



**BERGARA**™

Our barrels make the difference

INSTRUCTION AND SAFETY MANUAL FOR  
**BERGARA PREMIER**  
**AND CUSTOM SERIES RIFLES**



## INTRODUCTION

Congratulations on the purchase of your Bergara Premier Series or Bergara Custom Series rifle. All Premier and Custom rifles sold in North America are made in the USA at the Bergara USA shop. Premier Series rifles are production rifles, built in advance of sale, but with the same basic components (barrel, action, trigger) as our Custom models. Custom Series guns are made to order for the customer, be it an individual or an authorized Bergara Dealer. Whether you have purchased a Premier Series production rifle, or a Custom Series rifle built to your specifications, we assure you that you have purchased one of the finest rifles available today.

Both Bergara Premier and Custom rifles normally feature our proprietary Bergara Premium Action. However, on a custom build, a customer will occasionally request a different action, such as a Stiller, Defiance, or Surgeon, or they may even provide an action from a stripped Remington 700 or a Winchester M70. If you have purchased a Bergara Custom Rifle built on an alternative action, be advised that some of the information and/or photographs in this manual may not apply to your rifle. In such cases, it is your responsibility to obtain and familiarize yourself with the specific operational and/or safety precautions related to your non-standard action. Bergara Customer Service Representatives are available to answer any questions that you may have on a case by case basis.

## SAFETY

When you become a shooter you take on a tremendous responsibility. The bullet, once it begins its journey from the cartridge case to its final destination, cannot be called back or stopped. It is therefore imperative that you read, memorize and practice the safety information contained in this book. Some of the text is in **RED** to emphasize its special importance, but don't let this lead you to believe that the other information in this manual is of lesser importance. Read this manual in its entirety. If you sell, trade or give this gun to any other person please make sure a copy of this manual accompanies the gun. Replacement manuals are available from BPI Customer Service. You can contact BPI by telephone, mail or email.

BPI Outdoors  
ATTN: Bergara USA Customer Service Dept  
1270 Progress Center Avenue, Suite 100  
Lawrenceville, GA 30043  
1-800-320-8767 [info@bergarausa.com](mailto:info@bergarausa.com)

## THE TEN COMMANDMENTS OF FIREARM SAFETY

1. **Always keep the muzzle pointed in a safe direction.** This is the single most important safety rule. You must be aware of your muzzle at all times. Accidents do happen, even to the most careful shooter. Keeping control of the muzzle can prevent a misfire from becoming a catastrophe.
2. **Always keep your finger away from the trigger until you are ready to shoot.** Lay your finger alongside the trigger guard or on the grip of the gun. Unless you are ready to fire, do not touch the trigger.

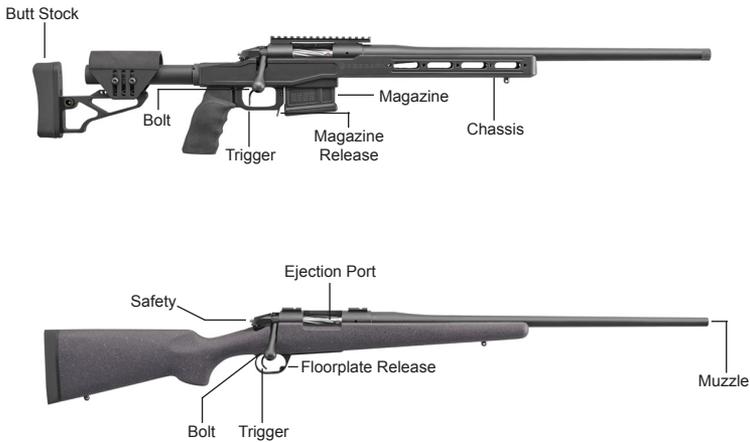
3. **Always keep the gun unloaded until ready for use.** When you pick up a gun, make it your habit to check to be sure it is not loaded. Engage the safety (if possible) and visually check the chamber to be sure it is empty. If you do not know how to work the mechanism-leave it alone until you can get help from someone who understands and can show you.
4. **Always know your target and what is beyond it.** Be absolutely sure you have identified your target beyond any doubt. Equally important, be aware of the area beyond your target. This means observing your prospective area of fire before you shoot. Never fire in a direction in which there are people, buildings or any other potential for mishap. Think first. Shoot second.
5. **Always be sure that you fully understand how to safely use your gun.** Read the manual that should come with the gun. Obtain a new one if necessary. Learn how to tell if a gun is loaded and how to unload it safely. **Understand that the manual safety on your gun is a mechanical device and, like all mechanical devices, it may fail.** Never depend on your gun's safety to replace safe gun handling. If your gun's manual safety should malfunction have it repaired immediately.
6. **Always use only the ammo that is correct for your gun.** Your barrel is marked with the proper caliber designation. The cartridge box and head stamp are also marked. Be sure that they match! Many incorrect cartridge/chamber combinations can result in disastrously high chamber pressures and can cause a catastrophic failure of the gun. If in doubt, properly dispose of the ammunition without firing.
7. **Always wear eye and ear protection.** This applies equally to shooters, bystanders and observers. Your ability to see and hear can never be replaced.
8. **Always avoid using alcohol, strong over-the-counter or prescription drugs, or any substance that may impair mental judgment while shooting or hunting.** Any substance that may impair you mentally or physically must be avoided while using firearms.
9. **Always store your guns in a securely locked area and away from the ammunition.** Although your gun may come with a mechanical locking device, these devices can be damaged or removed by children or unintended users. It is best to lock your guns in an enclosed cabinet or gun safe. Store your ammunition in a separate locked storage area.
10. **Always unload your gun prior to any transport by vehicle, horse, boat, etc., or upon entry into a building.**

