

MTAINTAIN EAGLE RIFLE™



OPERATORS MANUAL



MAGNUM RESEARCH, INC.



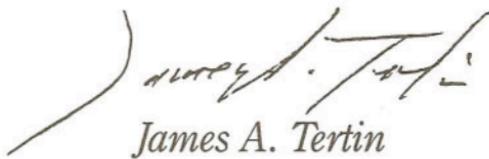
The new Mountain Eagle™ Rifle, from Magnum Research, is the last word in state-of-the-art technology. What we are offering is an off-the-shelf custom rifle.

Magnum asked me to design and build them a prototype rifle last year. I built them a custom rifle, the same as I would have for any one of my customers.

I selected the top quality krieger-cut rifled barrels, a modified Sako action, and built them a custom stock with proper dimensions for shooting a scope.

I pillar bedded the original prototype and used a Platform Bedding™ system in the first rifle as well. Magnum was able to take that rifle and put it into production.

This rifle is top quality. In my 24 years as a gunsmith, I can't think of any other factory rifle - at any price - that gives you what this rifle will deliver. I hope you enjoy shooting it as much as I enjoyed building it.



James A. Tertin

INDEX

Index	1
Technical data	2
Identification	3
Maintenance before use	4
Operation	5
Loading the magazine	6
Standard trigger mechanism	6
Trigger adjustment	6
Cleaning your rifle	7-8
Breaking in your barrel	8
Bolt disassembly and reassembly	9
Maintenance Procedures	10
Exploded drawing	11
Parts List	12

TECHNICAL DATA

TWIST RATE

.270 Win	1 in 10
.280 Rem.....	1 in 9
.30-06	1 in 10
.7 mm	1 in 9
.300 Win Mag	1 in 10
.300 Wby Mag	1 in 10
.338 Win Mag	1 in 10
.340 Wby Mag	1 in 10

Overall length	44"
Barrel length	24"
Weight	7.15 lbs. <i>(varies with caliber)</i>
Cartridge capacity	
Long Action	(1 in chamber and 5 in magazine)
Magnum	(1 in chamber and 4 in magazine)

OWNER'S MANUAL

HANDLING THE RIFLE

When holding the rifle, check that it is not loaded by opening and drawing back the bolt. All weapons, even unloaded ones, have to be handled carefully. Remember that most accidents happen with an "UNLOADED GUN."

IDENTIFICATION (Fig. 1)

You will find the model and serial number of the rifle stamped on the side of the receiver, while the caliber is shown on the barrel.

NOTE: Make sure you have ammunition of the correct caliber for your rifle, and that the chamber and bore are clean of any obstruction including water or excessive oil.

STORAGE

Always store your gun in a secure, dry place, where it will not be damaged and where children and unauthorized persons cannot gain access to it. Keep cartridges separately in a secure place.

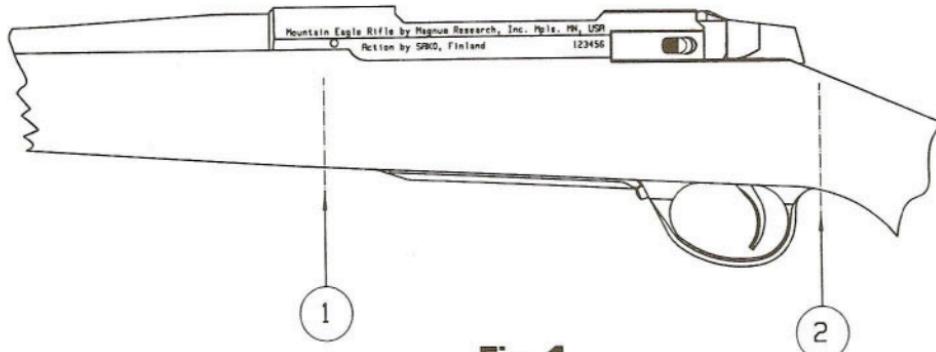


Fig. 1

GENERAL INFORMATION

The new Mountain Eagle™ rifle was designed to incorporate modern manufacturing technology while maintaining Sako's traditional old-world-craftsmanship. All Mountain Eagle™ rifles feature fixed magazines with a hinged floor plate, and ejection is achieved through the use of traditional and reliable mechanical ejectors.

