



**McMILLAN**

**O W N E R ' S M A N U A L**

McMillan Custom Collection bolt action rifle  
and the G30 action.

**S H O O T T O W I N<sup>®</sup>**



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



**Shoot to win.®**

## I. A LEGACY OF PERFORMANCE AND SAFETY

In 1973 Gale McMillan was confident he could make a fiberglass stock that was as good as or better than any he could buy. His confidence was well founded. The stock he handcrafted set a new standard for firearm accuracy in the benchrest field. While performance and style are certainly hallmarks of McMillan, we never lose sight of the fact that safety is the most critical aspect of manufacturing a rifle. After more than 35 years, the same holds true for any firearm produced by McMillan.

### SAFETY IS CRITICAL TO PERFORMANCE

A superbly crafted gun is only as good as the hands that hold it. You can never be too careful. Shooting accidents are often caused by careless oversight such as failing to control the direction of the muzzle, failing to fully engage the safety, leaving ammunition in the chamber or using improper loads. These oversights can result in the destruction of life, limb or property. There's no calling back a bullet once it's been fired, so it's critical that you know the principles of safe gun handling and storage before you ever take your new McMillan firearm out of the box.

The proper use and the performance of your firearm depends on the correct assembly and maintenance, so it's critical that you familiarize yourself with the information in the instruction book. Even if you're a veteran shooter with a collection of McMillan firearms, take the time to read this literature. Not all firearms are the same. That means the first step in handling is to learn the features and requirements of your new McMillan rifle.

## II. THE FUNDAMENTAL PRINCIPLES OF FIREARM SAFETY

The Fundamental Principles of Firearm Safety should be etched in your memory forever. Let them govern your actions wherever and whenever you're involved with firearms in the field, on the range, or in your home. Please take the time to review and understand these rules.

### 1ST FUNDAMENTAL PRINCIPLE

#### ALWAYS KEEP THE MUZZLE POINTED IN A SAFE DIRECTION

This is the most important gun safety rule. A safe direction is one in which an accidental discharge will not cause injury to yourself or others. Never allow your gun to point at anything you don't intend to shoot. Be especially careful when you're loading or unloading. Treat every gun as if it were loaded, and make it a habit to know where the muzzle is pointed at all times, even when your firearm is unloaded. No one will be injured by accidental discharge if you keep your firearm pointed in a safe direction. It's as simple as that.

### 2ND FUNDAMENTAL PRINCIPLE

#### FIREARMS SHOULD BE UNLOADED WHEN NOT ACTUALLY IN USE

Load your firearm only when you're in the field or on the target range and ready to fire. Never let a loaded gun out of your sight or out of your hands. Unload it as soon as you're finished shooting and before you bring it into your car, camp or home. Remember, unloading your firearm means unloading it completely, so there is no ammunition in

the chamber or in the magazine. Before handling a firearm or passing it to someone else, visually check the chamber, receiver and magazine to be certain they do not contain ammunition. Always keep the gun's action open when not in use. Never assume a gun is unloaded even if you were the last person to use it. Always check for yourself.

Let common sense rule when you carry a loaded gun. If you're in a situation that could risk accidental discharge, such as crossing a fence, wading through a stream or climbing a tree, always unload your gun. Never pull or push a loaded firearm toward yourself or another person. Never carry a loaded gun in a scabbard, detached holster or gun case.

In addition, some firearms owners use external devices, such as cable locks and trigger blocks, for the same purpose. Even if you use such a device, you should still keep your firearm unloaded when stored or not in use. Using internal or external devices cannot substitute, however, for securing your firearms and ammunition in a separate, locked location.

Safe storage of firearms is just as critical as safe handling. Never store guns loaded. Be sure to keep your firearms in a secure place where unauthorized persons cannot get their hands on them without your knowledge.

Take special care if there are children around. Kids are fascinated by guns. It's a natural curiosity that can have tragic consequences when

not properly supervised. Store your firearms in a locked gun safe or some other location that physically bars a child from gaining access.

Ammunition should be stored and locked in a location separate from your firearm. Never leave an unsecured firearm or ammunition in a closet, dresser drawer or under the bed. Remember, it is your responsibility to make sure that children and others unfamiliar with firearms cannot get access to your firearm and ammunition.

### **3RD FUNDAMENTAL PRINCIPLE**

#### **DON'T RELY ON YOUR GUN'S SAFETY**

Treat every gun as if it can fire at anytime, whether or not there's pressure on the trigger. Your firearm has been carefully designed to maximize performance and safety. However, because a gun's safety is a mechanical device, it could fail. Human error is a more likely reason for a gun safety to fail.

By mistake, you may think the safety is on when it really isn't.  
Or the safety may have been disengaged without your knowledge.

Or you could think your gun is unloaded when there's actually a cartridge in it.

