

# SIG SAUER®



\*SHOWN WITH OPTIONAL SCOPE AND MOUNT

## SIG CROSS®

**OPERATOR'S MANUAL: HANDLING & SAFETY INSTRUCTIONS**



READ THE INSTRUCTIONS AND WARNINGS IN THIS MANUAL CAREFULLY BEFORE USING THIS FIREARM. DO NOT DISCARD THIS MANUAL.

THIS MANUAL SHOULD ALWAYS ACCOMPANY THIS FIREARM AND BE TRANSFERRED WITH IT UPON CHANGE IN OWNERSHIP, OR WHEN THE FIREARM IS PRESENTED TO ANOTHER PERSON.



# WARNINGS



# WARNINGS

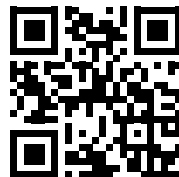
**SIGSAUER**



## WARNING

**BEFORE OPERATING THE FIREARM, REVIEW THE SAFETY WARNINGS MANUAL THAT WAS PROVIDED WITH THE FIREARM. ALTERNATIVELY, REFER TO SIGSAUER.COM FOR THE LATEST SAFETY WARNING INFORMATION.**

For more information, scan the QR code below to visit [sigsauer.com](https://www.sigsauer.com).





# WARNINGS

## 1.0 SAFETY WARNINGS

**READ THIS ENTIRE MANUAL THOROUGHLY AND CAREFULLY PRIOR TO USING THIS FIREARM.**

SIG SAUER, INC.® firearms are designed to function reliably with proper care and knowledgeable use. Operators must understand the safe operation and use of any SIG SAUER firearm. Read and follow these instructions carefully. Do not use the firearm without understanding the instructions outlined in this manual and the safe operation of the firearm. **Failure to follow the instructions outlined in this manual may result in serious injury or death to the operator and/or others. Damage to the firearm and other property may also occur.**

The warnings in this Operator's Manual are extremely important. By understanding the dangers inherent in the use of any firearm, and by taking the precautions described in this manual, you can experience a high level of safety in the use of your firearm. Failure to heed any of these warnings may result in serious injury or death to you or others, as well as severe damage to the firearm or other property.



# WARNINGS

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**WARNINGS** in this manual identify a clear danger to the person performing that procedure. Warnings are identified by a red banner with the word **WARNING** in white, bold, uppercase letters and a **WARNING** icon. Failure to comply with a **WARNING** can result in serious injury or death to you or a bystander.



**WARNING**

**CAUTIONS** in this manual identify a risk of damage to the firearm being maintained. **CAUTIONS** are identified by a black banner with the word **CAUTION** in white, bold, uppercase letters.

**CAUTION**



# WARNINGS

## 2.0 HANDLING

Your firearm comes equipped with effective, well-designed safety features. However, never rely completely on any safety mechanism. Safety mechanisms are designed to augment, not replace safe handling practices. Careless and improper handling of any firearm can result in an unintentional discharge.

Proper and applied training in safe firearm handling will ensure the safe use of your firearm. Like all mechanical devices, the safety mechanisms are subject to breakage or malfunction and can be negatively affected by wear, abuse, dirt, corrosion, incorrect assembly, improper adjustment or repair, or lack of maintenance. Moreover, there is no such thing as a safety mechanism that is “childproof” or that can completely prevent accidental discharge from improper usage, carelessness, “horseplay”, or abusive handling.

Always handle your firearm as though you expect the safeties not to work.

### **THE MOST EFFECTIVE SAFETY IS TO CARRY FIREARM WITHOUT A ROUND IN THE CHAMBER, AND TO LOAD A ROUND IN THE CHAMBER ONLY WHEN READY TO FIRE.**

Do not load a cartridge into the chamber until you are ready to use the firearm. Keep the firearm on SAFE until you are actually ready to use the firearm. Always move the selector fully to its engaged position and visually check it. The selector is not on SAFE unless it is completely on SAFE.



# WARNINGS

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## 2.0.1 BASIC RULES OF SAFE FIREARMS HANDLING

- ALWAYS treat every firearm as if it were loaded.
- ONLY load a round in the chamber when ready to fire.
- NEVER pull the trigger or place fingers on the trigger or in the trigger guard until ready to fire.
- NEVER allow clothing or other foreign objects to interfere or come in contact with the trigger.
- ALWAYS carry a pistol in a holster specifically designed for that pistol. It is the responsibility of the customer to ensure the holster is compatible with their specific pistol and any installed accessories.
- ALWAYS be sure the barrel is clear of any obstruction.
- ALWAYS be aware of the surroundings, and the safety of bystanders, before shooting. Know the target and what is in front of and beyond it.
- ALWAYS use clean, dry, original factory-made ammunition of the proper type and caliber for the firearm.
- ALWAYS wear ear protection and safety glasses when shooting.
- ALWAYS carry a firearm so that control of the muzzle can be maintained in the event of a fall or stumble.
- NEVER shoot at a flat surface or water.



# WARNINGS

- DO NOT leave a loaded firearm unattended. Only store a firearm that is unloaded, cleared of all ammunition, and locked in a secure place inaccessible to children or unauthorized persons.
- NEVER allow the firearm to be used by anyone who has not read and understood the Operator's Manual.
- ALWAYS unload and clear a firearm according to the instructions in the Operator's Manual before handing it to another person.
- DO NOT point any firearm, loaded or unloaded, at any undesignated or unsafe target.
- NEVER discharge a firearm near an animal unless the animal is trained to accept the noise. An animal's startled reaction could injure it or cause an accident.
- NEVER drink alcoholic beverages or use drugs before or during shooting, as vision and judgment could be seriously impaired, making firearm handling unsafe.
- ALWAYS seek a doctor's advice before using a firearm if using medication that would impair judgment or usage.



# WARNINGS

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## 2.1 ABUSIVE HANDLING

SIG SAUER firearms incorporate effective mechanical safeties. However, like any mechanical device, exposure to abusive conditions may harm these safety mechanisms and cause them to fail to work as designed. Do not subject the SIG SAUER firearm to any abusive handling. This includes the firearm being dropped, impact to the firearm, or the firearm being struck by another object. Always maintain control of the firearm. If the firearm suffers an abusive event such as previously described, or experiences a malfunction, do not attempt to use the firearm. Keep the firearm pointed in a safe direction, unload and clear the firearm of all ammunition immediately, and have it inspected by a certified SIG SAUER armorer before using the firearm.

ALWAYS keep the firearm pointed in a safe direction. A safe direction is defined as an area where, if the firearm were to discharge, no property damage would occur, and no personal injury would result.

As previously noted, if the SIG SAUER firearm suffers an abusive event, unload it immediately and have it inspected by a certified SIG SAUER Armorer prior to using the firearm. If the firearm suffers an abusive event during a life-threatening/self-defense situation, follow the steps below immediately:

1. Raise the bolt handle and pull it to the rear to eject the chambered cartridge.
2. Push the bolt forward to chamber a new cartridge and reset the trigger mechanism.
3. The firearm should now be returned to proper operational condition.

Intentional or repetitive abusive handling of any SIG SAUER firearm will void the manufacturer's warranty and could render the firearm unsafe.



# WARNINGS

## 3.0 ALTERATIONS AND REPLACEMENT PARTS

**Do not attempt to disassemble a SIG SAUER firearm beyond the point explained in the Operator's Manual. Disassembly beyond the instructions in the Operator's Manual is restricted to a certified SIG SAUER Armorer. Failure to comply with these restrictions will void the warranty.**

This SIG SAUER firearm was designed to function properly in its original condition. Unauthorized alterations can make it unsafe. Do not alter or substitute any parts in this firearm with unauthorized parts or accessories. Warnings and instructions about the use of SIG SAUER replacement parts, assemblies, and accessories may be described in instructions accompanying the specific products. Read and carefully follow those instructions. Failure to comply may result in serious injury or death to the operator and/or others. The use of aftermarket replacement parts is unauthorized and, in some instances, could alter the function of the firearm.

## 3.1 ACCESSORIES

It is the responsibility of the operator to ensure all accessories are compatible with the firearm and do not interfere with the safe operation and handling of the firearm.



# WARNINGS

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## 3.2 TRANSPORTING

When transporting a firearm, be sure the firearm is unloaded and cleared of all ammunition. It is the responsibility of the operator to know the laws of different states and jurisdictions when traveling with a firearm.

## 3.3 STORAGE

Safe and secure storage is an important responsibility. The only safe way to store a firearm is unloaded, cleared of all ammunition, and locked in a secure place inaccessible to children or unauthorized persons.

## 3.4 CHAMBER SAFETY FLAG

Every SIG SAUER firearm is shipped with a chamber safety flag. When installed, the chamber safety flag prevents the chambering of a round and provides a readily visible indication that the firearm's chamber is empty. The chamber safety flag is to be placed in the firearm's chamber at all times when the firearm is not in use. Many public ranges require chamber safety flags be installed when the firing line is cold.



# WARNINGS

## 3.5 LIABILITY

This product is classified as a FIREARM and is sold by SIG SAUER with the specific understanding that we shall not be responsible in any manner whatsoever for malfunctioning of the firearm, physical injury, or property damage resulting in whole or in part from:

- Criminal or negligent discharge
- Improper, careless, or abusive handling
- Unauthorized modifications or parts replacement
- Defective, improper, hand-loaded, or reloaded ammunition
- Corrosion
- Neglect
- Other influences beyond our direct and immediate control

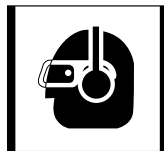
This limitation applies regardless of whether liability is asserted on the basis of contract, negligence, or strict liability (including any failure to warn). Under no circumstance shall SIG SAUER, Inc. be liable for incidental or consequential damages such as loss of use of property, commercial loss, and loss of earnings or profits.



# WARNINGS

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## 4.0 EYE AND EAR PROTECTION



Always wear safety glasses that meet the requirements of American National Standards Institute (ANSI) z87.1 or European Standard (EN)166:2001 and ear plugs and “ earmuff ” type protectors whenever shooting. Always make certain that persons close are similarly protected. Unprotected eyes may be injured by powder, gas, carbon residue, lubricant, metallic particles, or similar debris that may emanate occasionally from any firearm in normal use. Without ear protection, repeated exposure to shooting noise may lead to cumulative, permanent hearing loss.

## 5.0 AMMUNITION

Use only high-quality, original, factory-manufactured ammunition. Do not use cartridges that are dirty, wet, corroded, bent, or damaged. A damaged or deformed cartridge may impede chambering or cause the cartridge case to burst upon firing. Do not oil cartridges. Lubricant or other foreign matter on cartridges can potentially cause dangerous ammunition malfunctions. Some highly penetrative lubricants can also migrate inside cartridge cases and cause deterioration of the propellant powder; on firing, the powder might not ignite. If only the primer ignites, there is danger that the bullet may become lodged in the barrel. Only use ammunition of the caliber for which the firearm is chambered.

The proper caliber is permanently engraved on the firearm’s barrel.



# WARNINGS

The use of reloaded, hand-loaded (re-manufactured), or other nonstandard ammunition voids all warranties. Reloading is a science, and improperly loaded ammunition can cause severe damage to the firearm and may result in serious injury or death to the operator and/or others.

Always use ammunition that complies with the industry performance standards established by the Sporting Arms and Ammunition Manufacturers' Institute, Inc. (SAAMI) or ammunition manufactured to U.S. military specifications.

**SIG SAUER, Inc., specifically disclaims responsibility for any damage or injury whatsoever occurring in connection with, or as a result of, the use of any SIG SAUER firearm of faulty, nonstandard, hand-loaded (reloaded) ammunition, or cartridges other than those for which the firearm was originally chambered. Excessive pressure inside the chamber or barrel while firing a firearm may cause severe damage and serious injury or death to the shooter or to others may occur.**



**WARNING: CANCER AND REPRODUCTIVE HARM—[www.P65warnings.ca.gov](http://www.P65warnings.ca.gov)**



DISCHARGING FIREARMS IN POORLY VENTILATED AREAS, CLEANING FIREARMS, OR HANDLING AMMUNITION MAY RESULT IN EXPOSURE TO LEAD AND OTHER SUBSTANCES KNOWN TO THE STATE OF CALIFORNIA TO CAUSE BIRTH DEFECTS, REPRODUCTIVE HARM, AND OTHER SERIOUS PHYSICAL INJURY. MAINTAIN ADEQUATE VENTILATION AT ALL TIMES. WASH HANDS THOROUGHLY AFTER EXPOSURE. SHOOTING OR CLEANING FIREARMS MAY EXPOSE OPERATORS TO LEAD.



# WARNINGS

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## 6.0 LOCKING DEVICES



All SIG SAUER firearms are shipped with a key-operated locking device or a lockable case.

Never install the locking device inside the trigger guard or in any way that makes it possible to pull the trigger! Do not leave the keys in the lock.

All firearm owners are responsible for secure storage of any firearm.

ALWAYS refer to the locking device's manufacturer directions for installation and removal of the device.



## 7.0 SAFETY INFORMATION

This operator's manual is designed to assist you in learning how to use and care for your SIG SAUER® firearm properly.

Only when you are certain that you fully understand this manual and can properly carry out its instructions should you practice loading and firing your firearm with live ammunition. Having a firearm in your possession is a full-time job; you cannot guess and you cannot forget. You must know how to use your firearm safely.

If you have any doubts about your ability to handle or use this firearm safely, you should seek supervised instruction.

The SIG SAUER Academy provides all levels of firearms safety and skill training, from beginner to expert.