MAINTENANCE BEFORE USE

- Clean the oil from the barrel by inserting a dry patch into the breech end of the barrel.
- Clean extra oil from the bolt and breech area in the action.
- Check that the recessed bolt space and locking lugs (marked A) are clean. Make sure however that all areas (A - C) are lightly lubricated.
- Check the tightness of fastening screws 1 and 2 (Fig. 1 – page 3).
- The barrel is free floating from start of barrel contour.

- When inserting the bolt into the receiver, the guiding strip should be in line with the left locking lug.
- The bolt is released from the rifle by pulling the bolt backwards and simultaneously pressing the bolt release button.

After performing the above check points, your rifle is now ready for test-firing. However, if a telescopic sight is to be used, attach mounts and scope prior to test-firing.

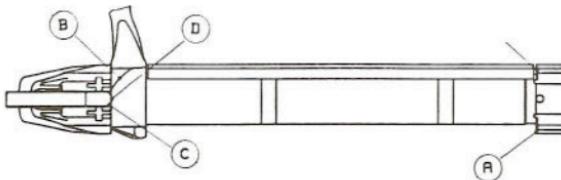


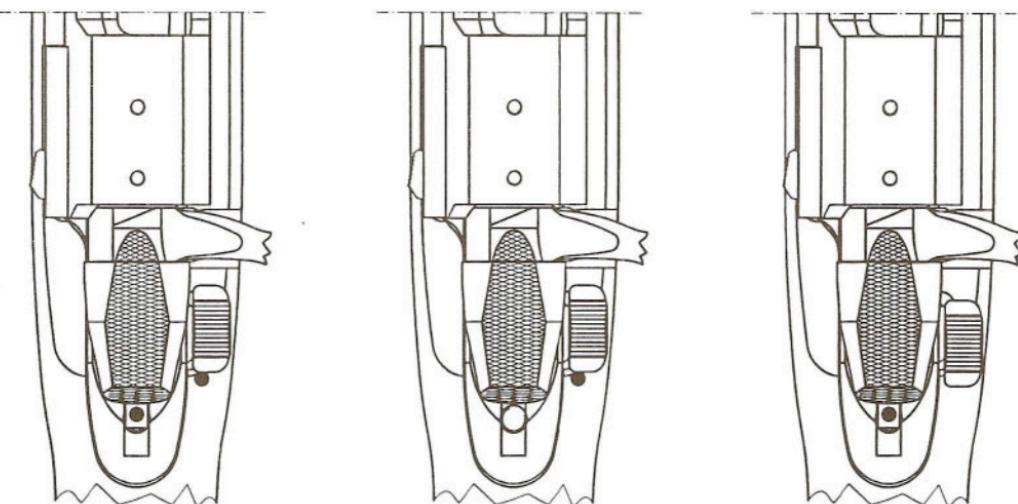
Fig. 2

GENERAL INFORMATION

OPERATION

- Loading is performed in the usual manner for a bolt-action rifle. The action is opened by first raising the bolt handle and then pulling the bolt back. As the bolt is pushed forward, the cartridge is fed into the chamber and by rotating the handle downward the action is closed and the rifle is cocked.
- The safety is the usual on/off type. When engaged it also locks the bolt handle in the closed position.
- The red warning dots (Fig. 3) indicate that the rifle is cocked and IS READY TO FIRE. The safety is now in the “off” position.

Fig. 3



GENERAL INFORMATION

LOADING THE MAGAZINE

The magazine is loaded by pressing the cartridge down into the magazine when the bolt is in open position. The magazine is unloaded by pressing the magazine catch located in front of the trigger guard until the floor plate is opened and the cartridges can be removed from the underneath side.

STANDARD TRIGGER MECHANISM

- The trigger has no first pull and the trigger pressure is set at the factory to approximately 4.5 lbs.
- Both the sear engagement and safety are set at the factory and need no adjustment of any kind.
- Should you wish to alter the trigger pressure, the stock must first be detached. To do this, remove the trigger guard fastening screws.

TRIGGER ADJUSTMENT (Fig. 7)

- The trigger pull is adjustable from 2 lbs. to 7 lbs. by means of the screw 1.
- Turning the screw clockwise will increase the pressure. Turning the screw counter-clockwise will reduce the pressure. **NOTE: FOR SAFETY REASONS DO NOT ATTEMPT TO REDUCE TRIGGER PRESSURE BELOW 2 LBS.**
- When assembling the firearm always remember to put the aluminum recoil block into place in the stock.

