



McMILLAN®

OWNER'S MANUAL



MCMILLAN ALIAS™ RIFLE LINE

SHOOT TO WIN®



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 ALIAS™.



Shoot to win.®

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PART 1 - ALIAS™ EQUIPMENT INTRODUCTION

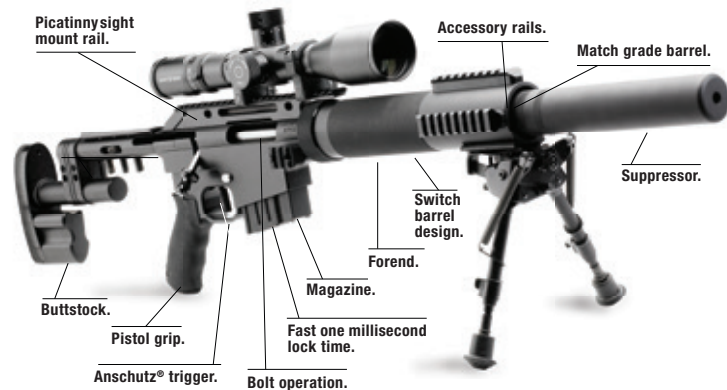
PURPOSE

The McMillan ALIAS™ rifle line features interchangeable components that enable one rifle to be customized for many applications. A shooter can mix and match components to create a customized configuration. This includes switch barrel capability for the utmost flexibility.

DESCRIPTION

ALIAS is designed as the most interchangeable bolt action rifle ever built. Every part of ALIAS can be switched to fit your exact mission. The buttstock, which connects directly to the back of the action, defines the start of a complete interchangeable system. In fact, we refer to ALIAS™ as a “stockless rifle” because it is designed without a traditional stock or chassis and has no recoil lug. The result is a complete inline rifle system providing three significant advantages for the shooter: reduced recoil, increased accuracy and complete interchangeability.

The McMillan ALIAS rifle line is designed for custom configuration. ALIAS™ includes three package configurations – the ultra-compact ALIAS CS5™ subsonic suppressed rifle for discrete carry and concealment, the ALIAS STAR™ Standard Tactical Application Rifle, and ALIAS Target™ configured for high power competition.



PART 2 - PREPARATION FOR USE

SAFETY RULES

WARNING: READ THESE BASIC SAFETY RULES

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

KNOW YOUR FIREARM

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

1. Treat ALL firearms as if they are loaded.
2. Never point your firearm at anything you are not willing to destroy.
3. Keep your finger off the trigger until your sights are on target and you are ready to fire.
4. Be sure of your target. Know what is in front of and behind the target.
5. Never make changes to or alter any parts in your rifle, especially the trigger. Use only original McMillan rifle parts.
6. Make yourself safe at all times by wearing eye protection, such as shooting glasses or impact resistant sunglasses, when shooting. Wear ear protection, such as earplugs or earmuffs, if not both. Repeated

exposure to shooting noise can cause permanent hearing loss.

7. Take care of your rifle system and keep the barrel (and muzzle brake if present) clean and free of obstruction. Keep the rifle clean and have it checked periodically to verify and maintain proper function. Any worn, missing or damaged parts may cause an unsafe condition resulting in possible injury or death.
8. Use only ammunition that matches the type marked on your firearm. McMillan is not responsible for any accidents or damage caused by handloads or improperly loaded ammunition. If for any reason the bolt closes or opens with difficulty or increased effort, discard the ammunition and replace it with suitable ammunition. Failure to do so may cause damage to the rifle and possible injury or death.
9. Never load a firearm until you are in a location where it is safe to fire and you are ready to shoot.
10. Know the range of your firearms. Remember, centerfire bullets can travel out to 5.5 miles.
11. If a firearm fails to fire, keep it pointed in a safe direction, wait one minute and carefully unload, avoiding exposure to the breech. If the firearm discharges but the report or recoil seems weak, unload and ensure there are no barrel obstructions.

12. Unload your firearm whenever you are not shooting. Never carry or store a loaded firearm in a building or vehicle. Unload your firearm before climbing up or over a fallen obstacle, fence or slippery area.
13. Store your firearm and ammunition safely, especially away from children. Lock unloaded firearms and ammunition securely in separate locations.

CAUTION: NEVER DRINK ALCOHOLIC BEVERAGES BEFORE OR DURING SHOOTING.

NEW RIFLE BREAK-IN PROCEDURES

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

14. Thoroughly clean the barrel before shooting. We recommend a good quality bronze brush (NEVER use stainless steel brushes as they can damage the bore), coated cleaning rod, bore guide, brass jag, and soft clean patches. Ammonia type copper removers may be used but are caustic and can cause damage if left on surfaces. Never leave any ammonia type copper remover in a barrel for over five (5) minutes. Follow all warning labels on any solvent or cleaners used.

