rifle components



Standard delivery includes:

- | | |
|------------------|------------------------|
| 1 Rifle | 1 T-Allen key SW 4 |
| 1 Magazine | 1 Allen key SW 3 |
| 1 Owner's Manual | 2 Allen screws M5 x 25 |

3.0 Technical specifications

Caliber	.308 Win.	.338 Lapua Mag.
Length overall	44.50" / 1130 mm	46.86 / 1190 mm
Barrel length	24.69" / 627 mm	27.00" / 685 mm
Rate of twist	11" / 279.40 mm	10" / 254 mm
No. of grooves	4	6
Magazine capacity	5	4
Weight (excl. scope)*	10.58 lbs / 4.8 kg	12.79 lbs / 5.8 kg
Trigger pull weight*	3.31 lbs / 1500 g	3.31 lbs / 1500 g

Specifications subject to change without notice.

*Weight approximate

4.0 Assembling



WARNING:

Make sure there are no cartridges in the chamber or magazine.

- Remove the large Allen key (SW 4) from its pocket in the shipping carton. With the barrel screw studs pointing down, insert the barrel into the receiver (fig. 1).
- Then, insert the Allen key into the holes on the bottom of the fore-end and tighten the two Allen screws equally locking the barrel and receiver together (fig. 2).

NOTE: Do not use any extension tools on the Allen key to tighten screws. Good hand tightness is sufficient.



Figure 1



Figure 2

- Insert the magazine from the bottom into the receiver until both magazine releases are engaged (fig. 3).
- Place both bolt rails parallel on the rear end of the receiver and insert the bolt by sliding the bolt rails forward (fig. 4). Push forward on the bolt handle until the bolt is closed completely.

NOTE: Do not use force while inserting and sliding the bolt forward. If you feel any resistance pull the bolt back and repeat the process.

NOTE: Always make sure the bolt handle is locked in the back position when installing the bolt assembly, i.e. at an angle of approx. 45°. If the bolt handle is close to vertical, you cannot mount the bolt assembly. Pull the bolt handle back until it engages in the 45° position.

NOTE: When assembling the rifle, ensure correct magazine and bolt assembly are fitted to match the caliber of the barrel (see sections 12.0 and 13.0).



Figure 3



Figure 4

4.2 Barrel Removal



WARNING:

Make sure there are no cartridges in the chamber or magazine.

- Push the safety slide forward slightly with the thumb (approx. 1/16"), simultaneously pulling the bolt handle back (see section 5.5). Then pull the bolt all the way straight back.
- Unload the rifle (see section 10.0).
- Push down and hold the bolt stop pin (see section 11.1) simultaneously withdrawing the bolt assembly with the other hand.
- With the 4 mm AF Allen key supplied, undo the two barrel attachment screws.
- Remove the barrel.

5.0 Safety and bolt handle lock

5.1 Safety system

The safety system of the Tactical 2 bolt action rifle is centered on the uncocked firing spring: you operate the safety slide to cock the firing spring just before firing the rifle or to release it again. When repeating, it remains cocked. With the safety slide released, the bolt handle is simultaneously locked to prevent accidental opening of the bolt when carrying the rifle, provided this was fully closed.



WARNING:

Do not touch the trigger while moving the safety. The firearm will fire when the trigger is pulled while operating the safety. Never place your finger or any object inside the trigger guard until you are ready to fire the rifle.



Figure 5



Figure 6

5.2 "OFF SAFE" position

- Place your thumb right into the ribbed finger recess on the safety slide.
- Push the safety slide all the way forward (fig. 5) and lift off your thumb to lock safety slide into position. The firing pin spring is cocked.
- You should see a red warning dot behind the safety slide to indicate the "Off safe" position (fig. 6).



Figure 7



Figure 8



Figure 9

5.3 "ON SAFE" position

- To release the safety to the most rearward position place your thumb on the rear portion of the safety slide, push the safety slide downwards (fig. 7) and release to the most rearward position (fig. 8) so the red dot marking cannot be seen.

5.4 Bolt handle lock

- Prevents accidental opening of the bolt. It is automatically activated when the rifle is in the "On Safe" position and fully locked.

5.5 Opening the bolt in the "ON SAFE" position

To open the bolt (for loading and unloading) in the "On Safe" position, push the safety slide with your thumb 1/16" forward, hold and simultaneously pull bolt handle backwards (fig. 9), then open bolt all the way.

