

SIGSAUER®



SIG MPX®

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

1.0 SAFETY WARNINGS

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

The warnings in this operators 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 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

SIG SAUER

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.**

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.



WARNINGS

1.0 SAFETY WARNINGS – CONTINUED

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.

ABUSIVE HANDLING

SIG SAUER firearms incorporate effective mechanical safeties. However, like any mechanical device, exposure to abusive conditions may have a negative effect on these safety mechanisms and cause them to fail to work as designed. Do not subject your SIG SAUER firearm to any type of abusive handling. This includes the firearm being dropped, impact to the firearm, or the firearm being struck by another object. Make sure you always maintain control of your firearm at all times. If your firearm does suffer an abusive event such as previously described, 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 prior to using the firearm.

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

As previously noted, if your SIG SAUER firearm does suffer an abusive event, unload it immediately and have it inspected by a certified SIG SAUER Armorer or gunsmith prior to using the firearm.

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



WARNINGS

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REPLACEMENT PARTS

Do not attempt to disassemble your SIG SAUER firearm beyond the point explained in this manual. Disassembly beyond the instructions in this manual is restricted to a certified SIG SAUER armorer. Failure to comply with these restrictions will void your warranty.

Warnings and instructions about the use of some SIG SAUER replacement parts, assemblies, and accessories may be described in literature accompanying the specific products. Read and carefully follow those instructions. Such warnings and instructions are provided to assure the safe functioning of the firearm. Failure to heed them may result in improper functioning, damage to the firearm, and serious injury or death to you or others.

ALTERATIONS

This SIG SAUER firearm was designed to function properly in its original condition. Unauthorized alterations can make it unsafe. Do not alter any part or add or substitute any parts or accessories not manufactured by SIG SAUER for this firearm. The addition of any parts or accessories beyond the user level of maintenance described in this manual is not authorized.



WARNINGS

1.0 SAFETY WARNINGS – CONTINUED

ACCESSORIES

It is your responsibility to ensure that all accessories, such as slings and firearm-mounted lights, are compatible with this firearm and that the accessories do not interfere with the safe operation and handling of the firearm.

TRANSPORTING

When transporting your firearm, be sure the firearm is unloaded and cleared of all ammunition. It is your responsibility to familiarize yourself with the laws of any state you will be traveling through with your firearm.

STORAGE

The only safe way to store your firearm is unloaded, cleared of all ammunition, and secure. Safe and secure storage is one of your most important responsibilities. Store your unloaded firearm separate from your ammunition and in places inaccessible to children or unauthorized persons.

CHAMBER SAFETY FLAG

Every SIG SAUER firearm is shipped with a chamber safety flag. The chamber safety flag prevents the chambering of a round when installed and provides a readily visible indication that the firearm's chamber is empty. The chamber safety flag is to be installed 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

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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

BASIC RULES OF SAFE FIREARMS HANDLING

1. ALWAYS treat every firearm as if it were loaded.
2. ALWAYS be sure the barrel is clear of any obstruction.
3. ALWAYS be sure of your backstop, what lies beyond, and the safety of bystanders before you shoot.
4. ALWAYS use clean, dry, original factory-made ammunition of the proper type and caliber for your firearm.
5. ALWAYS wear ear protection and safety glasses when shooting.
6. ALWAYS carry your firearm so that you can control the direction of the muzzle if you fall or stumble.
7. NEVER shoot at a flat surface or water.
8. DO NOT leave a loaded firearm unattended. Firearms and ammunition should be stored separately, locked if possible, and beyond the reach of children, careless adults, or unauthorized users.
9. NEVER allow your firearm to be used by anyone who has not read and understood this operator's manual.
10. DO NOT point any firearm, loaded or unloaded, at any undesired or unsafe target.
11. NEVER discharge your 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.
12. NEVER drink alcoholic beverages or use drugs before or during shooting, as your vision and judgment could be seriously impaired, making your firearm handling unsafe.



WARNINGS

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1.1 EYE AND EAR PROTECTION



Always wear safety glasses that meet the requirements of American National Standards Institute (ANSI) z87.1 and ear plugs and “ earmuff ”-type protectors whenever you are shooting. Always make certain that persons close to you 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.

1.2 AMMUNITION

Use only high-quality, original, factory-manufactured ammunition. Do not use cartridges that are dirty, wet, corroded, bent, or damaged. Do not oil cartridges. Do not spray aerosol-type lubricants, preservative, or cleaners directly onto cartridges or where excess spray may flow into contact with cartridges. Lubricant or other foreign matter on cartridges can cause potentially dangerous ammunition malfunctions. Use only ammunition of the caliber for which your firearm is chambered. The proper caliber is permanently engraved on your firearm; never attempt to use ammunition of any other caliber.

The use of reloaded, “re-manufactured” hand-loaded, or other nonstandard ammunition voids all warranties. Reloading is a science and improperly loaded ammunition can be extremely dangerous.