15. Always clean the barrel from the chamber end towards the muzzle. With the bolt removed and the bore guide in place, start by pushing a solvent wet patch through the bore, followed by 20 strokes of a solvent soaked bronze brush. Dry patch the barrel until patches come out clean and dry. Remove the bore guide and run a final dry patch through the chamber and bore. Install the bolt. The rifle is now ready for the first shot.
16. Fire one round and re-clean the bore as stated in step 15. In order to break in the barrel correctly it is critical to remove all traces of fouling. After the initial bore cleaning has been completed, run several patches soaked in the copper remover completely through the barrel. Dry patch after each wet patch. Once there is no trace of copper in the bore and the patches come out clean and dry, fire the next round. Repeat this procedure for the first 10-12 rounds.
17. When you have completed this initial single shot sequence, you may proceed to the next step. Shoot two (2) shots and clean, for a total of twenty (20) rounds. At no time should the barrel be allowed to get so hot that you cannot hold it comfortably in your hands.

CAUTION: DO NOT USE ANY KIND OF ABRASIVE CLEANER IN THE BORE OF YOUR RIFLE.

18. To continue to get the best accuracy and longest life from your custom barrel, we recommend that you clean the barrel every 60-80 rounds.

SAFE DRY FIRING

We recommend dry firing (actuating the firing mechanism on an empty chamber) a number of times throughout this manual. Before dry firing, make sure you have removed the magazine from your firearm.

Note: If the magazine contains live ammunition, remove it to a secure, inaccessible location until you are done dry firing.

CAUTION: ALWAYS CHECK TO MAKE CERTAIN YOUR RIFLE IS UNLOADED BEFORE DRY FIRING.

PART 3 – ABOUT ALIAS

1. To insert the bolt, first remove the buttstock assembly. Please note, the ALIAS bolt is packed separately.
2. You will need to disassemble your ALIAS to prepare it for initial use. Using a 5/32-inch hex wrench, loosen the screw located at the rear of the sight mounting rail. Do not over tighten the screw, it just needs to be snug—its only function is secondary security in retaining the buttstock assembly.



3. Above the pistol grip, find the knurled catch on the rear of the action. Slide the latch down toward the grip and pull the buttstock assembly rearward and remove it. To get rid of any residues resulting from shipping and handling, run a couple of patches through the bore.
4. Next, insert the bolt and replace the buttstock assembly. The bolt release is located on the left side of the action. To prevent wear from continued disassembly/assembly, clean and lightly lubricate the interior portion of the buttstock assembly that mates to the receiver. Depressing the catch when reattaching the buttstock will help prevent unnecessary wear to the latching mechanism.
5. Before firing ALIAS, remove the bolt, wipe down its exterior and apply grease to the lugs and body. The firing pin may also be lubricated with grease in the cam and lug areas.

PART 4 – AMMUNITION

ALIAS CS5: McMillan 308 Subsonic 200 gr.,

.308 Winchester or McMillan 308 Winchester 175 gr. match

ALIAS STAR: Match grade ammunition

ALIAS Target: Match grade ammunition

1. We recommend referring to a reloading manual when handling ammunition. Begin with the lowest charge stated, working up in charge weight with a chronograph. Be alert to any signs of excessive pressure.
2. ALIAS chamber specifications were selected to accept factory and handloaded rounds.
3. Insert the magazine with the bullets facing forward until the magazine latches firmly in place. It is important to determine the correct bullet seating depth. This is accomplished using standard tools and gauges.
4. To release the magazine, depress the magazine release button on the right side of the magazine housing above the magazine well opening, until it feels tight and will not engage or disengage the safety. ALIAS can be disassembled with the safety on or off.

PART 5 – RIFLE OPERATION

SAFETY ACTUATION

1. The safety, located on the rifle's left side, is a flat black lever that pivots fore and aft alongside the action. Slide the safety lever using the thumb.
2. Fire position: The lever is forward (facing the muzzle side of the rifle).
Safe position: The lever is rear (facing the butt of the rifle).

NOTE: Tactical Shooters: The safety release arm is located at the rear/left hand side of the lower magazine housing just above the grip. This is included to facilitate quick safety release.

NOTE: The safety bar lever snaps into its "safe" and "fire" positions — ALIAS has a positive click stop in each direction. Moving the safety lever until it feels tight will not engage or disengage the safety. ALIAS can be disassembled with the safety on or off.

