

# **MONTANA FIREARMS GROUP**

**MONTANA RIFLE COMPANY**

**MODEL 1999**



**INSTRUCTION MANUAL**

*Important Instructions for*

# Model 1999 Montana Action Bolt Rifle Receiver

Montana Rifle Company  
3172 MT Hwy 35  
Kalispell, MT 59901

Use the space below to record information about your  
New Model 1999 Montana Action

Model \_\_\_\_\_

Caliber \_\_\_\_\_

Serial Number \_\_\_\_\_

Purchased from \_\_\_\_\_

Date of Purchase \_\_\_\_\_

The Montana Rifle Company would like to welcome you to the select group of individuals who have purchased a custom built rifle. We think you will be pleased with your purchase and look forward to anything we can help you out with in the future. We are extremely proud of the many years of designing and developing that went into crafting this product. The time and effort our designers spent developing this product shows in its superiority and we think you will agree. There is a new tradition in the firearms industry and it begins with you. Thank you, and if you have any questions, please don't hesitate to write or call us at our headquarters;

Montana Rifle Company  
3172 MT Hwy 35  
Kalispell, MT 59901  
(406) 756-GUNS (4867)

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This manual covers current Model 1999 versions with the original magazine system and single piece bottom metal with swinging floor plate. *The safety warnings are subject to a completed barreled action with a stock, ready to be fired.* Study these instructions carefully to be sure you have covered all information about your particular Model 1999.

Action Safety Warnings

**IT IS ESSENTIAL THAT THESE OPERATING INSTRUCTIONS BE THOROUGHLY STUDIED BEFORE USING THIS FIREARM TO ASSURE PROPER AND SAFE GUN HANDLING. FAILURE TO FOLLOW THESE INSTRUCTIONS OR FAILURE TO OBEY ANY SAFETY WARNING MAY RESULT IN INJURY TO YOURSELF OR OTHERS, OR CAUSE DAMAGE TO YOUR GUN.**

As a gun owner, you accept a set of demanding responsibilities. How seriously you take these responsibilities can be the difference between life and death. There is no excuse for careless or abusive handling of any firearm. At all times handle your action and any other firearm with intense respect for its power and potential danger.

**PLEASE READ AND UNDERSTAND ALL OF THE CAUTIONS, PROPER HANDLING PROCEDURES AND INSTRUCTIONS OUTLINED IN THIS BOOKLET BEFORE USING YOUR NEW FIREARM.**

1. Do not carry a loaded gun with a live round in the chamber while walking, running, climbing a tree, crossing a fence or anywhere you might slip or fall, drop the gun or otherwise bump or jar the gun. A gun that is dropped, bumped, or jarred with a chambered round might accidentally discharge even with the safety on, causing serious injury to you or someone else. When a round is chambered, keep the safety on until you are ready to shoot.
2. Do not rely on the safety to prevent accidental discharge. Many safeties merely block the trigger and prevent firing by pulling the trigger. The safety may not prevent accidental discharge due to dropping, jarring, or bumping a gun.
3. Use only ammunition for which the gun is chambered as indicated on the barrel, to prevent excessive pressure and possible serious personal injury.
4. Incorrectly reloaded ammunition can cause serious personal injury and damage to the firearm due to excessive pressure. Reload only after proper instruction

and in strict compliance with instruction and data contained in our current reloading manuals.

5. Never point a gun at anything you do not intend to shoot. Always keep it pointed in a safe direction in case of accidental discharge.
6. Always check to ensure that the barrel is free of obstructions before loading and using the gun. If you experience light recoil or off sound, check the barrel for obstruction.
7. Before firing, clean any grease or oil in the barrel with a cleaning rod and patch. Grease or heavy accumulation of oil can cause excessive pressure and result in serious personal injury.
8. Keep barrel, chamber and action free of rust. Rust in the barrel and chamber can cause excessive pressures resulting in serious injury. A rusted, pitted or eroded barrel should be replaced.
9. Use hearing protection to prevent ear damage from repeated exposure to gunfire.
10. Always use proper shooting glasses to prevent eye injury from flying particles.
11. Never carry a loaded gun in a motor vehicle or carry

one into a dwelling. Always carefully unload the gun before entering a motor vehicle, a dwelling or an area such as a camp. Always point a gun in a safe direction while loading or unloading to prevent serious injury in case of an accidental discharge. Never load in the house or in your vehicle.

12. Never shoot at a hard, flat surface or at the surface of water to avoid a ricochet and possible serious personal injury to yourself or a bystander.