Be aware that certain types of guns, accessories and shooting disciplines have additional safety requirements. Be sure to read all owner's manuals, range rules and shooting program rules with an open mind toward safety.

Bergara encourages you to take a certified hunter's safety course before using this rifle or any other firearm. Consult the Game and Fish authorities in your area or your local sporting goods dealer for information on courses available. Even if you do not intend to hunt game animals, the information and training gained from taking a hunter's safety course can help in preventing dangerous or fatal accidents from happening.

Discharging firearms in a poorly ventilated area and/or handling ammunition may cause exposure to lead or lead compounds. According to the state of California, exposure to lead or lead compounds may cause cancer, birth defects or other reproductive harm. Make sure that you have proper ventilation at all times. Be sure to wash your hands thoroughly after shooting, handling ammunition, or cleaning your firearms. Do not eat or smoke during these activities.

## IMPORTANT PARTS OF YOUR FIREARM



## THE GUN'S MANUAL SAFETY



All Bergara Premier rifles and most Bergara Custom rifles utilize a manual safety with a lever located on the right side of the receiver at the rear of the bolt. This lever rocks rearward to the "safe" position and forward to the "fire" position. The rifle's bolt can normally be manipulated while in either position. Some custom triggers or bolt sleeves may feature a safety with a third position that locks the bolt.

## INITIAL INSPECTION

Whether you purchased your rifle new or used, as a production rifle or as a custom rifle, you have a responsibility to check your rifle to insure proper function of all mechanical parts and general safe condition. Begin by removing the rifle from the case, then remove the bolt by pressing the bolt stop release (located on the left side of the receiver) while pulling the bolt to the rear. Make sure that the rifle is unloaded and the barrel is not obstructed.

Bolt Stop Release



Following the instructions in this manual, clean the bore with a good solvent to remove any oil or grease. Lubricate the gun properly. Replace the bolt in the action and check the functions of the bolt, trigger and safety. If you identify any questionable or unsafe functions stop immediately and contact Bergara Customer Service. Refer to the section below for the proper positioning of the bolt gas shield before inserting it into the action.

## THE BOLT GAS SHIELD

Ammunition failures are, fortunately, very rare. But they do happen. The Bergara Premier Action features an integrated bolt gas shield. The bolt gas shield is located near the front of the bolt body (see photo). The bolt gas shield does not rotate with the rest of the bolt when the locking lugs are locked into position. Instead, the gas shield remains in the bolt raceway and helps to seal the raceway and block gases and debris that could possibly travel through the body of the receiver and into the shooter's face. The bolt gas shield must be correctly positioned in order to insert the bolt into the receiver.

Gas Shield Positioning



## MOUNTING A SCOPE

Mounting a scope on the Bergara Premier and Custom rifles is a very straight-forward procedure. Highly recommended is the one-piece Picatinny style mount with a 20 MOA cant. These are available through Bergara USA, Bergara Authorized Dealers and other scope mount manufacturers. For those who prefer 2 piece mounts, the Bergara Premier Action uses the same dimension 2-piece scope mounts as the Browning A-Bolt 3, Savage Accu-Trigger guns (8X40 screws only).

Following the below procedure when installing your scope mount or mounts will ensure that your scope is installed correctly. The following procedure is general in nature and you may have to adjust your procedure to match the rings and mounts that you have purchased as per the instructions provided with them.