WARNINGS

1.2 AMMUNITION – CONTINUED

Severe damage to the firearm and serious injury or death to the shooter or to others may result. 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 in any SIG SAUER firearm of faulty, nonstandard, "re-manufactured" hand-loaded (reloaded) ammunition, or cartridges other than those for which the firearm was originally chambered.

Firearms may be severely damaged and serious injury or death to the shooter or to others may result from any condition causing excessive pressure inside the chamber or barrel during firing. Excessive pressure can be caused by obstructions in the barrel, propellant powder overloads, the use of incorrect cartridges, or defectively assembled cartridges. In addition, the use of a dirty, corroded, or damaged cartridge can lead to a burst cartridge case and consequent damage to the firearm and personal injury from the sudden escape of high-pressure propellant gas within the firearm's mechanism.

OBSTRUCTED BORE

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

- You have difficulty in, or feel 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.



WARNINGS

SIG SAUER

Firing a subsequent bullet into the obstructed barrel can damage the firearm and cause serious injury to the shooter or to bystanders.

Bullets can become lodged in the barrel when:

- The cartridge has been improperly loaded without propellant powder, or if the powder fails to ignite (ignition of the cartridge primer alone will push the bullet out of the cartridge case, but usually does not generate sufficient energy to expel the bullet completely from the barrel);
- The bullet is not properly seated in the cartridge case. When such a cartridge is extracted from the chamber without being fired, the bullet may be left behind in the bore at the point where the rifling begins. Subsequent chambering of another cartridge may push the first bullet further into the bore.

If there is any reason to suspect 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.

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. Such techniques can generate excessive pressure, damage the firearm, and cause serious personal injury or death.

If the bullet can be removed by tapping it with a cleaning rod, 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.



WARNINGS

1.2 AMMUNITION – CONTINUED

Dirt, corrosion, or other foreign matter on a cartridge can impede chambering and may cause the cartridge case to burst upon firing. A damaged or deformed cartridge may also impede chambering or cause the cartridge case to burst upon firing.

Do not lubricate cartridges, and be sure to wipe the chamber clean of any oil or preservative before shooting. Oil interferes with the friction between cartridge case and chamber wall that is necessary for safe functioning, and subjects the firearm to stress similar to that imposed by excessive pressure.

Use lubricants sparingly on the moving parts of your firearm. Avoid excessive spraying of any aerosol gun care product, especially where it might get on ammunition. All lubricants, aerosol spray lubricants in particular, can penetrate cartridge primers and cause misfires. 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.

Death, serious injury, and damage to the firearm can result from the use of wrong ammunition, bore obstructions, powder overloads, or incorrect cartridge components. Always wear shooting glasses and hearing protectors.



WARNINGS

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WARNING: CANCER AND REPRODUCTIVE HARM—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 YOU TO LEAD.



WARNINGS

1.3 STATE-BY-STATE WARNINGS

Certain states require, by law, that their own specified warning notices, in larger than-normal type be conspicuously included by the manufacturer, distributor, or retail dealer with firearms sold in that state. SIG SAUER sells its products in compliance with applicable laws and regulations. Because our products may be sold in these states, we include the following:



CALIFORNIA: WARNING

Firearms must be handled responsibly and securely stored to prevent access by children and other unauthorized users. California has strict laws pertaining to firearms, and you may be fined or imprisoned if you fail to comply with them. Visit the Web site of the California Attorney General at <https://oag.ca.gov/firearms> for information on firearm laws applicable to you and how you can comply. Prevent child access by always keeping guns 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."

If you or someone you know is contemplating suicide, please call the National Suicide Prevention Lifeline at 1-800-273 TALK (8255).



ADVERTENCIA

Las armas de fuego deben manipularse de manera responsable y segura para evitar el acceso de niños y otros usuarios no autorizados. California tiene leyes estrictas relacionadas con armas de fuego, y usted puede ser multado o encarcelado si no las cumple. Visite el sitio web del fiscal general de California en <https://oag.ca.gov/firearms> para obtener información sobre las leyes de armas de fuego que son aplicables y cómo puede cumplirlas. Evite el acceso de niños manteniendo siempre las armas bloqueadas y descargadas cuando no estén en uso. Si mantiene un arma de fuego cargada donde un niño la puede obtener y la usa indebidamente, se le puede multar o enviar a prisión.

Si usted o alguien que conoce está contemplando el suicidio, llame a la Línea Nacional de Prevención del Suicidio al 1-800-273 TALK (8255).



WARNINGS

SIG SAUER

CONNECTICUT:

"UNLAWFUL STORAGE OF A LOADED FIREARM MAY RESULT IN IMPRISONMENT OR FINE."

FLORIDA:

"IT IS UNLAWFUL, AND PUNISHABLE BY IMPRISONMENT AND FINE, FOR ANY ADULT TO STORE OR LEAVE A FIREARM IN ANY PLACE WITHIN THE REACH OR EASY ACCESS OF A MINOR UNDER 18 YEARS OF AGE OR TO KNOWINGLY SELL OR OTHERWISE TRANSFER OWNERSHIP OR POSSESSION OF A FIREARM TO A MINOR OR A PERSON OF UNSOUND MIND."

