

# Stealth Recon Scout Rifle Owners Manual



# For video instructions see our website at <u>www.deserttacticalarms.com</u>

Welcome to the proud family of precision rifle owners. In acquiring your new Stealth Recon Scout rifle, you are the owner of the most versatile precision rifle system in the world. Whether a police marksman is shooting 50 yards or a military marksman is shooting a mile, the SRS offers unrivaled flexibility in an overall package that is shorter than any other precision rifle on earth.

To get the most out of your SRS rifle, please read this manual from cover to cover before handling and operating the rifle for the first time.

#### WARNING! KEEP OUT OF REACH OF CHILDREN! IT IS DANGEROUS TO ALTER OR MODIFY THIS FIREARM IN ANY WAY. ANY ALTERATION OR MODIFICATION OF THE FIRING MECHANISM MAY RESULT IN THE FIREARM BECOMING UNSAFE. ANY ATTEMPT TO ALTER OR MODIFY THIS FIREARM WILL NULLIFY ALL WARRAN-TIES.

# **TABLE OF CONTENTS**

SAFETY PRECAUTIONS	
SPECIFICATIONS	
FACTS ABOUT THE STEALTH RECON SCOUT	
DISASSEMBLY AND ASSEMBLY	
BUTTPAD	
BOLT	
BARREL	
MAGAZINE	
REMOVING STOCKPANELS	
OPERATING INSTRUCTIONS	
PRECAUTIONS BEFORE FIRING	
MAGAZINE	
LOADING AND UNLOADING	
TRIGGER ADJUSTMENTS	
MOUNTING SCOPE	
QUICK ZEROING	

CARE AND CLEANING	40
INITIAL CLEANING	41
PERIODIC MAINTENANCE	41
BEFORE AND AFTER FIRING	46
ADDITIONAL DISASSEMBLY & ASSEMBLY	
BOLT DISASSEMBLY	
BOLT ASSEMBLY	50
IMMEDIATTE ACTION AND TROUBLE SHOOTING	53
REPAIRS	59
REPLACING BARREL ALIGNMENT PIN	59
PARTS EXPLODED VIEW	61
RIFLE	61
BOLT	62
MAGAZINE	63
BUTTSTOCK	64
ACCESSORIES	65

# SAFETY PRECAUTIONS

Remember that even the safest gun is potentially dangerous to you and others when it is not properly handled. Read carefully the operating instructions and learn how the weapon works and is to be handled.

Make sure that the rifle is unloaded before:

- Receiving or handing over the rifle.
- Transporting the rifle.
- Clearing or disassembly.

Always remove the magazine immediately after firing and make sure that the chamber is empty. Make sure that the fire selector (safety catch) is on "S" (Safe) position to guarantee that the rifle is safe whenever:

- Inserting magazine.
- You have stopped firing it.
- The rifle is being transported or moved.
- The rifle is not in use.

Before shooting the rifle:

- Always wear eye and ear protection.
- Always be sure of target backstop and what lies beyond it.

Make sure that the barrel is fully seated and locking screws are tight before firing, as described on pages 16-18.

Do not use force when disassembling or assembling your weapon. A gun can only be safe as long as it is in a flawless technical condition. Incorrect handling and lack of maintenance may lead to malfunctions and reduced safety of the weapon. Unauthorized modifications to the mechanism, damages caused by the application of force, and modifications effected by third parties will lead to the manufacturer not to assume any liability. Only a DTA certified armorer is allowed to work on the gun.

**REMEMBER:** ALWAYS ASSUME THAT THE RIFLE IS LOADED: LOOK-ING INTO THE END OF THE BARREL (MUZZLE) IS NOT RECOMMENDED AT ANY TIME.

# SPECIFICATIONS

#### WEIGHT

Rifle empty, no accessories	.308 WIN	11 lb (5.0 kg)
	.243 WIN	12 lb (5.4 kg)
	.300 WIN .338 LM	12 lb (5.4 kg) 12.4 lb (5.6 kg)
LENGTH		
Minimum Length	.308 WIN	31.5 in (800.1 mm)
	.243 WIN	35.5 in (901.7 mm)
	.300 WIN	35.5 in (901.7 mm)
	.338 LM	37.5 in (952.5 mm)

#### **MECHANICAL FEATURES**

Method of operation	Bolt Action
Method of feeding	Magazine
EjectionThrough port at right s	side

AMMUNITION Caliber.308WIN, .243WIN, .300WIN, .338 LM

#### SIGHTS

#### Picatinny rail (no taper)

#### BARREL

Type Muzzle Threads Length Match fluted barrel .75x24x.625 26 in (660.4mm) Note: .308 WIN length is 22 in