6.0 Ammunition



WARNING:

- Use only commercially available, CIP proofed ammunition in the original packaging, and which matches the caliber of your rifle. The correct caliber is stamped on the left side of the rifle barrel at the rear.
- Never use reloaded, “refurbished”, hand-loaded, non-standard ammunition, or ammunition of a different caliber.
- Never use dirty, wet, corroded, bent, damaged or oiled ammunition.
- Never leave ammunition unattended.

7.0 Magazine

The Tactical 2 bolt action rifle is equipped with a removable single-row magazine. The detachable magazine is held in the rifle by two magazine releases on the right and on the left of the magazine well. See section 3.0 for magazine capacity.



WARNING:

Ensure correct magazine and ammunition is used to match the caliber of the barrel. The magazine is marked on the left hand side with the caliber for which it is designed to be used.

7.1 Filling the magazine

- Place the cartridge with the rim of the cartridge up against the feed lips.
- Push down on the rim (rear) of the cartridge until it is below the feed lips.



Figure 10

8.0 Loading the rifle



WARNING:

- Always keep muzzle of the rifle pointed in a safe direction.
- Before loading, always wipe off any excess grease and oil, then verify that there is no obstruction in the chamber or the trigger guard.
- Do not place your finger on trigger, keep it outside of the trigger guard.
- Never load or unload the rifle inside a vehicle, inside a building or other confined space (except in a designated firing range).
- Do not load the rifle by inserting the magazine until immediately before shooting.
- Never rely on safety mechanisms. They are never a substitute for careful and correct handling of your rifle.
- Never let a loaded rifle out of your hands.

Loading the rifle

- Move the slide in the “On safe” position (see section 5.3)
- Open the bolt (see section 5.5)
- Insert a loaded magazine from the bottom and make sure it has engaged the magazine release.
- Push the bolt handle forward all the way until it locks.

Check that:

- The red dot is not visible, bolt handle is all the way forward. The rifle is now loaded, “on safe” and locked to prevent accidental opening.



WARNING:

- Do not move the safety to the “off safe” position until you are ready to fire.
- Keep your finger away from the trigger unless you wish to fire the rifle.
- When you interrupt or finish firing move the safety slide immediately backwards in the “on safe” position.
- Before making each shot, check the terrain in front of and behind the target.
- Ensure that the target and the environment allow shots to be fired without danger.
- Always wear ear protection and safety glasses when shooting. Alert bystanders to the importance of wearing ear protection.
- If a cartridge fails, wait approximately 60 seconds before opening the breech to avoid danger from a cartridge that may be late firing.

9.0 Firing and repeating

- Push the safety slide all the way forward with the thumb in the “off safe” position (see section 5.2).
- Sight the target and pulling the trigger will fire the rifle.
- Repeating: Pull back the bolt as far as the bolt stop allows and then push it forward again making sure the bolt handle is completely forward.

NOTE: If the bolt handle is not in its most forward position, the rifle will not fire for safety reasons.

10.0 Unloading the rifle

- Remove your finger from the trigger and point the rifle in a safe direction.
- Move the safety slide in the “On Safe” position (see section 5.3)
- Press both magazine releases and remove magazine (fig. 11).
- To remove cartridge from chamber, push the safety slide 1/16” forward with your thumb, hold and pull bolt handle backwards, then open bolt slowly until the cartridge can be grasped with the fingers before it clears the receiver. Remove the cartridge from the rifle.
- Check that there is no cartridge in the rifle.



Figure 11



WARNING:

Make sure there are no cartridges in the chamber or magazine.

11.0 Removing and replacing the bolt assembly



WARNING:

Before performing any cleaning or maintenance, make sure there are no cartridges in the chamber or magazine.

11.1 Removing the bolt assembly

- Unload the rifle (see section 10.0).
- Remove the magazine.
- Pull the bolt assembly all the way back.
- Push down and hold the bolt stop pin (fig. 12) and simultaneously withdraw the bolt assembly backwards with the other hand.



Figure 12

11.2 Installing the bolt assembly

- Carefully position the ends of the two slide rails onto the rear end of the receiver in line with the bolt guide.
- Slide the bolt assembly forward into the receiver.
- Close the bolt by pushing the bolt handle forward.

NOTE: Do not use force when doing this! If the bolt assembly does not slide on smoothly. Make sure the two bolt housing rails are sliding past the breech face of the barrel. If they are not, slight outward pressure with your fingers should correct the alignment.