For more information contact:



sigsaueracademy.com • (603) 610-3400  
Epping, New Hampshire

### **SAFETY MUST BE THE FIRST AND CONSTANT CONSIDERATION OF EVERY PERSON WHO HANDLES FIREARMS AND AMMUNITION.**

For more information about safety, responsible firearms ownership, and shooting sports, contact:  
National Rifle Association (NRA) of America  
11250 Waples Mill Road, Fairfax, VA 22030-7400 • 1-800-672-3888  
nra.com

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## 8.0 MECHANICAL CHARACTERISTICS

### 8.1 GENERAL DESCRIPTION

The SIG CROSS is a magazine fed, bolt action precision rifle. The rifle features a folding stock that is adjustable for length of pull (LOP), comb height, butt pad height, butt pad cant, and stock folding direction. The trigger pull can be adjusted by the operator over an adjustment range of approximately 1.5 pounds.

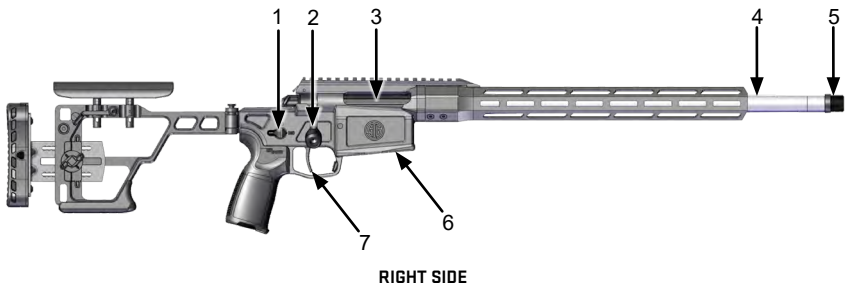
Most CROSS models come standard with a steel barrel. CROSS SAWTOOTH models are equipped with a carbon fiber barrel.

Additional information about SIG SAUER products, SIG SAUER Academy and the SIG Experience Center, Special Programs, and additional support can be found by scanning the QR code below to visit [sigsauer.com](http://sigsauer.com).

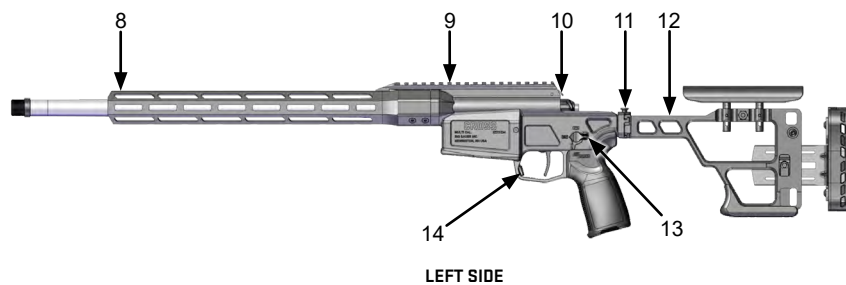




**8.2 CONTROLS AND FEATURES**



NUMBER	NOMENCLATURE
1	Ambidextrous Safety Selector
2	Bolt Knob
3	Ejection Port
4	Barrel
5	Thread Protector
6	Magazine Well
7	Trigger



NUMBER	NOMENCLATURE
8	Handguard
9	MIL-STD 1913 Rail
10	Bolt Catch
11	Stock Hinge Button
12	Stock
13	Ambidextrous Safety Selector
14	Magazine Catch



## 8.3 ASSEMBLIES

### 8.3.1 BOLT ASSEMBLY

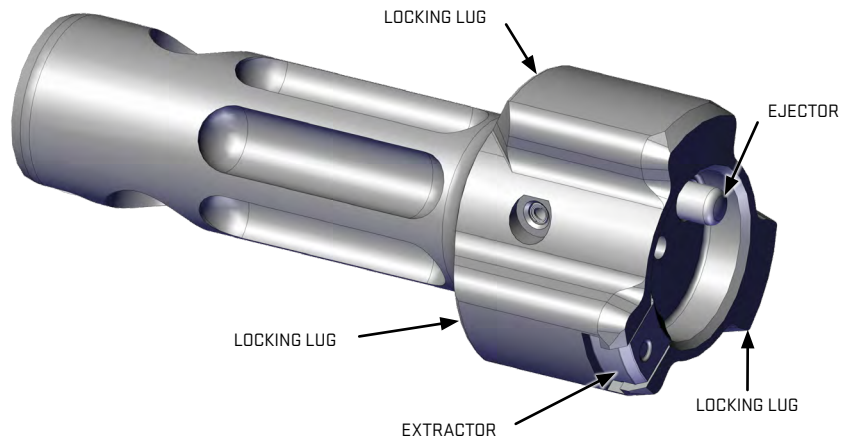
The bolt assembly consists of the bolt head assembly, bolt carrier, bolt handle with knob, and striker assembly.

The CROSS ships with a replaceable 5/16-24 threaded bolt knob as standard equipment. Other size bolt knobs are available as accessories.



### Bolt Head Assembly

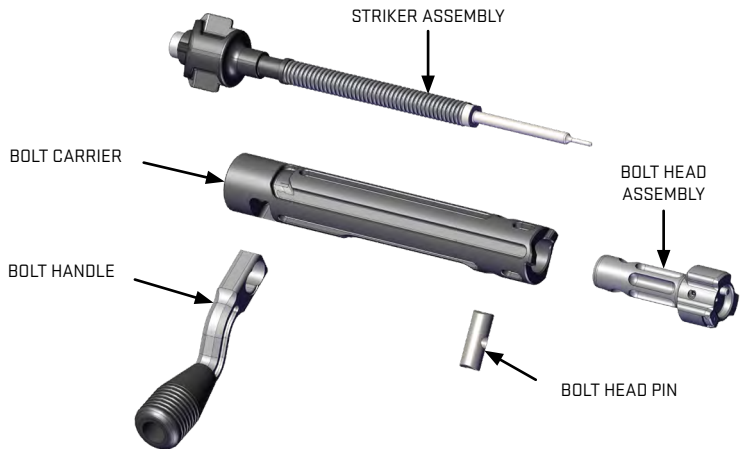
The bolt head assembly locks the chamber during firing and houses the extractor, ejector, and locking lugs.





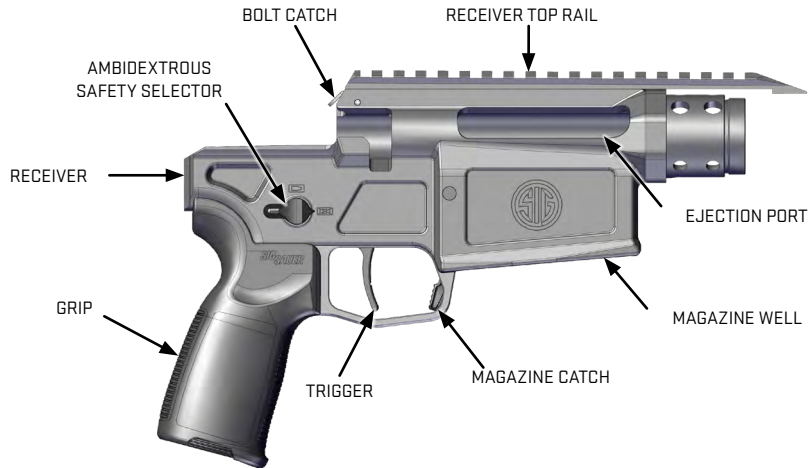
### Bolt Carrier

The bolt carrier houses the bolt head assembly, striker assembly, bolt head pin, and bolt handle.



### 8.3.2 RECEIVER ASSEMBLY

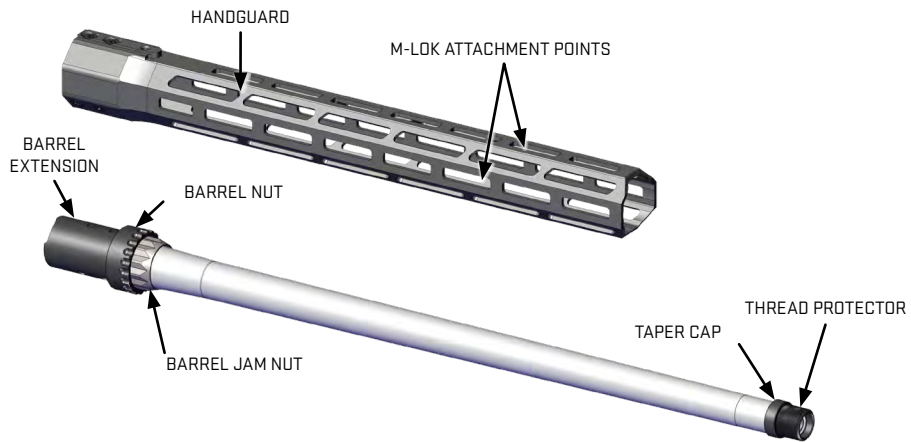
The receiver assembly houses the fire control components including the trigger, ambidextrous safety selector, bolt catch, receiver top rail, ejection port, magazine well, magazine catch, and grip.





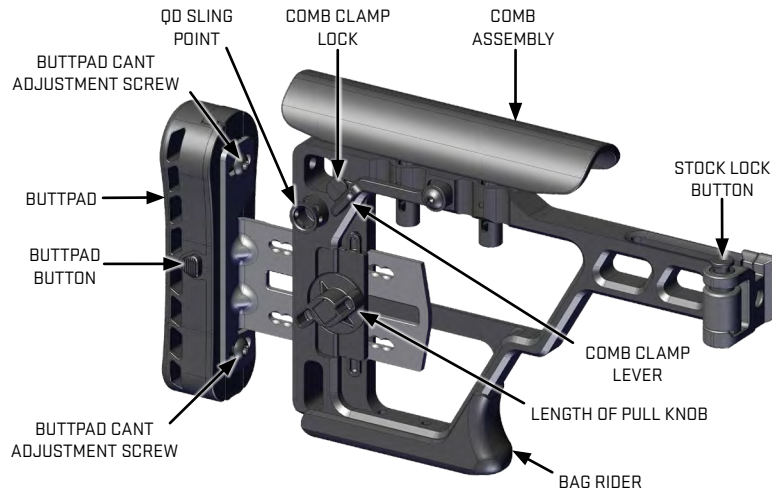
### 8.3.3 HANDGUARD AND BARREL ASSEMBLY

The handguard features multiple M-LOK® attachment points at 12, 3, 6, and 9 o'clock. The barrel assembly includes the barrel extension, barrel nut, barrel jam nut, barrel, taper cap, and thread protector.



### 8.3.4 STOCK ASSEMBLY

The stock assembly features the comb assembly, stock lock button, comb clamp lever, length of pull knob, QD sling point, buttpad, and buttpad button.





## 8.4 CYCLE OF OPERATION

The SIG CROSS has the following eight steps in its operation cycle:

- **FIRING:** With the bolt locked and the safety selector lever in the FIRE position, the firearm can be fired by pulling the trigger. Pulling the trigger rotates the trigger bar and releases the sear, which is cammed down by pressure from the spring-loaded striker assembly. The striker assembly is driven forward to strike the primer of the cartridge loaded in the chamber, firing the cartridge.
- **UNLOCKING:** Raising the bolt handle unseats the locking lugs on the bolt head from the lugs in the barrel extension, allowing the bolt to be pulled to the rear.
- **EXTRACTION:** This operation consists of two functions:
  1. **Primary Extraction:** Primary extraction occurs simultaneously with unlocking. The rim of the cartridge case is gripped by the extractor. During the final upward rotation of the bolt handle, the primary extraction cam partially retracts the bolt assembly, completing the primary function of extraction.
  2. **Secondary Extraction:** The bolt lugs are now free of the lugs in the barrel extension and the bolt can be pulled to the rear, completing the secondary function of extraction.

- **EJECTION:** The spring-loaded ejector applies constant pressure to the left side of the cartridge head. As the bolt is pulled to the rear, the front edge of the cartridge reaches the ejection port on the right side of the receiver. The pressure from the ejector combined with the extractor pulling on the right side of the cartridge case head causes the cartridge to be rotated and ejected out through the ejection port. Rearward movement of the bolt is halted by the bolt catch.
- **COCKING:** Primary cocking takes place as the bolt handle is raised. A cam at the rear of the rotating bolt carrier forces the striker assembly rearward, compressing the main spring. A notch at the rear of the bolt carrier holds the striker assembly in the cocked position until the bolt handle is pushed downward during the locking function.
- **FEEDING:** Feeding begins with the bolt at the rear and a loaded magazine inserted into the magazine well. As the user pushes the bolt forward, the cartridge is guided by the magazine feed lips and the feed ramp so that the cartridge is directed into the chamber.
- **CHAMBERING:** As the user continues to push the bolt forward, the cartridge is pushed clear of the magazine feed lips. The forward travel of the bolt pushes the cartridge the rest of the way into the chamber.
- **LOCKING:** Rotating the bolt handle downward causes the locking lugs on the bolt head to engage the lugs of the barrel extension. The cartridge head is now seated in the bolt head assembly, compressing the ejector while the extractor engages the rim of the cartridge. The sear engages and locks the striker assembly in the cocked position. The CROSS is now ready for firing.