ACTION DISASSEMBLY

1. Remove the buttstock assembly per instructions (see Part 8 of this manual). Next, remove the pistol grip screw (located on the inside of the pistol grip) and pistol grip.
2. Using a 3/16-inch hex wrench, remove the screw under the pistol grip.

Remove the screw forward of the magazine housing. Pull the magazine housing straight down, away from the rifle. Once this is complete, the trigger can be adjusted.

3. Remove the screw forward of the magazine housing.
4. Pull the magazine housing straight down and away from the rifle. The trigger is now fully accessible for adjustment.

NOTE: Reassemble in reverse except for tactical users. For tactical users, the safety release arm should be held to the rear while positioning the lower magazine housing for installation. The action screws have a torque requirement of 40-50 lbs.



PART 6 – CLEANING AND MAINTENANCE

CLEANING PROCEDURE

The ALIAS rifle line is manufactured with durable and corrosion resistant materials, mainly aluminum alloys and stainless steel.

1. Wipe down after each use with a soft, lint-free cloth and clean any corrosive materials from the stainless surfaces. Please note, surfaces are not impervious to pitting. In areas of high humidity or prolonged exposure to corrosive elements, use of a rust inhibiting chemical treatment may be warranted.
2. Clean the barrel from the breech (chamber) end. This decreases possible damage to the sensitive muzzle crown area from inserting a cleaning rod into the muzzle.
3. Wipe off the exterior surfaces of the bolt and relubricate the bolt bearing surfaces and lug recesses. You do not need to disassemble the bolt unless it needs to be repaired. Clean the lug recesses.
4. Reassemble your rifle and wipe down the portion of the bolt body accessible through the action loading port to decrease attraction to airborne particulates. Apply grease to the locking lugs, cocking cams and firing pin retainer. If the bolt needs to be recocked when it is removed from the rifle, insert the bolt's firing pin fingers backward into their channels in the action and twist the bolt to recock the firing pin.

5. Always inspect your magazine before each use and make certain you have removed all debris or residues from the follower and body. The magazine can be disassembled by inserting an appropriate sized tool into the hole on the base plate and sliding the plate to the rear.
6. The spring and follower can be removed through the bottom of the magazine. Cleaning and re-lubrication is recommended, especially after use in dusty conditions.

PART 7 – STOCK ADJUSTMENT

FINDING THE PERFECT FIT

The ALIAS line is engineered as a fully adjustable system. Its customizable trigger sights and stock allow you to fit the ALIAS to your body and shooting position. ALIAS' interchangeable component customization sets ALIAS apart from other rifles.

STOCK LENGTH

NOTE: Buttstock assembly has two extension tubes: The stock extension, which is the upper tube extending from the rear of the receiver and the butt extension, which connects to the butt plate and recoil pad.

1. The buttstock is adjustable in length over four inches. To adjust, move the buttplate tube in or out after loosening the four screws on the damping block.

2. Make certain the buttstock tube is fully contained in the block. The extent of rearward (lengthening) movement is determined by the front of the buttstock tube fitting flush with the front of the block.

CAST AND CANT

3. To adjust the buttstock for cast or offset, loosen the four screws on the clamping block and swivel the block on the receiver extension tube.
4. The buttplate can be adjustable for cant up to 360°. By loosening the screw directly in the center of the rubber recoil pad, it is adjustable for height to approximately 1-1/2 inches
5. The cheekpiece is adjustable vertically by approximately one inch. The vertical cheekpiece adjustment is accomplished by the knurled ring located in the center of the stock extension.

FOREND TUBE

6. The forend tube rotates to 3 pre-set positions. This adjustment is used to accommodate the shooter's cant as well as comfort.

To rotate the forend, loosen the knurled collar approximately 1-1/2 turns. An indexing pin stops at each setting. You should feel the notches engage as the forend is rotated.



SIGHT MOUNTING OPTIONS

7. Sight mounting adjustments include cant settings and flexibility in locating the sight along the receiver. The action's adjustable sight mounting system allows the sight rail to be mounted at one of three pre-set mounting angles – 0°, 5° and 10°. This allows you to cant the rifle when shooting while maintaining a straight-up level sight. This feature is not available for the quadrail forend.

STEP BY STEP

For the perfect fit, follow the sequence below to adjust your ALIAS.

Tools needed: 5/32-inch hex wrench.

We recommend adjusting the cant before mounting the sights to your rifle. This allows you to find a comfortable fit without the distraction of the sights.