13. Store guns in a clean dry place out of reach of children and separated from stored ammunition.

14. Never alter any parts of your gun. A qualified gunsmith should perform any alterations or adjustments that may become necessary to the operating mechanism

## GENERAL DESCRIPTION

Your new Model 1999 is one of a number of different versions and configurations offered. The basic operating procedures are the same for nearly all of them. Where there are differences they are pointed out for your convenience.

The Model 1999 is a bolt action design that allows the shooter to load a round by cycling the action and moving a cartridge from a loaded magazine to the chamber. This can be repeated until the magazine is

empty. A single round can also be inserted into the chamber manually. There are many different versions of the Model 1999. A variety of calibers are offered. Each gun is designed to shoot a specific centerfire cartridge.

Your Model 1999 is made from the design specifications developed from the imprint of a Model 70 Winchester. It has a claw extractor and controlled round feed. Every Model 1999 is equipped with a 3-position safety. This is considered by most to be the safest of all safeties in the gun business. With the safety in the middle position, the bolt can be opened and operated. In the middle position the safety remains “on safe.”

Magazine configurations vary depending on the caliber you will be shooting, whether it is a Standard Bolt face or a Magnum bolt face will determine the Magazine box.

**IMPORTANT:** Refer to figures 1A-D for general part descriptions regarding your new Action and/or Barreled Action. You must become familiar with all part names listed before proceeding with the rest of the instructions in this manual.

Safety ↓    **Action** ↓    ↓ Loading/ Ejection Port

Cocking piece →

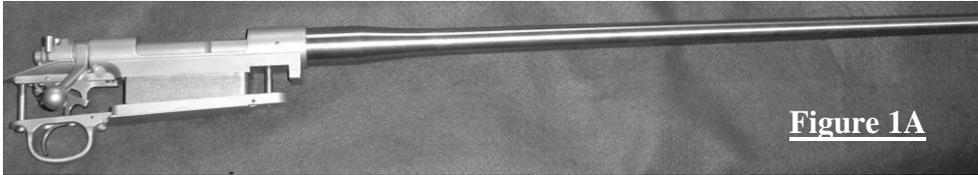


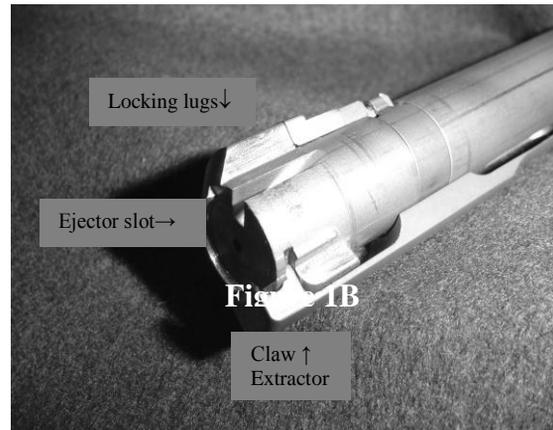
Figure 1A

Trigger & ↑  
Trigger Guard

### TERMINOLOGY AND DESCRIPTIONS

Descriptions in this manual generally refer to the gun in the historical position. That is, in the normal firing position. For example, the muzzle is forward or front; the butt stock is rear; the trigger is downward or underneath; the sight is upward or on top. For general parts terminology, refer to Figure 1-A.

The Montana Rifle Company Model 1999 is also shown disassembled to the extent necessary in order to follow instructions contained in this book (See Figure 1-B through 1-D). Figure 1-E covers the general features and benefits of the Model 1999 design.



Locking lugs ↓

Ejector slot →

Figure 1B

Claw ↑  
Extractor

The Model 1999 three position safety is still the preferred design of most gun experts – it actually blocks the firing pin and lets you open the bolt with the safety on.

←

The field-strippable firing pin mechanism is easy to inspect and service – even in the outdoors. It gives you the special confidence in extremely cold or dirty conditions.

→



Model 1999s feature the famous Pre- '64 type action with claw extraction.

←

No other competitor can give you the strength and accuracy of a button rifled and hand lapped Barreled Action. The Model 1999 Montana Action comes in both Chrome-moly and Stainless Steel. →



## SERIAL NUMBER

The serial number is located on the left side of a right handed action and on the right side of a left handed action. Take time now to record your serial number on the front page of this booklet for your records.

## AMMUNITION

The caliber of your Model 1999 Barreled Action is inscribed on the left side of the barrel on a right handed action and on the right side of the barrel on a left handed action. As stated previously, use only ammunition for which your Model 1999 is chambered – as indicated on the barrel – to prevent excessive pressure and possible serious personal injury.

