

# 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.

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## MAINTENANCE



# 01 | STATEMENT OF LIABILITY

## 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.

### 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 | OPERATING INSTRUCTIONS AND CARE

This rifle was designed from high grade ordnance steel to handle the new caliber .22TCM cartridge, developed and manufactured by Armscor Global Defense, Inc. This rifle is packed and shipped from the factory with detached bolt assembly.

### TO 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 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 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 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 release in its slot locking in place.

### TO REMOVE MAGAZINE BOX

To disengage magazine, press magazine release, hold on lock and pull box downward and out.

### 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 CLOSE ACTION

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

### 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

*IMPORTANT: CAL.22 TCM is a neck rifle style cartridge which uses a slower burning powder. When fired, some powder residues are left behind. Thus, cleaning the gun after around 300 rounds fired is highly recommended as keeping the chamber clean is much more critical on this type of ammunition.*

### 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.

### 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.

# 03 | TECHNICAL SPECIFICATION

Model	RIA 22TCM STANDARD RIFLE	RIA 22TCM RIFLETACTICAL	RIA 22TCM RIFLETACTICAL - CS
Model Number	51108	51110	51115
Caliber	.22TCM		
Action	Bolt Action		
Capacity	5 rounds		
Barrel	Contoured rear end, uniform OD to muzzle end	Contoured rear end, uniform OD to muzzle end, Ordnance steel, Precision rifled	Contoured rear end, uniform OD to muzzle end, Ordnance steel, Precision rifled. Threaded Barrel
Barrel Length	578mm. / 22 3/4in.	559mm. / 22in.	457.2mm. / 18in.
Overall Length	1045mm. / 41 1/8in.	1004mm. / 39 1/2in.	901.7mm. / 35 1/2in.
Overall Width	86mm. / 3 3/8in.		
Overall Height	203mm. / 8in.		
Front Sight	*Not included		
Rear Sight	*Not included		
Trigger Pull	1.81 – 2.72kgs (4.0 – 6.0lbs)		
Length of Pull	343 – 356mm. / 13 1/2in. – 14in.	356 – 393.7mm. / 14in. – 15 1/2in.	
Drop at Heel	79 – 89mm. / 3 1/8in. – 3 1/2in.	N/A	
Drop at Comb	41 – 44mm. / (1 5/8in. – 1 3/4in.	N/A	
Weight Empty	3.45kgs. / 761lbs.	3.18kgs. / 70lbs.	3.18kgs. / 70lbs.
Finish	Parkerized / Anodized		
Stock	Hand checkered Philippine wood, with contrasting grip and forend tip, Monte Carlo style with cheek piece, with rubber but pad	Polymer stock	
Safety	Positive thumb operated		
Rifling, Twist	Right hand, 1 turn in 400mm. (16in.)		
Number of Grooves	6		

## 04 | 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, drawn from the holster, 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.

# 05 | BASIC PARTS LIST

PART NO.	PART NAME	MODEL		
		RIA 22 TCM STANDARD RIFLE	RIA 22 TCM RIFLE TACTICAL	RIA 22 TCM RIFLE TACTICAL - CS
		51108	51110	51115
<b>A. BARREL - RECEIVER ASSEMBLY</b>				
150MM01	Barrel	✓	✓	✓
150MM01TCSTM	Barrel-CS			✓
1402A	Muzzle Thread Cover			✓
140 E06	Ejector	✓	✓	✓
150MM04	Ejector Screw	✓	✓	✓
150MM07	Picatinny Rail Block		✓	✓
150MM08	Picatinny Rail Block Screw		✓	✓
150MM11	Receiver	✓	✓	✓
150MM12	Receiver Take Down Screw Front	✓	✓	✓
150MM13	Receiver Take Down Screw Front & Rear Washer	✓	✓	✓
180MM18	Receiver Take Down Screw Rear	✓	✓	✓
18019	Bolt Stopper	✓	✓	✓
18020	Bolt Stopper Pivot Pin	✓	✓	✓
18021	Bolt Stopper Spring	✓	✓	✓
<b>B. BOLT ASSEMBLY</b>				
180MM22	Bolt	✓	✓	✓
15015A	Cocking Cam w/ handle	✓	✓	✓
15017	Cocking Cam Stud	✓	✓	✓
140 E17	Cocking Indicator	✓	✓	✓
140 E17A	Cocking Indicator Spring	✓	✓	✓
15018	Cocking Cam Stud Retainer	✓	✓	✓
150MM21	Extractor	✓	✓	✓
15022	Extractor Plunger	✓	✓	✓

