



# Nosler<sup>®</sup> RIFLES

## HANDBOOK

This manual applies to all the Nosler Rifle variants

Serial #

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# Congratulations On Your New Nosler Rifle!

Top quality rifles are nothing new for the staff at Nosler. We have been chambering barrels and assembling barreled actions to test the accuracy of our bullets for over 60 years, and along the way, we have built some outstanding hunting rifles. All of this background has brought us to what we believe is the premier hunting rifle. Your new Nosler isn't just another pretty rifle. It comes with a long list of quality features like our blueprinted and hand-lapped Nosler action, a hand-lapped match grade barrel, custom tuned trigger, top-of-the-line glass bedded stock, and an all-weather ceramic finish for the metal work.

My son John and I have personally tested our rifles in the toughest conditions from Africa to Alaska, so we know you will be completely satisfied with the craftsmanship, function, and accuracy.

Good hunting, and always keep your new rifle pointed in a safe direction.

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# 1

## **BASIC SAFETY RULES**

### 1. WATCH THAT MUZZLE!

Never point the muzzle of a firearm at any part of your body, or at another person. This is especially important when loading or unloading the firearm. When you are shooting at a target, know what is behind it. Some bullets travel over a mile. If you miss your target or if the bullet penetrates the target, it is your responsibility to ensure that the shot does not cause unintended injury or damage.

### **ALWAYS BE SURE OF YOUR BACKSTOP.**

### 2. ALWAYS TREAT A FIREARM AS IF IT WERE LOADED.

Never assume that a firearm is unloaded. The only certain way to ensure that a firearm is empty is to open the chamber and visually examine the inside to see if a round is present.

**IF YOU ARE HANDED A FIREARM TO ADMIRE OR EXAMINE, ALWAYS OPEN  
THE ACTION AND VERIFY THAT THE CHAMBER AND MAGAZINE ARE EMPTY.**

**WHEN HANDING OFF A FIREARM, OPEN THE ACTION BEFORE PASSING IT TO THE NEXT PERSON.**

### 3. STORE YOUR FIREARM SO THAT CHILDREN CANNOT GAIN ACCESS TO IT.

It is your responsibility to ensure that children under the age of 18 (or other unauthorized persons) do not gain access to your firearm. To reduce the risk of accidents involving children, unload your firearm, lock it and store the ammunition in a separate locked location. Please note that devices intended to prevent accidents may not prevent misuse of your firearm by a determined person. Steel gun safes may be more appropriate to reduce the likelihood of intentional misuse of a firearm by an unauthorized child or person.

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4. NEVER SHOOT AT WATER OR AT A HARD SURFACE.

Shooting at the surface of water or at a rock (or other hard surfaces) increases the chance of ricochets or fragmentation of the bullet, which can result in the projectile striking an unintended target.

5. KNOW THE SAFETY FEATURES OF THE FIREARM YOU ARE USING, BUT REMEMBER THAT SAFETY DEVICES ARE NOT A SUBSTITUTE FOR SAFE HANDLING PROCEDURES.

Never rely solely on a safety device to prevent an accident. It is imperative that you know and use the safety features of the particular firearm you are handling, but accidents can best be prevented by following the safe handling procedures described in these safety rules and elsewhere in the product manual.

**IF YOU ARE NOT FAMILIAR WITH FIREARMS OR PROPER  
FIREARMS SAFETY, TAKE A FIREARMS SAFETY COURSE.**

6. PROPERLY MAINTAIN YOUR FIREARM.

Store and carry your firearm so that dirt or lint does not accumulate in the working parts. Clean and oil your firearm, following the instructions provided in this manual, after each use to prevent corrosion, damage to the barrel or accumulation of impurities which can prevent use of the gun in an emergency.

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**ALWAYS MAKE SURE THE BARREL IS CLEAN AND FREE OF  
OBSTRUCTIONS BEFORE LOADING THE FIREARM.**

7. USE PROPER AMMUNITION.

Only use ammunition manufactured (or handloaded) to industry specifications: CIP (Europe and elsewhere), SAAMI (U.S.A.). The caliber of the firearm is clearly marked on the barrel of the rifle.