12.0 Caliber group table

Caliber group	Barrel and Bolt head are stamped with	Caliber
Standard	ST	308 Win.
Lapua	LA	.338 Lapua Mag.

There are 2 caliber groups available (see table section 12.0). When changing the barrel to a different caliber group, you will also have to change the bolt head to suit the caliber group of the barrel you have chosen to use. The table (section 12.0) shows the correct components to be used together. In addition, bolt heads and barrels are stamped with markings which identify the caliber group (fig. 13). Take a final check that these markings match after the rifle is assembled.

If you change barrels within the same caliber group you do not have to change the bolt head.

NOTE: Bolt heads for left-hand bolts are stamped "L" below the caliber group marking.

Make sure you also use the correct magazine to match the caliber of the barrel. The caliber marking can be found on the side of the magazine.



WARNING:

Always make sure there are no cartridges in the chamber or magazine.

13.0 Changing the barrel

- Unload the rifle (see section 10/0).
- Remove the magazine.
- Remove the bolt assembly (see section 11.0).
- Fully undo both barrel attachment screws with the 4 mm Allen key, these are captive so they cannot be lost.
- Lift the barrel out of the receiver.
- Place the new barrel in the bed of the receiver.
- Tighten both barrel attachment screws hand-tight with the Allen key.
- Insert a magazine matching the caliber of the barrel into the magazine housing
- Check that the marking stamped on the bolt head (ST, LA, fig. 13) matches the caliber group of the barrel.
- If you have to change the bolt head in the bolt assembly (see section 14.0).

NOTE: Always keep the barrel bedding clean. Excessive oil or grease between the barrel and receiver will impair the accuracy of the rifle.

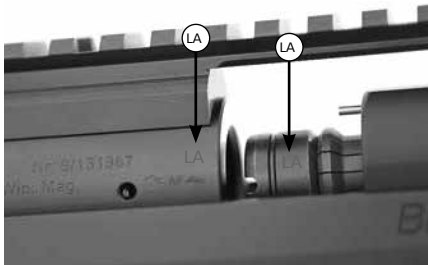


Figure 13

14.0 Bolt Head / Bolt Housing Configurations

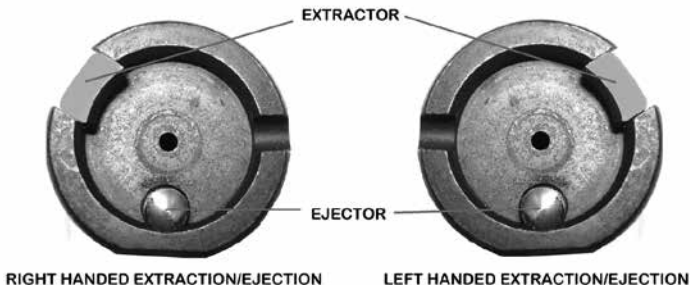
The Tactical 2 bolt head and bolt housing assembly can be configured in four (4) different operations depending on the shooter's preference. The bolt housing assembly is the part that has the actual bolt handle attached to it on the right or left side of the housing. The Bolt Head is the actual bolt that contains the expanding collets, extractor, and ejector as shown below.

Configurations can be set up as follows:

1. Right hand operation with right side ejection.
2. Right hand operation with left side ejection.
3. Left hand operation with left side ejection.
4. Left hand operation with right side ejection.

Tactical 2 bolt heads come in left side and right side extraction/ejection configurations.

The ejector will always be in the same location. You can identify right side from left side bolt heads by looking directly at the bolt face and locating the extractor as shown below.



The ability to configure the bolt and bolt housing to your specific preference affords the shooter the ability to manipulate the bolt housing without breaking the cheek weld and releasing the firing grip.

For example: A right handed shooter sets his rifle up with a left handed bolt housing and a right side extractor bolt head.

14.1 Changing the bolt head

NOTE: It is advisable to have this operation explained by your Tactical 2 dealer.

- Unload the rifle (see section 10.0).
- Remove the bolt assembly from the rifle (see section 11.0).
- Place bolt assembly upside down on a flat surface.
- With a small screwdriver or similar tool push the retaining latch to the left side and up (fig. 14).
- Grasp the retaining latch with thumb and forefinger and push to the left. With your other hand pull the bolt head out of the bolt assembly (fig. 15).