1. Each shooting position requires specific adjustments. Start lying face down in a prone position to make your initial adjustments. Put the rifle into your shoulder in a comfortable shooting position and make basic stock length and buttplate adjustments. You want the rifle to fit within a workable range. You can refine your settings later.
2. Next, you need to determine your natural hold and grip angle. Rotate (cant) the rifle counterclockwise until you are comfortable with your hand gripping position. This step is essential to achieve an efficient and stable shooting position.
3. To adjust the forend level, rotate it to suit your position. To do this, loosen the large knurled ring that secures the forend to the receiver. Next, rotate the forend tube until it locks into one of three pre-set positions that are controlled by a stop pin. After selecting a position, retighten the collar. Hand tighten only—do not use tools to tighten the collar ring.

4. To achieve a comfortable head position, adjust the cheekpiece height by raising or lowering it by rotating the knurled ring on the stock extension.
5. Remove the four 7/64-inch hex head screws that attach the sight rail to the receiver. Next, level the rail by choosing the nearest mounting angle that fits your shooting style while reattaching and tightening the mounting rail to the rifle receiver. For aperture sights, install the sight base at a position along the rail that offers correct eye relief. Before tightening the sight base clamping screws, ensure the base is fully engaged in the corresponding slots on the sight rail. Attach your sight to the base using the mounting screw or screws that came with the sight.

NOTE: Scope sight users follow the same procedure.

6. The front sight assembly, which is sold separately, is installed by sliding it onto the turned section at the muzzle. To level the front sight and secure it to the barrel, tighten the hex screw. Please be sure not to over tighten the sight onto the barrel—it can constrict the muzzle. Use the index ring to remove and reinstall the front sight.
7. Your ALIAS should now conform to your body and shooting style. Enter your settings in a notebook.

8. You can fine tune your ALIAS adjustments and settings at the shooting range. Note that buttstock adjustments will vary with different shooting positions.

PART 8 – BUTTSTOCK AND CHEEKPIECE TUNING

1. To secure the rifle into the shoulder pocket, buttplate height, length, and angle adjustments will be needed. Start by extending the length enough that you have to somewhat "reach" for the pistol grip. This results in the buttpad exerting extra pressure into the shoulder, which in turn, helps tighten and improve all shooting positions. The angle of the buttplate should be whatever allows the plate to fit into the shoulder pocket. Buttplate height has the effect of inclining the rifle. This influences the natural vertical position of the front sight on the target. Lowering the buttplate effectively drops the rifle muzzle and vice versa.
2. Offset or cast adjustment in the buttstock is strictly your preference. Most shooters find that offsetting the clamping block so the butt assembly moves outward (index mark on clamp to the right of center on the scale on the receiver extension tube) works well for the prone position. Conversely, swinging it inward works well for sitting and offhand.

NOTE: The butt clamp is reversible with the ALIAS Target model only.

3. Once you have the cheekpiece height setting, fine tuning the height as is necessary to center the eye in the rear sight in the shooting position. Thread the knurled ring up or down on your ALIAS. For a perfect fit, you can do this from the shooting position.
4. On the ALIAS Target model, the position adjustable handstop can be moved and fixed along any point within the slot it rides in. Using a 5/32-inch hex wrench, loosen the allen screw on the clamping piece. By loosening the screw on the stop piece itself, you can rotate and stop the handstop into one of five different positions to fit your preference and position structure. The handstop requires an Anschütz® sling swivel that is provided.

To facilitate shooting off of uneven surfaces, the optional bipod is adjustable for position fore and aft in the rail slot.

PART 9 – ANSCHÜTZ® TRIGGER ADJUSTMENTS

ALIAS employs an Anschütz® two-stage match trigger with safety that can be adjusted for pull weight, length of pull and trigger shoe angle. Anschütz® was selected because it is one of the best match triggers ever made. Not only is it reliable and durable, but it provides the finest touch of any trigger available.



The Anschütz® trigger on your ALIAS is pre-set with superior characteristics. The trigger is designed for performance, control and efficiency. We suggest you familiarize yourself with this adjustable system. To adjust trigger pull characteristics, remove the magazine housing from the rifle. Do this by removing two allen head screws. Note that ALIAS is designed so adjustments are hidden from the elements.

NOTE: Unload your rifle before you make any adjustments needed to the trigger. To test, dry fire several times before using live ammunition. Make certain you are familiar with trigger characteristics before firing live ammunition.