The various Model 1999 actions are able to handle a large variety of different centerfire cartridges. Many cartridges have similar sounding names.

**MAKE SURE YOU ONLY USE THE EXACT AMMUNITION/CALIBER AS LISTED ON THE SIDE OF THE BARREL.**

Incorrectly reloaded ammunition can cause serious personal injury and damage to the firearm due to excessive pressure.

Reload only after proper instruction and in strict compliance with instructions and data contained in current reloading manuals.

**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. WASH HANDS THOROUGHLY AFTER EXPOSURE.**

## MAGAZINE CAPACITY

It is extremely important that you know the magazine capacity of your Model 1999. The normal capacity is for three cartridges. If it is different, your action will be supplied with alternate instructions. Under appropriate circumstances – at a range or other suitable shooting location – load your magazine to full capacity and make note of the number of cartridges. Remember, “Total capacity includes an additional round which can be loaded manually in the chamber in addition to a full magazine.

## GENERAL OPERATIONAL/SPECIAL REMINDERS

**IMPORTANT: ALWAYS KEEP THE MUZZLE POINTED IN A SAFE DIRECTION.**

Prior to using live ammunition, familiarize yourself thoroughly with these operating instructions. Get accustomed to the feel of your new gun – know the forces required to operate the action. Learn how to pull the trigger and, above all, know the location and operation of the safety. Procedures for disassembly and operation of various components are outlined in the sections below. Please read and study them thoroughly. In addition, always remember:

**USE THE CORRECT AMMUNITION REFERENCED BY THE INSCRIPTION ON THE BARREL.**

**BEFORE LOADING YOUR GUN BE SURE ALL GREASE AND OIL HAVE BEEN REMOVED FROM THE BARREL AND CHAMBER, AND THERE ARE NO OBSTRUCTIONS.**

**INSTRUCTIONS IN THIS MANUAL ARE GIVEN FOR A RIGHT-HANDED GUN, MOST**

**PROCEDURES ARE THE SAME FOR RIGHT OR LEFT-HANDED RIFLES WITH EXCEPTION OF BOLT OPERATIONS.**

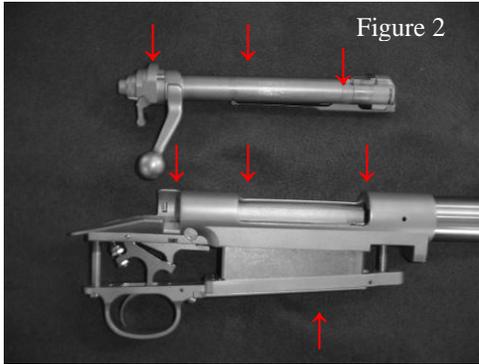
## INITIAL CLEANING

Some metal parts of your new Model 1999 have been coated at the factory with a rust preventative compound. Before using your Model 1999, clean the anti-rust compound from inside the barrel, receiver, breech bolt mechanism and the action/chamber areas. A high quality, light gun oil should be used to remove this compound and to give your new gun its first lubrication. Clean the barrel using a cleaning rod and patch, as explained under “Cleaning and Maintenance Suggestions” found later in this manual. First lubrication suggestions are outlined below.

## OILING THE ACTION

Before the first firing of your Model 1999 you should first wipe the mechanism completely clean, clean the bore and apply a few drops of quality oil on the following surfaces (see figure 2):

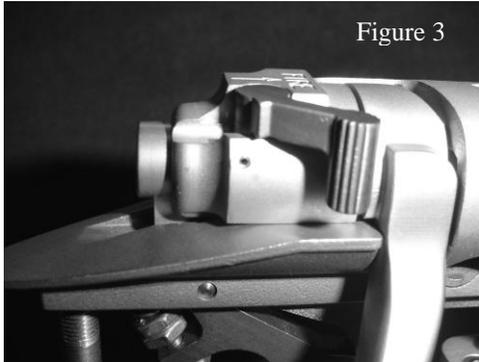
Figure 2



- Along the breech bolt surface and where the sleeve contacts the breech bolt
- Along the breech bolt surfaces on the receiver where the bolt contacts the receiver as it is worked.

Avoid applying too much oil. Only a light film is necessary. Cleaning and Maintenance Suggestions should be followed before each oiling.

Figure 3



### OPERATION OF THE SAFETY

The safety can only be operated when the firing pin is cocked. To cock the firing pin, lift up on the bolt handle and then return it to the locked position. When the firing pin is cocked, an indicator is visible at the rear of the bolt (See Figure 3).