A mechanical safety is not a substitute for common sense; it is merely a supplement to your proper handling of a firearm.

Never touch the trigger on a firearm until you are ready to shoot.

Keep your fingers away from the trigger when you're loading or unloading.

Don't pull the trigger when the safety is engaged or positioned between safe and fire.

Before using your gun, read this instruction book to understand the exact location and operation of your firearm's safety. Even when the safety is on, maintain control of your loaded firearm and control the direction of the muzzle. In other words, don't rely on your safety to justify careless handling. If your firearm's internal mechanisms are broken or have been altered your firearm may fire even when the safety is on. Remember, you and your safe gun handling practices are your gun's best safety.

## **4TH FUNDAMENTAL PRINCIPLE**

### **BE SURE OF YOUR TARGET AND WHAT'S BEYOND IT**

You can't stop a shot in mid-air, so never fire unless you know exactly where your shot is going and what it will strike. Never fire at a sound, a movement or a patch of color. A hunter in camouflage can easily be mistaken for a target by an impulsive shooter. Before you pull the trigger, make absolutely sure of your target and what's behind it. Make sure the shot had a backstop such as a hillside or dense material like sand. Remember, bullets can travel great distances with tremendous velocity. Know how far your shot will go if you miss your target or the bullet ricochets.

## **5TH FUNDAMENTAL PRINCIPLE**

### **USE PROPER AMMUNITION**

Every firearm is designed to use a certain caliber or gauge of ammunition. Using the wrong ammunition, mixing ammunition or using improperly reloaded ammunition can cause serious personal injury or death. It only takes one cartridge or shotshell of the incorrect caliber or gauge, or which had been improperly reloaded, to destroy your firearm. It's your responsibility to make sure the ammunition you use exactly matches the caliber of your gun. Refer to this instruction book to find out the specific requirements of your firearm. Always read and heed the instructions on ammunition boxes.

Confusing shells or cartridges can cause serious personal injury or death and destroy your firearm. Examine your shells or cartridges closely and use only the precise caliber for your specific firearm. Check all ammunition before you load it to make sure it matches your gun's requirements. Every cartridge is head-stamped with its caliber or gauge for easy identification. Likewise, you'll find the caliber of your new McMillan rifle imprinted on the barrel.

### **RELOADING REQUIRES EXTRA DILIGENCE**

If you're an ammunition loader, you are responsible for personally assuring that the loads and components of your reloaded ammunition meet your gun's factory-tested standards. Never use ammunition which has been reloaded by someone else!

Many shooters hand load as a hobby or to save money on commercial factory-made ammunition. However, it requires a

thorough knowledge of reloading procedures and a deep respect for the explosive potential of gunpowder.

Firearms are designed, manufactured and proof-tested to standards based on factory-loaded ammunition. Hand loaded or reloaded ammunition that deviates, either intentionally or accidentally, from load or component recommendations can be very dangerous.

Reloaders must observe all possible safety precautions and practices related to the proper handling of explosives. Whether you're a seasoned reloader or just starting out, you should study the subject, watch reloading demonstrations and talk to experienced reloaders.

The first rule of reloading is to always follow the manufacturer's instructions for the components you're using. They'll tell you to follow certain guidelines. Namely:

1. Don't mix or substitute powders and primers.
2. Don't use unknown or substandard components.
3. Use only suitable components that have been factory-tested by reputable ammunition, powder and bullet manufacturers.
4. Always be sure to use the manufacturer's recommended recipe when reloading.

Not following these guidelines could result in severe injury to yourself or severe damage to your firearm. Dangerously high pressure and explosions can result from an overcharge of powder or other deviations from established reloading guidelines. Be very careful. The process of reloading exposes you to environmentally

hazardous material. Lead, which is known to cause cancer and birth defects, is the most common substance in bullets. It is important to handle lead bullets with extreme care. Work only in a well-ventilated area and always wash your hands after exposure and before eating. Never smoke while reloading.

Primers and powders are also highly toxic and flammable. After reloading be sure to clean all materials from your work area. Don't leave primer or powder spills anywhere on the floor or bench top. Dispose of all waste material in accordance with the manufacturer's recommendations.

Finally, when reloading or hand loading, concentrate on what you're doing at all times. Do not be distracted by talking to others, listening to the radio or watching TV while reloading. Never reload after consuming alcoholic beverages or drugs of any kind. You are working with extremely hazardous materials and you can't risk even a few seconds of distraction. Remember, if you reload, you are the ammunition manufacturer and you are responsible for the performance and safety of your reloaded ammunition.

## **6TH FUNDAMENTAL PRINCIPLE**

### **IF YOUR GUN FAILS TO FIRE WHEN THE TRIGGER IS PULLED, HANDLE WITH CARE**

If for some reason the ammunition doesn't fire when you pull the trigger, stop, remember the 1st Fundamental Principle of Firearm Safety and always keep the muzzle pointed in a safe direction. Keep your face away from the breech, then put the safety on, carefully

open the action, unload the firearm and dispose of the cartridge safely. Remember that anytime there's a shell in the chamber, your gun is loaded and ready to use. Even if you tried to shoot and your gun doesn't fire, treat your firearm as if it could still discharge.

