

TCM BOLT ACTION RIFLE

USER'S MANUAL



WARNING: READ THE INSTRUCTIONS AND SAFETY PRECAUTIONS IN THIS MANUAL CAREFULLY BEFORE USING THE FIREARM.



ROCK ISLAND ARMORY

USER'S MANUAL TCM BOLT ACTION RIFLE

SAFETY, INSTRUCTION AND PARTS MANUAL



As a responsible owner of this firearm, you must read the instructions and warnings in this manual carefully. Before using this firearm, make sure you understand thoroughly the contents of this manual.

This manual must always be in the firearm's carrying case whenever the owner/user brings it or when it transfers ownership. A copy of this manual is available upon request from:

*ARMSCOR PRECISION INTERNATIONAL
150 N Smart Way, Pahrump NV 89060
E-mail: support@armscor.com*

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MAINTENANCE



STATEMENT OF LIABILITY

This rifle is classified as a firearm or dangerous weapon. It is expressly understood that we assume no liability for its resale or unsafe handling under local laws and regulations. Armscor assumes no responsibility for physical injury or property damage resulting from either intentional or accidental discharge, or for the function of the firearm subjected to influence beyond their control. Armscor will honor no claims which may result from careless handling, unauthorized adjustments, defective or improper ammunition, corrosion or neglect. Examine your firearm carefully at the time of purchase. It should be forwarded immediately to the factory or its sales agent if any adjustment of any kind of required.

State-By-State Warnings



CALIFORNIA STATE WARNING

CHILDREN ARE ATTRACTED TO AND CAN OPERATE FIREARMS THAT CAN CAUSE SEVERE INJURIES OR DEATH. PREVENT CHILD ACCESS BY ALWAYS KEEPING FIREARMS LOCKED AWAY AND UNLOADED WHEN NOT IN USE. IF YOU KEEP A LOADED FIREARM WHERE A CHILD OBTAINS AND IMPROPERLY USES IT, YOU MAY BE FINED OR SENT TO PRISON. IT IS UNLAWFUL TO USE A MAGAZINE WITH A CAPACITY OVER 10 ROUNDS.



MASSACHUSETTS STATE WARNING

IT IS UNLAWFUL TO CARRY ANY MAGAZINE OR BELT WHICH HOLDS MORE THAN TEN ROUNDS, UNLESS AUTHORITY IS GRANTED BY THE BOSTON POLICE COMMISSIONER. IT IS UNLAWFUL TO STORE OR KEEP A FIREARM, RIFLE, SHOTGUN OR MACHINE GUN IN ANY PLACE UNLESS THAT WEAPON IS EQUIPPED WITH A TAMPER RESISTANT SAFETY DEVICE OR IS STORED OR KEPT IN A SECURELY LOCKED CONTAINER.



NEW YORK STATE WARNING

IT IS UNLAWFUL TO CARRY ANY MAGAZINE OR BELT WHICH HOLDS MORE THAN SEVEN ROUNDS, UNLESS AUTHORITY IS GRANTED BY THE STATE OF NEW YORK. THE USE OF A LOCKING DEVICE OR SAFETY LOCK IS ONLY ONE ASPECT OF RESPONSIBLE FIREARMS STORAGE FOR INCREASED SAFETY, FIREARMS SHOULD BE STORED UNLOADED AND LOCKED IN A LOCATION THAT IS BOTH SEPARATED FROM THEIR AMMUNITION AND INACCESSIBLE TO CHILDREN AND OTHER UNAUTHORIZED PERSONS.

02 | SAFETY PRECAUTIONS

Safety must be the first and constant consideration of every person who handles firearms and ammunition. The person with a firearm in his possession has an important responsibility. He/she must know how to use his/her firearm safely:

1. Always keep the firearm holstered except when drawn for a definite purpose.
2. Always check the firearm for live ammunition when picked up, handed to, or received from another person.
3. Never point the firearm at anything you do not intend to shoot.
4. Never cock the hammer of the firearm unless you are ready to immediately shoot it. Do not even insert your finger in the trigger guard until you are ready to shoot.
5. Avoid dry firing even with dummy cartridges, unless the same is performed on a regular target range or at a known inanimate target.
6. When holding the firearm that is ready to fire, be absolutely certain that it is not pointed at any part of your body or at any person within your immediate vicinity.
7. Beware of obstructions in barrel. If, when firing, a weak or peculiar report is heard, cease firing and inspect the barrel for an obstruction. Remove magazine then check to insure there is no obstruction in barrel or chamber.
8. When a misfire or a "dud" is experienced keep the rifle pointed at the target for at least ten seconds before inspecting the firearm. A delayed firing may occur.
9. Remove magazine and ensure chamber and barrel are free of foreign objects.
10. When possible, wear shooting glasses and hearing protectors when firing.
11. Do not shoot at a hard surface, or water for the bullet can glance off and travel in unpredictable directions with considerable velocity.
12. Avoid drinking alcoholic beverages when handling the firearm.