#### FIRING CHARACTERISTICS

Muzzle Velocity Maximum Range Variable 1500+ m (1640+ yds)

#### **SAFETIES**

Fire Selector

Safe and Fire

# FACTS ABOUT THE STEALTH RECON SCOUT

The SRS rifle is a lightweight, bolt action operated, magazine-fed firearm. A brief description of the SRS rifle follows:

#### **KEY FEATURES**

Accuracy The SRS achieves better than ½ MOA of accuracy in all calibers, because it is built around the core components of accuracy. The SRS utilizes a match grade (free-floated) barrel, solid (return-to-zero) barrel mounting system, high quality match trigger, and match spec chambers.

#### Quick caliber conversion capability

The SRS rifle was designed around the 338 Lapua Magnum however it can quickly be converted between the following cartridges: 308 WIN, 243 WIN, 260 REM, 7MM WSM, 6.5x47mm Lapua, 300 WIN, 338 LM. This conversion feature allows the rifle to be deployed in an urban environment where mobility is desired and

over-penetration is to be avoided, yet you can deploy the same weapon in mountainous terrain where shots can be taken up to a mile away with the .338 Lapua Magnum. Plus, operators only need to learn one system, one rifle and one scope. New shooters can train with the smaller .308 Winchester cartridge, which is easier to shoot and has a barrel life that is four times longer than the .338 LM.

- **Compact** The SRS is the shortest precision rifle system in existence. The SRS is almost a foot shorter than most conventional precision rifles, because it utilizes a bullpup configuration as well as a collapsible bolt design. This compact design shifts the weight rearward creating not only a shorter weapon, but also a perfectly balanced rifle.
- **Rugged** The SRS was designed to operate under the harshest conditions and abuse. It utilizes high-impact polymers, aircraft grade aluminums (7075-T6), ultra high strength steels, and the strongest coatings known to man. The operating mechanisms are completely encased by the stock panels except for the ejection port area. The stock panels attach directly to the receiver which acts as

full length mounting chassis, eliminating the need for any sort of bedding interface. The SRS sustains its accuracy and reliability in virtually any environment including; subzero temperatures, extreme heat, and wet or dusty environments.

#### Ergonomics

The ergonomics and balance of the SRS are unmatched. We elected to build ergonomics into the weapon itself, instead of adding heavy gadgets and gizmos as an afterthought.

#### **Ergonomic Feature List**

- Match grade trigger, adjusts for creep, travel, and weight (1 to 6 lbs) and all trigger adjustments can be set without disassembling the rifle.
- Adjustable length of pull (1.5" of available adjustment)
- Optimized cheek rest, the cheek rest was designed into the rifle to be perfectly optimized with the height of our proprietary tapered scope rings, thus providing optimal mounting height for any scope with an objective lens of 56mm or less.

- Custom contoured pistol grip
- Comfortable rear support grip
- Raised butt pad, positions the shooters shoulder above the bore line, minimizing muzzle rise and felt recoil.
- Ambidextrous safety selectors are accessible without removing firing hand from pistol grip.
- 60 degree bolt lift
- Ambidextrous magazine release buttons easily facilitate one handed magazine changes so the shooter can stay on the rifle during magazine changes.
- Weapons balancing point is approximately ½ inch forward of the trigger guard, comfortable carrying grip is located at balancing point.
- 14 quick sling attachment points are located on the weapon for shooting versatility, the sling points are also perfectly balanced with the centerline of the weapon to ensure the rifle lies comfortably flat when slung.

#### **Other Benefits**

• The full length MIL-STD-1913 rail facilitates mounting state of the art night vision optics, thermal sights, and other mounted accessories.

- Our magazines incorporate a "shoulder retention" feature that prevents the projectile tips from slamming into the front of the magazine during recoil. In traditional magazines the projectile tips slam against the front of the magazine, deforming the projectile and in turn diminishing accuracy. This can not happen with our magazine. In addition our internal magazine length is a healthy 3.95" long which is .3" longer than the competitor, making it possible to load the 300+ grain bullets out where they are supposed to be.
- The SRS is available in a variety of color configurations; hard-coated anodizing can be had in either black or olive drab. The stock panel color options are; black, coyote brown, or olive drab.

#### **General Firearm Construction**

Refer to illustration, (see cover)

- The barrel (8) is attached to the receiver (5) by four captive locking screws (4)
- The stock panels (1) attach directly to the receiver (5).