## **7TH FUNDAMENTAL PRINCIPLE**

### **ALWAYS WEAR EYE AND EAR PROTECTION WHEN SHOOTING**

Your sight and hearing risk injury from shooting and should be protected at all times. Wear protective shooting glasses to guard against powder residue, ruptured cartridge cases and even twigs and branches in the field. Also, be sure to wear eye protection when you're disassembling or cleaning a gun so that tensioned parts (like springs) and cleaning solvents don't come in contact with your eyes. Continued exposure to shooting noise can permanently damage your hearing. On the range, where shooting volume is the loudest, be sure to use the best hearing protection available. Learn to use ear protection in the field, especially in confined locations like a covered shooting area at the local range.

## **8TH FUNDAMENTAL PRINCIPLE**

### **BE SURE THE BARREL IS CLEAR OF OBSTRUCTIONS BEFORE SHOOTING**

Before loading your gun, open the action and make sure there's no ammunition in the chamber or magazine. Check the barrel for any obstructions or debris. Even a small amount of snow, mud, excess lubricant or grease in the bore can dangerously increase pressure

and cause the barrel to bulge or burst when firing. Use a cleaning rod and patch to wipe away anti-rust compounds or any other residues or obstructions in the barrel. Never try to shoot out an obstruction by loading another shell and firing.

When firing, rely on your instincts. If the noise or recoil of your firearm seems weak, stop everything and be sure nothing is lodged in the barrel. Always be sure you're using the correct ammunition in your firearm and that it's free of obstructions.

## **9TH FUNDAMENTAL PRINCIPLE**

### **DON'T ALTER OR MODIFY YOUR GUN. HAVE IT SERVICED REGULARLY**

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

Like a mechanical device, a firearm is subject to wear. It must be maintained and periodically serviced to assure optimum safety and performance. Only a qualified service facility can repair or modify your McMillan rifle. Consult this instruction manual for instructions on how to send your firearm to the factory.

## 10TH FUNDAMENTAL PRINCIPLE

### LEARN THE MECHANICS AND HANDLING CHARACTERISTICS OF YOUR FIREARM

Not all guns are alike. They have different mechanical characteristics that dictate how you should carry and handle them. Anyone who plans to use a firearm should first become totally familiar with the type of firearm it is and the safe handling procedures for loading, unloading, carrying, shooting and storing it.

**WARNING!** Discharging firearms in poorly ventilated areas, cleaning firearms or handling ammunition may result in exposure to lead, a substance known to cause birth defects, reproductive harm, cancer and other serious physical injury. Have adequate ventilation at all times. Wash hands thoroughly after exposure.

### SHOOT SOBER!

There's one other rule that must be followed when handling firearms. In fact, respect for this rule is necessary in order to effectively practice The Fundamental Principles of Firearm Safety. The rule is SHOOT SOBER! Guns and alcohol or drugs make a deadly combination. Never consume anything that would mildly impair your judgment or physical coordination when you're using a firearm. A staggering percentage of the shooting accidents that occur every year involve alcohol or drugs. Be smart. Always shoot sober and stay alive.

**WARNING!** Failure to follow any of these safety rules may cause personal injury or death to the shooter or bystander and damage to

the property. Do not use a firearm until you fully understand and practice The Fundamental Principles of Firearm Safety. If you have any questions about the safe use of a McMillan firearm, write to us at McMillan Firearms Manufacturing, LLC, Consumer Service, at 1638 W Knudsen Dr, Phoenix, Arizona 85027 or call us at 1-877-365-6148.

### DON'T KEEP THIS TO YOURSELF

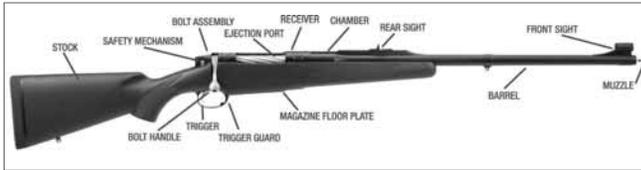
Now that you're a gun owner you have the obligation to help ensure that shooting sports are safe for everyone – participants and bystanders alike. You can do that by practicing these principles of firearm safety and passing them on to others – especially new shooters. Set an example for beginners. Be a guide to their safe entry into the exciting world of shooting sports. Invest your time and patience for the love of the sport and for its future. After all, it's your love of the sport that led you to buy a new McMillan.

