
SHAW CUSTOM RIFLES
Mk X - Mk VII BOLT ACTION RIFLE
INSTRUCTION MANUAL

Congratulations on your purchase of a Shaw Precision Rifle. You are now part of the Shaw family of quality firearms. This includes: Shaw Precision Rifles, Shaw Custom Barrels, and Shaw OEM Division.

SECTION 1: 10 Commandments of Shooting Safety

SECTION 2: Basic Functions

SECTION 3: Warranty Information

The following is only a guide to break in a rifle barrel based on our experience, and is *not* intended as a complete step by step instructional tool. This procedure is pertaining to centerfire rifle barrels. Variables including caliber, barrel material, bullet design, velocity, etc. will all affect the break in necessary. Some combinations will require more cleaning cycles and some less. *One* cleaning procedure is to run a cotton patch wet with solvent through the barrel and let sit for a few minutes. Follow with a soft brush or cotton patch rolled around a brush with solvent. Proceed with 8-10 passes through the barrel and discard the dirty patch. At this point run clean patches through the bore until the patch comes out clean. Initially you should perform the “Shoot one shot, clean, and cool” cycle 10 times, cleaning and allowing the barrel to cool between each shot. After initial shots, shoot two shots and clean, then a second two shots and clean. At this point you should have six rounds left in a standard box of 20 rounds. These last six can be used for final zeroing with two groups of three to be sure your scope is sighted in. This procedure effectively helps smoothen out and fill in any micro pores in the steel. Please note that using extremely harsh solvents can permanently damage a barrel. The use of *any* type of fire lapping bullets automatically voids all warranty. If a light abrasive paste is used be sure to remove all traces of paste before shooting again.

(10) 1 Shot, clean, cool (2) 2 Shots, clean, cool (2) 3 Shots, clean, cool

SECTION 1: TEN COMMANDMENTS OF SHOOTING SAFETY

FIREARM SAFETY DEPENDS ON YOU-ALCOHOL, DRUGS, AND GUNS DON'T MIX

From the time you pick up a firearm, you become part of a system over which you have complete control. You are the only part of the system that can make a gun safe or unsafe. You can help meet this responsibility by enrolling in hunter safety courses or other firearms safety courses. A list of local offerings can be found at firearmtraining.nra.org. You must stress safety when handling firearms, especially to children and non-shooters. Develop safe shooting habits and remember firearm safety is up to you.

1. ALWAYS KEEP THE MUZZLE POINTED IN A SAFE DIRECTION

Never point a firearm at something you do not intend to shoot. A safe direction means a direction in which a bullet cannot strike anyone or anything, taking into account ricochets and the fact bullets can penetrate walls and ceilings.

2. FIREARMS SHOULD BE UNLOADED WHEN NOT IN USE

When not in use, firearms and ammunition should be secured in a safe place, separate from each other. It is your responsibility to prevent children and inexperienced adults from gaining access to firearms and ammunition.

3. DO NOT RELY ON YOUR GUNS SAFETY

Treat every gun as if it was loaded. The safety serves as a supplement to proper gun handling and cannot possibly serve as a substitute for common sense. Never touch the trigger unless you are ready to shoot.

4. BE SURE OF YOUR TARGET AND WHAT IS BEYOND IT

Do not fire unless you know exactly what your bullet is going to or could strike. Bullets can ricochet and travel in unintended ways. Exercise extreme caution when shooting uphill. Think first, shoot second.

5. USE THE CORRECT AMMUNITION

Be absolutely certain that the ammunition you are using matches the specifications that are marked on the barrel of your rifle. Using improper ammunition can destroy a gun and cause serious personal injury or death.

6. HANDLE WITH CARE IF YOUR GUN FAILS TO FIRE

If the trigger is pulled and the gun does not fire, point the gun in a safe direction for 30 seconds. Carefully open the action and dispose of the cartridge in a safe manner.