## 9.0 HANDLING

### 9.1 PREPARATION INSTRUCTIONS



#### WARNING



**PRIOR TO PERFORMING ANY MAINTENANCE ON THE FIREARM, READ AND UNDERSTAND THE OPERATOR'S MANUAL. ENSURE THAT THE FIREARM IS UNLOADED, CLEARED, AND THE MAGAZINE IS REMOVED. SAFETY GLASSES SHOULD BE WORN WHENEVER DISASSEMBLING, CLEANING, INSPECTING, OR ASSEMBLING A FIREARM. FAILURE TO COMPLY MAY RESULT IN SERIOUS INJURY OR DEATH TO THE USER OR BYSTANDERS.**

Prior to using the firearm, read, understand, and follow all the safety warnings in the Safety Warnings Manual included with the firearm.

- Perform an initial field strip (*10.1 Field Strip the SIG CROSS on page 56*).
- Clean any fouling that might have occurred during factory testing (*10.2 Cleaning and Lubrication on page 62*).
- Inspect, lubricate, and reassemble the firearm (*10.3 Assembly on page 70*).
- Upon reassembly and prior to firing the firearm, conduct a function check (*12.0 Function Check on page 78*). If the firearm does not complete the function check as described, contact customer service (*17.0 Replacement Parts Policy on page 105*).

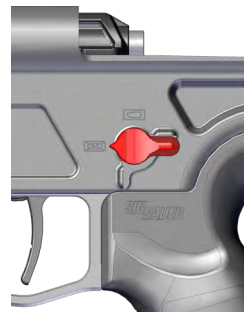
Any maintenance beyond the user level described in this manual is to be performed by a certified SIG SAUER Armorer specifically trained on the maintenance of the CROSS firearm.

### 9.1.1 UNBOXING THE SIG CROSS

The SIG CROSS firearm is packaged from the factory with the bolt assembly removed. Install the bolt assembly following the steps outlined in *10.3.2 Install Bolt Assembly on page 75* of this manual.

### 9.2 SELECTOR OPERATION

The SIG CROSS features an ambidextrous safety selector lever. Rotating either safety selector lever 90 degrees changes the firing mode from SAFE to FIRE. Moving one lever automatically moves the opposite lever to the same position.



SAFE



FIRE

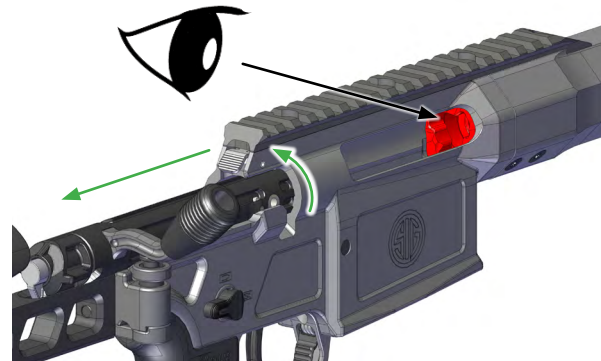


### 9.3 UNLOAD AND CLEAR THE RIFLE

1. Ensure that the muzzle is pointed in a safe direction at all times while unloading and clearing the firearm.
2. Rotate the safety selector to SAFE.
3. Remove the magazine by pressing the magazine catch and simultaneously pulling the magazine free.



4. Lift the bolt handle and pull the bolt assembly to the rear.
5. Visually and physically inspect the chamber for live or spent cartridges.



6. If passing the firearm to another person, allow that person to inspect the chamber prior to relinquishing the firearm. Pass the firearm with the bolt to the rear and the safety selector lever on SAFE.



## 9.4 ADVERSE/SPECIAL CONDITIONS

### Arctic (Extreme Cold/Sub Freezing)

- When exposed to subfreezing temperatures, thoroughly remove all existing lubricants and only apply lubricant that is designed to be used in temperatures of -65°F or below. Do not use Cleaner, Lubricant, Preservative (CLP) as it may freeze and prevent the firearm from firing.
- Avoid bringing the firearm into heated shelters or buildings as this can cause condensation to form on moving parts, which may freeze when the firearm is brought back outdoors.
- If it is necessary to bring the firearm indoors, allow it to warm to room temperature. Disassemble and clean the firearm thoroughly to ensure that all moisture is removed. Relubricate the firearm with the proper cold weather lubricant.
- When operating in snowy environments, conduct frequent inspections of the firearm to ensure that snow has not gotten into operating parts. Work the action to ensure that it is not frozen. Use muzzle covers if available.
- If the bolt carrier becomes frozen with snow / moisture, warm the firearm using body heat or bring it indoors until free movement is restored, and then clean and relubricate the firearm.

### Desert (Hot/Dry)

- Apply light lubrication to internal metal-on-metal moving parts only. If available, use dry graphite lubricant.
- Increase frequency of inspection and cleaning of firearm due to blowing dust and sand. Pay particular attention to the bolt assembly. Ensure the striker assembly assembly is free of any foreign matter, such as sand, dust, or mud.
- Use muzzle covers if available.
- Unload and clean ammunition and inside of magazines daily. Do not lubricate magazine.
- Cover the firearm when not in use.

### Jungle (Hot/Humid)

- Inspect and clean the firearm frequently to prevent corrosion.
- Apply a thin coat of lubricant on steel parts frequently.
- Inspect hidden surfaces of the bolt, receiver, chamber, and barrel extension (locking lugs) for corrosion.
- Unload the magazine, clean ammunition, and inspect the inside of magazines daily for corrosion.
- Wipe the ammunition dry before reloading the magazine.



## 9.5 STOCK ASSEMBLY



**WARNING UNLOAD/CLEAR**



**FAILURE TO ENSURE THE FIREARM IS UNLOADED AND CLEARED COULD RESULT IN UNINTENTIONAL DISCHARGE, CAUSING SERIOUS INJURY, DEATH, OR PROPERTY DAMAGE.**

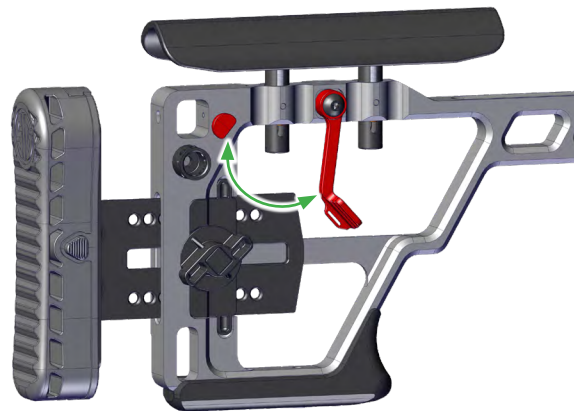
### 9.5.1 FOLDING/UNFOLDING THE STOCK

1. Bolt must be forward to fold or unfold the stock.
2. To fold, press the stock lock button while lifting the stock up and out of its latch, then rotate the stock to the folded position.
3. To unfold, press the stock lock button and rotate the stock out until it locks in position.



### 9.5.2 ADJUSTING COMB HEIGHT

1. Assume a shooting position behind the firearm.
2. Press the comb clamp lock and swing the comb clamp lever down.
3. Adjust the comb to the desired height and use a cheek to hold it in place while swinging the comb clamp lever up until it is captured by the comb clamp lock.



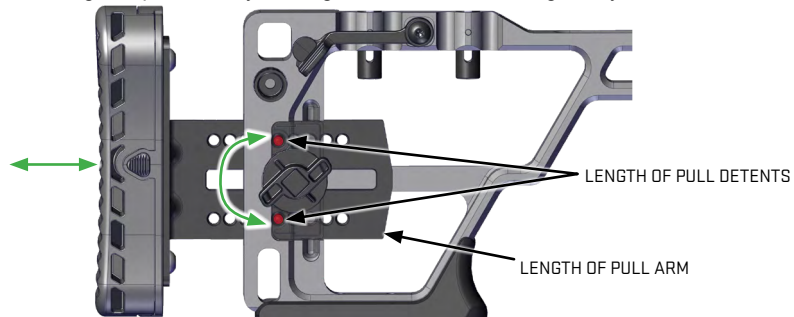


### 9.5.3 ADJUSTING LENGTH OF PULL

#### CAUTION

DO NOT USE TOOLS TO TIGHTEN THE LENGTH OF PULL KNOB AS DAMAGE TO STOCK MAY OCCUR.

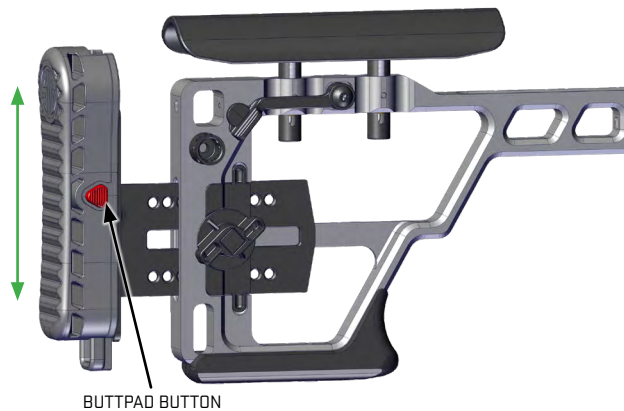
1. Loosen the length of pull knob by rotating counterclockwise several complete turns.
2. Adjust buttpad to desired position and ensure that the length of pull detents engage the intended holes in the length of pull arm.
3. Tighten the length of pull knob by rotating clockwise until hand tight only.



*\*PARTS SHOWN TRANSPARENT TO REVEAL DETENTS AND FOR CLARITY*

### 9.5.4 ADJUSTING BUTTPAD HEIGHT

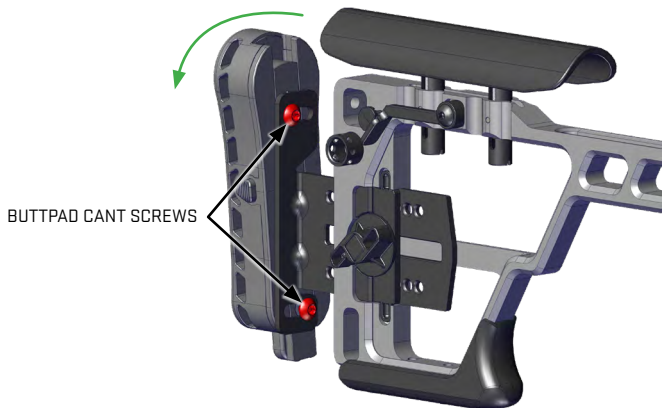
1. Press and hold the buttpad button.
2. Adjust the buttpad's height to desired position, then release the buttpad button.
3. Ensure the button engages the locking recess when released and the buttpad will not move vertically.





### 9.5.5 ADJUSTING BUTTPAD CANT

1. Using a T25<sup>®</sup> bit, loosen the two buttpad cant screws.
2. Rotate buttpad to the desired angle and ensure the positioning tabs on the buttpad are aligned in the grooves on the mating surface.
3. Tighten both buttpad cant screws to 25 in-lbf.

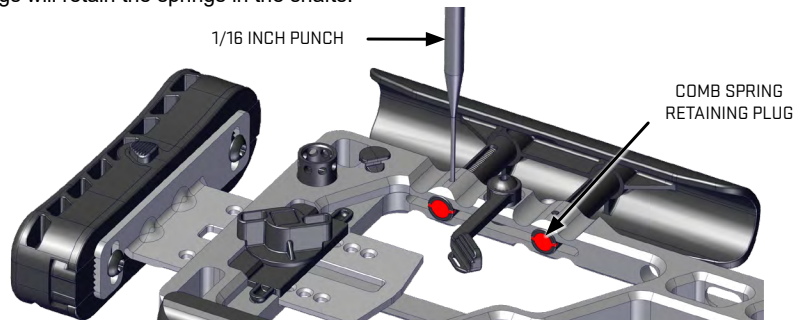


### 9.5.6 REVERSING COMB

#### CAUTION

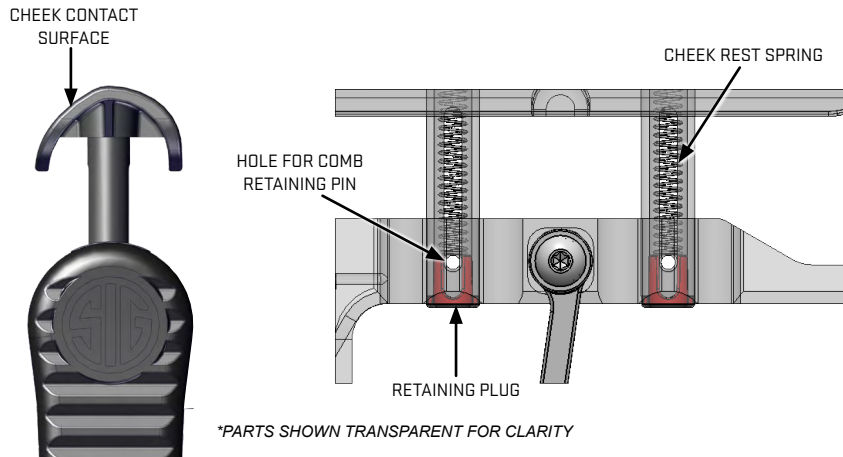
DO NOT REMOVE THE RETAINING PLUGS WHEN REVERSING THE COMB. FAILURE TO COMPLY COULD RESULT IN DAMAGE OR EXCESSIVE WEAR ON THE COMB SPRINGS.

1. Raise the comb to gain access to comb retaining pins. See 9.5.2 *Adjusting Comb Height* on page 39.
2. Push out both comb retaining pins with a 1 / 16 inch pin punch. The comb spring retaining plugs will retain the springs in the shafts.