MAINE:

"ENDANGERING THE WELFARE OF A CHILD IS A CRIME. IF YOU LEAVE A FIREARM AND AMMUNITION WITHIN EASY ACCESS OF A CHILD, YOU MAY BE SUBJECT TO FINE, IMPRISONMENT OR BOTH. KEEP FIREARMS AND AMMUNITION SEPARATE. KEEP FIREARMS AND AMMUNITION LOCKED UP. USE TRIGGER LOCKS."

MARYLAND:

"WARNING: CHILDREN CAN OPERATE FIREARMS WHICH MAY CAUSE DEATH OR SERIOUS INJURY. IT IS A CRIME TO STORE OR LEAVE A LOADED FIREARM IN ANY LOCATION WHERE AN INDIVIDUAL KNEW OR SHOULD HAVE KNOWN THAT AN UNSUPERVISED MINOR WOULD GAIN ACCESS TO THE FIREARM. STORE YOUR FIREARM RESPONSIBLY!"



WARNINGS

MASSACHUSETTS:

“WARNING FROM THE MASSACHUSETTS ATTORNEY GENERAL: This handgun is not equipped with a device that fully blocks use by unauthorized users. More than 200,000 firearms like this one are stolen from their owners every year in the United States. In addition, there are more than a thousand suicides each year by younger children and teenagers who get access to firearms. Hundreds more die from accidental discharge. It is likely that many more children sustain serious wounds, or inflict such wounds accidentally on others. In order to limit the chance of such misuse, it is imperative that you keep this weapon locked in a secure place and take other steps necessary to limit the possibility of theft or accident. Failure to take reasonable preventative steps may result in innocent lives being lost, and in some circumstances may result in your liability for these deaths.”



WARNINGS

SIG SAUER

MASSACHUSETTS: - Continued

“IT IS UNLAWFUL TO STORE OR KEEP A FIREARM, PISTOL, 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 JERSEY:

“IT IS A CRIMINAL OFFENSE TO LEAVE A LOADED FIREARM WITHIN EASY ACCESS OF A MINOR.”

NEW YORK CITY, NY:

“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 SEPARATE FROM THEIR AMMUNITION AND INACCESSIBLE TO CHILDREN AND OTHER UNAUTHORIZED PERSONS.”



WARNINGS

NORTH CAROLINA:

Any person who resides in the same premises as a minor, owns or possesses a firearm, and stores or leaves the firearm (i) in a condition that the firearm can be discharged and (ii) in a manner that the person knew or should have known that an unsupervised minor would be able to gain access to the firearm, is guilty of a Class 1 misdemeanor if a minor gains access to the firearm without the lawful permission of the minor's parents or a person having charge of the minor and the minor:

- (1) Possesses it in violation of G.S. 14-269.2(b)
- (2) Exhibits it in a public place in a careless, angry, or threatening manner;
- (3) Causes personal injury or death with it not in self defense; or
- (4) Uses it in the commission of a crime.

TEXAS:

"IT IS UNLAWFUL TO STORE, TRANSPORT, OR ABANDON AN UNSECURED FIREARM IN A PLACE WHERE CHILDREN ARE LIKELY TO BE AND CAN OBTAIN ACCESS TO THE FIREARM."

WISCONSIN:

"IF YOU LEAVE A LOADED FIREARM WITHIN THE REACH OR EASY ACCESS OF A CHILD YOU MAY BE FINED OR IMPRISONED OR BOTH IF THE CHILD IMPROPERLY DISCHARGES, POSSESSES, OR EXHIBITS THE FIREARM."

Please check with your licensed retailer, state police, or local police for additional warnings, which may be required by local law or regulation. Such regulations change constantly, and local authorities are in the best position to advise you on such legal matters.



WARNINGS

SIGSAUER

1.4 LOCKING DEVICES



All firearms are originally shipped with a key-operated locking device, except for Custom Works firearms that are shipped with a lockable case.

Although it can help provide secure storage for your unloaded firearm, any locking device can fail.

All firearms are designed to fire if they are loaded and the trigger is pressed.

Therefore, never install the locking device inside the trigger guard or in any way that makes it possible to press the trigger!

Do not leave the keys in the lock.

The ultimate responsibility for secure storage of any firearm must depend upon its owner and his or her individual circumstances.

Firearms should be stored unloaded, in a secure location, separate from their ammunition.

To maximize effectiveness and reduce the chances of malfunction or damage to a firearm, ALWAYS refer to the locking device's manufacturer directions for installation and removal of the device.