**BE CERTAIN THAT EACH ROUND YOU USE IS IN THE PROPER  
CALIBER AND TYPE FOR THE PARTICULAR FIREARM.**

8. ALWAYS WEAR PROTECTIVE GLASSES AND EARPLUGS WHEN SHOOTING.

The chance that gas, gunpowder or metal fragments will blow back and injure a shooter who is firing a gun is slight, but the injury that can be sustained in such circumstances can be severe, including the possible loss of eyesight. Earplugs help reduce the chance of hearing damage from shooting.

**ALWAYS WEAR IMPACT RESISTANT SHOOTING  
GLASSES WHEN FIRING ANY FIREARM.**

9. NEVER CLIMB TREES, FENCES OR OBSTRUCTIONS WITH A LOADED FIREARM.

Open and empty the chamber of your firearm before climbing or descending a tree, climbing through or over a fence, or jumping over a ditch or obstruction. Never pull or push a loaded firearm toward yourself or another person.

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10. NEVER USE ALCOHOLIC BEVERAGES OR JUDGMENT / REFLEX IMPAIRING MEDICATION WHEN SHOOTING.

Do not drink and shoot. If you take medication that can impair motor reactions or judgment, do not handle a firearm while you are under the influence of the medication.

**IN OUR HUNTING CAMPS, THE ALCOHOL DOESN'T COME OUT  
UNTIL THE FIREARMS HAVE BEEN PUT AWAY FOR THE DAY.**

11. NEVER TRANSPORT A LOADED FIREARM.

Always unload your firearm before putting it in a vehicle. Hunters and target shooters should load their firearm only when ready to shoot.

12. LEAD 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. Wash hands thoroughly after exposure.

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### The Nosler Rifle Safety

Nosler Rifles are equipped standard with a two-position safety. As with many rifles that are equipped with a side mounted safety lever, the forward position is the “fire” position. The rear position is the standard “Safe” position.

Some Nosler Rifles are equipped with a special three-position safety as a custom option. The forward position is the “fire” position. The intermediate, or middle, position allows the bolt to be lifted while the firing mechanism is in the “safe” mode. This position is particularly useful for unloading the chamber or checking the magazine in the field. The rear position is the standard “safe” mode—in this position the bolt cannot be lifted.

**FOR 3 POSITION SAFETY: DO NOT ATTEMPT TO FORCE THE BOLT HANDLE OPEN WHILE THE SAFETY IS IN THE REAR (SAFE) POSITION, AS DAMAGE MAY OCCUR TO THE SAFETY AND TRIGGER MECHANISM.**

**REMEMBER – A SAFETY IS A MECHANICAL DEVICE WHICH CAN FAIL. NO RIFLE IS TRULY “SAFE” UNLESS THE CHAMBER IS EMPTY AND THE ACTION IS OPEN.**

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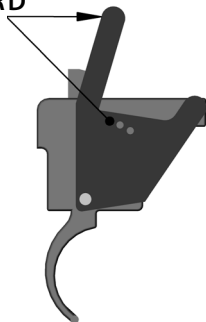




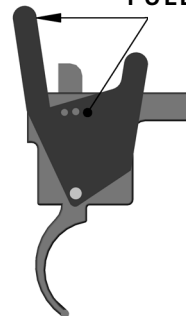


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LEVER PUSHED  
FULLY FORWARD



LEVER PULLED  
FULLY REARWARD



**FIRE POSITION**  
LEVER IS FULLY  
FORWARD

**FULL SAFE**  
LEVER IS IN REAR POSITION  
THIS POSITION PREVENTS  
THE RIFLE FROM FIRING

Trigger images depicted above are for general reference.  
Specific trigger design may vary by rifle.

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### RIFLE CLEANING

#### TO CLEAN THE BARREL

1. Point the muzzle in a safe direction.
2. Move the safety mechanism to the “Safe” position and check that all cartridges have been removed from the chamber and magazine.
3. Use the equipment provided in a good quality cleaning kit.
4. Remove the bolt assembly. See instructions #1 through #6 (Removing the Bolt Assembly) on page 9.
5. Select the correct caliber cleaning brush and attach the brush to the cleaning rod.
6. Apply gun cleaning solvent to the cleaning brush.

**THE BARREL SHOULD LAY HORIZONTALLY DURING CLEANING.**

**ALWAYS CLEAN THE BARREL FROM THE CHAMBER END TO THE MUZZLE.**

7. Push the brush through the barrel several times.
8. Remove brush from rod, attach tip with patch and push through bore.
9. Repeat several times, using a new cleaning patch each time, until the patch comes out clean.
10. Push a clean patch saturated with gun oil through the barrel.
11. Use clean, dry patches to remove excess oil from the chamber area and the interior surfaces of the barrel.