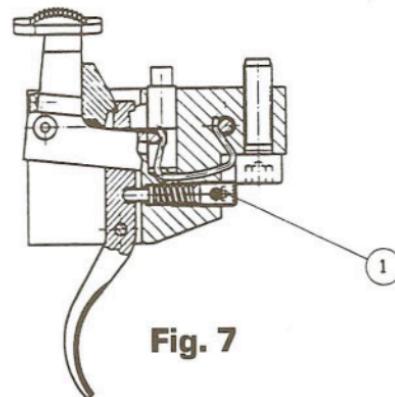


Fig. 7

GENERAL INFORMATION

CLEANING YOUR MOUNTAIN EAGLE RIFLE™

Your Mountain Eagle™ Rifle has a state-of-the-art cut rifled barrel; cleaning it regularly will help preserve its life and accuracy. We recommend the following:

1. Use a one-piece steel rod, a good bronze brush, a bore guide, a good solvent, cotton patches and a light rust preventing oil.
2. The correct procedure for cleaning your rifle barrel is as follows:
 - A. Always clean from the breech.
 - B. Be sure your rifle is unloaded.
 - C. Remove the bolt.
 - D. Install the bore guide.
 - E. "Wet" the bore with a good solvent.
 - F. Install the correct caliber brush on your one-piece steel rod and saturate the brush with solvent. Insert the brush into the rear of the bore guide and push all of the way

through the barrel so it protrudes from the muzzle. Pull it back through all of the way into the bore guide. Repeat this procedure and figure roughly one stroke with the brush for each shot fired.

- G. Once brushing is completed, push cotton patches through the barrel until the cotton patches come out clean.
- H. *Lightly* oil a cotton patch with a good rust preventing oil and push it through the barrel, leaving a super thin film of preventive oil in your bore.
- I. Remove your bore guide.
- J. Put a light film of oil on exterior metal parts to prevent rust. The bore guide serves two important purposes. It aligns your cleaning rod with the bore of your rifle so the rod does not damage the throat of your chamber by rubbing on it as you brush your barrel. Secondly it keeps solvent and dirt from falling into the

GENERAL INFORMATION

CLEANING continued

magazine of your rifle. **DO NOT** mix solvents; select a good one and use it regularly. Some solvents are extremely corrosive when mixed or used with each other.

When your rifle is cleaned and lightly oiled, check the guard screws. Keep them tight, remembering always to tighten the front one first. If you clean your barrel every 40 shots you will maintain the accuracy of your Mountain Eagle™ Rifle and it will always be a pleasure to shoot. Good Hunting.

BREAKING IN YOUR BARREL

Your Mountain Eagle™ Rifle has a hand lapped cut-rifled barrel. We recommend a simple one time break-in procedure. For the first 40 shots fired through the barrel, clean it every two or

three shots. Follow the cleaning steps outlined on pages 7-8. Once this is done, your "break-in" time is over and it never has to be repeated. Then you can follow regular cleaning and maintenance schedule.

Properly breaking in a new barrel insures consistent shot to shot accuracy and will help in reducing fouling of the bore as you shoot your rifle in the future. You may even notice a smaller group after your rifle barrel is shot in properly. Always remember — clean rifle barrels are directly related to accurate rifle barrels.

GENERAL INFORMATION

BOLT ASSEMBLY AND REASSEMBLY

It is not generally necessary to disassemble the bolt, but if there is reason to believe that oil may have penetrated the bolt causing stiffness, it should then be cleaned. If you intend to use the weapon in cold weather, cleaning the bolt is particularly important.

Having removed the bolt from the weapon, the firing pin assembly is removed by turning the bolt shroud counter-clockwise until its locking notch is disengaged from the bolt body and the

firing pin assembly can be removed from the bolt. Normally it is not necessary to disassemble the bolt any further for cleaning purposes.

Having cleaned the bolt, to reassemble, reverse the order. First insert the firing pin assembly into place, making sure that the locking notch of the bolt shroud fits in its space in bottom of the cocking slope (Fig. 8). The bolt shroud is then pushed against the bolt and turned simultaneously clockwise until the cocking piece cam stops in the notch (D - Fig. 9) before the cocking slope.