- The aluminum hand guard (7) is attached to the front of the receiver (5)
- Mil-spec picatinny rails (6) run along the top, bottom and sides of the hand guard. Front sling attachment points (19) are located along the bottom and sides of the hand guard (7).
- The bolt assembly travels inside of the receiver; the bolt handle (3) is located on the right side of the receiver (5).
- Ambidextrous safety selectors (17) are located above the trigger guard, on the right and left side of the firearm.
- The butt stock (9) is attached to the rear end of the stock panels (1).

## DISASSEMBLY AND ASSEMBLY

- 1. This chapter deals with those disassembling and assembling operations which the user may perform for routine maintenance of the rifle. Disassembling or assembling of any other part is not recommended. Any damage caused from improper disassembly will void warranty.
- 2. Disassembling must be carried out on a clean surface and disassembled parts should be placed in order of their removal.

**WARNING:** Carry out the following operations before dismantling: Remove magazine; clear the rifle several times to ensure there is no live cartridge in the chamber. (see page 27)

#### CAUTION: FOREARM IS TEMPORARILY SEALED TO THE RECEIVER. DAMAGE CAUSED BY THE REMOV-AL OF THE FOREARM WILL VOID WARRANTY!

#### **REMOVING THE BUTTPAD**

- 1. Depress the butt pad retaining switch (fig. 1)
- 2. While depressed slide down butt stock assembly.



Figure 1

#### **REMOVING BOLT MECHANISM**

- 1. Lift bolt handle (fig. 2)
- 2. Slide bolt rearward out of the receiver





#### **REMOVING BARREL**

- 1. Remove buttpad and bolt (see page 15)
- Using a 5mm allen wrench loosen the four barrel locking screws (fig. 3a)



Figure 3a

- Using a 5mm allen wrench rotate the barrel lock counter clockwise 180° to unlock (fig. 3b)
- 2. Pull out barrel.





#### **INSTALLING BARREL**

**Note:** For Rifles with serial number starting in DTA follow these instructions.

 Insert barrel into the receiver, note the locating notch on the barrel extension, position the notch in the six o'clock position. (fig. 4a) This notch lines up with a pin inside of the receiver. (fig. 4b)

**CAUTION:** DO NOT ALLOW BARREL TO FALL INTO RECEIVER; GUIDE IT IN GENTLY TO PREVENT DAMAGE TO ALIGNMENT PIN. (If pin gets damaged see page 59 for replacing it)

2. Fully seat the barrel (fig. 5)



Figure 4a

Figure 4b



Figure 5

Note: For rifles with serial number beginning in SRS follow these instructions.

- 1. Insert barrel into the receiver, note the locating notch on the barrel extension (fig. 4c), position the notch in the six o'clock position. (fig. 4d) This notch lines up with the feed ramp inside of the receiver.
- 2. Fully seat the barrel against feed ramp. (fig. 4e)







Figure 6

4. Insert the bolt mechanism into the receiver (fig. 7), fully close the bolt engaging the locking lugs in the barrel extension; this establishes headspace.

Ensure the caliber of the bolt matches the

caliber of the barrel (fig. 6)

3.



Figure 7

- Using a 5mm allen wrench tighten the four barrel locking screws to 68 inch / lbs of pressure, a torque wrench is highly recommended for this step to prevent over tightening the locking screws. (fig. 8)
- Using a 5mm allen wrench rotate the barrel lock clockwise 180° to lock. (see fig. 3b on page 16)



Figure 8

**CAUTION:** EXCEEDING THE TORQUE SPECIFICATION WHEN TIGHT-ENING THE BARREL LOCKING SCREWS CAN PERMANANTLY DAMAGE YOUR RECEIVER AND WILL VOID ALL WARRANTIES. (Portable torque wrenches are available to purchase at our website @ deserttacticalarms.com or by calling (801) 975-7272.)

#### DISASSEMBLY AND ASSEMBLY OF THE MAGAZINE

#### DISASSEMBLY

- 1. Before disassembling the magazine, remove all cartridges.
- 2. Hold magazine with bottom facing upwards.

#### **WARNING:** THE MAGAZINE SPRING IS UNDER TENSION. TAKE CAU-TION WHEN REMOVING THE MAGAZINE FLOORPLATE.

- 3. With the aid of a small pointed object, push base catch inward. (fig.9)
- With catch depressed, carefully pull the magazine base rearward approximately ¼". (fig. 9)
- Carefully holding spring in place with index finger, remove magazine floor-plate & spring guide (with other hand).