# 06 | BASIC PARTS LIST

15023	Extractor Spring	✓	✓	✓
180MM31	Firing Pin	✓	✓	✓
15025	Firing Pin Spring	✓	✓	✓
15026	Firing Pin Spring Retainer Pin	✓	✓	✓
15027	Firing Pin Spring Follower	✓	✓	✓
15028	Firing Pin Cross Pin	✓	✓	✓
18036	Hammer	✓	✓	✓
<b>C. TRIGGER HOUSING ASSEMBLY</b>				
4524A2	Magazine Release (HI-cap)	✓	✓	✓
4525	Magazine Release Lock	✓	✓	✓
4526	Magazine Release Spring	✓	✓	✓
15033	Safety Latch	✓	✓	✓
150MM33A	Safety Latch Stopper Pin	✓	✓	✓
15034	Safety Latch Bearing	✓	✓	✓
15035	Safety Latch Bearing Spring	✓	✓	✓
15036	Safety Latch Pivot Pin	✓	✓	✓
15037	Safety Latch Button	✓	✓	✓
15038	Sear	✓	✓	✓
150MM39	Sear Pivot Pin	✓	✓	✓
15040	Sear Spring	✓	✓	✓
15041	Sear Stop Pin	✓	✓	✓
15042	Trigger	✓	✓	✓
15043	Trigger Pivot Pin	✓	✓	✓
15044	Trigger Spring	✓	✓	✓
150MM45	Trigger Adjusting Screw	✓	✓	✓
150MM46	Trigger Housing	✓	✓	✓
150MM47	Trigger Housing H/D Screw (Front and Rear)	✓	✓	✓
150MM49	Feed Ramp	✓	✓	✓
150MM47	Feed Ramp Hold Down Screw	✓	✓	✓

# 07 | BASIC PARTS LIST

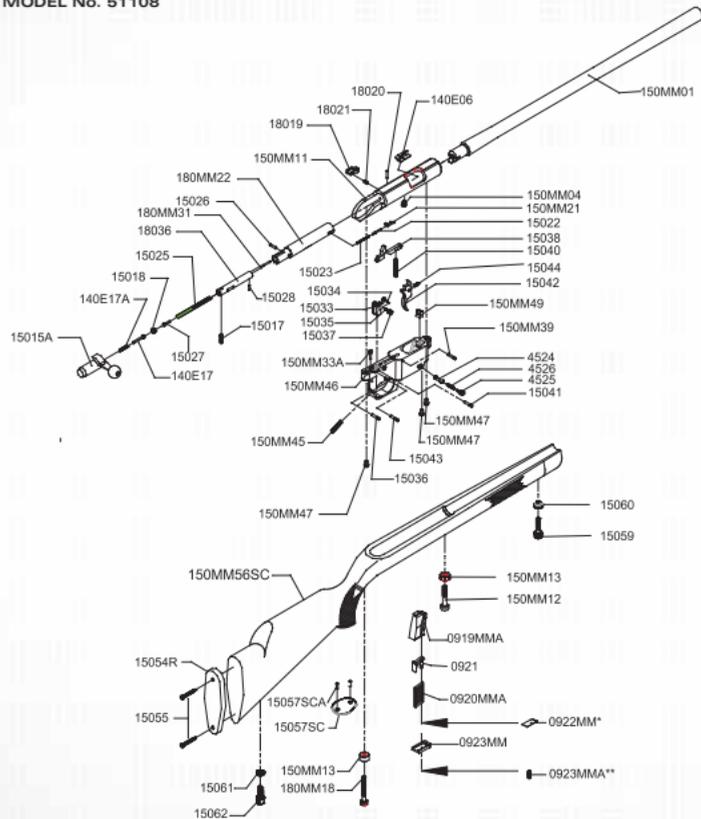
D. MAGAZINE ASSEMBLY (FOR ENP/KG COLUMN : IN-PLANT / MECGAR SUPPLIED)				
0919MMA	Magazine Box (5 rounds)	✓	✓	✓
E. GUNSTOCK ASSEMBLY				
15054R	Butt Pad (1/2" RUBBER )	✓		
15055	Butt Pad Retainer Screw	✓		
150MM56SC	Gunstock (Super Classic)	✓		
150MM56SCPA	Gunstock (Polymer)		✓	✓
15059	Swivel Stud	✓	✓	✓
15061A	Swivel Stud Retaining Nut		✓	✓
15061B	Swivel Stud Retaining Nut Washer		✓	✓
15061C	Swivel Stud Retaining Nut Lock Washer		✓	✓
15060	Swivel Base	✓		
15061	Swivel Base Washer	✓		
15062	Woodscrew-threaded Swivel Stud	✓		
150MM62	Extendable Bi-pod Unit	✓	✓	✓

## NOTES:

- When ordering parts, it is necessary to specify the model aside from the part number.
- Refer to the exploded drawing of the required model or variant for visual check of parts.

