



The pre64win.com
HIGH COUNTRY RIFLE



WARNING:

YOU MUST READ AND FOLLOW THESE INSTRUCTIONS BEFORE USING THIS FIREARM!

This firearm is a dangerous weapon and is potentially lethal. Improper or careless handling could cause a negligent discharge, leading to property damage, injury or death.

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INTRODUCTION

This manual contains important information on safety, handling, lubrication and recommended ammunition for your PRE64WIN.COM HIGH COUNTRY rifle. Your safety, as well as the safety of others, depends on your use of safe firearm handling practices.

SAFE HANDLING PROCEDURES

THE FOLLOWING SAFE HANDLING PROCEDURES ARE NOT INTENDED TO CONSTITUTE A COMPREHENSIVE LIST OF ALL SAFE HANDLING PROCEDURES OF A FIREARM. IF YOU REMAIN UNSURE REGARDING THE SAFE HANDLING OF YOUR FIREARM, PLEASE CONSULT AN APPROVED NRA INSTRUCTOR OR OTHER SIMILARLY QUALIFIED INDIVIDUAL OR ORGANIZATION TO ASSIST YOU.

- a) Always keep the muzzle of the firearm pointed in a safe direction, and away from all humans, including yourself.
- b) Handle every firearm as if it were loaded.
- c) Always check to be certain the firearm is unloaded - never take anyone else's word for it.
- d) Always keep and carry your firearm empty except when you are ready to shoot.
- e) Do not drink alcoholic beverages or take drugs before or during any shooting activity.
- f) Always wear ear protection when shooting.
- g) Always wear protective shooting glasses when shooting.
- h) Always make sure your firearm is clean. The barrel bore, chamber and action should be clean and free from obstructions.
- i) Use only clean, dry, original, high grade commercially manufactured ammunition in good condition and appropriate to the caliber of your firearm.
- j) Never put your finger inside the trigger guard or squeeze the trigger until you are aiming at a target and ready to shoot. This will prevent you from firing the firearm negligently.
- k) Always be sure of your target and the area behind it before you pull the trigger. A bullet can travel through or past your target up to 5 miles before it stops!
- l) If your firearm fails to fire, keep it pointed toward the target or a safe open area and wait at least 30 seconds. If it is a hangfire (slow or delayed ignition) the round will fire within 30 seconds. Although it is very rare, you need to be aware of and prepared for this possibility. If the round does not fire, eject the round and examine the primer. If the firing pin indent is light or non-existent, have the firearm examined by a professional gunsmith. If the firing pin indent on the primer appears normal, assume faulty ammunition and separate the misfired



round from all other live ammunition and empty cases. Make certain the bore is clear by removing the bolt and looking through it. Dispose of misfired rounds in accordance with the ammunition manufacturer's instructions.

- m) Never use your firearm if it fails to function properly. Never force a jammed bolt, a round may explode causing serious injury or death, and severe damage to your firearm. Before each shooting session, and before loading, give the firearm a safety check and visual inspection. If you find something that seems incorrect, do not load or fire. Ask a professional gunsmith for help or contact PRE64WIN.COM.
- n) Never shoot at a hard surface such as a rock nor a liquid surface such as water. The bullet could ricochet, hitting you, another person or unidentified object, causing injury, death or property damage.
- o) Always make sure the firearm is unloaded before cleaning, storing, or traveling. Ammunition should be removed with the action open before laying it down or handing it to another person, so that it cannot be fired.
- p) Always store your firearm and ammunition in separate, locked containers, out of the reach and sight of children, or anyone else who should not handle the firearm.