Figure 9

6. Use both hands, ease the spring and follower out of housing.

#### ASSEMBLING

- 1. Hold Magazine with feed-lips downward, slots facing away from you.
- 2. Insert follower with cavity facing up, and drop into place. (fig. 10)

3. When installing the spring, ensure when under pressure it bows to the rear of the magazine. (fig. 11)







Figure 11

4. Insert Spring into magazine. (fig. 12b) (spring should sit in follower female cavity as seen in figure 12a when inserted into the magazine) Other end should slide on spring guide.

 Compress spring so the nose of the Spring-guide is positioned below the floorplate locking tabs. While under tabs press rear of spring-guide below locking tabs and slide spring-guide forward. (fig. 13a) Spring guide should now be retained inside the magazine housing. (fig. 13b)



Figure 12a

Figure 12b



Figure 13a

Figure 13b

6. While holding spring with index finger, insert base with square edge facing magazine and push home until floorplate button locks. (fig. 14)

#### **REMOVING STOCKPANELS**

- 1. Remove butt pad, bolt, barrel, and magazine. (see pages 15-16, and 27)
- 2. Using a 4mm wrench, unscrew the flush cup sling swivel on the left side of the gun (fig. 15)
- 3. Lay rifle down with right side facing up.
- Loosen the 10 stock panel screws using a 3mm wrench (fig. 16a) and the flush cup sling swivel on the right side of the rifle using a 4mm wrench. (fig. 16b)



Figure 14



Figure 15

5. Grip inside the magwell and the trigger guard and wiggle back and forth until the two halves separate.

#### CAUTION: BUTT PAD RETAINING SWITCH IS UNDER SPRING PRES-SURE.



Figure 16a

Figure 16b

# **OPERATING INSTRUCTIONS**

#### **PRECAUTIONS BEFORE FIRING**

- 1. Before firing, always wear eye and ear protection.
- 2. Ensure that there is no magazine in the rifle.
- 3. Before firing, ensure barrel is dry, clean, and free of obstructions and rifle is unloaded.
- 4. With fire selector on "F" (Fire), cock and dry fire at least twice to make sure that the mechanism is working smoothly and properly.

- 5. Run the bolt, return fire selector to "S" (Safe), point barrel in safe direction, squeeze trigger to ensure safety catch is working properly. Return fire selector to "F" (Fire) and dry fire. Set fire select to "S" (Safe).
- 6. Never put your finger inside the trigger guard or squeeze trigger unless you are ready to fire. From the time the magazine is inserted, until the rifle is cleared and clearance is checked, keep rifle pointed in a safe direction.
- 7. Fire selector should always be on "S" (Safe) until you are ready to fire.
- 8. Check that magazines are clean and properly loaded.

#### FILLING & EMPTYING THE MAGAZINE

- 1. With magazine in upright position & slots facing you, place cartridge on follower.
- 2. Press down and slide cartridge rearward. (fig. 17)
- 3. Repeat until loaded





4. Do not load more than 5 cartridges in the 338LM/300WIN magazine, and no more than 6 cartridges in the 308WIN, and 243WIN magazines.

#### EMPTYING

- 1. Push out cartridge with thumb. (fig. 18
- 2. Repeat until magazine is empty.

## LOADING AND UNLOADING

#### INSERTING THE MAGAZINE

- 1. Clear the rifle. (see page 24)
- Set the fire selector on "S" (Safe). (fig. 19a)







Figure 19a

Figure 19b

Insert the magazine firmly until the magazine catch snaps into place. (fig. 20)



Figure 20

# FIRING THE SRS

- 1. Never chamber a round until you are ready to fire.
- 2. Set fire selector to "F" (Fire) (fig. 19b)
- 3. Lift bolt handle and slide all the way rearward. (fig.21)
- 4. Run bolt forward and lock into place.
- 5. The rifle is now ready to fire with a round chambered.
- 6. Pull the trigger to fire the gun.





7. Repeat step 3. The empty case is then ejected. If there is another cartridge in the magazine, it will be loaded into the chamber when running the bolt forward. The gun is loaded and ready to fire again.

**CAUTION:** After the last shot is fired the bolt must remain open. Check whether cartridge chamber is empty!

#### UNLOADING (CLEARING) THE SRS

- 1. Place the fire selector on "S" (Safe).
- 2. Depress magazine catch and remove magazine (fig. 22)
- 3. Holding bolt in rear position, look into chamber to ensure that chamber is empty.
- 4. With chamber empty, close bolt.
- 5. Place fire selector on "F" (Fire) and squeeze trigger with barrel pointing in safe direction.
- 6. Empty magazine. (see page 25)





#### TRIGGER ADJUSTMENTS

#### **Adjusting Creep**

 Insert a 2mm wrench through the front hole in the bottom of the trigger guard into the front screw on the trigger. (fig. 23) Turn clockwise to get less creep and counterclockwise for more creep.