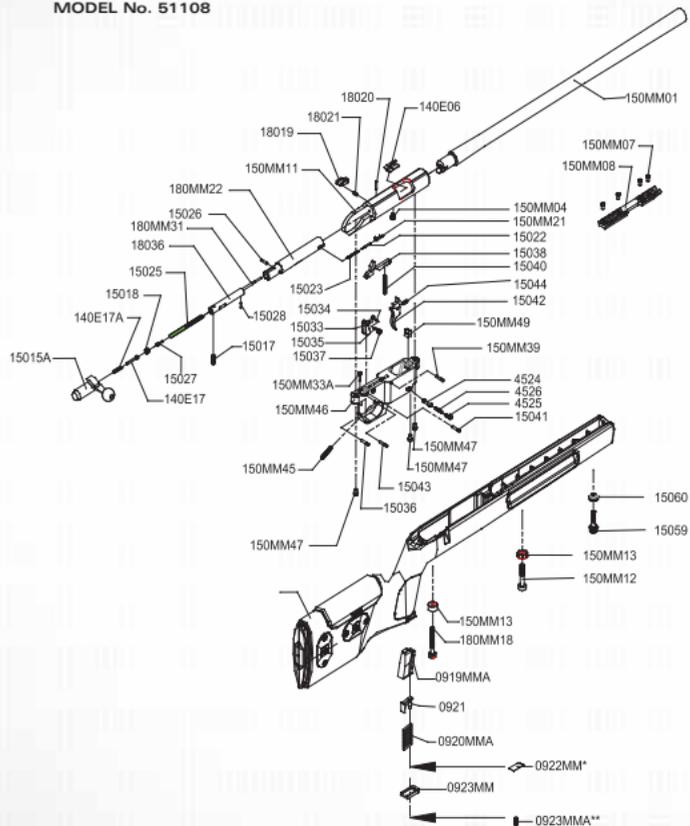
# 08 | EXPLODED DRAWING

**M22 TCM BA**  
MODEL No. 51108



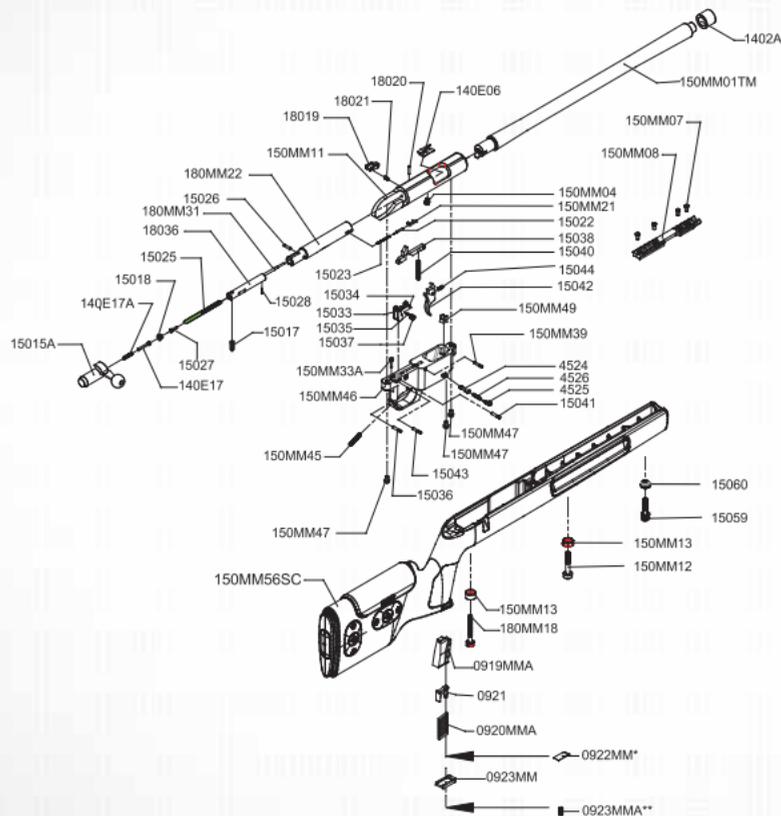
# 09 | EXPLODED DRAWING

**M22 TCM TACTICAL**  
MODEL No. 51108



# 10 | EXPLODED DRAWING

**M22 TCM TACTICAL - CS**  
MODEL No. 51115



## **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](http://www.advancedtactical.com)



## **WARRANTY REGISTRATION**

ARMSCOR PRECISION INTERNATIONAL / ARMSCOR GLOBAL DEFENSE, Inc. will adjust or repair, to its commercial standard, the firearms or any part thereof found to be defective in material or workmanship. Such services shall be made free of charge for a limited lifetime warranty from date of registered purchase. This product is only warranted when using factory TCM or original micromag ammunition. Always use factory spec ammunition loaded by Armscor.

If you have any questions or concerns, contact us at:

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