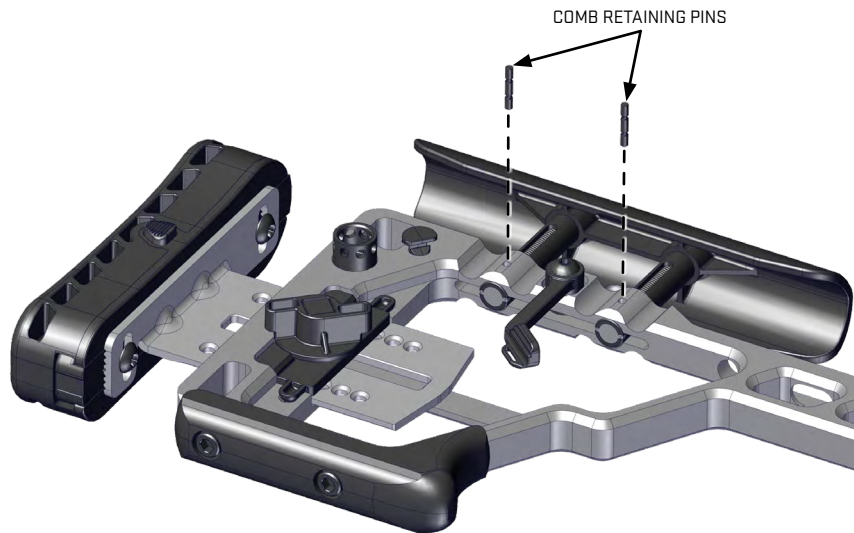




3. Reverse the comb so the cheek contact surface is on the opposite side.
4. Ensure the shafts of the comb assembly are seated so the holes for the comb retaining pins are aligned with their corresponding holes in the stock frame. The comb spring retaining plugs will keep the comb springs above the pin holes.



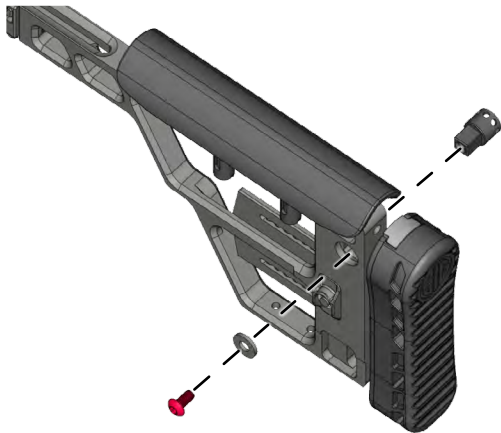
5. Install the comb retaining pins in the same direction as they were removed.





### 9.5.7 REVERSING QUICK DETACH SLING POINT

1. Using a T25 bit, remove the sling point retaining screw, washer, and QD sling cup.
2. Reverse the components and reinstall on the opposite side of the stock.
3. Tighten the retaining screw to 25 in-lbf.



### 9.5.8 REVERSING STOCK FOLD DIRECTION

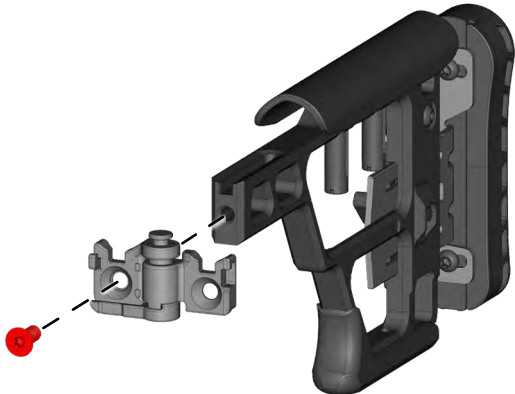
1. Fold the stock. See 9.5.1 *Folding/Unfolding the Stock* on page 38.
2. Using a T30® bit, remove the stock screw and stock assembly. Clean the screw threads.



**NOTE**

Do not rotate or flip stock hinge assembly when reversing the folding direction.

- Using a T30 bit, remove the stock hinge screw and stock hinge assembly from the receiver. Clean the screw threads.
- Reinstall the stock hinge assembly to the stock body using the other hole and tighten to 100 in-lbf.



- Reinstall the stock assembly to the receiver using a T30 bit and tighten the stock screw to 100 in-lbf.





## 9.6 ADJUSTING TRIGGER



### **WARNING UNLOAD/CLEAR**



**FAILURE TO ENSURE THE FIREARM IS UNLOADED AND CLEARED COULD RESULT IN UNINTENTIONAL DISCHARGE, CAUSING SERIOUS INJURY, DEATH, OR PROPERTY DAMAGE.**



### **WARNING TRIGGER**



**THE TRIGGER ADJUSTMENT SCREW IS THE ONLY AUTHORIZED METHOD OF ADJUSTING THE TRIGGER MECHANISM. ATTEMPTING TO ADJUST OR MODIFY THE TRIGGER MECHANISM IN ANY OTHER WAY COULD CAUSE A SERIOUS MALFUNCTION, RESULTING IN SERIOUS INJURY OR DEATH AND DAMAGE TO THE FIREARM.**

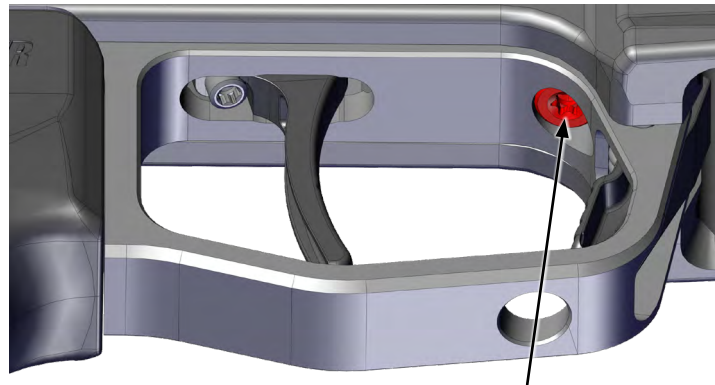
### **CAUTION**

**DO NOT ATTEMPT TO FORCE THE TRIGGER ADJUSTMENT SCREW BEYOND THE STOP. FAILURE TO COMPLY WILL CAUSE INTERNAL DAMAGE TO THE FIREARM.**

The SIG SAUER CROSS has a single T15® screw for trigger pull adjustment and can be adjusted between approximately 2.5 and 4 pounds without disassembling the firearm. Changing the trigger pull screw setting affects both the first and second stages of the trigger pull. The two stages are not independently adjustable. Over-travel and creep are not adjustable by the user.

The adjustment screw, located inside the trigger guard in front of the trigger, is accessible through an opening in the trigger guard. The adjustment screw will stop at the maximum and minimum available trigger pull weight.

- To decrease the trigger pull, turn the screw counterclockwise.
- To increase the trigger pull, turn the screw clockwise.



TRIGGER ADJUSTMENT SCREW



## 9.7 LOADING/RELOADING

### 9.7.1 LOADING THE MAGAZINE

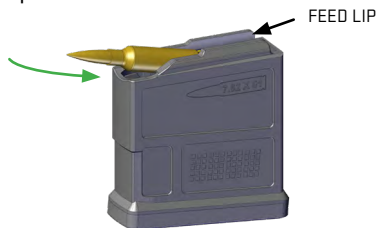
#### CAUTION

ENSURE THAT THE MAGAZINE IS THE PROPER TYPE AND CALIBER FOR THE RIFLE.

#### NOTE

Do not attempt to insert more cartridges than the magazine's designed capacity.

1. Insert the first cartridge into the magazine angled down so the rim of the cartridge slides under the feed lips and push it to the rear.



2. Load the next cartridge using the rim of the cartridge to depress the preceding cartridge and push to the rear underneath the feed lips. Repeat until the magazine is full.

### 9.7.2 LOADING THE RIFLE

1. Ensure the safety selector lever is on SAFE and the muzzle is pointed in a safe direction.
2. Lift the bolt handle to its upright position and pull the bolt assembly completely to the rear.
3. Insert a loaded magazine into the receiver until it engages and is retained by the magazine catch. Always pull down on the magazine to ensure it is locked in place.





4. Push the bolt assembly completely forward and rotate the bolt handle down to its locked position.



**WARNING LOADED FIREARM**



**THE RIFLE IS NOW LOADED AND READY TO FIRE**

### 9.7.3 RELOADING (MAGAZINE EXPENDED, CHAMBER EMPTY)

1. Rotate the safety selector lever to SAFE.
2. Press the magazine catch to remove the magazine from the magazine well.
3. Repeat steps 2 through 4 from 9.7.2 *Loading the Rifle on page 53*.

### 9.7.4 RELOADING (MAGAZINE EXPENDED/PARTIALLY EXPENDED, LIVE CARTRIDGE CHAMBERED)

1. Rotate the safety selector lever to SAFE.
2. Press the magazine catch to remove the magazine from the magazine well.
3. Insert a loaded magazine until it engages and is held by the magazine catch. Always pull down on the magazine to ensure that it is seated properly.

### 9.8 FIRING THE RIFLE

1. Unfold the stock if not already done. See 9.5.1 *Folding/Unfolding the Stock on page 38*.
2. Follow steps 1 through 4 from 9.7.2 *Loading the Rifle on page 53*.
3. Face the target and point the muzzle downrange.
4. Rotate the safety selector lever from SAFE to FIRE.
5. Pull the trigger to fire the rifle.



## 10.0 USER-LEVEL AUTHORIZED PREVENTIVE MAINTENANCE

### 10.1 FIELD STRIP THE SIG CROSS



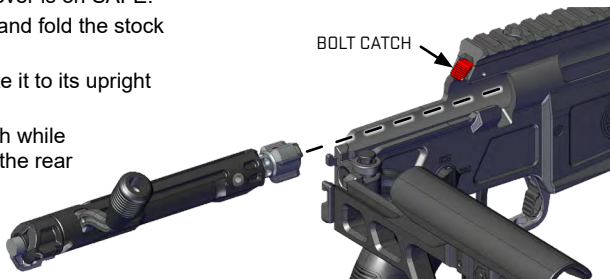
#### **WARNING UNLOAD/CLEAR**



FAILURE TO ENSURE THE FIREARM IS UNLOADED AND CLEARED COULD RESULT IN UNINTENTIONAL DISCHARGE, CAUSING SERIOUS INJURY, DEATH, OR PROPERTY DAMAGE.

#### 10.1.1 REMOVE BOLT ASSEMBLY

1. Unload and clear the firearm of all ammunition. Ensure the safety selector lever is on SAFE.
2. Press the stock lock button and fold the stock halfway.
3. Lift the bolt handle and rotate it to its upright position.
4. Press and hold the bolt catch while pulling the bolt assembly to the rear and out of the receiver.



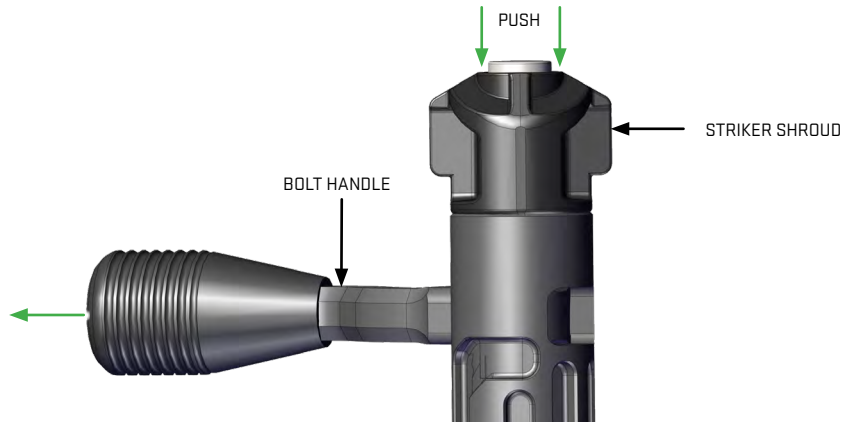
#### 10.1.2 DISASSEMBLE BOLT ASSEMBLY

1. Rotate the striker shroud counterclockwise to decock the striker.



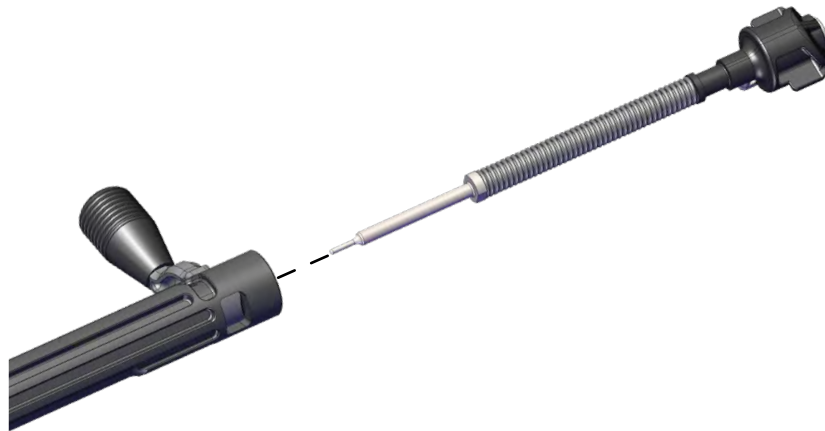


2. Hold the bolt assembly with the bolt face down against a hard flat surface.
3. Press down on the striker shroud while pulling the bolt handle away from the bolt carrier, leaving a slight gap approximately 3/16 of an inch.