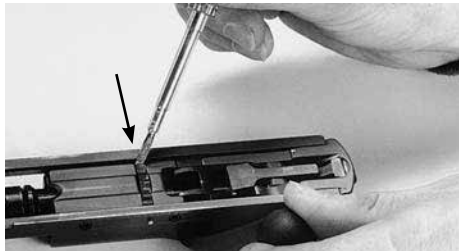


Figure 14

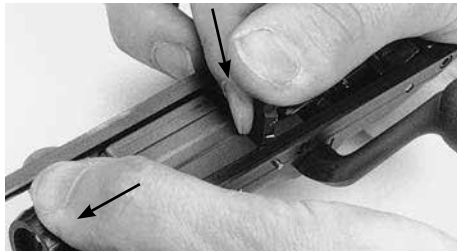


Figure 15

14.2 Installing the bolt head

- Grip the new bolt head to be installed and line up the two grooves of the expanding shell and bolt head by turning them in relation to each other (fig. 16).
- Lift the retaining latch in the bolt housing.
- Now insert the bolt head with the groove facing exactly upwards into the bolt assembly over the firing pin as far as the stop and hold it there.

NOTE: To make this process easier, jiggle the firing mechanism up and down with the thumb of the other hand (fig. 17).



Figure 16



Figure 17

- Flip the retaining latch down again and push it back into its recess so that it snaps into position (fig. 18).

NOTE: If the retaining latch is not in the correct position, a warning pin will project from the outside of the rail (fig. 19).



Figure 18



Figure 19

NOTE: The bolt assembly can only be inserted in the receiver when the warning pin is flush in the bolt rail (fig. 20), indicating that the retaining latch is seated correctly.

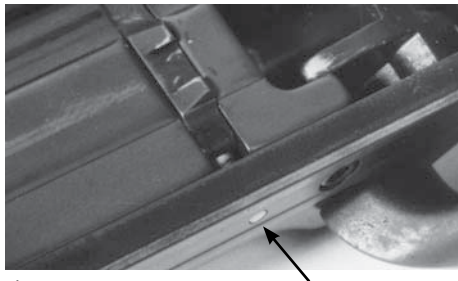


Figure 20

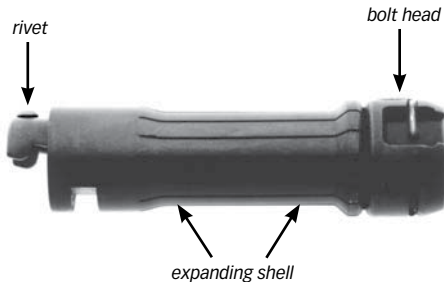


Figure 21



WARNING:

The bolt head assembly consists of two major parts: The bolt head and the surrounding expanding shell. These two parts are bound together by a rivet (fig. 21). It is strictly forbidden to loosen that rivet! Firing the rifle with the expanding shell removed, will inevitably cause the blow-out of the bolt head assembly and injury or death to the shooter or bystanders!

15.0 Trigger assembly

The Tactical 2 bolt action rifle is equipped with an adjustable trigger. The trigger pull weight is adjusted at the factory to approx. 1200 g (9.8 N).

Adjustment potential:

- Trigger position
- Trigger pull
- Trigger stop

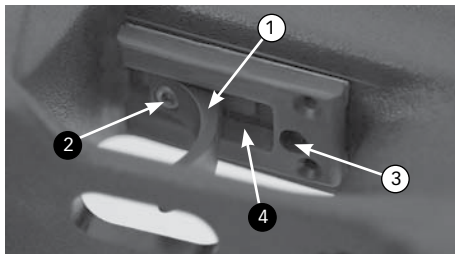


Figure 22



WARNING:

Before making any adjustments make sure there are no cartridges in the chamber or magazine.

15.1 Trigger position

The trigger blade (fig. 22-1) can be moved along the longitudinal axis to adapt to the hand of the shooter.

- loosen lock screw (fig. 22-2).
- shift trigger blade to the desired position.
- tighten lock screw (fig. 22-2).

15.2 Trigger pull

- The trigger pull weight can be adjusted with the trigger pull screw (fig. 22-3):
- increase trigger pull weight turn the trigger pull screw (fig. 22-3) clockwise
- decrease trigger pull weight turn the trigger pull screw (fig. 22-3) counterclockwise.