ADJUSTING THE ANSCHÜTZ® TRIGGER

STEP BY STEP

1. First, determine the best position for the trigger shoe. The trigger shoe is position adjustable horizontally along its attachment rail and can also be moved laterally. Loosen the screw on the trigger face side using the largest wrench provided (three wrenches are provided). Next position the trigger to a comfortable shooting grip.
2. There is a rectangular cam attached with an allen screw on the left side of the trigger body, loosen the allen screw—it may need to be removed. Set the cam finger (pointer) so that it is at the top outside edge of the allen screw. This corresponds with the cam finger indicating on line 6 to 6-1/4 from the bottom. These reference lines are located on the link directly ahead of the cam finger. Note that some of the index lines are miss-marked on certain triggers; it may be indicating between 7 and 7-1/4 when it is positioned as directed.
3. Tighten the allen screw with the short end of the allen wrench or the thumb and index finger—don't over tighten. The cam bracket must be in line with the arm to which it is mounted. The cam tip is designed to move up and down the arm for adjustment. Its position affects the feel of the trigger. Changing the amount of distance to and from the fulcrum point gives it a specific amount of leverage at each point. This makes the second stage break heavier (moving

up) or lighter (moving down). As you move the cam finger, you will probably have to readjust the sear engagement screw to get the proper feel.

4. The two rear screws (black and silver) in the back of the trigger are for first stage (black screw) and second stage (silver screw) weights. These adjustments are interdependent of one another—tightening the first stage, tightens the second, and vice versa. We suggest tightening the first stage (black) screw to increase it to the initial trigger load and the feel you desire. Next, use the second stage adjustment to fit your shooting style. The first stage weight can be adjusted later to suit your preference.

NOTE: The overtravel screw located immediately behind the trigger has been removed. This screw is not necessary because there is enough spring pressure in the trigger itself to overcome the momentum of the trigger finger.

5. Located directly in front of the trigger is the second stage sear engagement screw. Turn the screw clockwise to lessen the engagement of the second stage sear. If the screw is moved too far in, then the second stage stop will disappear from the trigger stroke; as the trigger moved through its first stage, the rifle would

fire without the shooter sensing any stop at the second stage. Next, back the screw out until you feel the second stage stop, and then back it out another 1/8 turn. This screw has a direct bearing on how crisp your trigger will feel. Less engagement of the second stage sear will mean a crisper trigger until, as mentioned, you over-adjust and the second stage stop is removed. This screw adjustment only indirectly affects trigger pull weight; it primarily affects the feel of the trigger.

6. The first stage movement is controlled by the second screw directly in front of the trigger. First stage movement increases as the adjustment screw is backed out. Tightening the screw shortens and eventually eliminates first stage movement from the trigger. At that point, you will have a single stage trigger. If you want to shoot a single stage trigger, follow the above directions in numerical order in order to get the type of engagement on the second stage that will result in a crisp trigger. Next, simply remove any first stage movement by tightening this screw.
7. The second (silver) screw at the rear of the trigger adjusts second stage weight. The black screw next to it adjusts the weight of the first stage. Turning either screw in increases weight, out decreases weight. Total trigger weight (first stage plus second stage) is adjustable from 10 ounces to an approximate total weight of 50-plus ounces. Weight range can vary depending on the particular trigger assembly installed on your rifle.

PART 10 – HOW TO CHANGE THE BARREL

TOOLS NEEDED

1. Barrel vise with jaws that match the contour of the barrel approximately 4 inches in front of the receiver.
2. Barrel wrench provided with ALIAS rifles.



STEP BY STEP

1. Release the magazine and ensure your firearm is unloaded.
2. Disassemble rifle down to barreled action only.
3. Tighten barrel in barrel vise.
4. Insert action wrench fully forward.
5. With a heavy mallet or other blunt object, strike the left side of the "T" handle to loosen the receiver from the barrel counterclockwise.
6. Once loose, remove action wrench and unscrew by hand.
7. Inspect and clean the threads of the receiver and the new barrel to be installed.

8. Inspect and clean the forend mount and ensure the locating pin is protruding approximately .050 inches.
9. Apply a small amount of light oil or anti-seize to the barrel threads without getting it on the shoulder.
10. Tighten barrel to be installed in barrel vise as before.
11. By hand, screw the receiver onto the barrel with forend mount fully forward and contacting the barrel shoulder.
12. Ensure the locating pin in the forend mount is inside the receiver notch.
13. Tighten by hand as tightly as possible and insert the action wrench.
Without Torque Wrench: With the mallet or other heavy blunt object strike the right side of the “T” handle to tighten the receiver clockwise. You do not have to strike it with great force; one or two solid strikes will seat the shoulders properly.
With Torque Wrench: Insert “T” handle into receiver fully forward and apply necessary torque value. See chart below.
ALIAS CS5 - 105 ft lb
ALIAS STAR - 95 ft lb
ALIAS Target - 95 ft lb
14. Check headspace with appropriate gauges and reassemble the rifle.