WARNING: DISCHARGING FIREARMS IN POORLY VENTILATED AREAS, CLEANING FIREARMS, OR HANDLING AMMUNITION MAY RESULT IN EXPOSURE TO LEAD AND OTHER SUBSTANCES KNOWN TO CAUSE BIRTH DEFECTS, REPRODUCTIVE HARM, AND OTHER SERIOUS PHYSICAL INJURY. HAVE ADEQUATE VENTILATION AT ALL TIMES AND WASH HANDS THOROUGHLY AFTER EXPOSURE.

7. ALWAYS WEAR PROPER EYE AND EAR PROTECTION WHEN SHOOTING
All shooters should wear protective shooting glasses and some form of hearing protection when shooting. When disassembling a firearm, many parts are under spring tension. Wearing eye protection is recommended while disassembling.

8. BE SURE THE BARREL IS CLEAR OF OBSTRUCTIONS BEFORE SHOOTING
Before you load your firearm, open the action and be certain that there is no cartridge in the chamber. Glance through the barrel to be sure it is clear of any obstructions. If you fire and the round sounds weak or recoil feels off, cease firing immediately and look down the bore. Inspect to see if an obstruction or projectile is lodged in the barrel.

9. DO NOT ALTER OR MODIFY THE GUN, MAINTAIN YOUR GUN REGULARLY
Firearms are complicated mechanisms which are designed to function properly in its original condition. Any alteration or change (other than adjusting the AccuTrigger™) made to a firearm can lead to the firearm not functioning correctly. A gun is a mechanical device which will not last forever and is subject to wear. As such, it requires periodic inspection and service.

10. LEARN THE MECHANISM AND HANDLING CHARACTERISTICS OF THE GUN
You should always read and refer to the instruction manual you received with your gun. If you have misplaced your manual contact Shaw Custom Division at 412-221-3636 for a free copy via mail.

Firearm safety is critical. Learn good habits and don't be afraid to call out bad ones. The shooting sports offer an astounding range of activities from recreational hunting to long range precision shooting. For more information go to gunsafetyrules.nra.org.

SECTION 2: BASIC FUNCTIONS

PRIOR TO LOADING OR OPERATING, FAMILIARIZE YOURSELF THOROUGHLY WITH THESE OPERATING INSTRUCTIONS AND THE MAIN PARTS OF YOUR FIREARM.

THIS MANUAL SHOULD ALWAYS ACCOMPANY YOUR FIREARM AND BE TRANSFERRED WITH IT UPON CHANGE OF OWNERSHIP. THIS IS YOUR RESPONSIBILITY AND MAY PROTECT YOU FROM FUTURE LIABILITY.

YOUR GUN IS A MECHANICAL DEVICE WHICH WILL NOT LAST FOREVER AND IS SUBJECT TO WEAR. WHEN SOMETHING DOES NOT SOUND, FEEL, OR LOOK RIGHT, SEEK THE ADVICE OF A PROFESSIONAL GUNSMITH BEFORE ATTEMPTING TO FIRE. NEVER TAKE A CHANCE.

FAILURE TO OBEY A SAFETY WARNING MAY RESULT IN INJURY OR DEATH TO YOU OR OTHERS.

KNOW HOW TO LOCATE AND OPERATE THE SAFETY MECHANISM.

THE USE OF RELOADS, HANDLOADS, MILITARY SURPLUS, OR ANY OTHER COMMERCIAL/NONCOMMERCIAL AMMUNITION NOT MANUFACTURED TO SAAMI (SPORTING ARMS AND AMMUNITION MANUFACTURERS INSTITUTE) OR ANSI (AMERICAN NATIONAL STANDARDS INSTITUTE) SPECIFICATIONS WILL VOID THE WARRANTY.