## **RIFLE CLEANING**

### **TO CLEAN THE RECEIVER AND TRIGGER ASSEMBLY**

1. Point the muzzle in a safe direction.
2. Move the safety mechanism to the “Safe” position and check that all cartridges have been removed from the chamber and magazine.
3. Remove the bolt, refer to instructions #1 through #6 of “Removing the Bolt Assembly” on page 9.
4. To remove the barreled action, refer to instructions #1 through #5 “Removing the Stock” on page 9.

### **CLEAN AND LUBRICATE THE RECEIVER AND TRIGGER ASSEMBLY AS A UNIT.**

#### **DO NOT REMOVE THE TRIGGER ASSEMBLY FROM THE RECEIVER.**

5. Scrub all areas of the chamber and receiver with solvent to remove any residue.
6. Once cleaned, wipe all parts with a clean rag to remove any solvent or residue.
7. Place a drop of oil in each of the places shown on page 19.
8. Follow the instructions on page 10 to reassemble the rifle.



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### **DISASSEMBLING THE RIFLE**

#### **REMOVING THE BOLT ASSEMBLY**

1. Point the muzzle in a safe direction.
2. Move the safety mechanism to the “Safe” position and check that all cartridges have been removed from the chamber and magazine.
3. Raise the bolt handle.
4. Pull the bolt handle all the way back.
5. Push the bolt stop release on the left hand side of the receiver, or the right hand side on left-handed rifles.
6. Pull the bolt assembly from the firearm.
7. Grasp the bolt shroud in the right hand, and the bolt body in the left hand.
8. Rotate the bolt shroud clockwise until it releases from the bolt body. Rotate counter clockwise on left-handed rifles.

**IT IS NOT NECESSARY, OR RECOMMENDED TO DISASSEMBLE  
THE FIRING PIN ASSEMBLY ANY FURTHER THAN THIS.**

#### **REMOVING THE STOCK**

1. Follow instructions #1 through #6 above.
2. Place the rifle on a padded surface, in an upside down and horizontal position.
3. Using a T27 Torx® bit, remove the rear guard screw from behind the trigger guard, and the front action screw (Front guard screw if equipped with a floorplate).
4. The barreled action will now pull free from the stock.





### **TRIGGER MECHANISM**

The trigger is adjusted at the factory. Only a qualified gunsmith should remove the trigger mechanism or make adjustments to the trigger or trigger assembly. Any alterations not made by Nosler gunsmiths will void the Nosler Rifle Warranty.

### **ASSEMBLING THE RIFLE STOCK ASSEMBLY**

1. Holding the barreled action upside down, place the magazine box in the recess under the feed rails.
2. For rifles with a hinged floorplate, place the stock over the action and magazine box, then install the bottom metal in the stock making sure the magazine box fits properly into the bottom metal. Go to step 5.
3. For rifles with blind bottom magazine, hold the stock right side up and place the magazine follower/spring assembly into the slot at the bottom of the magazine well. Lower the action and magazine box over the follower and into place.
4. Install front and rear action screws by hand and lightly snug them until no clearance remains. Check that the magazine box does not bind and is properly seated between the action and the bottom metal.
5. Using a T27 Torx® bit and an inch-pound torque wrench, lightly snug both action screws; then tighten the front screw to 40-45 inch-pounds, and the rear screw to 35-40 inch-pounds.
6. For rifles with hinged floorplates, install the magazine spring and follower into the floorplate slot. Turn the rifle over and verify the magazine follower travels freely, and does not bind.

### **BOLT ASSEMBLY**

1. Hold the bolt shroud in the right hand, and the bolt body in the left.
2. Push the firing pin and bolt shroud assembly into the bolt body.
3. Turn the bolt shroud counter clockwise while pushing it into the bolt body.
4. The bolt shroud will snap into place.
5. With the bolt handle in the up position, push the bolt into the receiver.

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## LOADING THE RIFLE

### **LOADING PROCEDURES:**

CAUTION: BEFORE LOADING, BE SURE YOU HAVE THE CORRECT AMMUNITION, AND MAKE SURE THAT ALL GREASE AND OIL HAS BEEN REMOVED FROM THE BARREL AND CHAMBER, AND THAT THERE ARE NO OBSTRUCTIONS.