THE THREE-POSITION SAFETY

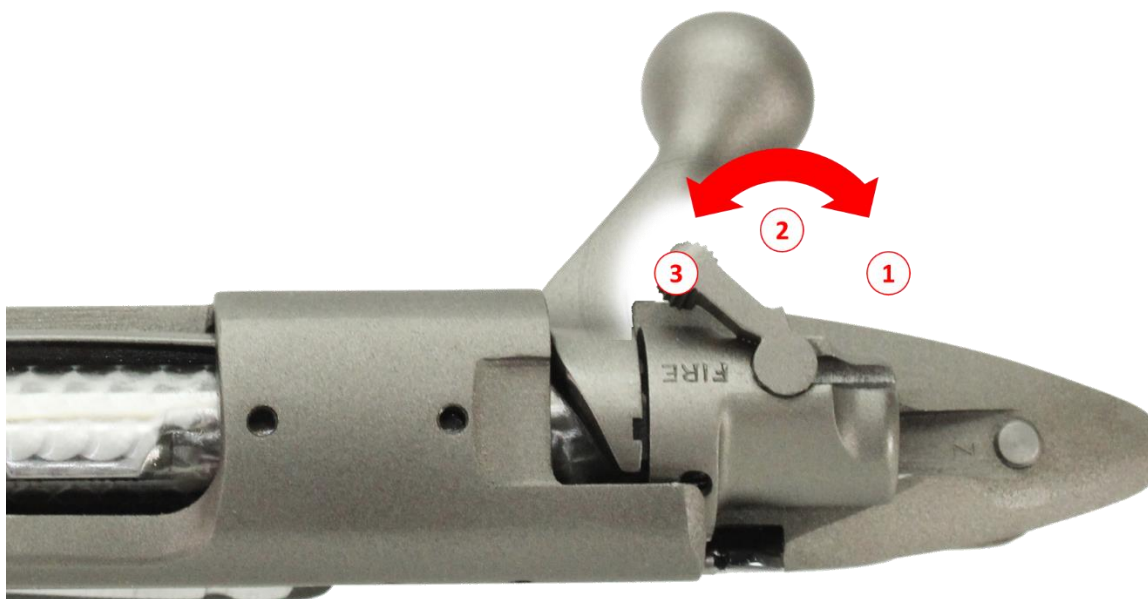


Figure 1 – Safety positions

The safety lever on your rifle has three positions (Refer to Figure 1):



Position 1 - Fully on position - The safety lever is fully engaged to the rear (toward the recoil pad). The safety is engaged with the firing pin and the bolt handle is locked in the down position.

Position 2 - Middle position - The safety lever is perpendicular to the bolt. This position locks the firing pin, but the bolt may be opened. This way an unfired cartridge can be unloaded while the safety remains operational.

Position 3 - Firing position - The safety lever is in the forward position (toward the muzzle). The firearm is ready to fire in this position. Never move the safety to the fire position unless the muzzle is pointed in a safe direction.

LOADING

Be sure you have the correct ammunition. Barrels are marked with the chambering of the rifle. Lift the bolt handle and pull it all the way back. Insert a cartridge into the magazine and press it down until it snaps in the magazine. If you choose to load more than one round, press each cartridge down with your thumb until it snaps in the magazine, and back to the rear of the magazine. Continue this process until the magazine is loaded to capacity, and then close the bolt. Close the bolt by pushing it forward and then locking it down.

The HIGH COUNTRY RIFLE is a true controlled round feed action. The cartridge is held by the extractor during the life cycle of the round. To fully employ the controlled round aspect of the action cycle, it is recommended that the bolt be cycled open and closed with concentrated effort and movement. Cycle the action smoothly and positively with speed to ensure that the round is properly engaged and chambered. Working the action slowly with light force may cause the round not to chamber properly.

UNLOADING

CAUTION: Always unload your firearm immediately after use and prior to cleaning and storage to minimize the risk of accidental discharge. To unload your firearm, point the rifle in a safe direction, move the safety to the middle position, unlock the bolt by lifting it up, and then pull straight back to eject the cartridge. Next release the magazine floorplate allowing any remaining cartridges in the magazine to fall out of the firearm.



FIRING

CAUTION: Always wear and encourage others to wear ear and eye protection when shooting.

Load the firearm as previously described. If your firearm fails to fire, keep it pointed toward the target or a safe open area and wait at least 30 seconds. If it is a hangfire (slow ignition) the round will fire within 30 seconds. Although it is very rare, you need to be aware of and prepared for this possibility. If the round does not fire, eject the round and examine the primer. If the firing pin indent is light, off center, or non-existent, have the firearm examined by a professional gunsmith. If the firing pin indent on the primer appears normal, assume faulty ammunition, separate the misfired round from other live ammunition and empty cases, reload and carry on firing. Dispose of misfired rounds in accordance with the ammunition manufacturer's instructions.

CAUTION: Keep firearm pointing in a safe direction and unload as previously described. If you cock your firearm but do not fire it, apply the safety until ready to fire. If you lose the opportunity to fire, safely unload your firearm as previously described. Remember, if a round is in the chamber, there is a risk of negligent discharge. Never leave a firearm cocked and ready to fire. The firearm could easily be accidentally discharged, causing injury, death, or property damage.