15.3 Trigger stop

- The trigger stop can be adjusted with the trigger stop screw (fig. 22-4):
- turn triggerstop screw (fig. 22-4) clockwise until trigger is past the release point.
- put the safety in the "off safe" position.
- pull the trigger and turn triggerstop screw (fig. 22-4) counterclockwise until the sear releases the firing pin.
- by counting to turn the triggerstop screw (fig. 22-4) counterclockwise the desired travel beyond the release point can be adjusted.

16.0 Stock / Fixed

The following adjustments are possible:

- Buttplate elevation
- Length of pull
- Cheekpiece height and offset
- Handrest

16.1 Buttplate

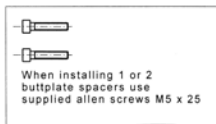
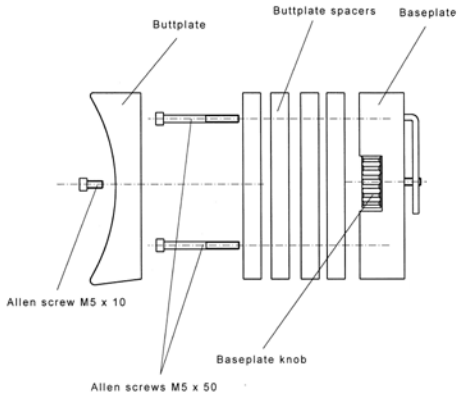
- Loosen baseplate knob and move buttplate to desired elevation and tighten.

16.2 Length of pull

- Loosen Allen screw (SW 4) and remove buttplate
- Loosen and remove Allen screws (SW 4) which hold the spacers to the baseplate. Add or remove spacers to set the desired length of pull.
- Installation in reverse.

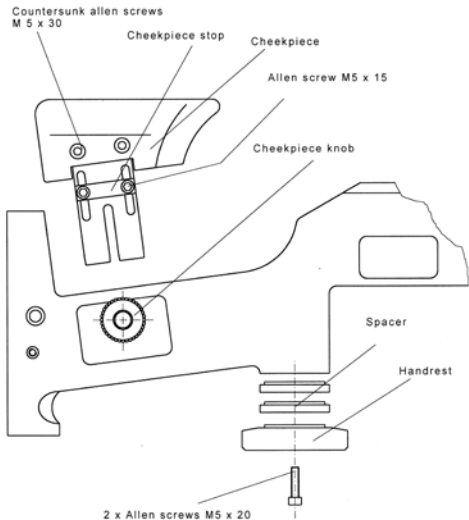
NOTE:

- When installing 1 or 2 buttplate spacers use Allen screws M5x25.
- When installing 3 or 4 buttplate spacers use Allen screws M5x50.



16.3 Cheek piece

- After loosening cheekpiece knob the cheekpiece can be moved up or down. To remove the cheekpiece from the stock just pull it out of the top.
- To maintain the same elevation of the cheekpiece when removing and installing adjust the cheekpiece stop to the desired position.
- Loosen Allen screw M5x30 with Allen key SW 3. To adjust the offset of the cheekpiece add or remove spacers on the inside.



16.4 Handrest

- Loosen the 2 Allen screws (SW 4) and remove handrest.
- Add or remove spacers to set the desired height.
- Installation in reverse.

17.0 Stock

The following adjustments are possible:

- Butt plate elevation
- Length of pull
- Cheek piece height

17.1 Buttplate

- Loosen center mounting screw and raise or lower butt plate as required.
- Retighten screw.

17.2 Length of pull

- Loosen and remove the screw holding the butt plate on.
- Lower the rear mono-pod to full extension to allow access to the screws for the length of pull spacers.
- Remove or add spacers as required.
- Re-install the butt plate

17.3 Cheek piece height

- Loosen the adjusting knob and raise or lower cheek piece as required.
- Re-tighten the adjusting knob.

18.0 Optional accessories

- Interchangeable barrels
- Bolt head
- Magazine
- Mirage band
- Scope mounts
- Transport case

19.0 Care and Maintenance



WARNING:

Before performing any cleaning or maintenance make sure there are no cartridges in the chamber or magazine.

Note: Always make sure you use suitable materials that are intended for the purpose of cleaning rifles.