PART 11 – HOW TO OBTAIN PARTS AND SERVICE FROM MCMILLAN FIREARMS MANUFACTURING TO ORDER PARTS

1. Fax completed order to 623.581.3825.
2. To order by phone call toll free: 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) 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: ONLY USE MCMILLAN PARTS IN MCMILLAN FIREARMS.

REPAIR SERVICES

1. Contact McMillan Firearms Manufacturing if your firearm needs servicing. Call our toll free number 877.365.6148, Mon-Fri., 7:00 a.m. to 4:00 p.m. Mountain Standard time or email us at info@mcmillanusa.com.

2. If shipment of your firearm is required, please:
- Record the serial number of your firearm before sending it to us.
 - Remove all accessories from the firearm to prevent loss or damage.
 - Pack your firearm for safety. To prevent damage in shipping, pack in a firearms box or case.
 - Enclose a letter with the firearm detailing the model name or number of your firearm and serial number along with a full description of the problem. Be sure to include your full name and address, including zip code, daytime telephone number and email address.
 - Ship your firearm by either United Parcel Service (UPS) or Parcel Post (US Post Office). McMillan is not responsible for damage or loss during shipment, so you may elect to purchase insurance from your carrier.

SHIP TO

McMillan Firearms Manufacturing
Attn: Rifle Service Division/Repairs
1638 W. Knudsen Dr.
Phoenix, Arizona 85027
Phone: 877.365.6148

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

A WORD ON THE MAINTENANCE AND CARE OF YOUR MCMILLAN FIREARM.

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

Your firearm has been designed to operate according to certain factory specifications. You'll jeopardize your safety and that of others around you by attempting to alter the trigger, mechanical safety or other mechanisms. Never alter or modify your firearm in any way. Like any mechanical device, a firearm is subject to wear. It must be maintained and periodically serviced to assure optimum safety and performance. Only McMillan Firearms Manufacturing should service, repair or modify your McMillan firearm. Consult your instruction book for instructions on how to send your firearm to McMillan. McMillan recommends that you have your firearm professionally serviced annually.

You should also have your firearm professionally serviced after prolonged storage or if there is ever any question pertaining to the proper functioning characteristics of your firearm.