ALWAYS BE SURE THE BARREL IS FREE AND CLEAR OF ANY OBSTRUCTIONS THAT MAY RESTRICT (OR SLOW DOWN) THE BULLET FROM LEAVING THE MUZZLE AT ITS NORMAL SPEED. THIS INCLUDES SNOW, WATER, BRUSH, STICKS, AND DEBRIS TO NAME A FEW.

NEVER PLACE THE END OF A BARREL OR SUBMERGE A FIREARM UNDERWATER, AS IT WILL CAUSE A SEVERE OBSTRUCTION. RESTRICTING, SLOWING, OR STOPPING A BULLET FROM LEAVING THE MUZZLE WILL CAUSE AN EXCESSIVE AMOUNT OF PRESSURE TO BUILD UP BEHIND IT AND MAY LEAD TO EXTENSIVE DAMAGE TO THE FIREARM OR SERIOUS INJURY TO THE SHOOTER AND BYSTANDERS MAY OCCUR. SAFE OPERATION IS YOUR RESPONSIBILITY AND CAN ONLY BE CONTROLLED BY YOU.

BOLT INSTALLATION

Right hand action described. (Left hand is the mirror image)

Bolt assemblies are specifically matched to a firearm. Using any other bolt assembly may cause extensive damage to the firearm and/or serious injury to the shooter or bystander.

1. Rotate FRONT BAFFLE to line up with BOLT GUIDE with the EXTRACTOR.
2. Pull the trigger fully rearward and hold it in that position.
3. Press down on the COCKING INDICATOR.
4. **WITH NO AMMUNITION IN THE FIREARM**, insert the BOLT into the firearm and push it forward.
5. Close the BOLT HANDLE (downward) and verify the THREE POSITION SAFETY is operational as explained in this section.

SAFETY

The safety on your Shaw Rifle has three positions.

FULL SAFE: Pull the safety button toward shooter. This blocks the trigger and locks the bolt in the closed position.

MIDDLE POSITION: The trigger is blocked and the bolt can be opened.

FIRE-SAFETY OFF: Push safety all the way forward to disengage completely.

FULL SAFE

1. The safety is in the FULL SAFE position when it has been moved fully rearward, covering the red indicator.
2. The safety should be moved in the FULL SAFE position when the bolt is closed and the firearm is ready to fire.
3. In the FULL SAFE position, the trigger is blocked from moving and the bolt cannot be opened.

WHEN CARRYING A LOADED FIREARM THE SAFETY SHOULD BE IN THE FULL SAFE POSITION.

THE ONLY TIME YOU CAN BE ABSOLUTELY CERTAIN THAT A GUN CANNOT FIRE IS WHEN THE ACTION IS OPEN AND NO AMMUNITION IS LOADED.

MID POSITION

1. MID POSITION allows the bolt to be opened and cycled while still blocking the trigger.
2. The safety will move the MID POSITION when the following is performed.
 - Lift the bolt handle
 - Move the safety to the FULL SAFE position
 - Close the bolt

WHEN IN DOUBT NEVER ASSUME! WITH THE BOLT OPEN, MUZZLE POINTED IN A SAFE DIRECTION, BLADE IN THE MID POSITION, THE TRIGGER SHOULD NOT HAVE ANY REAR MOVEMENT.

SAFETY OFF – READY TO FIRE

The safety is in the OFF position when moved fully forward, exposing the red indicator.

NEVER TRANSPORT A LOADED FIREARM WITH THE SAFETY OFF

LOADING

FIREARMS SHOULD BE LOADED ONLY WHEN YOU ARE IN THE FIELD, ON THE RANGE, OR AT A SHOOTING AREA READY TO SHOOT.

KEEP THE MUZZLE POINTED IN A SAFE DIRECTION AND ONLY USE AMMUNITION THAT IS STAMPED ON SIDE OF THE BARREL.

TO LOAD YOUR RIFLE

1. With the muzzle pointed in a safe direction, insert a cartridge into the chamber.
2. Close the bolt and verify the safety is in the FULL SAFE position.
3. Insert magazine until you hear a click.
4. Close bolt and fully rotate the handle downward.