Figure 4

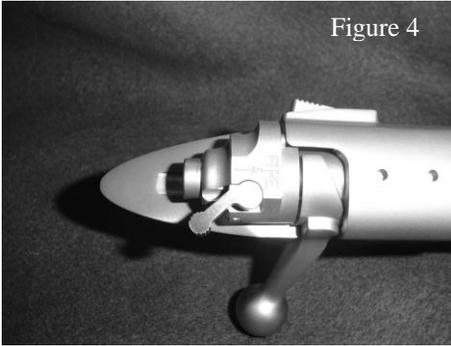
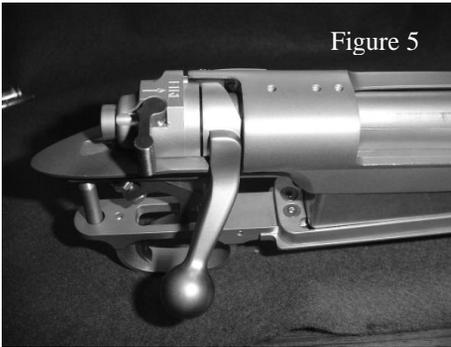
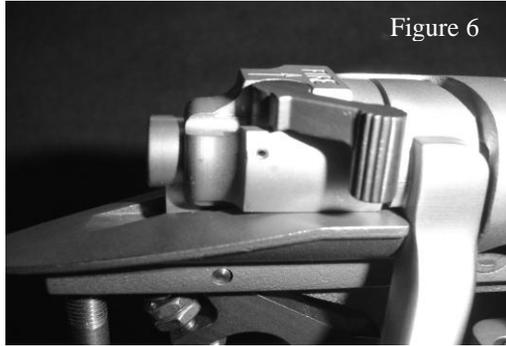


Figure 5



1. **Fully On** – This is when the safety is drawn to the most rearward position and in line with the bolt. Both the firing pin and the bolt are positively locked (See Figure 4).

Figure 6



Always maintain the safety in this position (Fully On) when carrying a loaded (cartridge in chamber or magazine loaded) Model 1999 Rifle.

2. **Intermediate Position** – This is when the safety is in a midway position (visually at a right angle to the bolt). This position locks the firing pin, but not the bolt. The intermediate position also allows for a safe removal of an unfired cartridge from the chamber or magazine (See Figure 5).

3. **Firing Position** – With the safety fully forward, the rifle is ready to fire (See Figure 6). For ease of operation, it is recommended that the safety be operated with the thumb.

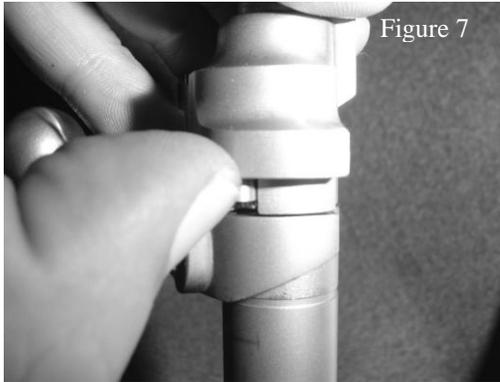


Figure 7

The safety mechanism – When it is engaged – is designed to block the firing pin and disengage the sear to prevent firing. However, this mechanism will not necessarily prevent the accidental discharge of this firearm as a result of jarring or abuse such as occurs when a firearm is dropped.

### INSTALLING/REMOVING THE BOLT

The bolt of your action may have been packed separately in the carton in which your action was shipped. You will need to insert the bolt into the action. In addition, it is always a good idea to remove the bolt before cleaning.

Consequently, becoming familiar with removing and inserting the bolt assembly quickly and easily is absolutely essential.

### **MAKE SURE THE FIRING PIN IS COCKED (FIRST INSTALLATION)—**

Before inserting the bolt for the first time, make sure the firing pin is cocked. Under most conditions it should be (and remain) cocked. When the firing pin is cocked, an indicator is visible at the rear of the bolt (Refer back to Figure 3). If the indicator is protruding from the bolt sleeve a minimum of 1/8", the firing pin is cocked. If the firing pin is not in the cocked position this means that the bolt has been partially disassembled. To remedy this simply turn the rear section of the bolt – Clockwise when viewed from the indicator end – until the breech bolt sleeve lock engages the notch in the breech bolt (see Figure 7). On a new Barreled Action where surfaces are not yet burnished from use, it may be difficult to rotate the bolt sleeve by hand. If so, carefully grasp the lower section of the firing pin in a padded vise, pull and turn.