Firearm ownership is a right and a privilege. It's a right guaranteed in this nation's Constitution. It's a privilege which carries with it a personal responsibility to use your firearm in a way which will ensure your safety and the safety of others. The preservation of this right and privilege depends on the personal commitment of you and your fellow shooters to the safe and responsible use of firearms. Let The Fundamental Principles of Firearm safety outlined in this manual guide you at all times. Teach and promote these rules whenever you can. Remember, firearm safety depends on you! That's the only way to really enjoy your new McMillan firearm and to preserve sport shooting as we know it today.

### III. MCMILLAN BOLT ACTION CENTERFIRE RIFLE

*Congratulations on your choice of a McMillan rifle.* With proper care, it should give you many years of dependable use and enjoyment. For best results we recommend that you use factory ammunition. Each McMillan has been tested using only factory ammunition.

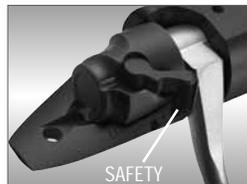
#### IMPORTANT PARTS OF A FIREARM



#### THE SAFETY MECHANISM

The safety mechanism provides protection against accidental or unintentional discharge under normal usage when properly engaged and in good working order. The safety mechanism is not a substitute for following the rules of safe gun handling.

To engage the safety mechanism, pull the safety mechanism fully to the rear towards the 'S' position before handling, loading or unloading the firearm.



When you are ready to fire the firearm, push the safety mechanism towards the 'F' position to disengage the safety mechanism.

Do not touch the trigger while moving the safety mechanism. Your fingers and all other objects should be kept outside of the trigger guard and away from the trigger until you are actually ready to fire by pulling the trigger.

Never pull the trigger when the safety mechanism is in the 'S' position.

**WARNING!** The firearm will fire when the trigger is pulled and the safety mechanism is in the 'F' position.

Even when the safety mechanism is in the 'S' position, careless handling can cause the firearm to fire. SEE THE FUNDAMENTAL PRINCIPLES OF FIREARM SAFETY.

Make it a practice to clean your bore every time you're going to shoot. Be sure to clean your entire gun before and after long-term storage and no less than once a year. It's also important to clean your gun whenever it's been exposed to adverse conditions such as rain, dirt, mud, snow, sleet or saltwater.

For safe and dependable operation of your firearm, all parts of your gun must be properly cleaned and lubricated. Periodically inspect the internal workings of your firearm to be sure they're clean and free of rust, unwanted dirt and debris.

Use recommended lubricants on your gun and do not over-lubricate. Excessive use of non-recommended lubricant could adversely affect the function and safe operation of your firearm. Remember, you are responsible for the proper care and maintenance of your firearm. Failure to properly maintain your firearm can not only damage or ruin your firearm, it can expose you and others to unnecessary risks of personal injury or death.

## TO INSTALL BOLT ASSEMBLY

The bolt assembly locks the cartridge into the chamber.

1. Point the firearm in a safe direction.
2. Put the safety mechanism in the 'S' position.
3. Depress the bolt stop located at the left rear of the action.
4. Align the locking lugs on the bolt with the bolt ways on each side of the center of the action and slide bolt forward.
5. When the bolt is completely forward, rotate the bolt handle down to lock the bolt into place. This action will chamber a round when the magazine has a cartridge(s) in it.
6. To remove the bolt, rotate handle up, depress the bolt stop and slide the bolt all the way back and remove from the action. Opening the bolt and pulling it rearward will extract a loaded round (if unfired) or an empty cartridge from the chamber.



## THE TRIGGER ASSEMBLY

The trigger is adjusted at the factory. All adjustments to the trigger assembly should be performed by McMillan or a McMillan Authorized Service Center.



**WARNING!** NEVER remove the trigger mechanism or make adjustments to the trigger or trigger assembly.

**WARNING!** NEVER put your finger on the trigger unless you are going to fire the firearm.

## THE BARREL

The inside of the barrel must be cleaned and free of obstructions.

### I. TO CHECK THE INSIDE OF BARREL:

1. Point the firearm in a safe direction.
2. Put the safety mechanism in the 'S' position.
3. Raise the bolt handle.
4. Pull the bolt all the way back.
5. Remove any ammunition from the chamber or magazine.
6. Remove the bolt.
7. Look through the inside of the barrel from the chamber end to the muzzle.

## II. TO REMOVE AN OBJECT FROM INSIDE THE BARREL:

1. Use correct size cleaning rod.
2. Push cleaning rod from the chamber end all the way through the barrel until the rod comes out of the muzzle.
3. If an object cannot be easily pushed out of the barrel with a cleaning rod, return the firearm to the factory or a MCMILLAN RECOMMENDED GUNSMITH.

**WARNING!** Never try to remove an object from the barrel by loading another cartridge and firing. This may cause the barrel to burst or a cartridge case to rupture and cause serious personal injury.