MAGAZINES

The Mk X rifle uses AI Pattern magazines. In rare occasions some modifications will be needed to make the cartridges feed correctly.

MK VII CAPACITIES

The magazine of the Mk VII Rifles is properly described as two a position (staggered), single feed type. When loading the magazine, always check to ensure that the cartridges are positioned in an alternating order with a slight amount of vertical play. Failure to do so could result in difficulty closing the bolt or the rifle to feed properly.

TOP LOADING

1. With the muzzle in a safe direction, place the safety in MID SAFE.
2. Load the correct caliber cartridges into the magazine by pressing downward. Continue with the desired amount of rounds.
3. Moving the bolt handle forward will push the first round from the magazine to the chamber.
4. An additional round can be topped off by inserting a round directly in the chamber and closing the bolt while pushing down on the rounds in magazine

The Mk VII VS line of rifles does not have an internal magazine. Rounds are single fed into the action.

<u>TYPE</u>	<u>MAG CAPACITY</u>		<u>IN CHAMBER</u>
Small Caseheads (17 Rem, 204 Ruger, 223 Rem)	4	+	1
Standard Caseheads (308 Win, 7x57, 30-06)	3	+	1
284 Win and Derivatives (6/284, 6.5/284 284 Win)	2	+	1
Standard Magnum Caseheads (Rem, Win Mag, WBY, Norma)	2	+	1

Occasionally due to dimensional differences between similar sized cartridges, it may be possible to load one additional round into the magazine beyond the recommended capacity. We strongly discourage this practice as it may lead to the firearm jamming at a critical moment.

TO FIRE

SHAW PRECISION RIFLES OFFERS FIREARMS WITH AN ACCUTRIGGER™. THIS IS A SPECIALLY DESIGNED USER ADJUSTABLE TRIGGER. AT THE LOWER SETTINGS SUCH FIREARMS ARE TO BE CONSIDERED TARGET FIREARMS.

IT IS THE SOLE RESPONSIBILITY OF THE SHOOTER TO EXERCISE EXTREME CARE WHILE ADJUSTING/HANDLING THESE FIREARMS. SHAW PRECISION RIFLES ACCEPTS NO RESPONSIBILITY/LIABILITY FOR DIRECT AND/OR CONSEQUENTIAL DAMAGE AND/OR INJURY RESULTING FROM THE MISUSE AND/OR MISHANDLING OF A FIREARM.

AS WITH ANY PRECISION TUNED MECHANICAL DEVICE, PERIODIC INSPECTION/MANITENANCE IS REQUIRED. WITH SAFETY AS OUR PRIMARY CONCERN, THE ACCUTRIGGER™ DESIGN REQUIRES THE SHOOTER TO PLACE THEIR FINGER SQUARELY OVER THE ACCUTRIGGER™. PULLING THE TRIGGER FROM THE SIDE AND NOT DIRECTLY REARWARD WILL CAUSE THE SEAR TO DISENGAGE AND BE BLOCKED BY THE ACCURELEASE™. A CLICK MAY BE HEARD, THE SEAR IS BLOCKED, PREVENTING THE FIRING PIN FROM HITTING THE PRIMER. WHEN THIS HAPPENS, THE BOLT MUST BE RAISED AND LOWERED TO RECOCK THE FIREARM.

DO NOT MOVE THE SAFETY FORWARD TO THE **FIRE** POSITION UNTIL YOU ARE READY TO SHOOT. THE ONLY TIME YOU CAN BE ABSOLUTLEY CERTAIN THAT A GUN CANNOT FIRE IS WHEN THE ACTION IS OPEN AND IT IS COMPLETELY EMPTY OF AMMUNITION. NEVER TOUCH THE TRIGGER UNTIL YOU ARE READY TO SHOOT.

NEVER POINT A FIREARM AT SOMETHING YOU DON'T INTEND TO SHOOT.