WARNING: When a round is in the chamber, the firearm may accidentally discharge if it is dropped or handled in a way it was not designed, regardless of the position of any of the safety devices. Do not chamber a cartridge until the firearm is in your hand and you are ready to fire. Clear the firearm immediately after shooting. We do not recommend carrying this firearm with a cartridge in the chamber. Remember ALL safeties on this firearm are mechanical devices and they can fail. You should never depend on a Safety device. Instead, depend upon safe firearm handling procedures, many of which are described in this manual.

REMOVING AND INSTALLING THE BOLT

Lift the bolt (unlock it) and pull it straight back. Depress the bolt stop release on the left side of the action with muzzle pointing away from you (see figure 2) and remove the bolt. Install the bolt by aligning the bolt lugs in the action raceways and push it forward. There is no need to depress the bolt release.





Figure 2 – The bolt stop release

DISASSEMBLING THE BOLT

Put the safety in the middle position and remove the bolt from the rifle.

IMPORTANT: Do not try to disassemble the bolt without the safety being in the middle position.

Depress the locking button on the left-hand side of the bolt sleeve, rotate the bolt counter-clockwise until the bolt sleeve and firing pin can be pulled from the bolt.

IMPORTANT: Disassembly of the bolt is not required or recommended for normal maintenance. The exception is if the rifle has been submerged in water.

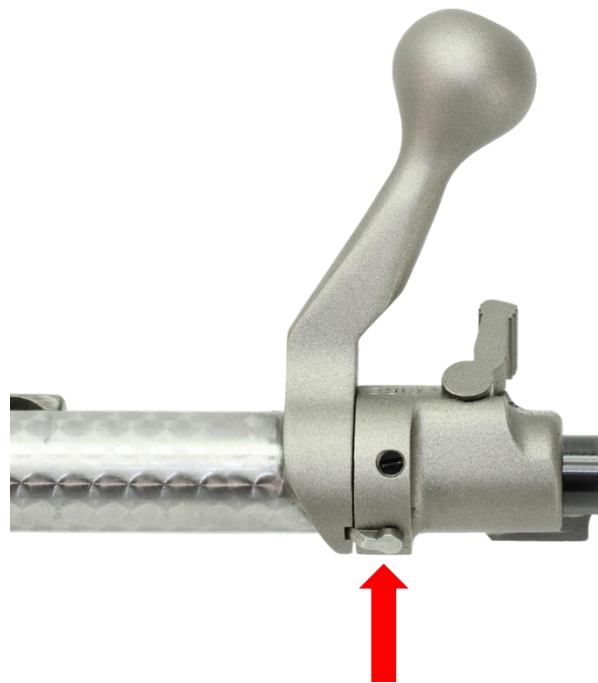


Figure 3 – Bolt sleeve locking button



REMOVING THE BARRELED ACTION FROM THE STOCK

The barreled action can be removed from the stock by removing the action screws, raising the bolt handle, and lifting the action from the stock.

IMPORTANT: Removing the barreled action from the stock is not required or recommended for normal maintenance. The exception is if the rifle has been submerged in water or exposed to heavy rain.

IMPORTANT: Disassembly of the magazine floorplate, follower and spring is not recommended as incorrect reassembly will cause the rifle not to feed properly.

INSTALLING THE BARRELED ACTION INTO THE STOCK

CAUTION: Improper installation of the barreled action into the stock may result in loss of accuracy, cracked stock or complete failure of the stock. If you remove your action from your stock, it is essential you follow these steps when reassembling your rifle.

IMPORTANT: The barreled action should be fully assembled, other than the bottom metal, before it is placed into the stock. Do not attempt to install the magazine box after the action is in the stock.

For wood stocks without pillars:

1. Bump the action aft in the stock so you know the recoil lug is sitting against the inletting of the stock.
2. Torque the front screw to 10 inch lbs.
3. Torque the middle screw to 10 inch lbs.
4. Torque the rear screw to 10 inch lbs.
5. Torque the front screw to 40 inch lbs
6. Torque the middle screw to 20 inch lbs.
7. Torque the rear screw to 40 inch lbs.

For synthetic stocks and wood stocks with pillars:

1. Bump the action aft in the stock so you know the recoil lug is sitting against the inletting of the stock.
2. Torque the front screw to 15 inch lbs.
3. Torque the middle screw to 15 inch lbs.
4. Torque the rear screw to 15 inch lbs.
5. Torque the front screw to 45 inch lbs
6. Torque the middle screw to 20 inch lbs.
7. Torque the rear screw to 45 inch lbs.



For rifles with just 2 action screws:

1. Bump the action aft in the stock so you know the recoil lug is sitting against the inletting of the stock.
2. Torque the front screw to 15 inch lbs.
3. Torque the rear screw to 15 inch lbs.
4. Torque the front screw to 45 inch lbs
5. Torque the rear screw to 45 inch lbs.