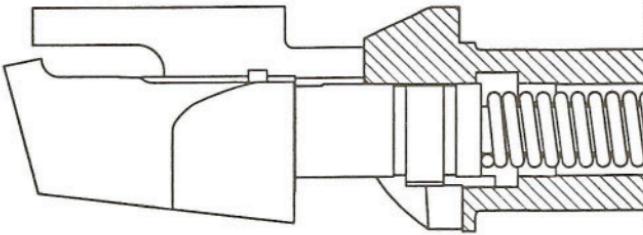


Fig. 8

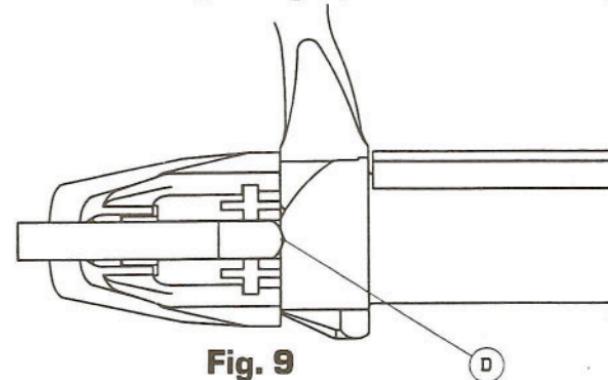


Fig. 9

MAINTENANCE PROCEDURES

By following the few simple maintenance procedures listed below, the Mountain Eagle™ Rifles will provide a lifetime of service.

1. Use only the best quality gun oil which can clean, protect and lubricate.
2. Corrosion can begin within 24 hours if the rifle is not cleaned after firing. This is especially true in damp conditions.
3. At least once a year, check the tightness of all screws including stock and receiver screws.
4. Take the gun to an authorized gunsmith or directly to the manufacturer-importer if any changes in the functioning of your firearm are noticed. For example:
 - the functioning of the trigger mechanism has changed
 - the gun does not fire the cartridge (misfires)
 - the safety does not hold
5. Use only original factory spare parts.
6. When loosening or tightening screws, take care that the screwdriver is the appropriate

- size and shape so as not to damage the screw heads and the general appearance of the gun.
7. If the gun is damaged while shooting, send the gun to the dealer/importer and include:
 - an explanation of what has happened
 - the cartridge case (with which the damage occurred)
 - preferably a sample of the cartridgesIn these circumstances do not dismantle the gun.
8. Damage to guns occurs almost exclusively when using hand-loaded cartridges. If you intend to load your own cartridges make absolutely sure that you are using the correct charge and type of powder.

MRI and Sako Ltd. do not accept any liability for any damage or injuries caused by reloaded/hand loaded ammunition.

NOTES

MOUNTAIN EAGLE™ RIFLE SPARE PARTS

SPARE PART SET NO.	KEY NO.	DESCRIPTION	SPARE PART SET NO.	KEY NO.	DESCRIPTION
1	1	Receiver L691		16	Extractor plunger
	2	Barrel cal. .270 Win		17	Extractor spring
	2	Barrel cal. .280 Rem	5		Bolt guiding strip L691
	2	Barrel cal. .30-06		18	Guiding strip
	2	Barrel cal. .7 mm Rem Mag		19	Guiding strip mounting ring
	2	Barrel cal. .300 Win Mag		20	Guiding strip stop spring
	2	Barrel cal. .300 Wby Mag		21	Guiding strip turn limiting stop
	2	Barrel cal. .338 Win Mag		22	Turn limiting stop spring
	2	Barrel cal. .340 Wby Mag	8		Bolt release complete
3	3	Bolt body L691		23	Bolt release
	3	Bolt body L691 Mag		24	Mounting screw M3.5x7.5
4	4	Stock complete		25	Trigger guard assembly L691
1		Trigger mechanism complete	10		Spare parts for trigger guard
	5	Trigger mechanism		26	Assembling screw M3.5x7.5 2 pcs
	6	Fastening screw M6x20		27	Magazine floorplate catch
2		Spare parts for standard trigger mechanism		28	Floorplate catch spring
	7	Trigger spring		29	Pin 2.5x16
	8	Trigger spring set screw M5x10	11		Magazine follower with spring L691
	9	Trigger sear spring		30	Magazine follower
	10	Safety lever spring		31	Magazine spring
	11	Safety silencer		32	Magazine box L691
4		Extractor		32	Magazine box L691 mag
	15	Extractor	12	33	Recoil block

EXPLODED VIEW