WE DO NOT RECOMMEND THE USE OF LEAD SLEDS WITH HEAVY RECOILING CARTRIDGES. ITEMS LIKE THEM LIMIT THE "FREE RECOIL" NEEDED FOR THOSE ROUNDS. THEY LIMIT THE MOVEMENT OF THE RIFLE AND CAN LEAD TO CRACKED STOCKS.

FIRING THE RIFLE

1. Keep your finger off the trigger and out of the trigger guard until you are ready to shoot.
2. Always look carefully around to be sure that no one will cross in front of you when you are ready to shoot.
3. Place the firearm to your shoulder and move the safety to the FIRE position and take aim.
4. Place your finger in the trigger guard and when you are on target squeeze the trigger slowly.

NOBODY CAN CALL A BULLET BACK

5. Pull up and fully rearward on the bolt handle to open the bolt and extract the fired case. The Mk X Rifle features a fixed ejector, racking the bolt at different speeds will eject the spent brass differently.
6. Moving the bolt handle forward will push the next cartridge from the magazine and into the chamber.
7. When done firing, move the safety fully rearward to FULL SAFE.

UNLOADING THE MK X RIFLE

1. WITH THE MUZZLE POINTED IN A SAFE DIRECTION, move your finger completely away from the trigger. Move the safety to the MID SAFE position.
2. Remove the magazine from the rifle.
3. If a live round is in the chamber, open the bolt and pull it rearward. This will eject the live round.

UNLOADING THE MKV II RIFLE

1. Place the rifle in the MID SAFE position.
2. WITH THE MUZZLE POINTED IN A SAFE DIRECTION open the bolt and pull it to the rear to eject the live round. The next round can then be fully chambered or simply bumped up with the bolt to pop the round from the magazine.
3. Verify the magazine is completely empty and the chamber is clear.

LOOK AND FEEL! BE SURE THE CHAMBER IS CLEAR. PHYSICALLY AND VISUALLY INSPECT.

ACCUTRIGGER™ DIRECTIONS

1. If a magazine is in the rifle, remove it by depressing the lever on the bottom metal and pulling down.
 2. Using a 5/32" Allen wrench, loosen and remove the two screws securing the stock. The bottom metal does not need to be removed. Mk VII VS rifles have three screws.
 3. Remove the stock. Since the barreled action is glass bedded a light tap may be needed to free it from the stock.
 4. Insert the ACCUTRIGGER™ adjustment tool into the rear spring at the rear of the trigger.
 5. To adjust the trigger towards the higher range of pull, turn the tool clockwise. The maximum trigger pull is at the point where the spring clicks when rotated.
 6. To adjust toward the lower end of pull, turn the tool counter clockwise. The minimum trigger pull is at the point where the large coil contacts the top surface of the trigger and you can detect some resistance.
- THE TRIGGER SHOULD NOT BE ADJUSTED PAST THESE LIMITS.
7. The ACCURELEASE™ adds an additional level of safety by stopping the sear if the rifle is accidentally jarred or dropped with the safety in the FIRE position.
 8. Follow the steps in reverse order to reassemble the rifle.
 9. If the bolt does not close, the screws are reversed.
 10. WITH THE RIFLE CLEARED, rack the bolt several times and ensure each position of the safety works correctly.

SHAW PRECISION RIFLES RECOMMEND THE LOWER SETTING BE USED ONLY FOR CONTROLLED PRECISION SHOOTING DUE TO THE SENSITIVITY OF THE TRIGGER AND SEAR. WHEN SHIPPED FROM THE FACTORY AT THE LOW SETTING, EXCESSIVE JARRING OR PULLING THE TRIGGER WITHOUT DEPRESSING THE ACCURELEASE™ MAY CAUSE THE SEAR TO MOVE. AS DESIGNED, THE ACCURELEASE™ WILL PREVENT ACCIDENTAL DISCHARGE BY LOCKING THE TRIGGER. THE BOLT MUST BE RECOCKED TO ENGAGE THE SEAR.