## III. TO CLEAN THE BARREL FOLLOW THE INSTRUCTIONS ON PAGE 24.

## TO LOAD THE FIREARM

There are two types of model G30 rifles: one with a floorplate, and one with a DETACHABLE MAGAZINE BOX.

Before loading the firearm, make sure the inside of the barrel is free of dirt or other obstructions.

### I. TO LOAD ONE CARTRIDGE ONLY:

1. Point the firearm in a safe direction.
2. Put the safety mechanism in the 'S' position.
3. Raise the bolt handle.
4. Pull the bolt handle all the way back.

5. Put one cartridge of the correct caliber on the magazine follower or in the chamber.
6. Slide the bolt handle forward, then push the bolt handle down to lock the cartridge into the chamber.

### THE FIREARM IS NOW LOADED.

7. To fire the firearm put the safety mechanism in the 'F' position.

### THE FIREARM IS READY TO FIRE.

## II. TO LOAD THE CHAMBER AND MAGAZINE:

1. Point the firearm in a safe direction.
2. Put the safety mechanism in the 'S' position.
3. Raise the bolt handle.
4. Pull the bolt handle all the way back.
5. Push desired number of cartridges of the correct caliber, one at a time, into the magazine. The magazine will hold five cartridges. Keep the bullets aligned toward the chamber.
6. Put one cartridge into the chamber.
7. Use your fingers to push the cartridges in the magazine all the way down. Slowly slide the bolt assembly forward so that the bolt slides over the top of the cartridges in the magazine.
8. Push the bolt handle down to lock the cartridge into the chamber.

### **THE CHAMBER AND MAGAZINE ARE NOW FULLY LOADED.**

**WARNING!** Always check the cartridge for the correct caliber before loading the firearm.

9. To fire the firearm put the safety in the 'F' position.

### **THE FIREARM IS READY TO FIRE.**

### **ALTERNATE METHODS TO LOAD THE CHAMBER AND MAGAZINE**

#### **FOR MODEL G30 WITH DETACHABLE MAGAZINE BOX**

1. Point the firearm in a safe direction.
2. Put the safety mechanism in the 'S' position.
3. Raise the bolt handle.
4. Pull the bolt handle all the way back.
5. Press magazine release lever and pull the magazine box from the firearm.
6. Push cartridges of the correct caliber, one at a time, into the magazine box, pushing the cartridges to the rear of the magazine. Keep the bullets aligned toward the chamber.
7. Place the magazine box into the trigger guard opening and push it until the magazine release lever snaps into the fully latched position.

Most Model G30 rifles with floorplates will hold four standard rounds in the magazine and one in the chamber for a total of five rounds when fully loaded. In addition, they will hold three magnum caliber rounds in the magazine and one in the chamber for a total of four magnum rounds when loaded. The Prestige and the Heritage have drop-belly floorplates with extended magazines which will allow for 4 rounds of .375 H&H or .416 Rem rounds in the magazine and one in the chamber for a total of five rounds when fully loaded.

### **THE MAGAZINE IS NOW FULLY LOADED.**

8. Put one cartridge of the correct caliber into the chamber.
9. Use your fingers to push the cartridges in the magazine all the way down. Slowly slide the bolt assembly forward so that the bolt slides over the top of the cartridges in the magazine.
10. Push the bolt handle down to lock the cartridge into the chamber.

### **THE CHAMBER AND MAGAZINE ARE NOW FULLY LOADED.**

11. To fire the firearm put the safety mechanism in the 'F' position.

### **THE FIREARM IS READY TO FIRE.**

**WARNING:** Always check the cartridge for the correct caliber before loading the firearm.

## TO UNLOAD THE FIREARM (WITH FLOORPLATE)

### INSTRUCTIONS FOR THE MODELS WITH A FLOORPLATE

1. Point the muzzle of the firearm in a safe direction
2. Put the safety mechanism in the 'S' position.
3. Raise the bolt handle.
4. Put one hand over the top of the ejection port.
5. Slowly pull the bolt handle rearward with your other hand to remove the cartridge from the chamber.
6. Hold cartridge and remove it from the firearm.
7. Put your hand under the floorplate.
8. Push the floorplate release button to release the floorplate. The magazine spring and follower will be released from the magazine.
9. Remove released cartridges.
10. Push in the magazine follower then close the floorplate.



**WARNING: CHECK THE CHAMBER AND THE MAGAZINE TO MAKE SURE THERE ARE NO CARTRIDGES IN THE FIREARM.**

## INSTRUCTIONS FOR THE MODELS WITH A DETACHABLE MAGAZINE BOX

1. Point the firearm in a safe direction.
2. Put the safety mechanism in the 'S' position.
3. Raise the bolt handle.
4. Slowly pull the bolt handle rearward with your other hand to remove the cartridge from the chamber.
5. Depress the magazine release lever to release magazine box.
6. Hold the magazine box in one hand with bullets facing away from you and slide the round forward by pushing on the rim of the case with the thumb of your other hand. Repeat until empty.
7. Replace the magazine box.