#### **Adjusting Weight Pull**

2. Using a 2.5mm wrench, loosen the screw on the side of the trigger. Slide trigger forward or back to the position desired then tighten screw.





#### **Adjusting Trigger Location**

3. Using a 2.5mm wrench, loosen the screw on the side of the trigger. Slide trigger forward or back to the position desired then tighten screw. (fig. 25)





**NOTE:** ONLY DTA CERTIFIED AMRORERS CAN DISSASEMBLE THE TRIGGER ASSEMBLY TO ENSURE MAXIMUM RELIABILITY AND SAFETY! DISSASEM-BLY OF TRIGGER OR SEAR COMPONENTS BY ANYONE OTHER THAN CERTI-FIED DTA ARMORERS WILL VOID WARRANTY!

#### **MOUNTING SCOPE**

- 1. Identify front of base (fig. 26) (Screws should be on right side) Front should face muzzle.
- 2. Loosen and remove ring screws, loosen but DO NOT remove ring base screws.

- 3. Tilt base on right side, placing dove tail catch under picatinny rail. (fig. 27a)
- Rotate base until flat on top of picatinny 4. rail. (ensure left dove tail goes under rail)
- 5. Tighten base screws to 68 inch lbs. (fig. 27b)



Figure 26



Figure 27a

Figure 27b

- 6. If applicable install bottom half of 30mm reducer inserts (fig. 28)
- 7. Place scope inside ring.
- 8. If applicable install top ring inserts.



Figure 28

- 9. Install ring tops. (fig. 29)
- 10. Finger tighten ring screws (leave it loose enough that the scope can still rotate inside the rings)



Figure 29

#### 11. Establish eye relief

- Get into favorite shooting position
- Pull rifle firmly into shoulder
- Close your eyes
- Affirm cheekweild
- Open your eyes
- Adjust scope forward or backward until any ghost ring goes away. (additional forward or backward adjustment can be gained by moving the entire scope ring base forward or backward along the picatinny rail)
- 12. Place feeler gauges (and spacer if necessary) between flat of bottom of scope and the flat on ring base, (fig. 30) adjusting the filler gauges until there is a snug fit.

**CAUTION:** Take caution when adjusting the filler gauges. Do not make fit too tight as damage may result.


13. Tighten ring screws to 15 in lb, rotating from left to right in a criss cross pattern. While you tighten, ensure filler gauges are not too tight. They should always have some left to right play.

## QUICK ZEROING

- 1. Find center of scope, place windage & elevation turret in center of travel range.
  - First identify your scopes adjustment values (MOA or MIL).
  - Determine total windage and elevation adjustment from scopes literature or by turning the knobs from one end to the other while viewing a bore sighter. Note – many scope's knobs will rotate beyond the erector cells available movement, thus at the extreme ends of the knobs travel the reticle will stop moving before the knob stops.

# CAUTION: DO NOT FORCE SCOPE KNOBS WHEN YOU REACH THE END OF TRAVEL RANGE

- Once total travel has been determined, rotate windage clockwise all the way.
- Once windage knob stops, rotate the knob back out in the counter clockwise motion by half of the total windage travel.
- e.Rotate elevation knob until it bottoms out.

- Once bottomed out, rotate the elevation knob back up by half of the total elevation knobs travel.
- Next, identify your scope bases taper (20, 30, 40 MOA). Rotate elevation knob down by whichever taper you have.

Example:
Scope: Nightforce NXS 5-22x50
$\frac{\text{Total Windage}}{2} = \frac{60 \text{ MOA}}{2} = 30$
$\frac{\text{Total Elevation}}{2} = \frac{100 \text{ MOA}}{2} = 50  \begin{array}{c} \text{Less the scope base} \\ \text{taper of 40 MOA} \end{array} = 10$
The scopes center is approximately 30 MOA from the edge of the windage travel and 10 MOA from the bottom of the elevation travel.

- 2. You are now ready to zero.
- 3. You can zero the rifle at any distance you desire. Starting your initial zeroing at 25 yards is the easiest method to get on paper. Zeroing at 100 yards requires an alert spotter, a good spotting scope, and a large white

paper target. If your first shots are not on the paper try shooting a dirt backstop because shooting dirt is much easier to observe than paper.

- 4. Once on paper, shoot a three shot group while aiming the crosshairs at the bullseye. (fig 31)
- 5. Use crosshairs subtended lines/dots to measure groups distance from bullseye. You can also measure the distance from bullseye using a tape-measure, however you will need the conversion formulas on page 39 to change from inches to MOA or MILS. Adjust as per measurements and shoot another 3 shots while aiming at

bullseye. (fig. 32)

Example: Down 1.6 Mils Left 1.1 Mils



6. Repeat step 5 until you are satisfied. Note, a rifle shoots at an area not at a single point, so ensure that the center of the group is where your zero is.