- Lock your rifle into a padded bench vise or a commercial gun cradle made for scope mounting and cleaning.
- Lay out your mount or mounts and all screws. Clean the screws with a solvent such as acetone or alcohol to remove any oil. Check the screw threads for damage.
- Clean the screw holes in the receiver with solvent.
- Place the scope mount on the receiver making sure that it is oriented correctly. Place a small amount of threadlock or equivalent directly onto the screw thread. Insert the screw and turn until only light resistance is felt.
- Tighten the scope mount screws a little at a time alternating from one screw to another until all screws reach a final tightness of 25 inch-pounds of torque. Pre-set commercial torque drivers are available from gunsmith supply houses. If the mount manufacturer recommends a different torque setting, use that setting.
- Place a precision level on top of the scope mount perpendicular to the bore and adjust the rifle in the vise until the bubble is centered. Follow the ring manufacturer's instructions to assemble the rings onto the scope and to place them correctly onto the scope mount. Press forward on the ring/scope assembly so that the rings contact the vertical recoil surface of the mount and secure the rings to the mount. Follow the ring manufacturer's instructions on torque setting.
- Set your eye relief. This is the distance from the shooters eye to the rear of the scope and it varies from one shooter to another. Move the scope forward or rearward in the rings until your view through the scope is correct – meaning a full circle view through the scope.
- In most cases the top of the scope adjustment turret can be used as a level reference. With the scope level in the rings, begin to tighten the rings onto the scope tube. Be careful to watch the level and adjust the scope tube accordingly. Follow the ring manufacturer's instructions on torque setting.

## **LOADING AND FIRING**

- **Check the barrel and be sure it is unloaded and unobstructed!**
- **Be sure that the ammunition you have is the correct ammunition for the gun!** Many rounds can fit into an incorrect chamber and create dangerously high pressures. For example, a .308 Winchester can easily chamber into a .270 Winchester rifle. Such mistakes are extremely dangerous and can result in serious injury or death. Military

ammunition, such as the 5.56 NATO and the 7.62 NATO, generally has thicker case walls than civilian ammunition such as the .223 Remington and the .308 Winchester. Other differences exist in the chamber throat and the pressure to which the ammunition is often loaded. Therefore, Bergara and the Small Arms and Ammunition Manufacturers' Institute (SAAMI) recommend against using military surplus ammo in civilian arms.

- Internal box magazines (non-removable) are loaded from the ejection port. With the bolt open, place the cartridge on the magazine follower or on top of the previously loaded cartridge. Push the round down into the magazine and to the rear. Repeat until the magazine is fully loaded. Your Bergara rifle will normally hold 4 standard or 3 magnum cartridges in the magazine, plus 1 in the chamber. The cartridges in the magazine can be pushed downward with the thumb to allow the bolt to close on an empty chamber or on a final round inserted directly into the barrel.
- External box magazines are loaded outside of the rifle. The Bergara Premier Series rifles in chassis stocks and many of the Bergara Custom rifles use compatible AICS magazine in 5 or 10 round. These are single column magazines. To load the magazine, press the base of the cartridge down on the front of the magazine follower and slide backwards under the feed lips. Each successive round will load in a similar way on top of the preceding cartridge. Insert the loaded magazine into the magazine well until it “clicks” into place.
- With the manual safety engaged, open the bolt by raising the bolt handle and pulling the bolt to the rear until it stops. Push the bolt forward, stripping a cartridge from the magazine and loading it into the chamber. Close the bolt fully.
- With your finger off the trigger, carefully align the scope's cross-hairs with the target, push the safety to its forward position, move your finger into the firing position, and smoothly pull the trigger.
- When finished shooting follow these instructions to safely unload your rifle:
  - o Raise the bolt handle and pull it fully to the rear. This will extract and eject any round that may be in the barrel. Look into the rear of the barrel and make sure that the chamber of the barrel is empty. Leave the bolt in the open position.
  - o Remove the detachable magazine, if applicable, by pressing the magazine release located at the front of the trigger guard. If you have a floorplate, as most hunting models do, press the release button at the front of the trigger guard and open the floorplate to release any ammo that may be in the internal magazine.
  - o If your rifle features a blind magazine without a floorplate, you must carefully work the bolt to cycle any rounds in the internal box magazine through the action. **Be sure to keep your rifle pointed in a safe direction and, if possible, keep your safety in the safe position during this operation.**