WARNINGS

1.5 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:

SIG SAUER[®]
ACADEMY

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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2.0 MECHANICAL CHARACTERISTICS AND RIFLE THEORY

2.1 RIFLE DESCRIPTION

2.1.1 GENERAL

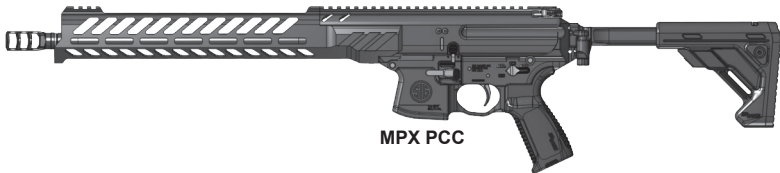
The SIG MPX is a magazine fed, gas operated firearm available in 9X19 mm. The SIG MPX fires from a rotating locking closed bolt. The SIG MPX is available in SAFE-SEMI and SAFE-SEMI-AUTO variants. The operating system is a short stroke piston system enabling optimum function under adverse conditions. The SIG MPX features an AR-style ambidextrous fire control selector lever and left side bolt catch and right side bolt release.

The MPX is fitted with an aluminum handguard which provides a MIL-STD 1913 rail at the 12 o'clock position. There are multiple M-LOK™ mounting interfaces for accessories at the 3, 6, and 9 o'clock positions. There are several sling attachment points provided. SIG offers the MPX rifle with several stock variations.

2.2 SPECIFICATIONS

All MPX specifications and configurations can be found online at sigsauer.com.





MPX PCC



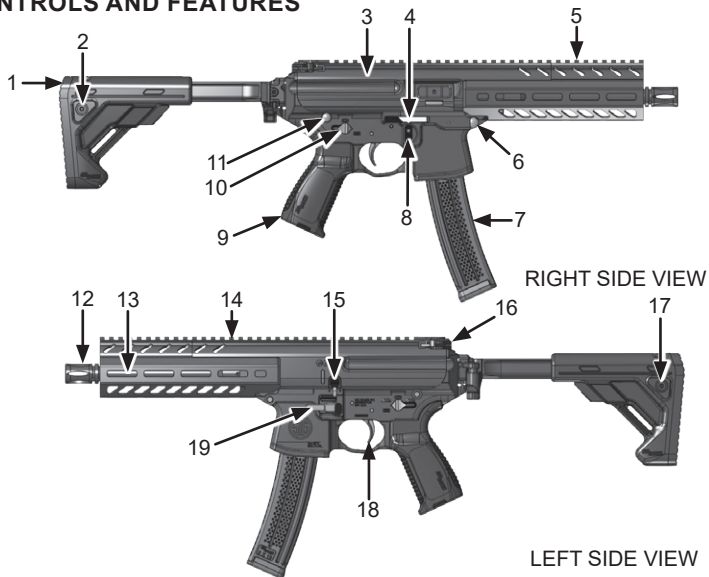
MPX



MPX K



2.3 CONTROLS AND FEATURES



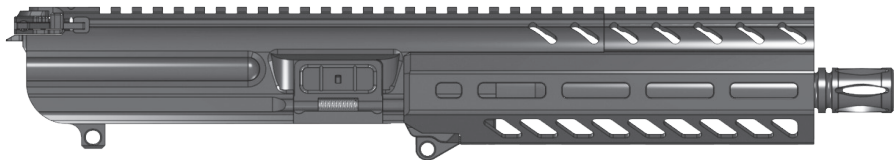
POSN	NOMENCLATURE
1	Buttstock
2	QD Sling Cup
3	Upper Receiver
4	Bolt Release
5	M-LOK Handguard
6	Pivot Pin
7	Magazine
8	Magazine Release Button
9	Grip
10	Ambidextrous Fire Control Selector
11	Takedown Pin
12	Flash Hider
13	Barrel
14	MIL-STD 1913 Rail
15	Left Side Bolt Catch
16	Charging Handle
17	QD Sling Cup
18	Trigger
19	Ambidextrous Magazine Catch



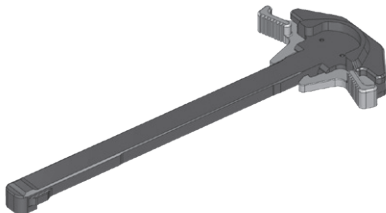
2.4 GROUPS AND ASSEMBLIES

2.4.1 UPPER RECEIVER GROUP

The upper receiver group consists of the following:

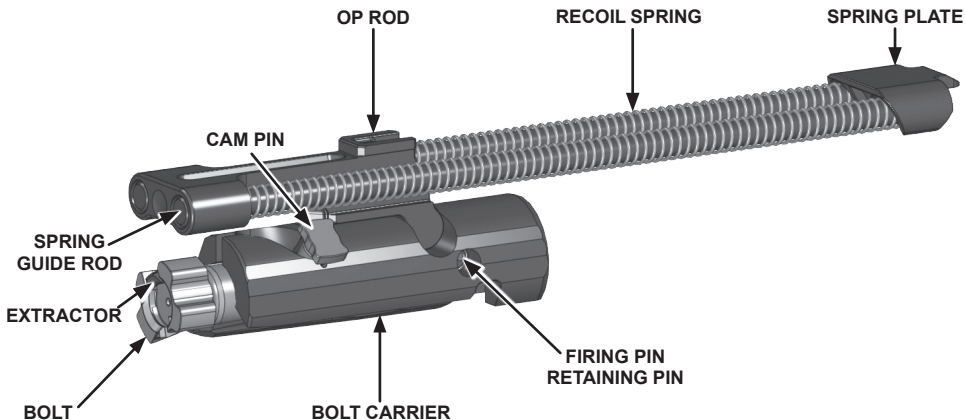


- A. Ambidextrous Charging Handle Assembly.