**WARNING!** Check the chamber and the magazine box to make sure there are no cartridges in the firearm.

## TELESCOPIC SIGHTS

The top of the receiver has holes for the installation of telescopic sights.



## LUBRICATION AND MAINTENANCE

When the firearm is to be stored, it should be carefully cleaned and thoroughly oiled. Outside surfaces should be wiped with a light coat of M-Pro 7 oil occasionally. When the firearm is to be reused, all excess lubrication must be removed and the chamber and bore must be thoroughly wiped dry.

### TO CLEAN THE BARREL

**WARNING!** Check the chamber and magazine to make sure that there are no cartridges in the firearm.

1. Use the equipment provided in a good cleaning kit. For recommendations, see your MCMILLAN AUTHORIZED GUNSMITH.
2. Remove the bolt assembly.
3. Select the correct caliber cleaning brush and cleaning rod.
4. Put the cleaning brush into the gun cleaning solvent.

**NOTE:** Barrel should be angled horizontally with the muzzle being slightly lower than the breech during cleaning. Always clean the barrel from the chamber end to the muzzle.

5. Push the cleaning brush through the barrel several times.
6. Remove brush from rod, attach tip with patch, and push through the bore.
7. Repeat several times, using a new cleaning patch each time, until the patch is not dirty.

8. Push a clean patch saturated with M-Pro 7 through the barrel.
9. Push a clean dry patch through the barrel to remove excess lubricant.
10. Apply a thin coat of M-Pro 7 to the outside of the barrel with a soft clean cloth.
11. After cleaning the barrel, clean the receiver and the trigger assembly.

**WARNING:** Firearm should be inspected periodically by McMillan or a McMillan Authorized Service Center. This will ensure proper inspection and any necessary replacement of worn or damaged parts.



### TO CLEAN THE RECEIVER AND TRIGGER ASSEMBLY

1. Put the safety mechanism in the 'S' position.
2. Remove the bolt assembly. See instructions on page 16.
3. Turn the rifle upside down.
4. Remove the stock screws. See picture above.
5. Lift the stock away from the receiver and trigger assembly.

### FOR MODELS WITHOUT A FLOORPLATE ONLY

Remove the magazine spring and follower from the receiver.

**NOTE:** Clean and lubricate the receiver and trigger assembly as a unit.

Do not remove the trigger assembly from the receiver.

1. Thoroughly clean the receiver inside and out with bore solvent. Do not allow the solvent to dry.
2. Wipe the trigger clean with gun patch soaked in bore cleaner. Wipe dry immediately after cleaning.
3. Place the safety in the fire "F" position. Pull the trigger rearward and release multiple times.
4. Release the trigger and operate the safety from the fire "F" to the safe "S" position multiple times.
5. Place a drop of M-Pro 7 in each of the four points in the trigger assembly specified in the picture.
6. Place the safety in the fire "F" position. Pull the trigger rearward and release multiple times ensure the trigger returns completely to the forward position each time.



**WARNING!** If the trigger does not fully return to the forward position each time it is released, then your rifle is NOT in a safe operating condition and it must NOT be used until you have had it inspected by a McMillan Authorized Service Center.

7. If the trigger completely returns as specified, pull and hold the trigger rearward and using a small punch or screwdriver depress the sear and release multiple times. The sear must return to the full upward position without hesitation.

**WARNING!** If the sear does not return to the full upward position without hesitation, then your rifle is NOT in a safe operating condition and it must not be used until you have had it inspected by a McMILLAN Authorized Service Center.

8. If the sear freely returns to the full upward position as specified in operation 7, release the trigger and operate the safety from the "F" to the safe "S" position multiple times. The safety must operate freely. The safety detent spring must position the safety in the full safe "S" or "F" position. The safety should not remain in a position anywhere between the full safe "S" or fire "F" position. If the safety does not freely return to the full safe "S" or fire "F" position, return the firearm to a McMILLAN Authorized Service Center for an inspection of the safety and trigger assembly.
9. Place the safety in the safe "S" position and lightly apply M-Pro 7 on all the external surfaces of the trigger assembly and receiver. Wipe off excess oil.

## TO ASSEMBLE MODELS WITH A FLOORPLATE ONLY

Put the magazine all the way into the bottom of the receiver.

## MODELS WITH A FLOORPLATE OR DETACHABLE MAGAZINE

1. Assemble the trigger guard assembly on the stock.
2. Put the stock over the receiver and trigger assembly.
3. Replace and tighten the trigger guard (stock) screws. Torque specifications: front screw 45 inch pounds, middle screw and rear screw 45 inch pounds of torque.
4. Close the floorplate or replace detachable magazine.