## SCOPE TURRETS VALUE

The two most common scope adjustment values are Minutes of Angle (MOA) and Mil Radians (MILS)

- 1. 1 MOA = 1.047" @ 100 yards
- 2. 1 MIL = 3.6" @ 100 yards
- 3. 1 MIL = 3.438 MOA
- 4. 1 MOA = 0.29 MILS

If you think in terms of inches you must realize that MOA values and MIL values are angular measurements, which means that the inch value of both MOA and MIL increases with distance. (see illustration below)



It is much easier to train yourself to stop thinking in inches and think in terms of MOA and MILS instead. Their values don't change with distance therefore it will eliminate a lot of unnecessary conversion formulas.

Conversion Formulas

- Inch to MOA: <u>Inch Value x 100</u> = MOA Correction Target Distance
- Inch to MIL:  $\frac{\text{Inch Value x 100}}{\text{Target Distance}} \div 3.6 = \text{MIL Correction}$
- MOA to MIL:  $\frac{\text{MOA Value}}{3.438} = \text{MIL Correction}$
- MIL to MOA:  $\frac{\text{MIL Value}}{0.2908}$  = MOA Correction

## **CARE AND CLEANING**

### GENERAL

Comprehensive knowledge of how to service and handle rifles is of great importance. Experience has shown that most failures which occur while operating the rifle are due to negligence in maintenance. Special attention must be paid to cleaning, lubricating and inspecting the rifle; this will determine whether or not the rifle will function properly when you need it. In order to maintain accuracy, the barrel must be serviced thoroughly. The receiver, the bolt assembly and other moving parts of the rifle must be kept clean and lightly lubricated to ensure proper operation. Care and cleaning includes the magazine, which must be kept free from rust, grit, etc., in order to function properly.

## INITIAL CLEANING

- 1. Upon receipt of rifle, disassemble (see page 14) and inspect.
- 2. Clean rifle as per Periodic Maintenance Procedure. (see page 41)
- 3. Any heavy or gummy deposits may be removed using very light rust preventive oils such as Break Free, C.B.C., W.D. 40, or similar. After cleaning, wipe dry and lightly coat with gun oil.
- 4. Never use abrasive or metallic object, synthetic cloth, dry cleaning fluids, detergents, acids, lyes, water or steam.
- 5. Reassemble and make sure proper function of rifle and safeties. (see page 16)
- 6. Observe all safety precautions. (see pages 4 and 5)

## PERIODIC MAINTENANCE

1. Bore Obstruction: If the bore is obstructed the operator first must determine what the obstruction is, where it is located and how tightly It is lodged in the barrel. NEVER attempt to "shoot out" a bore obstruction as

damage to the system may occur (as well as possible operator injury). Snow and/ or ice can generally be pushed out with a cleaning rod w/patch. Should it not be possible to move it in this manner, it can be warmed until it either melts or loosens sufficiently to allow a push out. Sand, mud and dirt can present a challenge to the operator and care must be taken to ensure that the bore is not damaged during removal. As much debris as possible should be removed by shaking out the barrel (while pointed in a safe direction) prior to lubricating the bore with "Break Free" and pushing out with a patch.

- 2. Bore Fouling: Ideally, the bore should be cleaned every 40 rounds in a thorough fashion utilizing a proper one piece cleaning rod, a jag, a bronze brush, a pull through, and cleaning patches to ensure optimum accuracy. Should field conditions not allow a cleaning at 40 rounds the operator can be confident of acceptable accuracy well beyond this threshold, however a proper cleaning becomes critical to accuracy after 80 rounds has been fired. We suggest the following procedure to clean our rifle barrels:
  - Remove butt pad and bolt (see page 15).
  - Insert bore guide.

- Wet patch with Shooter's Choice bore cleaner and push through.
- Brush thoroughly with sized bronze brush and Shooter's Choice making at least two full passes for every shot fired since the last cleaning.
- Allow to sit for 15 minutes
- Push patch through wet with Shooter's Choice.
- Patch with 4 dry patches or until patches come out dry and clean.
- Run patch through bore wet with Sweet's 7.62 bore solvent and let sit for NO LONGER than 10 minutes.
- Patch with a clean dry patch. If there is blue residue on the patch repeat the cleaning process until no blue residue remains on the final stage.
- Once the bore is clean, utilize the pull through w/patch saturated with Shooter's Choice in a back and forth motion for 10 strokes.
- Push through 4 dry patches or until patches come out dry and clean.
- 3. Muzzle Brake: Ensure that the vents are clear of debris and occasionally check to ensure the brake has not "shot loose".