WARNING:

DO NOT ATTEMPT TO USE ANY FIREARM WITHOUT HAVING A COMPLETE UNDERSTANDING OF ITS PARTICULAR CHARACTERISTICS AND SAFE USE.

WARNING:

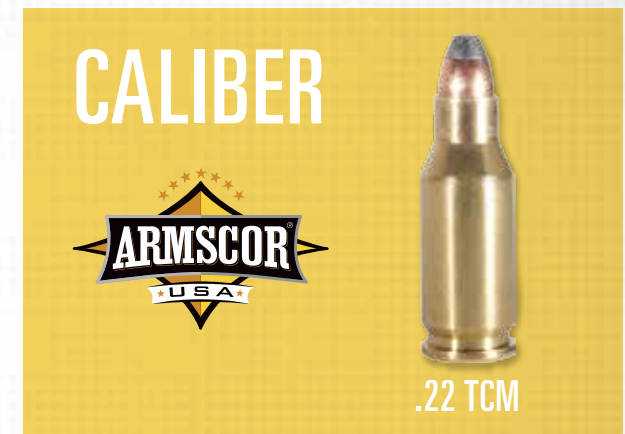
YOU SHOULD NEVER DEPEND ON A SAFETY MECHANISM OR ANY OTHER MECHANICAL DEVICE TO JUSTIFY CARELESS AND IMPROPER HANDLING.

WARNING:

THIS FIREARM WAS MANUFACTURED TO PERFORM PROPERLY WITH THE ORIGINAL PARTS AS DESIGNED. PLEASE MAKE SURE ANY PARTS YOU BUY ARE INSTALLED CORRECTLY AND THAT NEITHER REPLACEMENTS NOR ORIGINALS ARE ALTERED OR CHANGED. PUTTING A FIREARM TOGETHER INCORRECTLY OR WITH MODIFIED PARTS CAN RESULT IN DAMAGED FIREARM, DANGER, AND INJURY OR DEATH. ANY MODIFICATIONS TO FIREARM WILL VOID FACTORY WARRANTY.

03 | TECH SPECS

Model	RIA 22 TCM RIFLE
Caliber	.22 TCM
Action	Bolt Action
Magazine Capacity	5 Rounds
Barrel	Contoured rear end, uniform outside diameter to muzzle end, ordnance steel, precision rifled with 6- groove right hand twist
Barrel Length	578mm / 22.76in
Overall Length	1045mm / 41.14in
Overall Width	86mm / 3.36in
Overall Height	203mm / 8in
Trigger Pull	1.81 - 2.72kgs (4.0 - 6.0lbs)
Length of Pull	343mm - 356mm (13.5in - 13in)
Drop at Heel	79mm - 89mm(3.13in - 3.5in)
Drop at Comb	41mm - 44mm(1.63in - 1.75in)
Drop at Monte Carlo	3.45kgs / 7.61lbs
Finish	Parkerized / Anodized
Safety	Positive thumb-operated trigger block
Stock	Hand checkered Philippine wood, with contrasting grip and forend trip, Monte Carlo style with checkpiece, with rubber butt pad
Rifling, Twist	Right hand, 1 turn in 400mm(16")
Number of Grooves	6



.22 TCM				
CALIBER	BULLET		VELOCITY, fps	ENERGY, ft-lbs
	Weight, grains	Style	Muzzle	Muzzle
.22 TCM	40	JHP	2,000	355

TCM BOLT ACTION RIFLE BASIC PARTS

A. BARREL-RECEIVER ASSEMBLY	
PART NAME	PART NUMBER
Barrel	150MM01
Ejector	140E06
Ejector Screw	150MM04
Receiver	150MM11
Receiver Take Down Screw Front	150MM12
R.T. Down Screw Front Washer	150MM13
Receiver Take Down Screw Rear	180MM18
R.T. Down Screw Rear Washer	150MM13
Bolt Stopper	18019
Bolt Stopper Pivot Pin	18020
Bolt Stopper Spring	18021