**WARNING!** Before you replace the bolt assembly, make sure the barrel is free of obstructions.

5. Replace the bolt assembly.

**WARNING!** After cleaning the trigger assembly, check the chamber and magazine to make sure there are no cartridges in the firearm. Put the safety mechanism in the 'F' position. Close the bolt smartly. The firing pin must remain cocked. To check, pull the trigger. The firing pin must fall. Repeat the test at least ten times. If the firing pin will not remain cocked when the bolt is closed smartly, return the firearm to the factory or a McMILLAN recommended gunsmith.

## CLEANING FREQUENCY

1. Before and after long term storage.
2. When the rifle has been subjected to adverse conditions such as shooting in the rain, snow, sleet or saltwater areas.
3. When the rifle is exposed to dirty conditions such as lying on the ground outdoors, being dropped in mud, etc.

**NOTE:** While the McMILLAN G30 rifle with a McMILLAN fiberglass stock has been designed and manufactured to provide improved corrosion protection, only proper care will keep your firearm in good operating condition and maintain its appearance. After extensive use, the protective coating on plated parts may be worn sufficiently to reduce corrosion protection. Such worn parts should be replaced to assure the integrity of the corrosion protection.

**WARNING!** After each use, follow the lubrication and maintenance direction in this instruction book. If the firearm is immersed in water, it must be thoroughly cleaned and lubricated as soon as possible. In the case of salt water immersion, first flush all parts with fresh water, then dry, clean and lubricate the firearm. If the firearm does not function properly, have it corrected by a McMILLAN recommended gunsmith before further use. Failure to follow this warning may lead to firearm malfunctions which could result in serious personal injuries or death.

## INSTRUCTIONS FOR CLEANING THE BOLT ASSEMBLY

### TO DISASSEMBLE THE BOLT ASSEMBLY

1. Remove the bolt assembly from the firearm.
2. For Model G30: Hold the bolt in your left hand with cocking piece housing facing right. Grasp the cocking piece housing firmly with your right hand and rotate clockwise. When turned 45 degrees, the firing pin spring will force the firing pin loose. At this point the firing pin can be removed.



**CAUTION:** Clean the firing pin as a unit.

3. Clean all parts with gun cleaning solvent. Dry with a clean cloth.
4. Apply a thin coat of M-Pro 7.

### TO ASSEMBLE

1. Put the firing pin assembly into the rear of the bolt assembly with the top of the cocking piece housing pointing the same



direction as the bolt handle. Press the cocking piece housing toward the bolt until you are able to rotate the firing pin counter-clockwise 45 degrees. The cocking piece will slip into the detent that will lock the firing pin and cocking piece in place.

## IV. HOW TO OBTAIN PARTS AND SERVICE FROM MCMILLAN FIREARMS MANUFACTURING TO ORDER PARTS

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

Please have the following information ready before you call.

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

**WARNING! USE ONLY MCMILLAN PARTS IN MCMILLAN FIREARMS.**

## REPAIR SERVICES

1. To locate the McMILLAN Authorized Service Center nearest you, visit our website at [www.mcmillanusa.com](http://www.mcmillanusa.com). If you need additional on-line assistance, e-mail us at [info@mcmillanusa.com](mailto:info@mcmillanusa.com) to obtain a listing of Authorized Service Centers. Contact the Authorized Service Center of your choice for evaluation of your firearm and/or additional shipping instructions.
2. If your McMILLAN Authorized Service Center cannot provide the service or repair you require and you need further assistance, please call our toll free number 1-877-365-6148, Mon-Fri., 8:00 AM - 4:00 PM Mountain Standard time.
3. If shipment of your firearm is required, please:
  - Record the serial number of your firearm before sending it to us.
  - Pack your firearm for safety and to prevent damage in shipping and handling in a firearms box.
  - Remove all accessories from the firearm to prevent loss or damage.
  - Enclose a letter with the firearm detailing the model name or number of your firearm and serial number along with a full description of the problem. Be sure to include your full name and address (P.O. Box and Street Address), including zip code, daytime telephone number and e-mail address.
  - Ship your firearm by either United Parcel Service (UPS) or Parcel Post (US Post Office). McMILLAN is not responsible

for damage of loss during shipment, so you may elect to purchase insurance from your carrier.