- 4. Magazine: It is imperative that the magazine be given the best of care and kept in perfect condition. They should be disassembled, cleaned, and lightly oiled. (see page 19) Check magazine lips. They should not be deformed, nicked, or cracked in the back.
- 5. Receiver Interior: A visual and manual inspection of the inside of the receiver will reveal what, if any cleaning is necessary. Most debris can be removed with a cloth, cleaning patch or cleaning brush.
- 6. Bolt Face: Ensure that the bolt face is free from debris that will create headspace, chambering problems, and/or inhibit function of either the extractor or ejector. This area can be wiped clean or blown out. This is also a good time to ensure that both the double ejectors and the extractor are functioning properly by manually actuating them to ensure proper spring function and return. Also, a small amount of Break Free may be applied to the bolt face area at this time.

- 7. Bolt Interior: The operator should occasionally remove the firing pin assembly from the bolt (see page 48). Wipe this area clean prior to applying a small amount of Break Free.
- 8. General Cleaning: The entire rifle should be wiped off with a clean cloth lightly saturated with Break Free on occasion. This includes the barreled action, scope rings, and ancillary components.

## **BEFORE AND AFTER FIRING**

## **CLEANING BEFORE FIRING**

- 1. Disassemble the rifle (see page 14)
- 2. Run clean patches through bore and chamber to remove all dust and oil. There should be no oil in bore and chamber before firing as this may cause dangerous pressures to develop.
- 3. Remove excess oil from interior of bolt and bolt face.
- 4. Check that all moving parts are lightly oiled.
- 5. Assemble the rifle and check functioning. (see page 16)

## **CLEANING AFTER FIRING**

- 1. The rifle should be cleaned no later than the evening of the day on which it was fired to prevent corrosion and caking of deposits.
- 2. Follow procedures of periodic maintenance and pay particular attention to all parts which have been in contact with powder gases.

- Barrel: In order to remove heavy deposits, use cleaning brush. Make sure the brush goes all the way through the bore before reversing the direction. Deposits that cannot be readily removed with the brush may be treated by coating bore & chamber with good quality bore & chamber fluid and allowing to soak for at least twelve hours.
- After soaking, repeat above procedure. The barrel should be cleaned and re-oiled, at least once on the day after firing.
- Firing Mechanism Remove all powder residues from bolt face and interior surfaces of bolt. If necessary, use stiff nylon brush or tooth brush.
- Receiver: Wipe off any heavy deposits in interior and oil lightly.
- Magazine: Make sure magazines are clean and follower moves freely.

#### ADDITIONAL DISASSEMBLY & ASSEMBLY

## **BOLT DISASSEMBLY**

- 1. Using a punch tool, press the end cap detent button (fig. 33) while pushing the end cap out of the bolt sleeve.
- 2. Remove end cap and Firing pin spring.



Figure 33

## **WARNING:** THE FIRING PIN SPRING IS UNDER TENSION! TAKE CAUTION WHEN REMOVING THE END CAP!

3. Remove firing pin spring (fig. 34)





4. Slide Bolt Sleeve off the bolt. (fig. 35)





- 5. Remove the striker from the bolt sleeve. (fig. 36a)
- 6. Remove firing pin from bolt. (fig. 36b)



Figure 36a

Figure 36b

#### BOLT ASSEMBLY

Insert the firing pin into the bolt. (fig. 37a) Make sure the pin protrudes out the end of the bolt (fig. 37b)



2. Insert the striker into the bolt sleeve. (fig. 38)





3. Slide bolt sleeve onto the bolt. (fig. 39)





Insert Firing pin spring into bolt. (fig. 40)



Figure 40

5. Insert end cap into the bolt. (fig. 41a) Press it in with your thumb while using a punch tool with your other hand to push the detent button in until it snaps into place. (fig. 41b)



Figure 41a

Figure 41b

## **IMMEDIATE ACTION AND TROUBLE SHOOTING**

A failure to fire (including one caused by an empty magazine) may often be corrected by taking immediate action.

#### **IMMEDIATE ACTION**

Remove magazine and wait 3 seconds with barrel pointing in a safe direction, then inspect magazine.

#### 1. MAGAZINE EMPTY

Cock to remove possible last round. Inspect chamber and if empty, insert full magazine, run the bolt and continue firing.