1. Point the muzzle in a safe direction.
2. With the safety in the "Safe" position, lift the bolt handle and pull the bolt back all the way. Lay a cartridge in the receiver just forward of the bolt face. Press the cartridge down with your thumb until it snaps into the magazine. Make sure each cartridge is seated against the rear of the magazine box before attempting to insert the next cartridge, as the tip of the bullet may hang up on the feed ramp as it is pushed down into the magazine.
3. Press each succeeding cartridge similarly into the magazine. Maximum capacity is 3 or 4 rounds depending on caliber. Do not attempt to load more rounds in the magazine than it is designed to hold.
4. 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 action, inserting a round in the chamber, and pressing down on the top cartridge in the magazine as the bolt is closed.

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

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## **UNLOADING THE RIFLE**

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### **UNLOADING PROCEDURE:**

1. Point the muzzle in a safe direction.
2. With the safety in the "Safe" position, raise the bolt handle. Place one hand over the ejection port, and pull the bolt handle back with the other hand to remove the cartridge from the chamber.
3. To empty the magazine, the magazine floor-plate will swing open allowing the cartridge to fall free.

-Or if equipped with the blind-bottom magazine-

4. To empty the magazine, verify that the safety is on and the muzzle is pointed in a safe direction. Push the bolt forward until the cartridge is chambered, and close the bolt just enough for the extractor to engage the cartridge rim. Open the bolt and pull rearward to eject the cartridge. Repeat this process until the magazine is empty.

**ALWAYS VISUALLY CHECK THAT YOUR RIFLE IS NOT LOADED.  
DO THIS WITH THE ACTION OPEN AND THE BOLT FULLY TO THE REAR,  
BY LOOKING DIRECTLY INTO THE CHAMBER AND MAGAZINE.**

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### **MAINTENANCE**

By following the few simple maintenance procedures listed below, your Nosler® rifle should provide many years of trouble-free 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 to ensure the tightness of all screws including the stock and receiver screws.
4. If you notice any changes in the functioning of your firearm, STOP SHOOTING IMMEDIATELY!

You should contact Nosler if you experience any occurrences similar to the following:

- The functioning of the trigger mechanism has changed.
- The rifle does not fire the cartridge (misfires).
- The safety does not operate.
- There is any cartridge malfunction, such as spitting gas, a punctured primer, a bulged or ruptured case or a different sound when firing.

**CAUTION! IN THE CASE OF A MISFIRE, POINT THE RIFLE IN A SAFE DIRECTION, MOVE THE SAFETY LEVER TO THE "SAFE" POSITION, AND WAIT 30 SECONDS BEFORE OPENING THE BOLT. THE BOLT SHOULD BE OPENED WITH EXTREME CARE.**

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5. 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 rifle.

**DO NOT SEND YOUR RIFLE TO NOSLER WITHOUT PRIOR AUTHORIZATION.**

If you have any problem with your new Nosler Rifle, please contact our Customer Satisfaction Department at 800-285-3701. Our representative can help with information that will make the use of your new Nosler rifle more enjoyable, or assist you with the best way to return the rifle for service. IN THE EVENT THAT SERVICE IS NECESSARY, NOSLER, INC. HAS A LISTING OF STANDARD PARTS, LABOR AND FREIGHT CHARGES—PLEASE CALL FOR ESTIMATES. Our Customer Satisfaction Department is available 8:00 AM until 4:30 PM (Pacific Time), Monday through Friday. Customer Satisfaction is usually closed on all legal holidays.

**Our shipping address:**

**Nosler, Inc.**

**107 SW Columbia Street**

**Bend, Oregon 97702**

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## **Additional Information**

### **Warning**

If your rifle is fitted with a muzzle-brake, make sure to wear adequate hearing protection when shooting! Muzzle-brakes dramatically increase the audible report of the rifle and WILL damage your hearing if you are not protected. Be considerate of those around you when firing your rifle as to not damage their hearing as well.

### **Barrel Break-In Procedure**

Following is the necessary barrel break-in procedure to ensure reliable and consistent accuracy from your new rifle:

1. Shoot one round and then clean, for first ten rounds.
2. Shoot three rounds and then clean, for next fifteen rounds.
3. Shoot five rounds and then clean, then shoot a fouler round, and then shoot three rounds for accuracy.

**NOTE:** Allow barrel to cool to ambient temperature before shooting each series of break-in rounds to avoid unnecessary throat erosion. Do not shoot your rifle in succession until the barrel is too hot to touch with a bare hand.