**IMPORTANT: FULLY UNLOAD YOUR RIFLE AS EXPLAINED PREVIOUSLY. BE CERTAIN THERE ARE NO CARTRIDGES IN THE MAGAZINE OR CHAMBER.**

Removing the bolt.

Figure 8



#### REMOVE –

1. To remove the bolt the firing pin must be in the cocked position. If it already is, proceed to step 2. If not, first perform the following: With the rifle unloaded and the muzzle pointed in a safe direction, cock the firing pin by raising and lowering the bolt handle.
2. Place the safety in the intermediate position.
3. Again, raise bolt handle and draw the bolt fully to the rear.
4. Depress the bolt release mechanism located to the rear of the receiver and remove the bolt (See Figure 8).

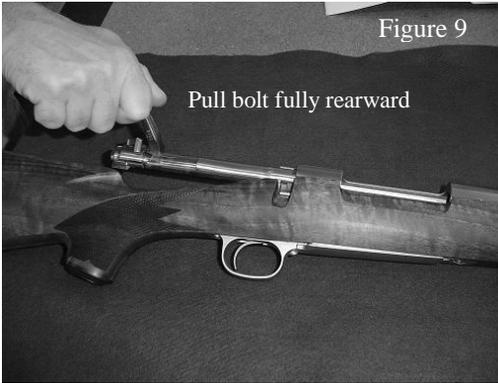
#### INSTALL—

1. Make sure the claw extractor is perfectly lined up with the right hand locking lug.
2. Insert the bolt into the receiver with the lugs on the bolt aligned with the lug tracks in the receiver.
3. Push fully forward and lower the bolt handle down to a locked position. The safety can now be operated.
4. Again, make sure the safety is already in (or placed in) either the intermediate or rear safe positions.

The Breech bolt has been carefully selected and fitted to assure correct head space (on a barreled action). It is etched with the last four digits of your Actions serial numbers for identification purposes. To assure your safety, never interchange breech bolts. You will not have the proper head space. If the breech bolt is lost or damaged, return the barreled action to the factory for replacement with a properly fitted bolt.

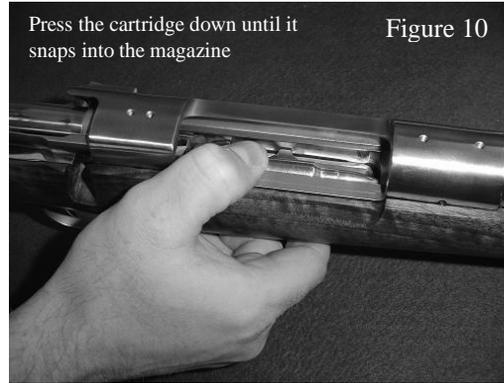
Figure 9

Pull bolt fully rearward



Press the cartridge down until it snaps into the magazine

Figure 10



### Loading Procedures

These instructions apply to the Barreled Model 1999 Montana Action that has been placed on a stock. Use the correct ammunition referenced by the inscription on the barrel. Before loading your gun, be sure all grease and oil has been removed from the barrel and chamber, and there are no obstructions.

1. With the safety in the intermediate position lift the bolt handle and pull the bolt back all the way (see Figure 9). Lay a cartridge in the receiver just forward of the bolt. Press the cartridge down with your thumb until it snaps into the magazine (See Figure 10).

Place the next cartridge on top  
and push into magazine

Figure 11



Hold down the top cartridge  
and close the bolt

Figure 12



2. Press each succeeding cartridge similarly into the magazine (see figure 11).

3. With the magazine loaded to capacity, an additional cartridge may be placed directly into the chamber only when you are ready to fire. This is done by opening the actions, inserting a round in the chamber, and pressing down on the top cartridge in the magazine as the bolt is closed (See Figure 12).

**DO NOT CARRY A GUN WITH A CARTRIDGE IN THE CHAMBER TO AVOID ACCIDENTAL DISCHARGE.**

Special note: When loading a cartridge directly into the chamber (bypassing the magazine) you will experience a slight resistance as the bolt is rotated to the locked position, and the extractor clears the cartridge rim.

#### UNLOADING PROCEDURES

Perform the following to remove cartridges from the chamber and magazine on all Model 1999 Montana Actions.