#### 2. MAGAZINE NOT EMPTY (Malfunction)

- Run the bolt and clean possible defective or wrongly positioned round. If a round or case ejects, inspect chamber and if empty, reload and continue firing.
- If nothing ejects, fully draw back bolt and check if cartridge or case is in chamber. If empty, reload and continue firing.
- If base of cartridge is visible, close bolt and fire in a safe direction. If rifle fires and ejects, reload and continue.
- If rifle does not fire, set fire selector on "S" (Safe) and follow "spent case or round stuck in chamber". (see page 58)

#### **TROUBLE SHOOTING**

#### A. FAILURE TO FEED

#### CAUSE

- 1. Incorrect Cocking
- 2. Poor Magazine
- 3. Magazine Improperly Seated
- 4. Magazine Improperly Loaded
- 5. Dirty Magazine
- 6. Damaged Magazine
- 7. Double Feed

\* Rifle jams or closes on empty chamber

#### REMEDY

Clear jam if necessary and run bolt Replace with DTA factory magazine Push magazine home until latch catches

- a. Seat top cartridge properly
- b. Check that no more than 5 rounds are in the Magazine

Disassemble and Clean

Replace

- a. Inspect for stuck case or cartridge (see section E. on page 58)
- b. Check extractor and ejector (see section D. on page 57)

# **B. FAILURE TO CHAMBER**

#### CAUSE

- 1. Incorrect Cocking
- 2. Dirty Chamber
- 3. Defective Ammunition
- 4. Very dirty rifle

#### \* Bolt does not fully close and rifle will not fire.

## REMEDY

Remove magazine. Re run the bolt and reload. Clean. Check for damaged cartridges. Check for sluggishness in bolt and firing mechanism. Clean and oil as necessary.

## C. FAILURE TO FIRE \* Striker assembly snaps home but rifle will not fire. CAUSE REMEDY

1. Bolt not Fully Closed

Follow procedure for incorrect cocking or short recoil. (A)

2. Defective Cartridge

Inspect primer. If fully indented discard safely. If not fully indented, check firing mechanism.

- Dirty Firing Mechanism Defective Firing Pin Defective Striker Assembly
- 4. Barrel Not Properly Seated

#### D. FAILURE TO EXTRACT OR EJECT

#### CAUSE

1. Overpowered Ammunition (Stuck Case)

2. Dirty or Damaged Chamber

Check for sluggishness of operation. Clean and replace as necessary.

Make sure the locating notch on the barrel extension lines up with the pin inside of the receiver and is fully seated. (see pages 16-17)

# The fired case may not eject, or the rifle may jam (spent case left in chamber).

#### REMEDY

Check ammunition and change to a different brand of currently commercially manufactured ammunition if problem persists.

Inspect, clean, replace barrel if necessary.

- 4. Fouled Extractor
- 5. Extractor Defective or Missing
- 6. Damaged Ejector

Check ammunition for damage. Replace if problem persists. Clean Extractor Replace Replace if necessary

#### E. SPENT CASE OR ROUND STUCK IN CHAMBER

**Caution:** The following procedure should be carried out only after following the steps in "Immediate Action". (see pages 53 & 54 - 2b, c, d)

- 1. Remove bolt and striker assembly.
- 2. With barrel in place, insert cleaning rod through front of barrel. Push or tap gently to remove obstruction.
- 3. Check chamber and bore. Clean before reassembly.
- 4. If obstruction cannot be removed, disassemble barrel and contact authorized service station.

#### REPAIRS

#### **REPLACING FIRING PIN**

- 1. Disassemble the bolt (see page 48)
- 2. Insert new firing pin
- 3. Assemble the bolt (see page 50)

#### STORAGE

#### WARNING! KEEP OUT OF REACH OF CHILDREN! IT IS DANGEROUS TO ALTER OR MODIFY THIS FIREARM IN ANY WAY. ANY ALTERATION OR MODIFICATION OF THE FIRING MECHANISM MAY RESULT IN THE FIREARM BECOMING UNSAFE. ANY ATTEMPT TO ALTER OR MODIFY THIS FIREARM WILL NULLIFY ALL WARRANTIES.

## PARTS EXPLODED VIEW STEALTH RECON SCOUT



## BOLT



## MAGAZINE



## BUTTSTOCK



## ACCESSORIES

Day Scopes Night Vision Tapered Scope rings Suppressor Hard Case **Rifle Matt Carrier** Magazines **Bipods and Adapters** Slings Rail Covers Field Cleaning Kit Bench Cleaning Kit Tools Spare parts kit Armorer Tools Scope Installation & Zeroing Kit

## Stealth Recon Scout US Patent D584,373 PATENTS PENDING

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