B. MPX Carriage Assembly.

The carriage assembly guides the bolt and controls locking and unlocking by means of the cam pin. The carriage assembly also incorporates the op rod/recoil springs assembly, and firing pin. The bolt carrier is responsible for cocking the hammer.





WARNING PHYSICAL INJURY/DAMAGE

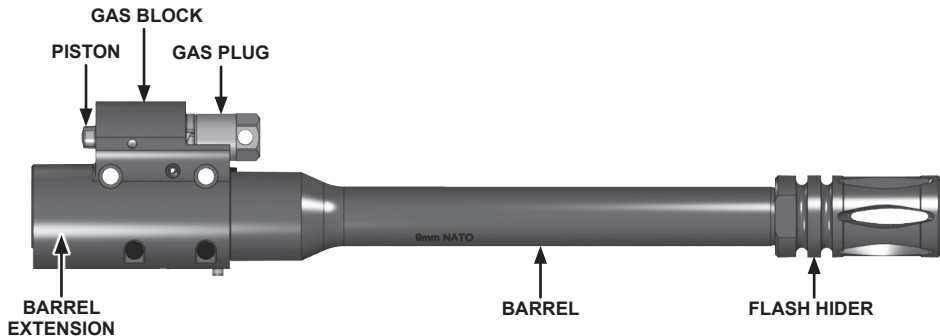


DUE TO THE MODULARITY OF THE SIG SAUER MPX PLATFORM, IT IS POSSIBLE TO IMPROPERLY CONFIGURE THE HANDGUARD AND BARREL ASSEMBLY. THE FOLLOWING GUIDELINES MUST BE FOLLOWED TO AVOID DAMAGE TO THE FIREARM AND INJURY TO THE OPERATOR. DO NOT INSTALL A BARREL ASSEMBLY THAT IS SHORTER IN LENGTH THAN THE HANDGUARD UNLESS A SUPPRESSOR IS ATTACHED. IF A SUPPRESSOR IS NOT ATTACHED, THE ENTIRE LENGTH OF THE FLASH HIDER OR MUZZLE BRAKE MUST EXTEND PAST THE END OF THE HANDGUARD. FAILURE TO FOLLOW THESE DIRECTIONS COULD RESULT IN SERIOUS INJURY TO THE OPERATOR'S EXTREMITIES DUE TO POSITION OF HANDS IN RELATION TO THE MUZZLE BLAST AND FLASH. DAMAGE TO THE FIREARM CAN OCCUR DUE TO MUZZLE BLAST OCCURRING WITHIN THE CONFINES OF THE HANDGUARD.

C. Barrel Assembly.

The SIG MPX barrel assembly includes the barrel extension, barrel, gas block, gas plug, gas piston, and the flash hider.

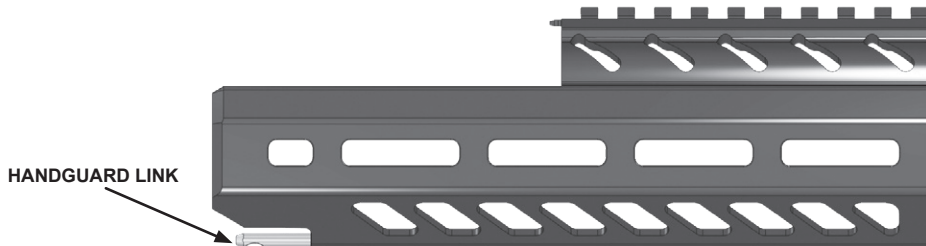
The image below depicts an 8 inch barrel assembly.





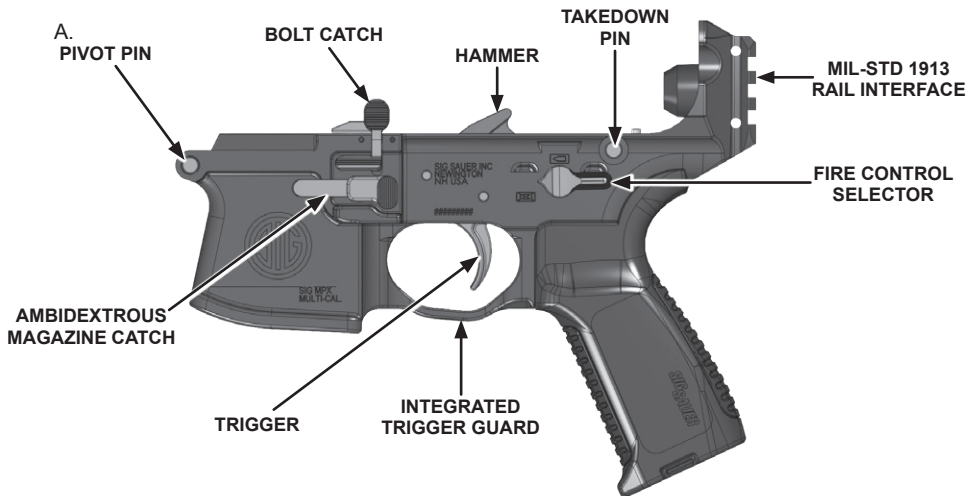
D. Handguard Assembly.