Barrels:

After firing, prior to storing for long periods and after carrying the rifle, treat barrels and cartridge chamber with suitable gun oil, particularly when conditions are damp or wet. Make sure you thoroughly remove excess oil from barrels and cartridge chamber before firing. With a heavy build-up of cartridge deposits, we recommend treating these parts with cleaners designed for cleaning rifle bores and chambers.

ATTENTION:

Make sure you read and adhere to the instructions and warnings given by the manufacturer of the cleaning agent.

Metal parts:

Always keep all metal parts of the rifle clean and lightly oiled.

Optics:

Refer to the service instructions of the manufacturer.

Maintenance:

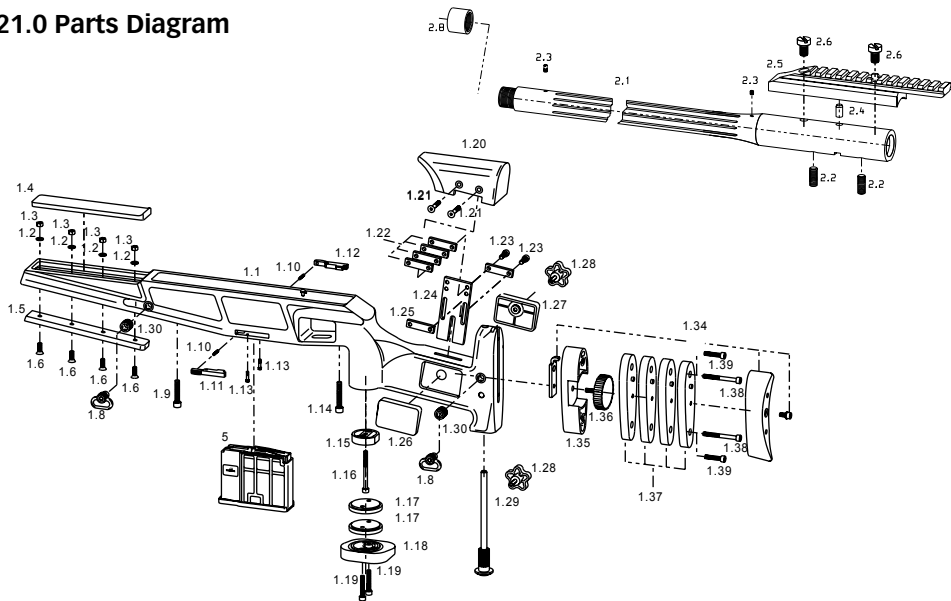
Take your rifle to your gun dealer for examination and maintenance before the hunting season and before hunting trips. Like your automobile, your rifle is an item of equipment that needs regular maintenance and inspection.