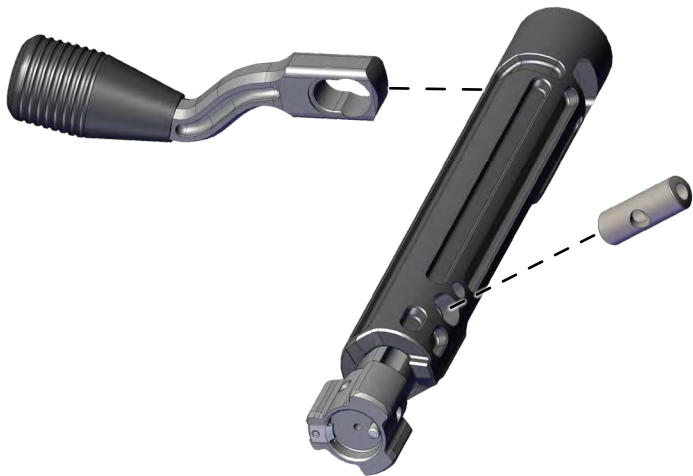
4. Release pressure on the striker shroud and pull the handle out to release the striker from the bolt carrier.

5. Grasp the striker shroud and pull the striker assembly from the bolt carrier.





- 6. Remove the bolt handle.
- 7. Remove the bolt head pin.



- 8. Remove bolt head assembly.



**NOTE**

No further disassembly of the bolt head assembly is authorized.



## 10.2 CLEANING AND LUBRICATION



### WARNING CLEANING



**READ AND FOLLOW THE MANUFACTURER'S WARNINGS BEFORE USING SOLVENTS OR CLEANERS. USE IN A WELL-VENTILATED AREA. WEAR EYE PROTECTION.**

- Always ensure the firearm is unloaded and cleared of all ammunition.
- Use only cleaning and lubrication products specifically designed for use on firearms.
- Do not use wire brushes on aluminum surfaces such as the receiver; this can scratch the finish.
- Follow all manufacturer instructions and cautions when using cleaning and lubricating products.
- Wherever the term "CLP" (Cleaner-Lubricant-Preservative) or the word "lubrication" appear, they are used to mean any cleaner, lubricant, and preservative designed for use on a firearm. SIG SAUER recommends only using products designed for firearms.

### CAUTION

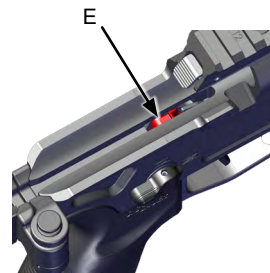
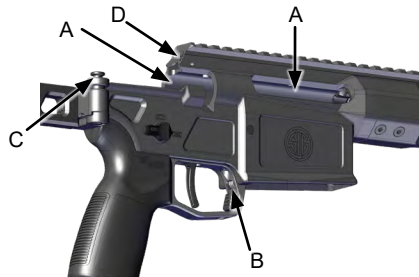
USE A WELL-FITTING BORE GUIDE, DESIGNED TO ALIGN THE CLEANING ROD WITH THE BORE, TO PREVENT IT FROM DIRECTLY CONTACTING THE CHAMBER AND / OR RIFLING THROAT. FAILURE TO COMPLY CAN DAMAGE THE BORE AND CHAMBER.

### 10.2.1 CLEANING RECEIVER AND EXTERIOR OF FIREARM

- Scrub the interior of the receiver with a soft bristle brush and CLP. Wipe off excess CLP.
- Wipe down the exterior surfaces of firearm.

### 10.2.2 LUBRICATE RECEIVER AND EXTERIOR OF FIREARM

- Apply a light coat of lubricant to the interior of the receiver that contacts the bolt assembly.
- Apply 1-2 drops of lubricant to the magazine release spring.
- Apply 1-2 drops of lubricant to the stock hinge.
- Apply 1-2 drops of lubricant to the bolt catch.
- Apply a light coat of a molybdenum disulfide-based anti-seize lubricant to the sear surfaces.



*\*Do not lubricate moving parts of the stock comb or buttpad*



### 10.2.3 CLEANING THE BORE AND CHAMBER

Clean the bore of the CROSS with a high quality one-piece cleaning rod. Use a short chamber rod to clean the chamber. Avoid the use of metal or military sectional cleaning rods as they can damage the bore of the barrel.

1. Use a clean patch moistened with bore solvent and swab the chamber with the chamber rod.
2. Attach a nylon bristle chamber brush to chamber rod and scrub the chamber.
3. Install a nylon bore brush on the chamber rod and scrub the throat area of the chamber.
4. Swab the chamber with a wet patch, then a dry patch. Repeat until the chamber is clean.
5. Attach a new clean patch moistened with bore solvent onto the cleaning rod.
6. Push the moistened patch completely through the bore from the chamber end. Repeat the process, alternating between wet patches and dry patches until the dry patches come out clean.
7. If the barrel shows signs of heavy fouling, replace the jag with a bore brush and push the brush through the bore from the chamber end until the brush is clear of the muzzle. Repeat several times.
8. Run another patch moistened with bore cleaner through the bore to remove any heavy residue loosened by the bore brush. Repeat until the patches come out clean.

9. Soak a patch in a copper remover / solvent designed for firearms and run it through the bore. If copper is present, the patch will display a greenish / blue tint. Repeat until the patches indicate no copper is present.
10. Use a regular bore solvent or CLP to clean all remaining copper remover / solvent from the bore.
11. If the firearm is to be stored for extended period of time, run one last patch moistened with CLP through the bore. Ensure all lubricant and CLP is removed from the bore prior to firing the rifle. For more details on long-term storage, see *15.0 Storage and Transportation on page 97*.

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

Completing this procedure is suggested to obtain the best possible accuracy out of the firearm.

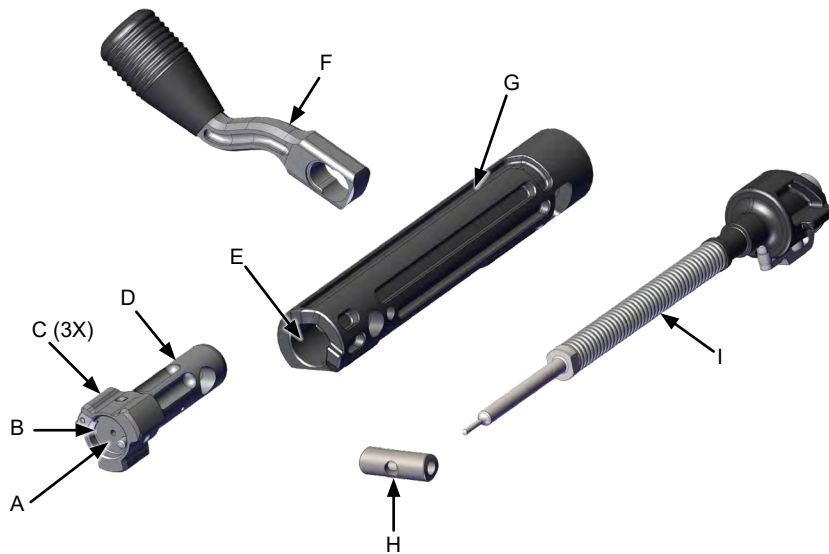
1. Clean the barrel as described in *10.2.3 Cleaning the Bore and Chamber on page 64*.
2. Fire 1 shot, then clean per section 3.2.3. Repeat 5 times.
3. Fire 2 shots, then clean per section 3.2.3. Repeat 5 times.
4. Fire 5 shots, then clean per section 3.2.3. Repeat 5 times.

During cleaning cycles, inspect the copper remover / solvent patch for green / blue color which indicates copper fouling. Use the copper remover / solvent per the manufacturer instructions or as described in section 3.2.3 until the copper is removed, then continue with the break-in steps.



### 10.2.4 CLEANING THE BOLT ASSEMBLY

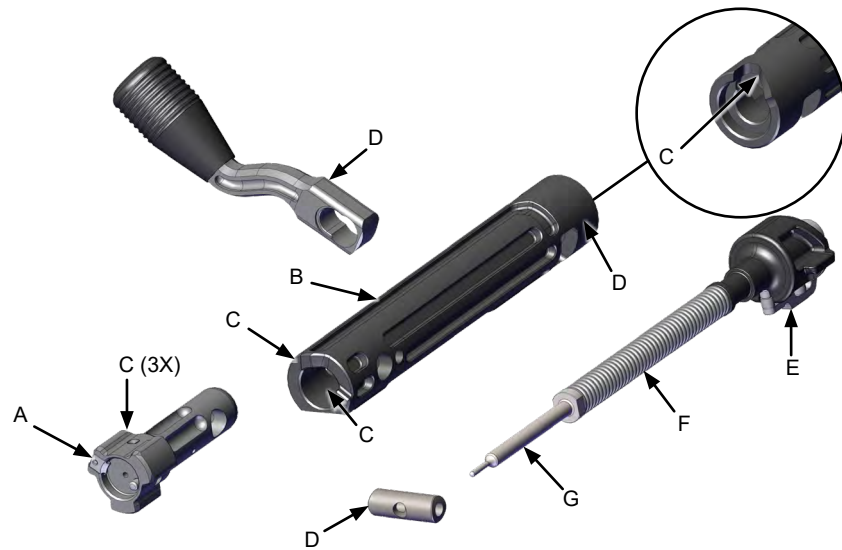
- A. Scrub the bolt face with nylon bristle brush and CLP. Wipe off excess CLP.
- B. Clean the hook of the extractor.
- C. Remove any carbon from the bolt lugs.
- D. Scrub the bolt head with nylon bristle brush and CLP. Wipe off excess CLP.
- E. Clean the interior of the bolt carrier.
- F. Wipe down bolt handle.
- G. Wipe down bolt carrier body.
- H. Scrub the bolt head pin with nylon bristle brush and CLP. Wipe off excess CLP.
- I. Wipe down the striker assembly.





### 10.2.5 LUBRICATING BOLT ASSEMBLY

- A. Apply 1-2 drops of lubricant to the extractor.
- B. Apply a small amount of grease to the side walls of the bolt latch pin groove in the top of the bolt carrier.
- C. Apply a small amount of grease to the camming surfaces of the bolt lugs, bolt carrier, and cocking cam at the rear of the bolt carrier.
- D. Apply a light coat of lubricant to the exterior of the bolt carrier, bolt handle, and bolt head pin.
- E. Apply a light coat of a molybdenum disulfide-based anti-seize lubricant to the striker blade.
- F. Spread 2-3 drops of lubricant along the length of the striker spring with a nylon bristle brush.
- G. Apply a small amount of grease to the large diameter of the front of the firing pin.



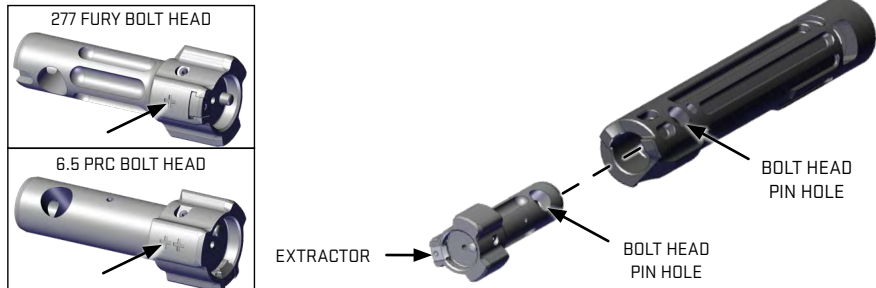


## 10.3 ASSEMBLY

### 10.3.1 ASSEMBLE BOLT ASSEMBLY

The bolt head assembly is keyed and can only be installed one way. Always ensure that the barrel is the correct caliber for the bolt head.

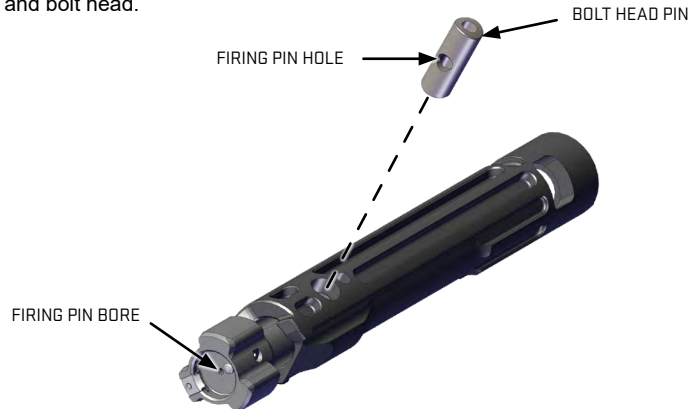
- The 243 WIN and the 308 WIN bolt heads have no identification marks.
  - The 277 Fury bolt is identified by a “+” on the lug over the extractor.
  - The 6.5 PRC bolt is identified by a “++” on one of the locking lugs.
1. Install the bolt head into the bolt carrier with the extractor on the right side and align the bolt head pin holes on the bolt head and carrier.



### WARNING BOLT HEAD ASSEMBLY

**FAILURE TO PROPERLY INSTALL BOLT HEAD PIN MAY RESULT IN SERIOUS INJURY OR DEATH TO OPERATOR AND DAMAGE TO FIREARM.**

2. Install the bolt head pin with the firing pin hole aligned with the firing pin bore of the bolt carrier and bolt head.