The SIG MPX handguard assembly is comprised of the handguard and the handguard link. There are several versions depending on barrel length and use of suppressors. The handguard features multiple M-LOK points for mounting M-LOK accessories.



2.4.2 LOWER RECEIVER GROUP

The Lower Receiver Group consists of the following assemblies: Lower Receiver Assembly with Fire Control Components, Buttstock Assembly, and Grip Assembly.





2.5 CYCLE OF FUNCTION

There are eight steps in the cycle of function of the SIG MPX which begin after a loaded magazine is inserted into the firearm.

FEEDING

As the bolt carrier is released from its rearward position, the carrier group moves forward allowing the lower lugs of the bolt to make contact with the rear of the cartridge as it sits in the magazine. The cartridge is stripped from the magazine and begins its forward movement toward the chamber.

CHAMBERING

As the bolt moves forward, the bolt locking lugs move forward into the barrel extension. The last action that occurs is the extractor snapping over the rim of the cartridge case.

LOCKING

The movement of the bolt and the cartridge is stopped by the chamber. The bolt carrier continues to move forward until it is stopped by contact with the rear face of the barrel extension. As the carrier goes through the last portion of movement, the bolt is rotated to the left, through the action of the cam slot in the carrier and the cam pin through the bolt. This engages the bolt lugs with the barrel extension lugs to lock the bolt into the barrel extension.

FIRING

The selector is rotated to the Semi position. The trigger is pressed and the hammer is released. The hammer spring drives the hammer forward into the firing pin. The firing pin strikes the cartridge primer, causing detonation.

UNLOCKING

As the bullet passes the gas port in the barrel, a small amount of gas is bled off, traveling up through the gas port and into the gas block. The gas is regulated by the gas plug. This gas acts upon the piston to move the operating rod to the rear. The operating rod transfers its energy to the carrier assembly setting it in motion. The rearward movement of the carrier causes the bolt cam pin to rotate the bolt to the unlocked position.

EXTRACTION

As the bolt carrier assembly moves rearward the spent case is pulled free from the chamber by the extractor. The twisting motion of the bolt aids in the extraction from the chamber.

EJECTION

The extractor continues to grip the rim of the spent case on the right side. As the expended case clears the chamber, then the barrel extension, it strikes the fixed ejector and ejects out through the ejection port on the right side of the receiver.

COCKING

The rearward movement of the bolt carrier overrides the hammer, forcing it down into the receiver, which compresses the hammer spring and cocks the hammer in the firing position.



3.0 OPERATING THE SIG MPX

3.1 PREPARATION BEFORE USING THE FIREARM

Ensure you have read, understand, and are capable of following all the safety warnings on pages 2-20 of this manual in addition to the safety rules, regulations, procedures, or guidelines of your club or local shooting range.

Prior to using the firearm it is strongly suggested to field strip the firearm (Section 4.1) and clean any fouling that might have occurred during factory testing (Section 5.0). Inspect, lubricate, and reassemble the firearm (Section 6.0). Upon reassembly and prior to firing the rifle, conduct the function check (Section 6.6).

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 SIG MPX in accordance with the SIG SAUER MPX Technical Armorer's Manual.

3.2 SELECTING MODES OF FIRE

The SIG MPX is available in two fire control configurations. SAFE-SEMI and SAFE-SEMI-AUTO. Modes of fire are selected by rotating the selector lever to the desired position. The SAFE position prevents the firearm from firing by blocking the action of the trigger. The SEMI position is for the semi-automatic mode and allows the firing of one round each time the trigger is depressed. AUTO, if so equipped, allows for a continuous rate of fire until the trigger is released by the operator or the magazine is depleted of ammunition.