Figure 13

↓ Floor plate release

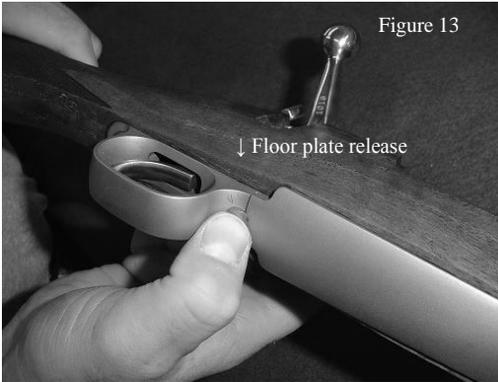
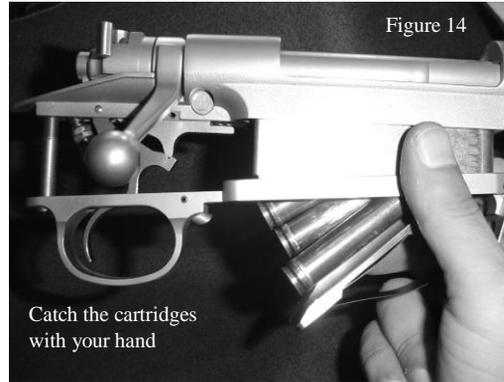


Figure 14

Catch the cartridges  
with your hand



1. With the safety in the intermediate position, open the floor plate by pressing the release mechanism in the front of the trigger guard (See Figure 13).
2. Allow the Floor Plate to swing open (downward). Allow the follower to lower until it is out of the magazine opening. This will allow any cartridges to fall into your hand (See Figure 14).
3. Lift bolt handle up and pull the bolt fully back to remove the cartridge from the chamber.

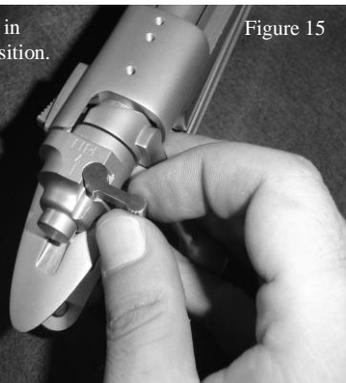
4. Carefully reposition the follower and magazine spring back into the magazine opening. Close the hinged floor plate and make sure it snaps into place.
5. Recheck the chamber to assure it contains no cartridge. If it does, cycle the action (as explained earlier) to eject the loaded round.

#### UNLOADING BY CYCLING THE ACTION

This unloading method can be used for any Model 1999.

Place the safety in intermediate position. Open action.

Figure 15



1. Place the safety in the intermediate position.

2. With the rifle pointed in a safe direction and your finger off the trigger, operate the action (See Figure 15), extracting and ejecting each loaded round from the chamber. Work the action very slowly in order to easily capture the loaded cartridges with your free hand as they are ejected. Do not eject them onto the ground. This risks damaging them and affecting accuracy.

**IMPORTANT—ALWAYS VISUALLY CHECK AND KNOW FOR SURE THAT YOUR RIFLE IS NOT LOADED. DO THIS BY LOOKING DIRECTLY INTO THE CHAMBER AND MAGAZINE WITH THE ACTION OPEN AND BOLT FULLY TO THE READ.**

### FIRING PROCEDURES

1. When ready to shoot, and with a loaded cartridge in the chamber, the safety on, and your finger off the trigger, push the safety fully forward. Your rifle is now ready to fire with a pull of the trigger.

**REMEMBER, THE RECOIL FROM A CENTERFIRE RIFLE, ESPECIALLY MAGNUM CALIBERS, WILL BE SOMEWHAT HEAVIER THAN MOST OTHER GUNS, SO FIRMLY SHOULDER YOUR GUN, TAKE AIM, AND – WHEN ON TARGET – SQUEEZE THE TRIGGER.**

2. Pull the bolt handle up and fully rearward until the fired cartridge is ejected.

Immediately move the safety to one of the “safe” positions.

Figure 16



3. Push the bolt fully forward, positioning a new cartridge from the magazine into the chamber. Lock the bolt by moving the bolt handle (knob) fully down. Your rifle is again cocked and ready to fire. Immediately put the safety in the middle or rear “on safe” positions until you are ready to fire again (see Figure 16).

### **IN THE CASE OF A MISFIRE**

Only rarely will modern factory ammunition experience a misfire. If this ever happens to you when shooting your Model 1999 please follow these instructions carefully.