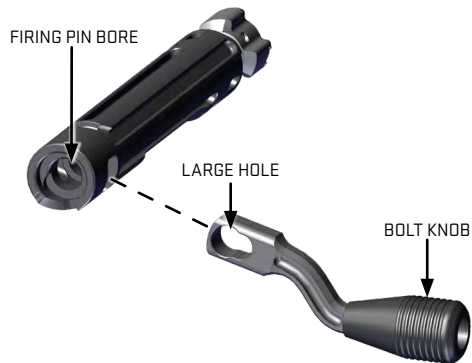




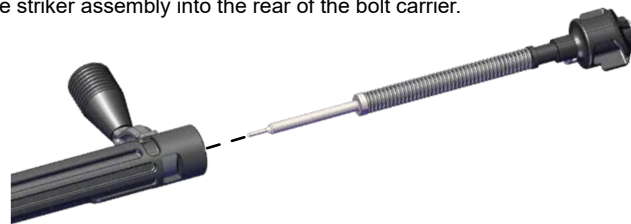
## CAUTION

THE BOLT HANDLE IS DESIGNED TO ONLY BE INSTALLED AS DESCRIBED IN THIS MANUAL. TRYING TO FORCE THE BOLT HANDLE INSTALLATION IN THE WRONG ORIENTATION CAN RESULT IN DAMAGE TO THE CROSS RIFLE.

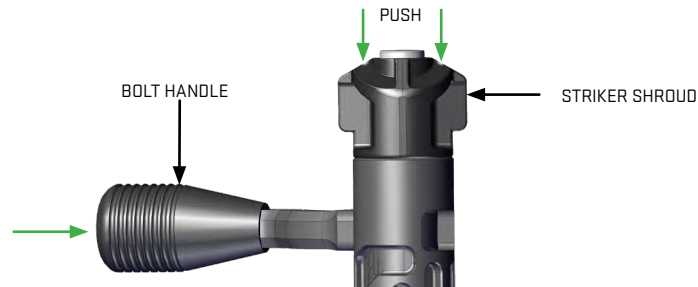
3. Install the bolt handle into the right side of the bolt carrier with the bolt knob down and the large diameter hole aligned with the firing pin bore.



4. Insert the striker assembly into the rear of the bolt carrier.



5. Press down firmly on the striker shroud and push the bolt handle in until it stops. Release the striker shroud and ensure the bolt handle cannot be pulled out.



**NOTE**

Striker must be cocked in order to install bolt assembly.

6. Grasp the striker shroud and firmly twist clockwise to cock the striker.

**10.3.2 INSTALL BOLT ASSEMBLY**

1. If the stock is set up for right side fold, press the stock lock button and fold the stock halfway. If the stock is set up for left side fold, the stock can be fully folded.
2. Insert the bolt assembly into the back of the receiver. Push the bolt forward until it stops.
3. Press and hold the bolt catch and continue pushing the bolt fully forward.
4. Push the bolt handle down into its locked position.





## 11.0 MAGAZINE MAINTENANCE



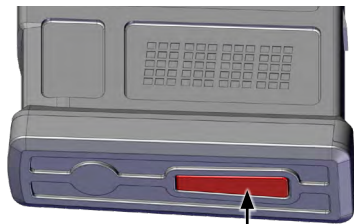
**WARNING PARTS UNDER SPRING TENSION**



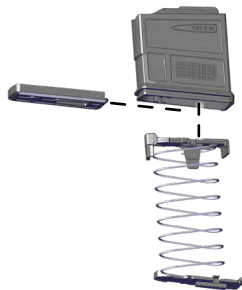
**FIREARMS CONTAIN SEVERAL SPRING-LOADED PARTS. WEAR EYE PROTECTION AND MAINTAIN CONTROL DURING MAINTENANCE. FAILURE TO COMPLY MAY RESULT IN INJURY.**

### 11.1 DISASSEMBLY

1. Press and hold the tab on the magazine floorplate.
2. Slide the magazine base plate forward and remove the floorplate, spring, and follower from the magazine tube.



FLOORPLATE TAB

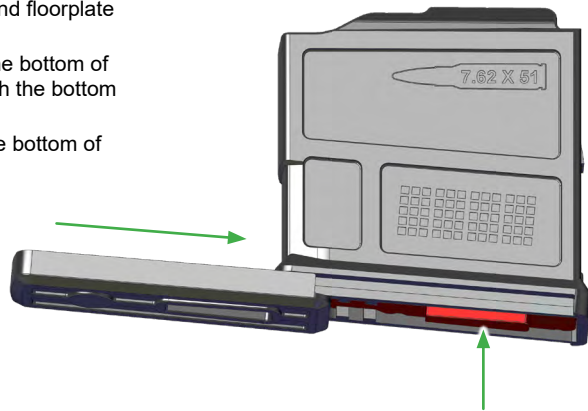


### 11.2 CLEANING

- Remove any dirt, dust, or debris from the magazine components with a rag or dry nylon bristle brush. Do not use lubricant, solvent, or metal bristle brushes when cleaning magazine.

### 11.3 ASSEMBLY

1. Insert the follower, spring, and floorplate into the magazine tube.
2. Compress the spring until the bottom of the floorplate tab is level with the bottom of the magazine tube.
3. Slide the base plate onto the bottom of the magazine tube.





## 12.0 FUNCTION CHECK

A function check is performed on the assembled firearm to verify its proper function. It should be performed after the completion of repairs and after each cleaning and assembly of the firearm.



### **WARNING UNLOAD/CLEAR**



**FAILURE TO ENSURE THE FIREARM IS UNLOADED AND CLEARED COULD RESULT IN UNINTENTIONAL DISCHARGE, CAUSING SERIOUS INJURY, DEATH, OR PROPERTY DAMAGE.**



### **WARNING FUNCTION CHECK**

**KEEP THE FIREARM POINTED IN A SAFE DIRECTION DURING THE ENTIRE FUNCTION CHECK.**

**IF THE FIREARM FAILS TO COMPLETE THE FUNCTION CHECK, DO NOT USE THE FIREARM. CONTACT CUSTOMER SERVICE.**

1. Insert an empty magazine into the magazine well and verify that it is fully seated by pulling it downward.
2. Push the bolt forward and rotate the handle down to lock the bolt.
3. Ensure the safety selector lever is rotated to SAFE.
4. Press the magazine catch. The magazine should pull free from the rifle with little resistance.

5. With the muzzle pointed in a safe direction and the safety selector on SAFE, pull the trigger. Nothing should happen.
6. Rotate the safety selector lever to the FIRE position and pull and hold the trigger to the rear. The striker should release with an audible click. Release the trigger.
7. Cycle the bolt, rotate the safety selector lever to SAFE, and recheck SAFE by pulling the trigger.
8. Unlock the bolt and leave it to the rear in the open position.

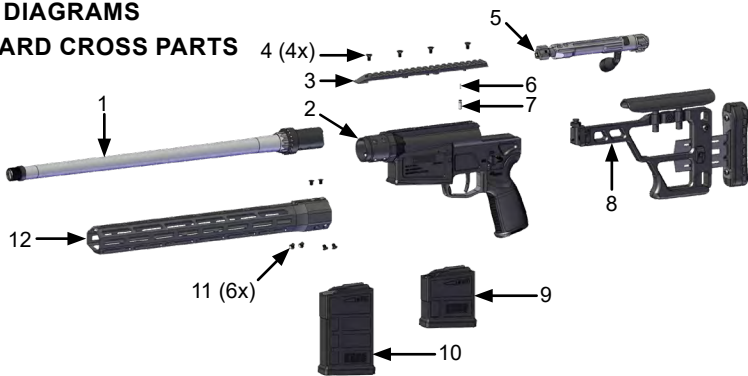
### **CAUTION**

**NEVER USE A FIREARM OR MAGAZINE THAT SHOWS SIGNS OF DAMAGE OR FAILS A FUNCTION CHECK. VERIFY THE MAGAZINE IS THE CORRECT MODEL AND CALIBER FOR THE RIFLE. IF THE CONDITION OR FUNCTION OF THE RIFLE OR MAGAZINE IS SUSPECT, RETURN THE RIFLE OR MAGAZINE TO SIG SAUER FOR EVALUATION. ALWAYS VERIFY THE CONDITION AND FUNCTION OF THE EQUIPMENT BEFORE USE.**



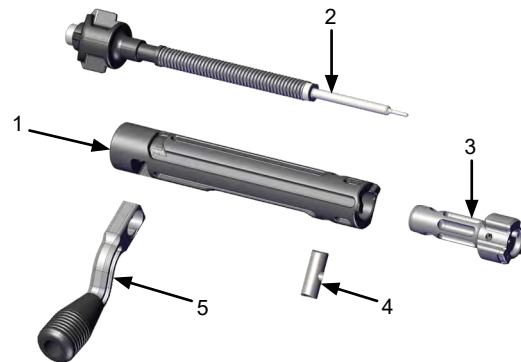
**13.0 PARTS DIAGRAMS**

**13.1 STANDARD CROSS PARTS**



NUMBER	NOMENCLATURE	NUMBER	NOMENCLATURE
1	Barrel Assembly	7	Bolt Catch
2	Receiver Assembly	8	Stock Assembly
3	Receiver Rail	9	5 Round Magazine
4	Receiver Rail Screws (4X)	10	10 Round Magazine (Optional)
5	Bolt Assembly	11	Handguard Screw (6X)
6	Bolt Catch Spring	12	Handguard

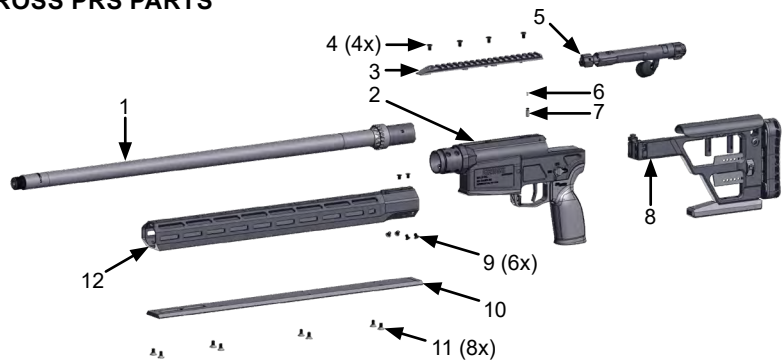
**13.2 BOLT ASSEMBLY PARTS**



NUMBER	NOMENCLATURE
1	Bolt Carrier
2	Striker Assembly
3	Bolt Head Assembly
4	Bolt Head Pin
5	Bolt Handle

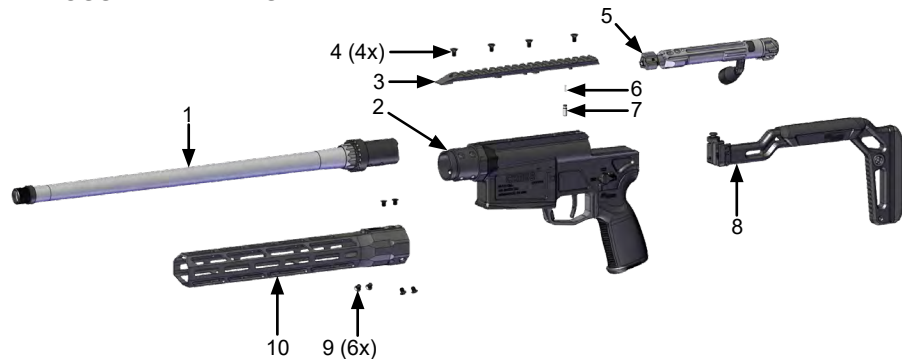


**13.3 CROSS PRS PARTS**



NUMBER	NOMENCLATURE	NUMBER	NOMENCLATURE
1	Barrel Assembly	7	Bolt Catch
2	Receiver Assembly	8	PRS Stock Assembly
3	Receiver Rail	9	Handguard Screw (6X)
4	Receiver Rail Screws (4X)	10	Removable ARCA Rail
5	Bolt Assembly	11	ARCA Rail Screws (8X)
6	Bolt Catch Spring	12	PRS Handguard

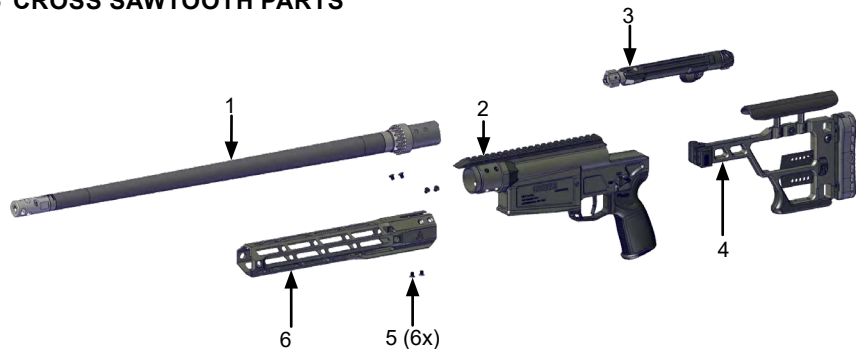
**13.4 CROSS TRAX PARTS**



NUMBER	NOMENCLATURE	NUMBER	NOMENCLATURE
1	Barrel Assembly	6	Bolt Catch Spring
2	Receiver Assembly	7	Bolt Catch
3	Receiver Rail	8	Minimalist Stock Assembly
4	Receiver Rail Screws (4X)	9	Handguard Screw (6X)
5	Bolt Assembly	10	Lightweight Handguard



### 13.5 CROSS SAWTOOTH PARTS

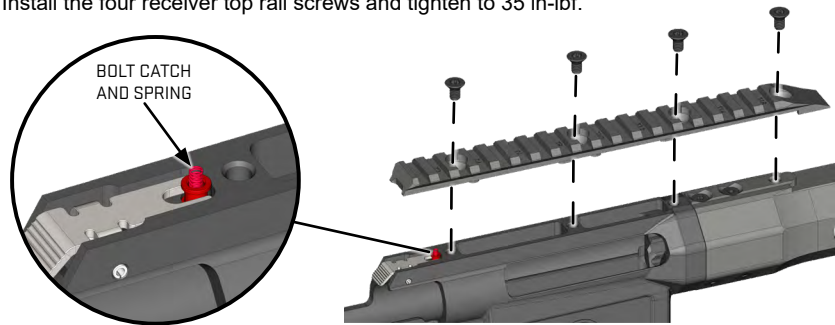


NUMBER	NOMENCLATURE
1	Carbon Fiber Barrel Assembly
2	Receiver Assembly
3	Bolt Assembly
4	Stock Assembly
5	Handguard Screw (6X)
6	SAWTOOTH Handguard

### 14.0 OPTIONAL CONFIGURATIONS

#### 14.1 CHANGING RECEIVER TOP RAIL

1. To remove the receiver top rail, use a T25® drive bit to remove the four receiver top rail screws.
2. Remove the receiver top rail, taking care not to dislodge the bolt catch and spring underneath.
3. To install, ensure that the bolt catch pin and spring are in place
4. Place the top rail on the receiver, aligning the rail screw holes with those in the receiver.
5. Install the four receiver top rail screws and tighten to 35 in-lbf.