B. BOLT ASSEMBLY	
PART NAME	PART NUMBER
Bolt	1801MM22
Cocking Cam w/ Handle	15015A
Cocking Cam Stud	15017
Cocking Indicator	140E17
Cocking Indicator Spring	140E17a
Cocking Cam Stud Retainer	15018
Extractor	150MM21
Extractor Plunger	15022
Extractor Spring	15023
Firing Pin	180MM31
Firing Pin Spring	15025
Firing Pin Spring Retainer Pin	15026
Firing Pin Spring Follower	15027
Firing Pin Cross Pin	15028
Hammer	18036

05 | BASIC PARTS

C. TRIGGER HOUSING ASSEMBLY	
PART NAME	PART NUMBER
Magazine Release	4524
Mahazine Release Lock	4525
Magazine Release Spring	4526
Safety Latch	15033
Safety Latch Stopper Pin	150MM33A
Safety Latch Bearing	15034
Safety Latch Bearing Spring	15035
Safety Latch Pivot Pin	15036
Safety Latch Button	15037
Sear	15038
Sear Pivot Pin	150MM39
Sear Spring	15040
Sear Stop Pin	15041
Trigger	15042
Trigger Pivot Pin	15043
Trigger Spring	15044
Trigger Adjusting Screw	150MM45
Trigger Housing	150MM46
T.H. Hold Down Screw (Front)	150MM47
T.H. Hold Down Screw (Rear)	150MM45
Feed Ramp	150MM49
Feed Ramp Hold Down Screw	150MM47

D. MAGAZINE BOX ASSEMBLY	
PART NAME	PART NUMBER
Magazine Box	0919MMA
Magazine Spring	0920MMA
Magazine Spring Follower	0921
Magazine Spring Plate*	0922MM
Magazine Base Pad	0923MM
Magazine Base Pad Retainer**	0923MMA

E. GUNSTOCK ASSEMBLY	
PART NAME	PART NUMBER
Butt Pad	15054R
Butt Pad Retainer Screw	15055
Gunstock	150MM56SC
Grip Cap	15057SC
Grip Cap locator Pin	15057SCA
Swivel Stud	15059
Swivel Base	15060
Swivel Base Washer	15061
Woodscrew-threaded Swivel Stud	15062

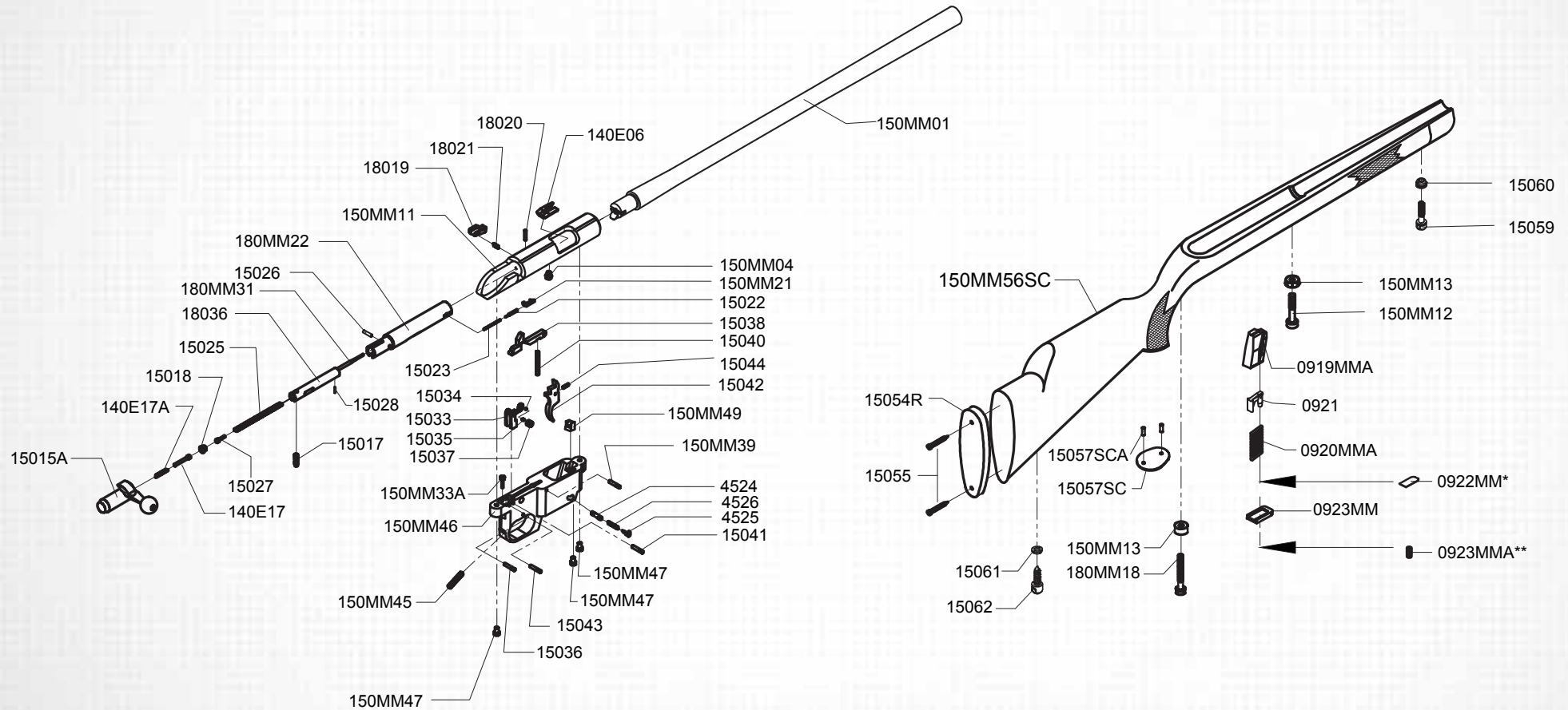
Note:

* For polymer magazine base pad only

** For aluminum magazine base pad only

06 | EXPLODED VIEWS

TCM BOLT ACTION RIFLE



07 | OPERATING INSTRUCTIONS

OPERATING INSTRUCTIONS

This rifle was made from high grade ordnance steel to handle the new caliber .22TCM cartridge, developed and manufactured by Rock Island Armory. This rifle is packed and shipped from the factory with detached bolt assembly.

TO LOAD INSERT BOLT INTO RECEIVER



Cock the bolt assembly by gripping the bolt firmly and rotating the cocking cam counter clockwise. Move safety to "F" position. Align the lug underneath the bolt assembly with the receiver track. Slide the cocked bolt assembly into the receiver, push it fully forward and turn the cocking cam clockwise until its top and bottom lugs are properly seated.

TO MAKE SAFE



Pull safety on right side of the receiver in the direction of the "S" mark. This locks trigger and gun cannot be fired.

TO OPEN ACTION



Hold bolt handle and rotate cocking cam counter clockwise. As soon as the lugs clear the lug seat, pull bolt handle fully rearward.

TO LOAD MAGAZINE BOX



Hold magazine firmly in one hand. With the other hand, position cartridge over magazine lip just forward of notch. Insert cartridge head under ears at rear of magazine. Repeat until five cartridges are loaded.

TO ATTACH MAGAZINE BOX



Position magazine open end up and ears rearward. Insert magazine into the opening forward of the trigger guard. Push magazine inward until it engages with the magazine catch.

TO CLOSE ACTION



Push bolt handle fully forward and rotate cocking cam clockwise until lugs are properly seated.

08 | OPERATING INSTRUCTIONS

TO FIRE



BE SURE THAT RIFLE IS POINTED AT TARGET! With action closed, move safety to "F" position. Pull trigger. To repeat, open and close action. The discharged shell will be ejected and a new cartridge will be fed into the chamber. Pull trigger. Repeat process as desired until magazine is empty.

TO LOAD FOR SINGLE SHOT



Open action. Insert cartridge directly into chamber with empty magazine in place.

FOR LONG STORAGE



After firing, swab bore with clean cloth patch wet with approved cleaning solvent. Wipe dry. Apply a good grade of gun grease or gun oil on the bore and other outside metal surfaces.

Before firing after storage, remove all traces of gun grease or gun oil from barrel bore. CHECK THAT BORE IS FREE OF ANY OBSTRUCTION! Obstruction will block passage of bullet and may cause injury to barrel or person.

TO REMOVE MAGAZINE BOX



To disengage magazine, pull magazine catch rearward, hold on lock and pull box downward and out.

FOR SHORT STORAGE



After firing, swab bore with clean cloth patch wet with approved cleaning solvent. Wipe dry. Apply light coat of oil on barrel bore, cocking cam, bolt and other metal surfaces to keep free of rust.