**CAUTION: IN CASE OF MISFIRE, KEEP THE BARREL POINTED IN A SAFE DIRECTION, CAREFULLY OPEN THE ACTION WHILE**

**AVOIDING DIRECT EXPOSURE TO THE BREECH BY YOURSELF AND OTHERS. REMOVE THE CARTRIDGE FROM THE CHAMBER. LEAVE THE ACTION OPEN AND FULLY UNLOAD YOUR RIFLE, REMOVING ALL CARTRIDGES FROM THE MAGAZINE.**

Carefully inspect the ejected cartridge. If the primer is indented, the cartridge should be disposed of in a manner that would prevent accidental injury to you or others. If there is no indentation, your gun has malfunctioned and should be serviced by a qualified gunsmith or by The Montana Rifle Company Service Department.

### **BOLT DISSASSEMBLY**

One of the unique advantages of a Model 1999 is the ability to “field strip” the bolt for cleaning the firing pin mechanism. Under very harsh weather conditions and in dirty environments just knowing that all the firing pin parts are clean and lightly oiled can add an extra measure of confidence to your hunt.

Make sure you have a clean place to work and a good place to put the bolt components as they are disassembled.



Disassembling the bolt can be done in the field, but remember, there are small parts involved, some of which are under spring tension.

**BE CERTAIN THERE ARE NO CARTRIDGES IN THE MAGAZINE CHAMBER.**

## DISASSEMBLY—

1. To remove the bolt, the firing pin must be in the cocked position. If it already is, proceed to step 2. If not, first perform the following: With the rifle unloaded and the muzzle pointed in a safe direction, cock the firing pin by raising and lowering the bolt handle.
2. Place the safety in the intermediate position.
3. Raise the bolt and remove it from the rifle as explained previously.
4. Depress the small breech bolt sleeve lock with your thumb (see figure 17) and turn the breech bolt sleeve to the left (counterclockwise) looking from the rear of the bolt). It takes about six turns for the breech bolt sleeve (and the connected firing pin assembly) to unscrew from the breech bolt. Carefully pull the entire assembly out of the breech bolt.



5. Be extremely careful to leave the safety in the intermediate position.
6. It is not necessary or recommended that you disassemble the firing pin assembly further than this (see figure 18).
7. Carefully wipe clean and very lightly oil the assembly. Aerosol lubricants are excellent for forcing out any dirt, grit or moisture.

#### REASSEMBLY—

1. Screw the firing pin assembly back into the breech bolt until the breech bolt sleeve lock engages the notch in the breech bolt.

2. Reinsert the bolt into the receiver as previously explained.

**IMPORTANT:** Should the safety be inadvertently put in the forward (fire) position with the firing pin removed, the firing pin will be released forward and locked in the forward position. This makes reassembling the firing pin into the breech bolt somewhat more difficult.

As the breech bolt sleeve/firing pin assembly is screwed back into the breech bolt the cocking ramp of the firing pin must compress then uncompress several times before the assembly is fully screwed in. Place the breech bolt on a flat hard surface and using the breech bolt handle and the head of the bolt as a support, firmly turn the breech bolt sleeve clockwise until it snaps into position. Once the bolt assembly is installed in the action and the bolt closed and cycled, the firing pin will recock, and the safety can be moved back to the intermediate or rear position.

## CLEANING AND MAINTENANCE SUGGESTIONS

The Model 1999 will function better and more reliably over a longer period of time if it is properly maintained and kept clean.

### **BEFORE PERFORMING ANY CLEANING PROCEDURES, ALWAYS MAKE CERTAIN THERE ARE NO CARTRIDGES IN THE CHAMBER, MAGAZINE OR ACTION/FEED AREAS.**

You should clean your Model 1999 after every day of shooting and more often if it becomes excessively dirty. If shooting for extreme accuracy your Model 1999 should be cleaned after every 50 shots or even as few as every 25 shots under competitive conditions.

A minimum cleaning includes wiping down the action and oiling key parts. Most regular maintenance will also include cleaning the barrel. If you encounter a function problem (right action when working the bolt), be sure to give your gun a thorough cleaning to see if it solves the problem before seeking the services of our service facility or a competent gunsmith.

## CLEANING PROCEDURES—

### **BE CERTAIN YOUR GUN'S CHAMBER AND MAGAZINE ARE UNLOADED. ALWAYS WEAR PROTECTIVE SAFETY GLASSES DURING ALL CLEANING PROCEDURES, KEEP AMMUNITION AWAY FROM THE CLEANING AREA. DO NOT TEST THE FUNCTION OF YOUR FIREARM WITH LIVE AMMUNITION.**

Always place the safety in the intermediate “on” (safe) position before beginning any cleaning procedure. Remove the bolt from your rifle as explained previously.