SAFE



SEMI



AUTO

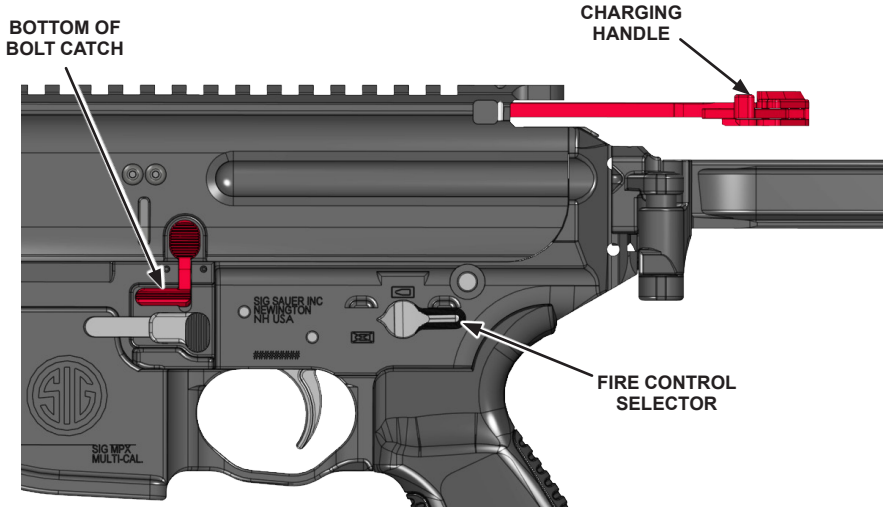


3.3 UNLOADING AND CLEARING THE SIG MPX

1. Ensure the muzzle of the firearm is pointed in a safe direction at all times while clearing the firearm.
2. Remove the magazine from the firearm by pressing the magazine catch and simultaneously pulling the magazine from the receiver.



3. Press and hold the bottom portion of the bolt catch while pulling the charging handle briskly and fully to the rear. The bolt carrier assembly should remain locked to the rear. Return charging handle to its forward and locked position. Rotate fire control selector to SAFE.





WARNING PARTS UNDER SPRING TENSION



THE CARRIAGE ASSEMBLY IS UNDER SPRING TENSION AND WILL FORCEFULLY CLOSE IF THE BOLT CATCH IS PRESSED, POSSIBLY CAUSING INJURY. DO NOT ALLOW BOLT CATCH TO BE PRESSED WHEN INSPECTING THE FIREARM.

4. Inspect the chamber, bolt face, and magazine well to ensure that there are no live rounds or spent cartridges present.



5. If passing the firearm to another person, allow that person to inspect the chamber before handling the firearm. Pass the firearm with the bolt locked to the rear and the fire control selector on SAFE.

3.4 LOADING/RELOADING

3.4.1 LOADING/BOLT LOCKED TO THE REAR

1. Grasp and retract the charging handle, locking the bolt carrier to the rear by pressing inward on the bottom of the bolt catch.
2. Return the charging handle to the forward locked position.
3. Rotate the fire control selector to the SAFE position.
4. Visually and physically inspect the chamber, bolt face, and magazine well to ensure it is clear.
5. Insert a loaded magazine until it engages and is held by the magazine catch. Always pull down to ensure the magazine is seated properly.
6. Press the top of the bolt catch inward or press the right side bolt release, releasing the bolt carrier. If the firearm is not to be fired immediately, close the ejection port cover.

3.4.2 LOADING/BOLT FORWARD

1. Insert a loaded magazine until it engages and is held by the magazine catch. Always pull down to ensure the magazine is seated properly.
2. Grasp the charging handle and pull it completely to the rear.
3. Release the charging handle, allowing it to move forward under full spring pressure (DO NOT RIDE IT FORWARD).
4. Rotate the fire control selector to SAFE.



3.4.3 RELOADING (EXPENDED MAGAZINE/BOLT LOCKED TO THE REAR).

1. Rotate the fire control selector to SAFE.
2. Press the magazine catch from either the left or right side. The magazine should fall free from the magazine well.
3. Insert a loaded magazine until it engages and is held by the magazine catch. Pull down to ensure the magazine is seated properly.
4. Press the top of the bolt catch inward or press the right side bolt release, releasing the bolt carrier. If the firearm is not to be fired immediately, close the ejection port cover.

3.4.4 RELOADING (MAGAZINE PARTIALLY EXPENDED/BOLT FORWARD, LIVE ROUND CHAMBERED)

1. Rotate the fire control selector to SAFE.
2. Grasp the magazine with the support hand and press the magazine catch from either the left or right side to release the magazine.
3. Remove the partially loaded magazine and secure it.
4. Insert a loaded magazine until it engages and is held by the magazine catch. Pull down to ensure the magazine is seated properly.

3.5 FIRING

SEMI: When the fire control selector is rotated to this position, one press of the trigger will result in a single round being fired. The trigger must be released to reset.

AUTO: When the fire control selector is rotated to this position, pressing the trigger will result in continuous fire at the cyclic rate until the trigger is released or the magazine is depleted of ammunition.

To fire the SIG MPX:

1. Adjust the buttstock, if not already done.
2. Insert a loaded magazine into the magazine well, charge the firearm, and place on SAFE.
3. Face the target, placing the firearm to your shoulder.
4. Rotate the fire control selector from SAFE to SEMI or AUTO.
5. Press the trigger to release the hammer, causing the cartridge to be fired.