WHEN THE SEAR IS BLOCKED BY THE ACCURELEASE™ THE FIRING PIN IS RESTRAINED WITHIN THE BOLT ASSEMBLY, PREVENTING IT FROM HITTING THE PRIMER. THE CLICK THAT IS HEARD IS THE SEAR BEING BLOCKED BY THE ACCURELEASE™, NOT THE FIRING PIN.

CLEANING YOUR FIREARM

VERIFY THE RIFLE IS UNLOADED, NEVER ATTEMPT TO OIL OR WORK ON A LOADED FIREARM. CHECK WARNINGS ON CLEANING PRODUCTS BEFORE USE.

1. Prepare an area for cleaning with adequate space and ventilation. Use correct caliber cleaning rod, patches, and quality solvents/oils.
2. Remove the bolt
3. Always clean from the chamber towards the muzzle.
4. Using a small amount of powder solvent on the brush, push the cleaning rod through the barrel several times.
5. Unscrew the brush and replace with a patch tip.
6. Push a new patch thorough the bore staring from the chamber and out the muzzle.
7. Repeat the prior step (6) several times.
8. Push a lightly saturated oil patch through the bore to lightly coat the bore with oil.
9. Reinsert the bolt and verify the three positions on the safety work.

CHECK THE BORE CAREFULLY AFTER CLEANING TO BE SURE THERE ARE NO OBSTRUCTIONS SUCH AS CLOTH PATCHES OR BRUSH TIPS.

A VERY THIN COAT OF OIL IS ALL THAT IS NEEDED FOR PROTECTION. OVER OILING CAN LEAD TO THE OIL FLOWING INTO THE TRIGGER ASSEMBLY OVER TIME.

PROTECTING METAL SURFACES

1. Remove the bolt from the firearm.
2. With a soft cloth, remove any foreign matter such as mud, grass, or dirt.
3. Apply a thin coat of gun oil to exterior surfaces.
4. When accessible, clean and lightly oil interior metal surfaces.
5. A light brush can be used to clean the bolt face.
6. Place a small amount of grease on the to the rear faces of the bolt locking lugs to prevent galling of the lap mated surfaces.
7. Generally disassembly of the bolt is not required.
8. Verify the three positions of the safety are functional.

Stainless steel is not completely rustproof. In adverse conditions or lack of care it can still rust/tarnish.

SECTION 3: WARRANTY INFORMATION

STATEMENT OF LIMITED WARRANTY

Shaw Precision Rifles must be noted within one (1) year from the date of delivery of any defect in materials or workmanship encountered during normal use.

Excluded from the warranty is damage to your firearm caused by:

- Failure to provide proper care and maintenance
- Barrel obstructions
- Accidents, abuse, or misuse
- Use of handloaded or improper ammunition
- Adjustments, repairs, or modifications preformed without the expressed consent of Shaw Precision Rifles
- Normal wear and use

This warranty and the remedies set forth herein are exclusive and take the place of all other expressed or implied warranties, including and implied warranty or merchantability or fitness for any specific purpose. Shaw Precision Rifles will not pay any incidental or consequential damages under this warranty. Some state or jurisdictions do not allow exclusions of limitations on how long an implied warranty lasts. So these limitations may not apply to you. This warranty grants you specific legal rights. You may have other rights that vary from jurisdiction to jurisdiction.

RETURNING A FIREARM

It is a violation of Federal Law to ship a firearm with live ammunition in either the box or in the firearm itself. If received, by law we are required to notify The Bureau of Alcohol, Tobacco, Firearms, and Explosives.

Shaw Precision Rifles is not responsible for the loss or damage to any accessories shipped with the firearm.

If there is a question whether the firearm should be returned or parts could be purchased, please call 412-221-3636 and ask for the service department.