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

**CONTACT: MCMILLAN FIREARMS MANUFACTURING
1638 W. KNUDSEN DR.
PHOENIX, ARIZONA 85027
PHONE 877.365.6148.**

PART 12 – PARTS

ALIAS CS5 PARTS LIST

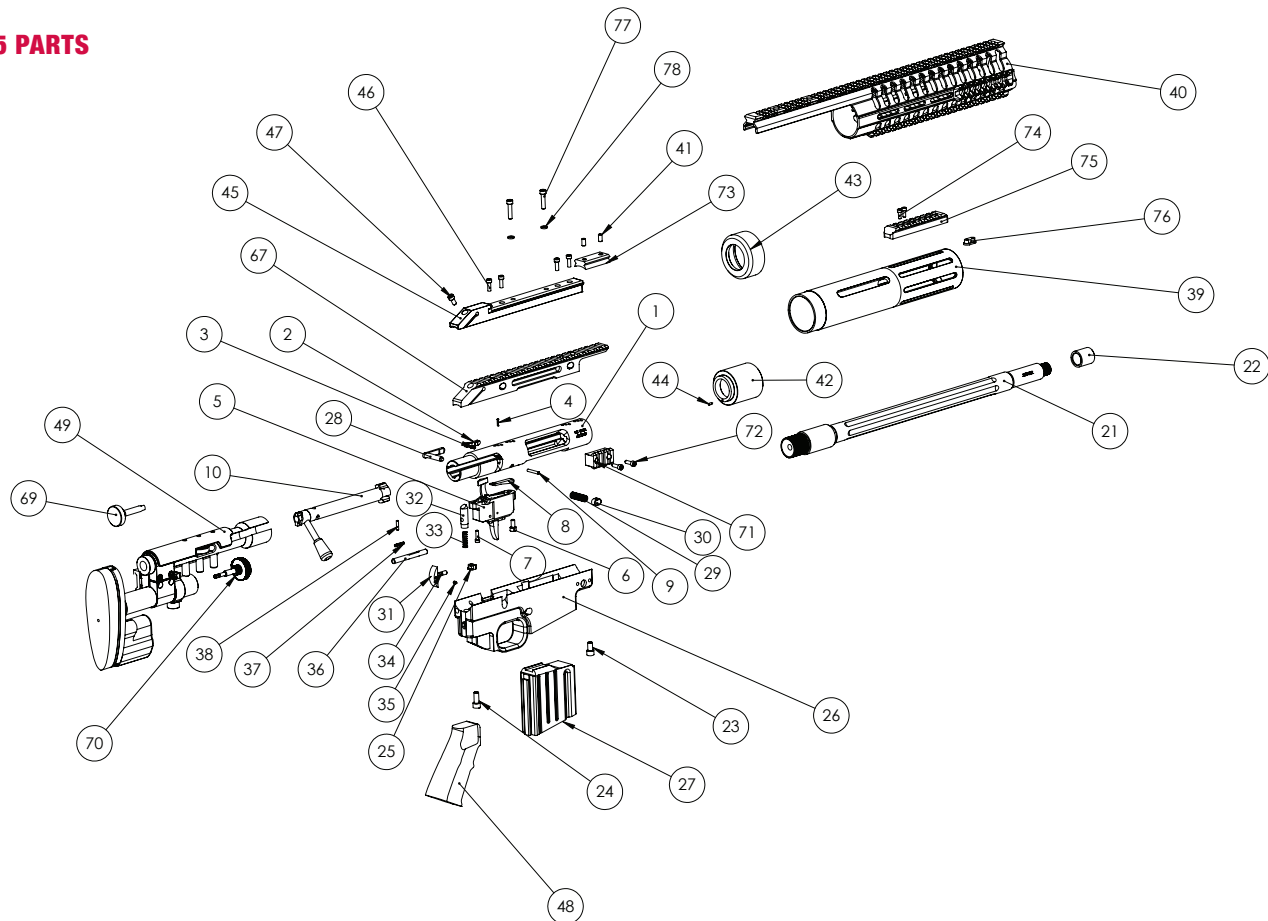
No.	Part Number	Description
1	ALS-100R	RECEIVER, RH
2	ALS-1110	BOLT STOP
3	ALS-1111	BOLT STOP SPRING
4	ALS-1112	BOLT STOP PIVOT PIN
5	ALS-1201	TRIGGER, RH, ANSCHÜTZ®
6	ALS-1210	TRIGGER SCREW, FRONT, ANSCHÜTZ®
7	ALS-1212	TRIGGER SCREW, REAR, ANSCHÜTZ®
8	ALS-122X	FLOATING SEAR
9	ALS-1220	SEAR PIN
10	SPECIFY	BOLT, RH COMPLETE w/FINISH
21	SPECIFY	BARREL
22	ALS-3900	STAR BARREL THREAD CAP
23	ALS-4000	MAG HOUSING SCREW, FRONT
24	ALS-4002	MAG HOUSING SCREW, REAR
25	ALS-4008	SPACER, REAR MAG HOUSING
26	SPECIFY	MAG HOUSING
27	ALS-4250	MAGAZINE, 10 RD
28	ALS-4310	MAG CATCH, RH

No.	Part Number	Description
29	ALS-4311	MAG CATCH SPRING
30	ALS-4312	MAG CATCH RELEASE BUTTON
31	ALS-4400	STOCK RELEASE BUTTON
32	ALS-4410	STOCK RELEASE PLUNGER
33	ALS-4411	STOCK RELEASE PLUNGER SPRING
34	ALS-4412	STOCK RELEASE PLUNGER SCREW
35	ALS-4413	STOCK RELEASE SET SCREW
36	ALS-4510	SAFETY RELEASE ARM
37	ALS-4511	SAFETY RELEASE ARM SPRING
38	ALS-4512	SAFETY RELEASE RETAINER
39	SPECIFY	HAND GUARD, TACTICAL ROUND
40	ALS-5020	HAND GUARD, QUADRAIL
41	ALS-5060	SET SCREW, QUADRAIL WEDGE
42	SPECIFY	HAND GUARD MOUNT
43	SPECIFY	HAND LOCK RING
44	ALS-5255	HAND GUARD MOUNT LOCATING PIN
45	ALS-5308	QUAD RAIL ADAPTER
46	ALS-5318	ADAPTER SCREW, QUADRAIL
47	ALS-5322	REAR TENSION SCREW, QUADRAL ADAPTER
48	SPECIFY	PISTOL GRIP

No.	Part Number	Description
49	SPECIFY	BUTTSTOCK COMPLETE
50	SPECIFY	STOCK EXTENSION
69	ALS-7750	FIRING PIN TOOL (STOCK MOUNTED)
70	ALS-7755	HEX TOOL (STOCK MOUNTED)
71	ALS-7211	ACCESSORY MOUNT, MAG HOUSING
72	ALS-7213	ACCESSORY MOUNT SCREW
73	N/A	QUAD RAIL TENSION WEDGE
74	ALS-7203	T-NUT SCREW ACCESSORY MOUNT
75	ASL-7201	ACCESSORY MOUNT, ROUND TAC
76	ALS-7202	T-NUT, ACCESSORY MOUNT
77	ALS-5320	QUADRAIL MOUNT SCREW
78	ALS-5722	QUADRAIL MOUNT SCREW WASHER