TRIGGERS

Your new PRE64WIN.COM HIGH COUNTRY rifle is equipped with one of the following triggers:

- Factory Winchester trigger
- Timney #401
- Canjar 70-1A
- Jewell M70W-2A

Unless you have requested otherwise, your trigger has been set to a pull weight between 3.0 lbs and 3.5 lbs. Each of these triggers can be set to a range between 1 and 4 lbs. For best performance and safety, PRE64WIN.COM recommends a minimum trigger weight of 2.5 lbs. Trigger adjustments should always be done by a qualified gunsmith. Any alteration to the trigger, the cocking piece, or substitution of different triggers will VOID the rifle warranty and may render the rifle inoperable or UNSAFE.

BARREL BREAK-IN

Your rifle has been test-fired and checked for evidence of fouling. No more than 25 additional rounds should be required to complete the break-in process. A properly broken in barrel will resist fouling and retain its accuracy better than a barrel which has not been broken in.

Break-in can be completed by using the following process over the next 20-25 rounds:

1. Fire up to 3 rounds.
2. Push a cotton patch wet with solvent through the barrel. This will remove much of the powder fouling and wet the inside of the barrel with solvent.
3. Wet a bronze brush (not a nylon brush) with solvent and stroke the barrel 5-10 times.
4. Push another wet patch and then a dry patch through the bore.



5. Wet the bore with a strong copper removing solvent on a nylon brush. Let this sit for up to 5 minutes.
6. Run a dry patch through the bore. Repeats steps 5 and 6 until no blue/green copper is seen on the patch.
7. Repeat steps 1 through 6 until evidence of copper fouling has stopped. When copper fouling has stopped, your barrel is completely broken in.

CLEANING

Once break-in is complete, clean the bore at an interval of every 10-25 rounds.

Normal cleaning:

1. Push a cotton patch that is wet with solvent through the barrel.
2. Wet a bronze brush with solvent and stroke the barrel 5-10 times.
3. Push another wet patch and then one dry patch through the bore.
4. Push an oiled patch through the bore before storing the rifle

A bronze bore brush will not damage your bore and will be more effective for cleaning than a nylon brush. However, a nylon brush should be used whenever applying a copper solvent.

Use a strong copper solvent and nylon brush every 200 rounds to remove any accumulated fouling.

Use a plastic coated or soft metal cleaning rod to prevent damage to your bore. Never use steel rods or steel jags for cleaning.

IMPORTANT: A bore-guide should always be used when cleaning the rifle in order to prevent the cleaning rod from damaging the throat of your barrel (see Figure 4). Never push a cleaning rod into the barrel from the muzzle end.



Figure 4 – a bore guide for cleaning



MUZZLE DEVICES AND CROWN

WARNING: Never fire a rifle with damage to the crown or muzzle break.

The crown of your rifle barrel is a precision machined feature and should be carefully protected from damage. Never insert anything into the muzzle of your rifle which may damage the crown. Never clean your bore by inserting the rod from the muzzle end. Preserving the integrity of your crown will help to preserve the accuracy of your rifle.

If your rifle is equipped with a muzzle break or other muzzle device, always inspect the device before firing the rifle.

GENERAL CARE

The PRE64WIN.COM HIGH COUNTRY rifle is designed to handle nearly all environmental conditions commonly encountered in the field. Keep all metal parts of your rifle clean and well oiled. This is particularly important in adverse climates and conditions. Rust represents neglect! Rust in the barrel and/or chamber can cause excess pressures resulting in serious injury. Any parts showing evidence of rust or other signs of serious wear should be replaced. Replacement parts are available from PRE64WIN.COM. To ensure lifelong accuracy, always clean the barrel thoroughly after each shooting session.



LIMITED LIFETIME WARRANTY

PRE64WIN.COM warrants to the original purchaser of a PRE64WIN.COM rifle against any and all manufacturer's defects in material and workmanship that affect reasonable operation for the lifetime of the firearm. This warranty is non-transferrable from the original purchaser to subsequent owners. Limited lifetime warranty does not apply to any accessory items.

Warranty claims may be made by contacting Customer Service at support@pre64win.com for a Return Authorization prior to delivering the unloaded firearm to PRE64WIN.COM. All shipping costs for warranty claims with a Return Authorization number must be paid by the owner. Firearms and ammunition must be shipped separately. PRE64WIN.COM will repair or replace only those parts determined to be defective by PRE64WIN.COM. This warranty does not apply to normal wear and tear of any parts or protective finishes.