## CLEANING AND MAINTENANCE

- There are many suitable products on the market for cleaning and maintaining your rifle. Choose good quality products and follow the manufacturer's instructions. We recommend a basic pull-through cleaning kit. If you prefer to use a cleaning rod, choose a one-piece rod without joints. Dirt and grit easily embed into soft materials such as aluminum and brass. Avoid cleaning rods made from these materials. Use ammonia-based copper removers only when necessary and never mix ammonia based products with chlorinated solvents. Products that clean, lubricate and protect (CLP) are a good choice in most instances.
- Disassembly
  - o **Be certain that the gun is unloaded before proceeding!**
  - o Remove the detachable magazine, if applicable, by pressing the magazine release located at the front of the trigger guard. If you have a floorplate, as most hunting models do, press the release button at the front of the trigger guard and open the floorplate to release any ammo that may be in the internal magazine.
  - o If your rifle features a blind magazine without a floorplate, you must carefully work the bolt to cycle any rounds in the internal box magazine through the action. Be sure to keep your rifle pointed in a safe direction and, if possible, your safety in the safe position during this operation.
  - o Remove the bolt by raising the bolt handle and pulling the bolt to the rear. Simultaneously press the bolt stop lever on the opposite side of the receiver and pull the bolt from the rear of the action. Set the bolt aside. Look into the action at the cartridge chamber at the rear of the barrel and be certain that the rifle is unloaded.
  - o Normally the barrel can be cleaned with no further disassembly. If you choose to remove the barrel and action from the stock, use a properly fitting wrench to remove the 2 action screws and carefully lift the action straight up and out of the stock.



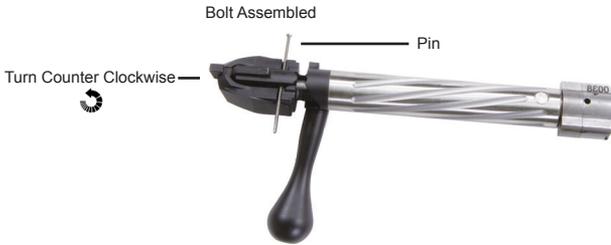
### Bolt Parts

for serial prefix A, B, C

- ① Firing Pin Assembly
- ② Bolt Body
- ③ Bolt Head Pin
- ④ Spring Washer
- ⑤ Gas Shield
- ⑥ Bolt Head

- Bolt Disassembly

- o Insert a pin through the area shown and turn the bolt shroud counter-clockwise to remove the firing pin assembly from the bolt body.
- o Use the tip of the firing pin to push the bolt head pin through the bolt body.



- o Pull the bolt head, gas shield and spring out of the bolt body.

- Reassemble in reverse order. When reassembling, be sure to properly orient the bolt head, gas shield and spring. The bolt head and gas shield have a groove that aligns with the ejection port side of the receiver. *Reference photo on page 3.*



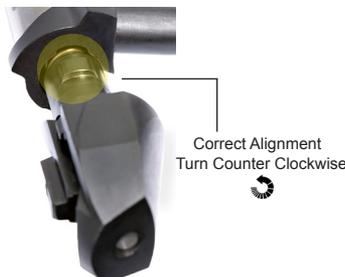
**Bolt Parts**

for serial prefix amd.C, D, E...

- ① Firing Pin Assembly
- ② Bolt Body
- ③ Bolt Head Pin
- ④ Spring Washer
- ⑤ Gas Shield
- ⑥ Bolt Head

- Bolt Disassembly

- o Turn the Bolt shroud clockwise until the firing pin assembly releases from the bolt body.
- o To assemble insert the firing pin assembly into the bolt body. Ensure the firing pin assembly lug is aligned with the recess in the bolt body as pictured below.



- o Push the firing pin assembly in against the bolt body depressing the firing pin spring and turn counter clockwise until the cocking piece engages the recess.
- The 2 action screws should be gradually tightened to a final torque of 55 inch-pounds for consistent performance.
- Lubricate the bolt and action at contact points.

## **WARRANTY**

Bergara USA warrants all Premier and Custom rifles to be free of defects in materials and workmanship for the lifetime of the firearm. This Limited Lifetime Warranty only applies to the original owner. This warranty must be registered by the consumer either through mail return of the warranty card or by on-line registration at <http://bergarausa.com/warranty.php>. Any Bergara rifle or part thereof displaying any defect as described above may be returned to Bergara USA to be repaired or replaced at no charge. This warranty does not apply to any damage to structures, buildings, vehicles, persons or animals, or any other damages resulting from improper loading, careless handling, improper maintenance, improperly loaded ammunition, or customer alterations, and Bergara USA reserves the right to refuse repair or replacement due to any damages resulting from such misuse of the firearm. This warranty does not cover normal wear of any part or any inconvenience and/or expense incurred due to product failure.



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