1. Use a cleaning rod with a tip and patch suitable for the caliber of your barreled action's bore. Make sure the patch is large enough for a snug fit in the bore. Insert the rod and patch into the barrel at the receiver end and run it back and forth several times. Use a crown protector if you are cleaning from the muzzle end of the barrel. Damage to the crown of the barrel can affect the accuracy of your rifle.
2. Inspect the chamber and bore for brass, copper and powder fouling. A normal amount of powder residue can be expected and is not serious.

- It can usually be removed by repeating step one, using a patch saturated with solvent. If or when fouling should become heavy, it can be removed with a brass bore brush. Dip or spray the brush with solvent and scrub the chamber and bore until the fouling is removed. To prevent brass bristles from breaking off, the brush should be pushed completely through the bore before being withdrawn.
3. After fouling has been removed the bore should be wiped dry. Then pass a slightly oiled patch through the bore, for preservation. A fine, light gun oil is recommended.
  4. Wipe all exposed metal surfaces of the receiver, forearm and barrel with a clean rag. Finger marks should be removed because they provide a place where moisture can accumulate. Any dried oil in the receiver area should also be removed.
  5. Lightly oil your gun at the points described under “Oiling the Action” explained earlier in this manual. Ordinary good judgment will, of course, indicate that the metal of the gun should receive a light film of oil any time the rifle has been exposed to weather or handling. This is very important and must be done with every rifle—even stainless steel models.

Remember, the polished, finely fitted surfaces of the receiver and action mechanisms must always have a thin film of oil. Make sure that the surfaces of the breech bolt are especially clean and lightly oiled with high quality gun oil. Do not use pure silicone or lanolin.

6. Inspect the barrel and chamber. Make certain that no patches have been inadvertently left in them. Remove any that remain.
7. When transporting only, store your Model 1999 in a quality protective case to prevent scratches and debris. Store in a dry place to prevent corrosion. Store away from children.

**MAKE SURE YOUR RIFLE IS UNLOADED AND ALWAYS STORE AMMUNITION SEPERATLY.**

#### **OTHER CLEANING SUGGESTIONS---**

- Never pour large quantities of oil into the receiver or other parts. It can damage the stock and possibly the bedding compound.
- After extended periods of heavy use, your gun should be taken to a qualified gunsmith to have the action disassembled for a professional cleaning and lubrication.

**NEVER ATTEMPT TO TAKE YOUR MODEL 1999 APART FURTHER THAN EXPLAINED IN THIS MANUAL.**

This is a specialized, finely fitted mechanism. You may permanently mar it by attempting to disassemble the inner mechanism assemblies. If further disassembly for service or cleaning is required, call the Montana Firearms Group at (406) 756-4867 for instructions on where to take it.

**ORDERING PARTS**

To order parts, please write our service department and furnish the following: name, address, and telephone number. Also specify the caliber, model, and serial number of your Model 1999. When we receive your request, we will send an order form and a parts breakdown with prices or someone will contact you.

Write to:  
The Montana Firearms Group  
3172 MT Hwy 35  
Kalispell, MT 59901

**CAUTION: PARTS ARE MADE FOR MONTANA RIFLE COMPANY BRAND GUNS MANUFACTURED BY THE MONTANA RIFLE COMPANY AND SHOULD NOT BE USED IN OTHER GUNS EVEN THOUGH MODELS MAY BE SIMILAR. IMPROPERLY FITTED PARTS MAY BE DANGEROUS**

**SERVICE OR REPAIR**

If your Model 1999 Rifle should ever need repair or service we suggest you find a competent gunsmith or contact us at the previously state number and address to have the rifle shipped back to The Montana Rifle Company for service.

When returning your firearm for servicing you must.

1. Make sure it is completely unloaded
2. Package the firearm securely. Wrap the rifle in paper or other protective packaging and place gun in a gun case or suitable box along with a note of explanation.

**THE MONTANA RIFLE COMPANY IS NOT RESPONSIBLE FOR DAMAGE INCURRED DURING SHIPPING.**

3. Ensure that a letter is enclosed with your firearm (attached to it in some way) describing the trouble experienced and the repairs or alterations desired. Include your complete address and both work and home phone numbers.
4. Remember, never return ammunition with your firearm. It is against postal and most commerce regulations.



# **MONTANA FIREARMS GROUP**

**DBA MONTANA RIFLE COMPANY**

3172 MT Hwy 35  
Kalispell MT 59901

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