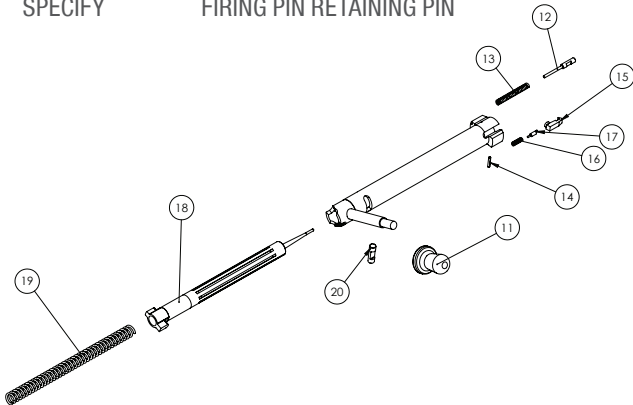
EXPLODED VIEW ON FOLLOWING PAGE

ALIAS CS5 PARTS



ALIAS BOLT ASSEMBLY PARTS LIST

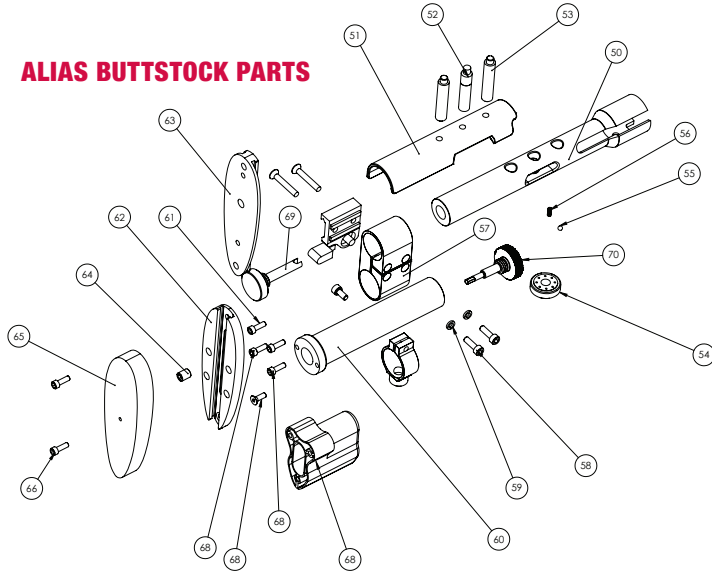
No.	Part Number	Description
11	ALS-2200	BOLT KNOB
12	ALS-2310	EJECTOR
13	ALS-2311	EJECTOR SPRING
14	ALS-2312	EJECTOR RETAINING PIN
15	ALS-2410	EXTRACTOR
16	ALS-2411	EXTRACTOR SPRING
17	ALS-2412	EXTRACTOR ACTUATING PIN
18	ALS-2510	FIRING PIN
19	ALS-2550	FIRING PIN SPRING
20	SPECIFY	FIRING PIN RETAINING PIN



ALIAS BUTTSTOCK PARTS LIST

No.	Part Number	Description
51	SPECIFY	CHEEKPIECE
52	ALS-5620	CHEEKPIECE ADJUSTMENT LEAD SCREW
53	ALS-5622	CHEEKPIECE GUIDE POST
54	ALS-5625	ADJUSTMENT WHEEL
55	ALS-5626	ADJUSTMENT WHEEL BALL DETENT
56	ALS-5627	ADJUSTMENT WHEEL DETENT SPRING
57	SPECIFY	BUTTSTOCK CLAMP
58	SPECIFY	BUTTSTOCK CLAMP SCREW
59	ALS-5722	WASHER, BUTTSTOCK CLAMP
60	SPECIFY	BUTT EXTENSION
61	ALS-5812	BUTT PLATE SCREW
62	ALS-5819	BUTT PLATE
63	ALS-5820	BUTT PLATE SLIDE
64	ALS-5822	BUTT PLATE SLIDE SET SCREW
65	ALS-5830	RECOIL PAD
66	ALS-5832	RECOIL PAD SCREW
67	ALS-73XX	SIGHT RAIL
68	ALS-7500	PINCH BLOCK W/ SCREWS

ALIAS BUTTSTOCK PARTS



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 McMillian 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.



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