## SHIP TO

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

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

### **DON'T ALTER OR MODIFY YOUR GUN AND HAVE IT SERVICED REGULARLY.**

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

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

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

# MODEL G30

## BOLT ACTION CENTERFIRE RIFLE PARTS LIST

### PART 10 – SPARE PARTS LIST

PART NUMBER	DESCRIPTION
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300.1	Barreled Action Assembly
300.1.1	Rifle Barrel
300.1.2	G30 Action Assembly
300.1.2.1	Bolt Assembly
300.1.2.1.1	Firing Pin Assembly
300.1.2.1.1.1	Firing Pin
300.1.2.1.1.2	Firing Pin Spring
300.1.2.1.1.3	Cocking Piece
300.1.2.1.1.4	Cocking Piece Housing
300.1.2.1.1.5	Firing Pin Locking Set Screws (x2)
300.1.2.1.2	Ejector Assembly
300.1.2.1.2.1	Ejector Pin
300.1.2.1.2.2	Ejector Retaining Pin
300.1.2.1.2.3	Ejector Spring
300.1.2.1.3	Extractor Assembly
300.1.2.1.3.1	Extractor (Specify)
300.1.2.1.3.2	Extractor Actuating Pin
300.1.2.1.3.3	Extractor Spring
300.1.2.2	Bolt Stop Assembly
300.1.2.2.1	Bolt Stop
300.1.2.2.2	Bolt Stop Pivot Pin
300.1.2.2.3	Bolt Stop Spring

300.1.2.3  
300.1.2.3.1  
300.1.2.3.2  
300.1.2.3.3

Wt Ejector Assembly  
Wt Ejector Blade  
Wt Ejector Pivot Pin  
Wt Ejector Spring

300.1.2.4  
300.1.2.4.1  
300.1.2.4.2

Trigger/Safety Assembly  
Trigger  
Safety

300.1.3

Recoil Lug w/Pin

300.1.4.1  
300.1.4.2  
300.1.4.3

Express Rear Sight Insert (Prestige)  
Front Sight Insert (Prestige)  
Front Sight Hood (Prestige)

300.2  
300.2.1  
300.2.2  
300.2.2.1  
300.2.2.2  
300.2.2.3

Stock Assembly  
Butt Pad  
Butt Spacer Assembly  
1/2 Inch Spacer  
1/4 Inch Spacer  
Sling Swivel Studs

300.2.3  
300.2.3.1  
300.2.3.2  
300.2.3.3  
300.2.3.4  
300.2.3.5

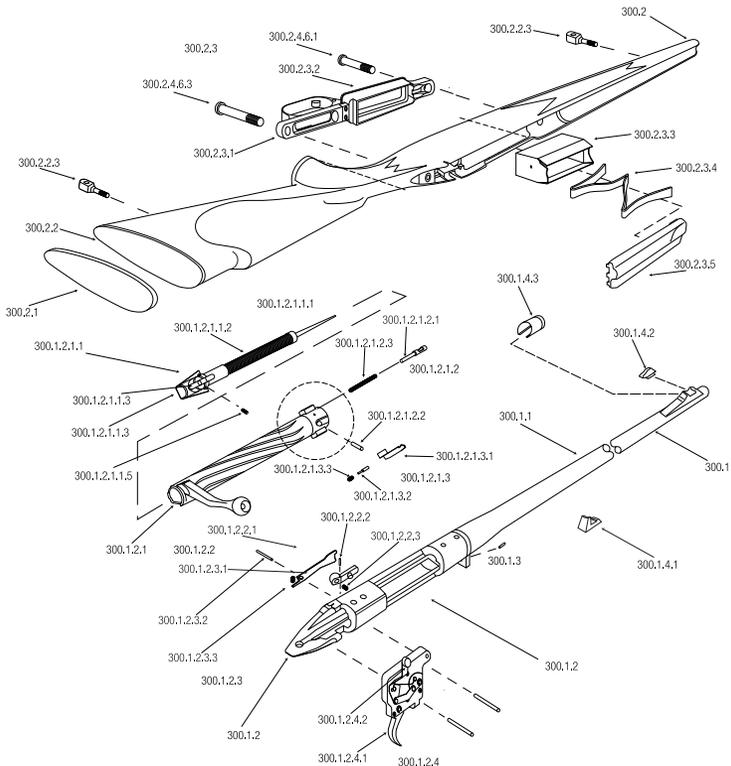
Bottom Metal Assembly (Aluminum or Stainless)  
Trigger Guard  
Floor Plate  
Magazine Box  
Magazine Spring  
Magazine Follower

300.2.4.6  
300.2.4.6.1  
300.2.4.6.3

Guard Screw Set  
Front Guard Screw  
Rear Guard Screw

# MODEL G30

## CUSTOM COLLECTION



# FIREARM OWNER'S RECORD

Model \_\_\_\_\_

Serial # \_\_\_\_\_

Date Purchased \_\_\_\_\_

Purchased From \_\_\_\_\_

Price Paid \_\_\_\_\_

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

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

## 100% Guaranteed Satisfaction

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

OR

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

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



**Shoot to win.®**

Visit our website at: [www.mcmillanusa.com](http://www.mcmillanusa.com)

McMillan Firearms Manufacturing, LLC. 1638 W. Knudsen Dr. Suite 101  
Phoenix, Arizona 85027 623.582.0536 phone 623.581.3825 fax  
[info@mcmillanusa.com](mailto:info@mcmillanusa.com)