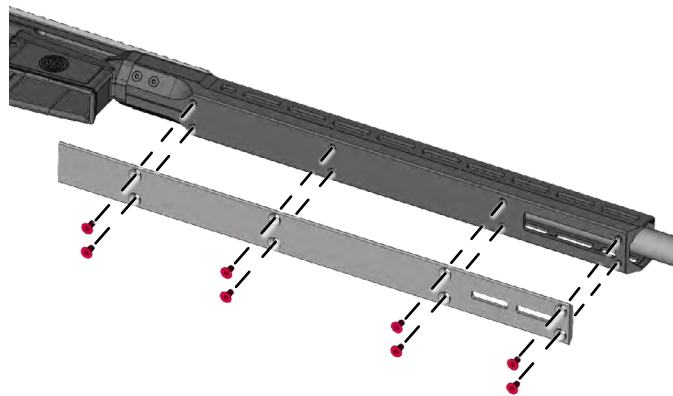
## 14.2 CHANGING BOLT KNOB

1. Using a T25 drive bit, unscrew the bolt knob.
2. Clean the bolt handle threads and apply a few drops of red Loctite 263, then screw on the optional bolt knob. Using a T25 drive bit, torque to 40 in-lbf.



## 14.3 CHANGING ARCA-SWISS RAIL

1. To remove the ARCA rail on the CROSS PRS, unscrew the 8 ARCA rail screws and remove the rail.
2. To install, align the screw holes in the handguard with the corresponding holes in the handguard. Ensure that the M-LOK attachment points are towards the muzzle.
3. Install the ARCA rail screws and tighten to 35 in-lbf.



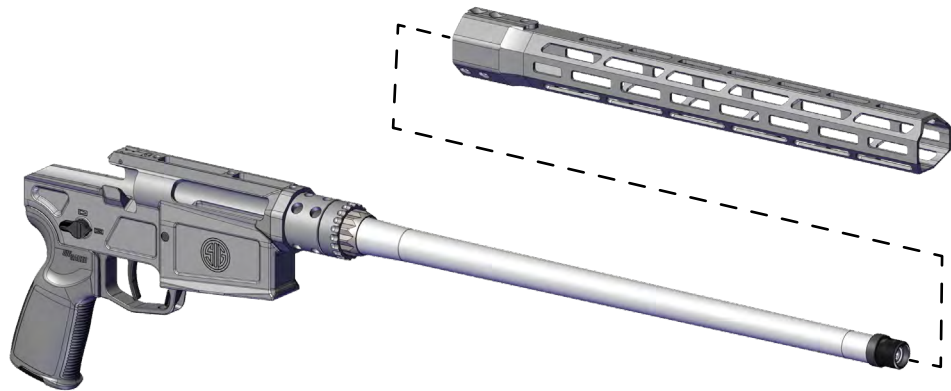


#### 14.4 CHANGING THE BARREL

1. Fold the stock assembly halfway. See 9.5.1 *Folding/Unfolding the Stock* on page 38.
  - If preferred, the stock can be removed for this procedure. See 9.5.8 *Reversing Stock Fold Direction* on page 47.
2. Remove the bolt assembly. See 10.1.1 *Remove Bolt Assembly* on page 56.
3. If necessary to access the handguard screws, remove the receiver top rail. See 14.1 *Changing Receiver Top Rail* on page 85.
4. Using a T15 drive bit, remove the six handguard screws.

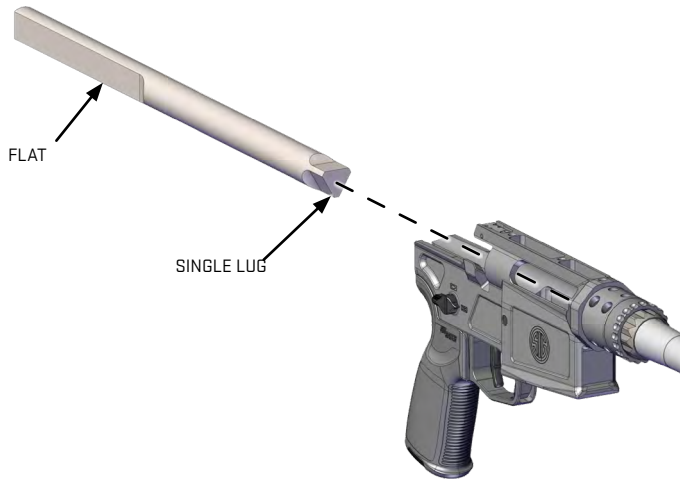


5. Remove the handguard.





6. Insert the barrel assembly tool into the rear of the receiver with a single lug down and the flats perpendicular to the top of the receiver. Ensure the assembly tool is fully inserted into the receiver and the lugs of the tool engage the lugs of the barrel extension.



## CAUTION

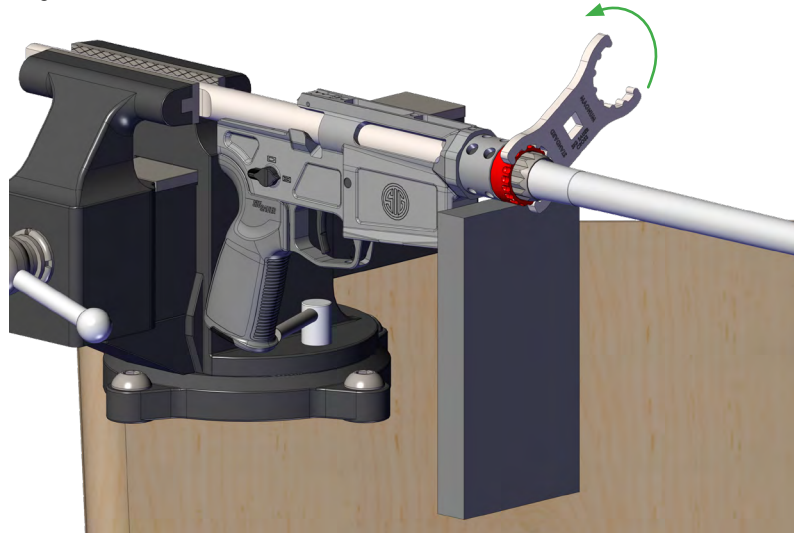
THE FRONT OF THE RECEIVER MUST BE SUPPORTED BY A WOODEN BLOCK OR SIMILAR OBJECT WHEN REMOVING OR INSTALLING THE BARREL. FAILURE TO DO SO MAY RESULT IN DAMAGE TO THE RECEIVER. DO NOT CLAMP THE RECEIVER IN A VISE OR DAMAGE WILL RESULT.

7. Clamp the flats of the barrel assembly tool into a bench mounted vise.





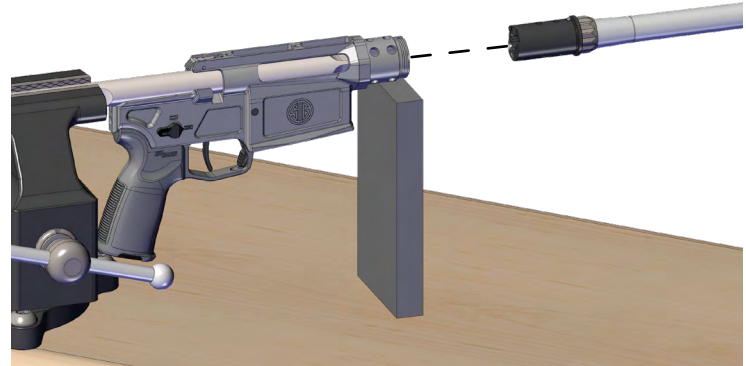
8. Using a barrel wrench, remove the barrel nut.



**CAUTION**

DO NOT WIGGLE OR TWIST THE BARREL WHILE REMOVING IT FROM THE RECEIVER. FAILURE TO COMPLY MAY RESULT IN DAMAGE.

9. Remove the barrel by pulling it out of the receiver. If the barrel does not come out of the receiver when pulled by hand, insert a wooden dowel into the rear of the receiver and gently tap out the barrel.

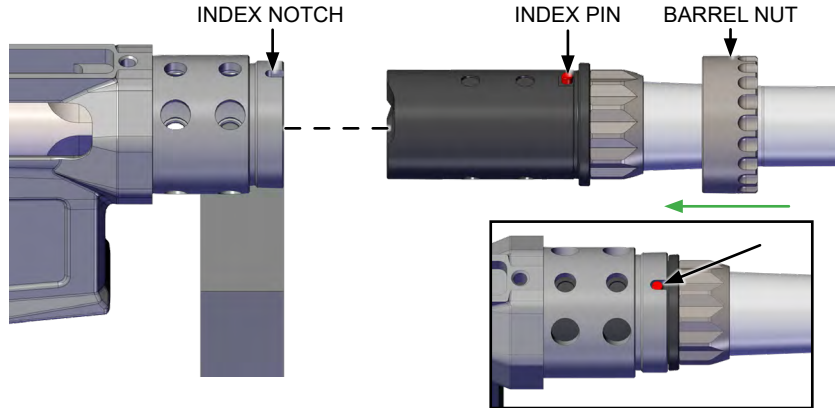




## CAUTION

ENSURE THE INDEX PIN IN THE BARREL EXTENSION IS ALIGNED WITH THE INDEX NOTCH IN THE RECEIVER WHEN INSTALLING THE BARREL. FAILURE TO PROPERLY ALIGN THE INDEX PIN WILL RESULT IN DAMAGE TO RECEIVER.

10. Insert the barrel into the receiver and thread on the barrel nut.

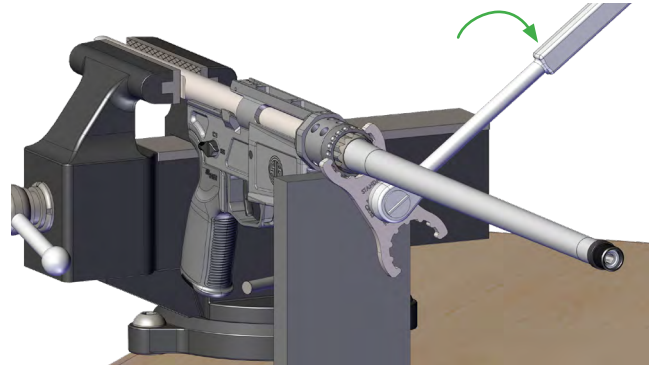


## WARNING ASSEMBLY



**FAILURE TO PROPERLY INSTALL AND TORQUE THE BARREL NUT COULD CAUSE SERIOUS INJURY OR DEATH TO THE OPERATOR AND DAMAGE TO THE FIREARM.**

11. Insert a torque wrench into the barrel wrench with the handles of both wrenches perpendicular.
12. Pressing only on the torque wrench handle, torque the barrel nut to 40 ft-lbf.





13. Replace handguard and, using a T15 drive bit, torque the screws to 30 in-lbf.
14. Replace the receiver top rail. See *14.1 Changing Receiver Top Rail on page 85*.
15. Replace the bolt assembly. See *10.3.2 Install Bolt Assembly on page 75*.
16. If applicable, reinstall the stock assembly. See *9.5.8 Reversing Stock Fold Direction on page 47*.
17. Conduct a function check. See *12.0 Function Check on page 78*.

## 15.0 STORAGE AND TRANSPORTATION



### **WARNING STORAGE**

**NEVER PLACE OR STORE ANY FIREARM IN SUCH A MANNER THAT IT MAY BE DISLODGED. FIREARMS SHOULD ALWAYS BE STORED, LOCKED, UNLOADED, SEPARATE FROM THEIR AMMUNITION, AND INACCESSIBLE TO CHILDREN AND ANY OTHER UNAUTHORIZED PERSON. THE USE OF A LOCKING DEVICE OR SAFETY LOCK IS ONLY ONE ASPECT OF RESPONSIBLE FIREARMS STORAGE. FAILURE TO PROPERLY STORE FIREARMS MAY CAUSE SERIOUS INJURY OR DEATH TO SELF OR OTHERS, OR PROPERTY DAMAGE.**

#### **Short Term Storage (90 days or less)**

1. Ensure the chamber and magazine do not contain live ammunition.
2. Clean the bore and chamber.
3. Apply a generous coat of CLP to the chamber and bore.
4. Apply a light coat of CLP to all other metal surfaces for corrosion protection.