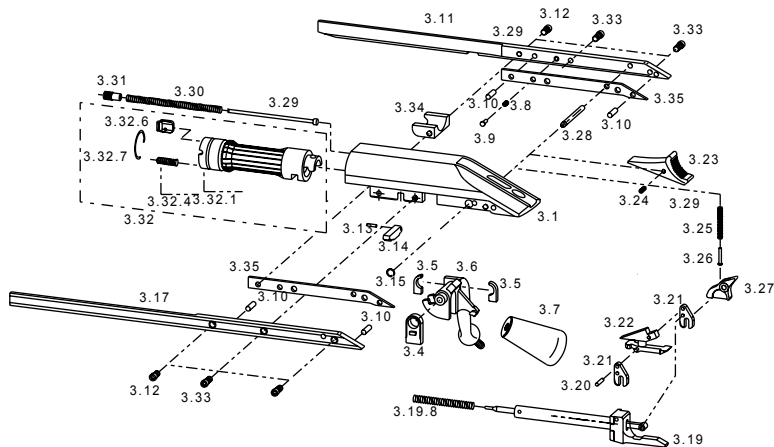
20.0 Parts List

- | | | | |
|------|-------------------------------------|------|------------------------------------|
| 1.1 | Buttstock R93 LRS2 | 1.26 | Cheekpiece Clamp, Left, R93 LRS2 |
| 1.2 | Washer DIN7349-5.3-A2 | 1.27 | Cheekpiece Clamp, Right, R93 LRS2 |
| 1.3 | Hexagon Nut DIN934-M5-A2 | 1.28 | Trail Spade Adjustment Screw |
| 1.4 | Buttstock Cover R93 LRS2 | 1.29 | Trail Spade |
| 1.5 | Forearm Rail R93 LRS2 | 1.30 | Sling swivel insert |
| 1.6 | Contersunk Screw DIN7991-M5x14 | 1.31 | Trigger cover |
| 1.8 | Sauer Sling Swivel | 1.32 | Cylinder Screw DIN912-M2x6-12.9 |
| 1.9 | Cylinder Screw DIN912-M6x30 | 1.34 | Buttstock Cap |
| 1.10 | Pressure Spring 2.8x0.5x8 D-O90 | 1.35 | Buttstock Base Plate R93 LRS2 |
| 1.11 | Magazine Holder Left R93 LRS2 | 1.36 | Base Plate Clamping Screw R93 LRS2 |
| 1.12 | Magazine Holder Right R93 LRS2 | 1.37 | Buttstock Spacer R93 LRS2 |
| 1.13 | Cylinder Screw (Sling Swivel Screw) | 1.38 | Cylinder Screw DIN912-M5x50 |
| 1.14 | Cylinder Screw DIN912-M6x35 | 1.39 | Cylinder Screw DIN912-M5x25 |
| 1.15 | Pistol Grip Cover | 1.40 | Receiver R93 LRS2 |
| 1.16 | Cylinder Screw DIN912-M5x55 | 1.40 | Receiver R93 Tactical 2 |
| 1.17 | Hand Rest Spacer | 1.41 | Barrel Bushing Washer |
| 1.18 | Hand Rest | 1.42 | Barrel Bushing |
| 1.19 | Cylinder Screw DIN912-M5x30 | 1.43 | Contersunk Screw DIN7991-M3x6 |
| 1.20 | Cheekpiece R93 LRS2 | 1.44 | Cylinder Screw DIN912-M3x20-12.9 |
| 1.21 | Contersunk Screw DIN7991-M5x30-10.9 | 1.45 | Receiver Bar 5.87 |
| 1.22 | Cheekpiece Spacer | 1.46 | Countersunk Screw DIN7991-M4x8 |
| 1.23 | Cylinder Screw DIN912-M5x16-8.8 | 1.47 | Match Cam Base |
| 1.24 | Cheekpiece Holder R93 LRS2 | 1.48 | Trigger stud |
| 1.25 | Cheekpiece Nut R93 LRS2 | 1.50 | Trigger Group Cover R93 LRS2 |

- 1.52 Threaded Pin DIN913-M4x6-45H
- 1.53 Pressure Spring 0.5x2.5x12 D-089
- 1.54 Bolt Catch
- 2.1 Barrel Tactical 2
- 2.2 Stud Bolt
- 2.3 Threaded Pin DIN551-M3x3
- 2.4 Cylinder Pin DIN7-6m6x10
- 2.5 Picatinny Rail
- 2.6 Screw for Picatinny Rail
- 2.8 Protective Sleeve
- 3.1 Bolt Housing
- 3.4 Full Bearing
- 3.5 Bearing
- 3.6 Bolt Handle
- 3.7 Bolt button
- 3.8 Bolt Lock Spring
- 3.9 Match Bolt Lock Pin
- 3.10 Cylinder Pin DIN7-3m6x8-A2
- 3.11 Right Rail
- 3.12 Short screw for Rail
- 3.13 Cylinder Pin DIN7-1.5m6x6
- 3.14 Bolt Lock
- 3.15 Central Axis Spring
- 3.17 Left Rail
- 3.19 Firing Pin Unit
- 3.19.8 Pressure Spring 0.5x4x38.2
- 3.20 Cylinder Pin DIN7-2m6x10
- 3.21 Transmission
- 3.22 Cocking Slide Base
- 3.23 Cocking Slide
- 3.24 Threaded Pin DIN913-M2x8
- 3.25 Cam Disk Return Spring
- 3.26 Rivet
- 3..27 Cam Disk
- 3.28 Match Central axis
- 3.29 Extractor Pin
- 3.30 Pressure Spring 0.85x4.2x61
- 3.31 Extractor Bushing
- 3.32 Bolt unit right "mini"
- 3.32.4 Ejector
- 3.32.6 Extractor
- 3.32.7 Extractor Spring
- 3.33 Long Screw Rail
- 3.34 Edge Protector
- 3.35 Rail Widener

21.0 Parts Diagram





22.0 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

23.0 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.



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

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.

24.0 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 - SHIPPING

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

ORDER PARTS

In the event you want to order parts for your Tactical 2 rifle, 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 20.0 and 21.0.

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.

Notes:

Notes:

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