When cleaning, use these simple instructions:

#### **DO:**

- Use a quality one-piece cleaning rod.
- Use a bore guide.
- Clean from chamber end only.

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1. Clean powder residue from bore using a solvent like Shooter's Choice™ or Butch's Bore Shine™ following instructions on bottle.
2. Follow with a copper remover like Montana X-Treme™ Copper Killer to remove copper fouling. Instructions on bottle work the best.
3. Follow with a second group of patches coated in Shooter's Choice™, Butch's Bore Shine™, or similar solvent, then finish with dry patches until all solvent is removed from the bore.
4. Finish with a patch lightly coated with gun oil such as Tetra Gun Oil™ or Montana X-Treme Bore Conditioner Accuracy Gun Oil™. Shooting a dry bore will greatly promote copper fouling.

**DO NOT:**

- Use a stainless Steel bore brush.
- Leave strong ammonia cleaning products in your bore for extended periods of time – additionally, do not allow solvents to contact stock as it can remove the finish.

Once the barrel is broken in, remember to clean the barrel after approximately every 20 to 40 rounds to keep accuracy optimal. A dirty bore is a primary cause of poor accuracy.

**Scope Mount Information**

The Nosler Model 48 action is contoured to accept any standard two-piece scope base that would otherwise fit a Remington® Model 700™. Be aware that some scopes may have shorter main-tubes and may require reverse-front type bases, or extension scope rings to be properly mounted to the rifle.

**Caution**

When using this rifle in a shooting sled or rest, ensure the butt stock is firmly seated and there is adequate clearance for the sling swivel studs as to not be captured by any portion of the shooting rest during firing. Failure to do so can shear off the stud and cause serious damage to your rest, and rifle stock.

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### **Nosler Rifle Warranty**

I. Given Proper Care, your Nosler Rifle will provide a lifetime of service. We will review all warranty claims on a case by case basis to determine the cause of an issue. Any defects in materials or workmanship discovered within 5 years of the original purchase date will be corrected by Nosler free from charge. Any repairs needed as a result of customer negligence, wear from normal usage, or abuse can be repaired by Nosler staff for minimal cost, a listing of standard repair charges is available upon request. The Nosler Rifle Warranty will become void if the firearm is found altered in any way. If a warranty issue is suspected, please contact Nosler Customer Support. See pg. 14 for instructions.

II. All Nosler Rifles carry a guarantee for accuracy performance. We will support that guarantee for 30 days after the rifle has been picked up, provided the following criteria are met:

- a. The rifle is fitted with a high quality rifle scope.
- b. The rifle is fired using the prescribed Nosler Ammunition.
- c. The recommended rifle break-in procedure listed on pg. 15 has been completed.

If the rifle has not fired a group within the stated guarantee during this 30 day period, please contact Nosler Customer Support. We will determine if the rifle should be returned for inspection.

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III. DO NOT return the firearm to the dealer you purchased or picked up your rifle from. Call Nosler Customer Support first.

IV. Nosler Inc. is not responsible for damage during return shipments.

V. In no event shall Nosler Inc. be liable for consequential damages. Some states do not allow the exclusion or limitation of incidental or consequential damages, so the above limitation or exclusions may not apply to you. The limited warranty gives you specific legal rights, and you may also have other rights, which vary from state to state.

a. This warranty specifically excludes the cost of trips to the range, hunting trips, airfare, gasoline, guide fees, licenses, tags, ammunition, or any other related expenses.

**Important information for foreign customers:**

Due to the complexity of export/import rules between the United States of America and other countries, rifles that are sold outside the U.S.A. are sold "as is", and are not covered by all portions of Nosler's Limited Warranty. Please contact us directly and we will assist you if possible.

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# Warranty Registration

## Nosler Rifle

Model \_\_\_\_\_

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

Caliber \_\_\_\_\_

Name \_\_\_\_\_

Street Address \_\_\_\_\_

City \_\_\_\_\_ State \_\_\_\_\_ Zip Code \_\_\_\_\_

Phone Number ( ) \_\_\_\_\_ Email \_\_\_\_\_

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

Place of Purchase \_\_\_\_\_

Please Return To:

**Nosler Registration**  
Nosler, Inc.  
P.O. Box 671  
Bend, OR 97709

**www.nosler.com**

**800.285.3701**





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