### Long Term Storage (90 days or longer)

1. Ensure the firearm is thoroughly cleaned.
2. Apply a medium coat of CLP to the chamber and bore.
3. Apply a light coat of CLP to all other metal surfaces for corrosion protection.
4. Wrap the firearm with a waterproof material.
5. Place the firearm in a corrosion resistant barrier bag.

### Environmental Storage Recommendations (Armory)

Provide humidity control to limit the relative humidity to no greater than 40% at 80°F (26.7°C). If personnel will be working in these areas, design to 68°F (20.0°C) dry bulb and 40% RH for indoor design heating conditions, and 75°F (23.9°C) dry bulb and 40% RH for indoor design cooling conditions.

### 15.1 TRANSPORTATION

IT IS THE OWNERS RESPONSIBILITY TO FAMILIARIZE THEMSELVES WITH THE LAWS OF ANY JURISDICTION(S) THEY ARE PLANNING TO TRAVEL TO AND THROUGH WITH THE FIREARM.

When transporting the firearm to and from shooting activities, keep it unloaded for safety purposes. When storing the firearm for transportation, keep it separated from ammunition, under lock and key, and out of the reach of children and other inexperienced or unauthorized persons.

If transporting the firearm in a vehicle, ensure that it is secured within the confines of the vehicle. Should the vehicle become involved in an accident, the firearm could become dislodged and move about the interior of the vehicle or be ejected from the vehicle.

## 16.0 TROUBLESHOOTING GUIDE

### 16.1 STOPPAGES



**WARNING STOPPAGE**



**STOP FIRING IMMEDIATELY. UNLOAD AND CLEAR THE FIREARM.**

A stoppage is an interruption in the firearm's cycle of function that can be cleared by the operator taking immediate action. Immediate action consists of steps taken by the operator to place the firearm back in service without investigating the cause of the stoppage.

6. Immediate action:

1. Keep the firearm pointed in a safe direction.
2. Unload and clear the firearm immediately by removing the magazine, locking the slide to the rear, and clearing any ammunition from the firearm.
3. Visually and physically check the chamber, breech face, and magazine well.

With the firearm unloaded and cleared, perform an additional visual inspection of the firearm and the ammunition. If a bore obstruction exists, refer to *16.2 Obstructed Bore on page 100*. If damage to the firearm is found, the stoppage persists, or a malfunction is suspected, take the firearm to a certified SIG SAUER Armorer for service.



## 16.2 OBSTRUCTED BORE



### **WARNING OBSTRUCTED BORE**



**STOP FIRING IMMEDIATELY AND KEEP THE FIREARM POINTED IN A SAFE DIRECTION. UNLOAD AND CLEAR THE FIREARM. DO NOT FIRE ANOTHER ROUND UNTIL THE OBSTRUCTION IS CLEARED. FAILURE TO COMPLY CAN RESULT IN SERIOUS INJURY OR DEATH TO THE OPERATOR AND/OR OTHERS AND CATASTROPHIC DAMAGE TO THE FIREARM.**

Immediately stop shooting and keep the firearm pointed in a safe direction whenever:

- There is difficulty or unusual resistance in chambering a cartridge;
- A cartridge misfires (does not go off);
- The mechanism fails to extract a fired cartridge case;
- Unburned grains of propellant powder are discovered spilled in the mechanism;
- A shot sounds weak or abnormal.

It is possible that a bullet is lodged part way down the barrel. If a bullet is in the bore, do not attempt to shoot it out by using another cartridge or by blowing it out with a blank or a cartridge from which the bullet has been removed. Firing a subsequent bullet into the obstructed barrel can damage the firearm and cause serious injury to the shooter or bystanders. Bullets can become lodged in the barrel when the cartridge has been improperly loaded without propellant powder, the powder fails to ignite, or the bullet was not properly seated in the cartridge case.

If it is suspected that a bullet is obstructing the barrel, immediately unload and clear the firearm. Field strip the firearm and look through the bore of the barrel. It is not sufficient to merely look in the chamber; a bullet may be lodged some distance down the barrel where it cannot easily be seen. Attempt to remove the bullet by tapping it out with a cleaning rod. If the bullet can be removed, clean any unburned powder grains from the bore, chamber, and mechanism before resuming shooting. If the bullet cannot be dislodged by tapping it with a cleaning rod, take the firearm to a certified SIG SAUER Armorer.

## 16.3 COOK-OFF



### **WARNING COOK-OFF**



**COOK-OFF IS DEFINED AS A CHAMBERED CARTRIDGE DETONATING DUE TO THE HEAT OF THE BARREL. FAILURE TO COMPLY WITH THE BELOW LISTED STEPS COULD RESULT IN DEATH, SERIOUS INJURY, OR PROPERTY DAMAGE.**

If the firearm stops firing with a cartridge in the chamber of a hot barrel due to a misfire or stoppage, remain calm and do the following:

1. Keep the firearm pointed in a safe direction.
2. Immediately remove the magazine and chambered cartridge.
3. If the cartridge cannot be removed within 10 seconds, keep firearm pointed in a safe direction and wait at least 15 minutes for the chamber and barrel to cool, then remove the cartridge.



## 16.4 GENERAL STOPPAGES

Stoppage	Test / Inspection	Corrective Action
<b>Fails to Fire</b>	Selector lever on SAFE	Rotate to FIRE position
	Bolt handle not in the fully closed position	Ensure bolt handle is rotated all the way down prior to firing
	Excessive lubricant in firing pin recess of bolt	Clean out lubricant, see <i>10.2.3 Cleaning the Bore and Chamber on page 64</i>
	Defective ammunition	Replace ammunition
<b>Bolt is Hard to Unlock</b>	Dirty bolt	Clean, lubricate, and reinstall, see <i>10.2.3 Cleaning the Bore and Chamber on page 64</i>
	High pressure ammunition	Use only the correct ammunition, conforming to SAAMI specifications
	Damaged component	Contact Customer Service
<b>Bolt is Hard to Lock</b>	Dirty bolt lugs	Clean lugs
	Dirty chamber	Clean chamber
	Ammunition not to specification	Use only the correct ammunition, conforming to SAAMI specifications

Stoppage	Test / Inspection	Corrective Action
<b>Failure to Feed</b>	Dirty, corroded, or damaged ammunition	Replace ammunition
	Dirty magazine	Clean and replace, see <i>10.2.3 Cleaning the Bore and Chamber on page 64</i>
	Defective magazine	Replace magazine
	Magazine not seated	Remove magazine and ensure it is fully seated
<b>Double Feed</b>	Defective magazine	Replace magazine
<b>Failure to Chamber</b>	Dirty / corroded ammunition	Replace ammunition
	Dirty chamber / feed ramps	Clean chamber / feed ramps
<b>Failure to Extract</b>	Dirty / corroded ammunition	Replace ammunition
	Dirty chamber	Clean chamber
	Damaged extractor	Contact Customer Service



## 16.5 MINIMIZING STOPPAGES

- Most stoppages can be minimized by cleaning and lubricating the firearm. See *10.2 Cleaning and Lubrication on page 62*.
- Cleaning and lubricating the firearm after each range session will reduce the chances of a stoppage due to dirt and residue buildup.
- Perform maintenance if the firearm is exposed to extreme environmental conditions (rain, mud, snow, freezing temperatures, etc.).
- Periodically inspect the firearm if it is to be stored for extended periods of time without use.
- Most stoppages are directly related to the magazine. Perform maintenance on the magazines as well as the firearm. See *11.0 Magazine Maintenance on page 76*.
- Mark the magazines so that magazines related to a stoppage can be easily identified.

## 17.0 REPLACEMENT PARTS POLICY



### **WARNING PARTS REPLACEMENT**

**IT IS THE PURCHASER'S RESPONSIBILITY TO BE ABSOLUTELY CERTAIN THAT ANY PARTS ORDERED FROM THE FACTORY ARE CORRECTLY FITTED AND INSTALLED. FIREARMS ARE COMPLICATED MECHANISMS AND IMPROPER FITTING OF PARTS MAY RESULT IN A DANGEROUS MALFUNCTION, DAMAGE TO THE FIREARM, AND SERIOUS INJURY TO THE SHOOTER AND OTHER PERSONS. THE PURCHASER AND INSTALLER OF PARTS MUST ACCEPT FULL RESPONSIBILITY FOR THE CORRECT ADJUSTMENT AND FUNCTIONING OF THE FIREARM AFTER SUCH INSTALLATION.**

### **Parts Policy**

Our Service Department maintains a full complement of replacement parts. Even though most gunsmiths have the knowledge, training, and the ability to make necessary repairs to the firearm, the skill and workmanship of any particular third-party gunsmith is totally beyond our control.

Should the firearm ever require service, it is strongly recommended that it be returned to SIG SAUER Inc. A firearm is a precision instrument and some replacement parts will require individual fitting to ensure correct operation. A wrong part, improper fitting, or incorrect mechanical adjustment may result in an unsafe condition or dangerous malfunction, damage to the firearm, or cause possible serious injury to the shooter or others.



IF ANY PART IS ORDERED WITHOUT RETURNING THE FIREARM TO SIG SAUER, Inc. the customer bears full responsibility for ensuring that the part supplied is correct for their particular firearm and is properly installed and fitted by a qualified gunsmith.

SIG SAUER INC. IS NOT RESPONSIBLE FOR THE FUNCTIONING OF ANY FIREARM IN WHICH REPLACEMENT PARTS ARE INSTALLED BY OTHERS.

THE USE OF UNAUTHORIZED AFTERMARKET PARTS WILL VOID THE WARRANTY OF THIS FIREARM. THE REPLACEMENT OF ORIGINAL EQUIPMENT MANUFACTURER (OEM) SIG SAUER PARTS WITH AFTERMARKET PARTS IS UNAUTHORIZED AND IN SOME INSTANCES COULD ALTER THE FUNCTION OF THE FIREARM, CREATING A DANGER TO THE OPERATOR.

Scan the QR code below to visit the Small Parts Shopper page at sigsauer.com.

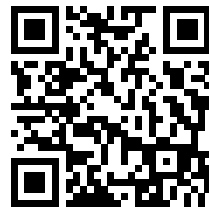


## 18.0 FACTORY REPAIR OF THE FIREARM

Contact Customer Service for questions or concerns regarding the performance or serviceability of the firearm. There are three ways to contact Customer Service:

Have the firearm's serial number available before contacting Customer Service.

1. Call (603) 610-3000, choose option 1.
2. Email [CustomerService@sigsauer.com](mailto:CustomerService@sigsauer.com).
3. Go to <https://www.sigsauer.com/customer-support> to message Customer Service electronically. Scan the QR code below to visit the Customer Support page at sigsauer.com.





## 18.1 RETURNING FIREARMS FOR REPAIR

Do not ship a firearm without an RMA number provided by Customer Service.



**WARNING DO NOT SHIP AMMUNITION**



**BEFORE SHIPPING ANY FIREARM, BE ABSOLUTELY CERTAIN THAT THE FIREARM AND MAGAZINES ARE UNLOADED. DO NOT SHIP AMMUNITION WITH A FIREARM.**

1. The RMA number allows SIG SAUER to track the status of the return from the time SIG SAUER receives the firearm until it is returned.
2. Package the firearm securely to prevent damage.
3. Do not include any accessories such as scopes or mounts unless directed to do so.
4. Some states and localities require firearms to be shipped and returned to SIG SAUER using a federally licensed firearms dealer.
5. Federal law prohibits persons who do not possess a Federal Firearms License (FFL) from shipping a firearm via the U.S. Postal Service.
6. Any shipment of firearms outside U.S. borders is subject to the export laws of the United States and to the valid laws of the specific country.
7. SIG SAUER is not responsible for any damage to a firearm during shipping until it is received.
8. Firearms must be insured and prepaid prior to shipment (SIG SAUER does not accept collect shipments) to the address provided by Customer Service.



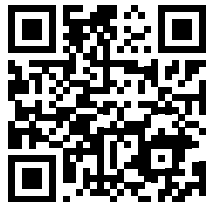
## SUB-MOA GUARANTEE™

SIG SAUER guarantees that any CROSS rifle will deliver MOA accuracy within 3-shot groups at 100 yards using factory premium ammunition.

The new CROSS-Magnum SAWTOOTH from SIG SAUER is certified to deliver sub-MOA performance of 3 shot groups under 1-inch at 100 yards using factory premium ammunition.

**SIG SAUER INFINITE GUARANTEE™****NOTES:**

For warranty information on new SIG SAUER firearms, scan the QR code below to visit the SIG SAUER Warranty Information and Registration page. New firearms can also be registered and warranty information can be found on the website.







CALIBER			CARTRIDGE			BARREL		
	RANGE (YDS)	Mv (FPS)		ENERGY ( FT-LBS)	TRAJECTORY (IN)	ADJ (MOA)	ADJ (MILS)	WIND DRIFT (IN)
100								
200								
300								
400								
500								
600								
700								
800								
900								
1000								

CALIBER			CARTRIDGE			BARREL		
	RANGE (YDS)	Mv (FPS)		ENERGY ( FT-LBS)	TRAJECTORY (IN)	ADJ (MOA)	ADJ (MILS)	WIND DRIFT (IN)
100								
200								
300								
400								
500								
600								
700								
800								
900								
1000								

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