The following are specifically excluded from coverage under this warranty and will cause the warranty to become null and void:

- Damage or malfunction resulting from accident, negligence, misuse or unauthorized repair or alteration.
- Barrel obstruction, use of ammunition other than labeled for use with the specific firearm and imported or factory re-manufactured ammunition.
- Failure to provide reasonable and necessary maintenance as described in the Owner's Manual accompanying the firearm.
- Rust or corrosion.
- Use of replacement parts other than parts authorized by PRE64WIN.COM for use in PRE64WIN.COM firearms, any unauthorized repair or any alteration, including of a cosmetic nature, performed on the firearm by an individual, organization, company or entity other than PRE64WIN.COM.
- Any finished products that are not assembled at our facilities or are assembled using imported or used parts.
- Normal wear and tear



DISCLAIMER OF LIABILITY

PRE64WIN.COM WILL NOT BE RESPONSIBLE FOR INJURY, DEATH, OR PROPERTY DAMAGE RESULTING FROM EITHER INTENTIONAL OR UNINTENTIONAL DISCHARGE OF THIS FIREARM.

PRE64WIN.COM WILL NOT BE RESPONSIBLE FOR THIS FIREARM'S FUNCTION WHEN USED FOR PURPOSES OR SUBJECTED TO TREATMENT FOR WHICH IT WAS NOT DESIGNED.

PRE64WIN.COM WILL NOT HONOR CLAIMS INVOLVING THIS FIREARM WHICH RESULT FROM CARELESS OR IMPROPER HANDLING, UNAPPROVED ALTERATION OR PARTS REPLACEMENT, CORROSION, NEGLIGENCE, THE USE OF INCORRECT CALIBER AMMUNITION, THE USE OF AMMUNITION OTHER THAN AN ORIGINAL HIGH GRADE COMMERCIALY MANUFACTURED AMMUNITION.

PRE64WIN.COM WILL NOT ACKNOWLEDGE CLAIMS INVOLVING THIS FIREARM FOR ANY REASON OR CAUSE WHEN SUCH CLAIMS ARE MADE BY THE SECOND OR SUBSEQUENT OWNER, OR ANY OTHER PERSON OR ORGANIZATION. BEFORE THIS FIREARM LEFT PRE64WIN.COM IT WAS CAREFULLY INSPECTED, TESTED AND PACKAGED.

PRE64WIN.COM CANNOT BE RESPONSIBLE FOR PRODUCT HANDLING AFTER IT IS OUT OF PRE64WIN.COM CONTROL, THEREFORE, PLEASE EXAMINE THE FIREARM CAREFULLY AT THE TIME OF PURCHASE TO ENSURE THAT IT IS UNLOADED AND UNDAMAGED; THIS IS YOUR RESPONSIBILITY. THE DEALER CAN ASSIST YOU IN MAKING THIS EXAMINATION AND ANSWER ANY FURTHER QUESTIONS YOU MAY HAVE. IF YOU HAVE SPECIFIC QUESTIONS CONCERNING THE STATE OF THE FIREARM WHEN IT WAS SHIPPED, CONTACT PRE64WIN.COM IMMEDIATELY.

KEEP THIS INSTRUCTION MANUAL WITH YOUR FIREARM AT ALL TIMES AND IT SHOULD BE TRANSFERRED WITH THE FIREARM UPON CHANGE OF OWNERSHIP. WE HOPE YOU SAFELY ENJOY YOUR NEW PRE64WIN.COM FIREARM. READ THIS MANUAL AND FOLLOW THE INSTRUCTIONS FOR YOUR SAFETY AND THE SAFETY OF OTHERS.

PRE64WIN.COM HEREBY DISCLAIMS ANY IMPLIED WARRANTIES, INCLUDING THE IMPLIED WARRANTY OF MERCHANTABILITY AND THE IMPLIED WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE.



PRE64WIN.COM and its employees are not responsible for any damages suffered, including but not limited to incidental or consequential damages, medical expenses, temporary or permanent injuries suffered as a result of the use of its firearms, if such damages were due to the negligence of the user and/or the result of any repair, adjustments or modifications to the product(s) that were not authorized, in writing, by PRE64WIN.COM. The foregoing warranty and disclaimer is exclusive and in lieu of all other warranties of quality, whether written, oral or implied (including any warranty of merchantability or fitness for the purpose). Some states do not allow the exclusion or limitation of incidental or consequential damages and therefore this limitation may not apply to you.

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