SCAN QR

SEE FULL VIDEO TUTORIALS ON OUR WEBSITE



CAUTION

THE SAFETY IN YOUR FIREARM IS CORRECTLY DESIGNED, FITTED AND TESTED. HOWEVER, ANY MECHANICAL DEVICE CAN FAIL. NEVER POINT AT ANYTHING BUT A SAFE TARGET AND NEVER RELY UPON THE SAFETY TO JUSTIFY CARELESS HANDLING. USE HIGH VELOCITY .22 CALIBER LONG RIFLE CARTRIDGES ONLY. WHEN LOADING, PULL BOLT HANDLE REARWARD AND ALLOW IT TO SNAP FORWARD SHARPLY. BREECH AREA AND MAGAZINE SHOULD BE CLEANED THOROUGHLY.

STORAGE AND TRANSPORTATION

When storing the firearm and ammunition, store in separate locations, store ammo in a cool, dry location.

When storing the gun for a prolonged period of time, It is necessary to oil it heavily with an acid-free lubricant. The external parts must be coated with an anti-rust oil or grease to prevent moisture causing the parts to rust and malfunction. Before usage, the rifle must be cleaned and wiped dry again as discussed previously.

WARNING:

CHILDREN ARE ATTRACTED TO AND CAN OPERATE FIREARMS THAT CAN CAUSE SEVERE INJURIES OR DEATH. PREVENT CHILD ACCESS BY ALWAYS KEEPING FIREARMS LOCKED AWAY AND UNLOADED WHEN NOT IN USE. IF YOU KEEP A LOADED FIREARM WHERE A CHILD OBTAINS AND IMPROPERLY USES IT, YOU MAY BE FINED OR SENT TO PRISON.

WARNING:

THE FIREARM SHOULD BE RE-STORED IN ROOMS WITH A DRY ATMOSPHERE AND WITH THE LEAST HUMIDITY. IT SHOULD NOT BE STORED ENCASED IN LEATHER OR ANYTHING THAT WILL ATTRACT AND HOLD MOISTURE, CAUSING IT TO RUST.

ORDERING PARTS

Visit RIA website to browse, learn more about and purchase parts and ammunition for all of your Rock Island Armory products.

 www.advancedtactical.com



WARRANTY REGISTRATION

Armcor's warranty covers its firearms and parts. We offer limited lifetime warranty on our products for their intended purpose. As with any product, abuse, gunsmithing by an unqualified person and normal wear and tear are excluded. Additionally, if the firearm was modified and/or repaired by an unqualified gunsmith without permission from Armcor, then the warranty will be void. If warranty work should be required, return the firearm to the address listed below. There is no refund for the shipping cost. Gunsmithing services are available by registered Armcor Gunsmithers. Please email the address below.

To register your firearm, please go to www.rockislandarmory.com/support-center/warranty/ and complete online warranty form. In comments section, write warranty registration and press submit. You can also go to www.rockislandarmory.com and press warranty section at the bottom.

For more information on warranty, visit www.rockislandarmory.com, or email support@armcor.com

Armcor Precision International
150 North Smart Way
Pahrump, NV 89060
Email: support@armcor.com

IMPORTANT WARRANTY INFORMATION

Our Rock Island Armory rifles are warranted to function only with Factory Brass Cased Ammo and the Original Factory Magazine. Use of Handloads is not covered in Warranty of Repair for the function of the Firearm.

DUE TO THE FIT AND TIGHTNESS OF FIREARM, RIA RECOMMENDS A BREAK-IN PERIOD OF 500 ROUNDS.

THIS IS HOW YOU VOID YOUR WARRANTY

- * Refinishing your RIA firearm
- * Misuse, Mishandling, Dropping your RIA Firearm
- * Firing Remanufactured or Reloaded Ammunition
- * Not properly reassembling your RIA Firearm resulting in damage, ie reverse plugs!
- * Any addition of after market parts
- * Unauthorized repairs done by any other than Rock Island Armory

LIMITS ON WARRANTY (will not cover)

- * Finish, Holster wear, Scratches, Chemical damage
- * After Market Magazines
- * Damage to Factory Magazines
- * Sights not installed by Rock Island Armory
- * Recoil Springs

WE RESERVE THE RIGHT TO CHARGE FOR LABOR, PARTS AND SHIPPING TO RETURN YOUR RIA FIREARM BACK TO FACTORY SPECIFICATIONS IF IT HAS BEEN ALTERED.

NOTES



WWW.ROCKISLANDARMORY.COM