3.6 ADVERSE/SPECIAL CONDITIONS

Arctic (Extreme Cold/Sub-Freezing)

- When operating in sub-freezing temperatures, use a lubricant designed for use in this climate. Do not use CLP in temperatures below -10°F (-23°C), as it can prevent the firearm from firing. Ensure that all existing lubricants are thoroughly removed prior to applying cold weather lubricant.
- Remove the O-Ring from the extractor spring when in temperatures below -20°F (-29°C).
- Avoid bringing firearm into heated shelters or buildings to prevent condensation from forming on moving parts which will freeze when the firearm is brought back outdoors.
- If you must bring the firearm indoors, allow it to warm to room temperature and then disassemble and clean thoroughly, ensuring that all moisture is removed from the firearm. Re-lubricate the firearm.
- When operating in snowy environments, conduct frequent inspection of the firearm to ensure that snow has not gotten into operating parts. Work the action to ensure it is not frozen. Use muzzle covers if available.
- If the bolt carriage becomes frozen with snow/moisture, DO NOT discharge the firearm to free the carriage. Warm the firearm using body heat or bring indoors until free movement is restored, and then clean and re-lubricate 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. Use muzzle covers if available.
- Unload and clean ammunition and inside of magazines daily. Do not lubricate magazine.
- Cover firearm when not in use.
- Close the ejection port cover when not in use.

Jungle (Hot/Humid)

- Increase frequency of inspection and cleaning of the firearm for rust/corrosion.
- Apply thin coat of lubricant on steel parts frequently.
- Inspect hidden surfaces of bolt and carriage assembly, upper receiver, chamber and barrel extension (locking lugs).
- Inspect the lower receiver for corrosion.
- Inspect and lubricate the spring-loaded detents of the firearm.
- Unload magazine, clean ammunition, and inspect the inside of magazines daily for corrosion.
- Wipe ammunition dry before reloading.



3.7 STOPPAGES

If the SIG MPX stops firing, apply immediate action:

1. Slap up on the bottom of the magazine.
2. Pull charging handle completely rearward.
3. Observe the ejection of the case/cartridge and check the chamber for any obstruction.
4. Release the charging handle to feed a new cartridge.
5. Press the trigger and attempt to fire the rifle.

If the SIG MPX still fails to fire upon completion of the above steps, apply remedial action:

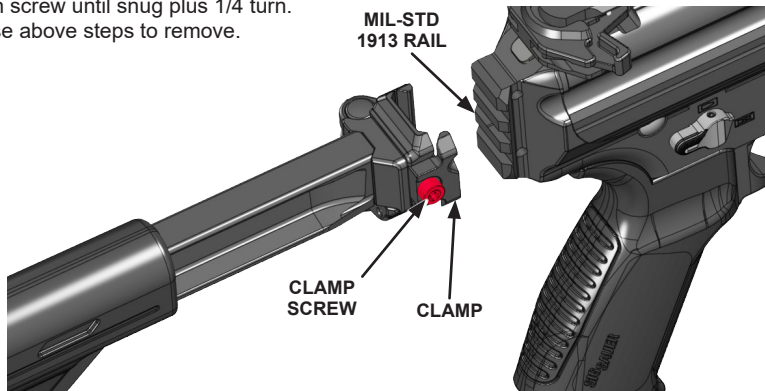
1. Place MPX on SAFE.
1. Check the chamber for a stuck case.
2. If a case is present, separate the receivers and remove the bolt and carriage assembly.
3. Attempt to tap out the case with cleaning rod from the muzzle end of the barrel. If the firearm still fails to fire, refer to section "7.0 Troubleshooting" on page 94 of this manual.

3.8 FOLDING / ADJUSTABLE STOCK

SIG SAUER offers several stocks for the MPX series of rifles. All are designed to attach to the MIL-STD 1913 interface on the rear of the lower receiver.

3.8.1 INSTALLING STOCK

1. Loosen rail clamp screw with a T27 drive bit.
2. Place clamp onto the MIL-STD 1913 rail at the desired height.
3. Tighten screw until snug plus 1/4 turn.
4. Reverse above steps to remove.





3.8.2 FOLDING AND DEPLOYING STOCK

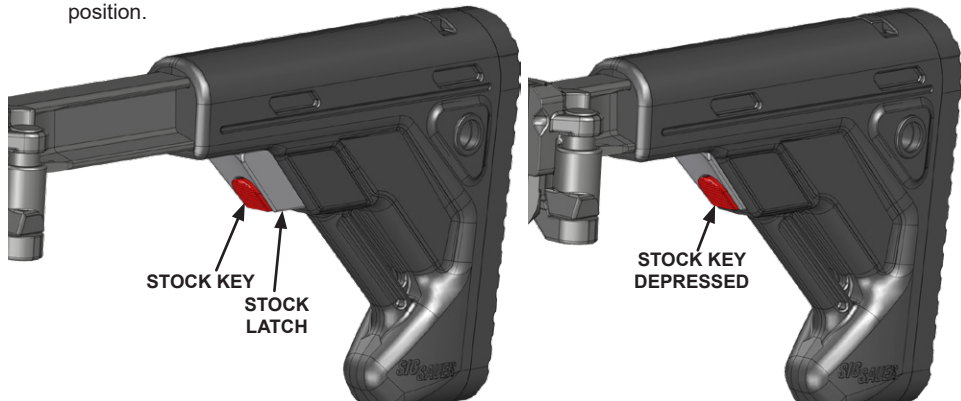
To fold, lift up on the stock until the stock adapter clears the stock mount and swing it around to the left side of the rifle. To deploy the stock, pull it firmly to the open position. It is not necessary to lift up on the stock to deploy it.



3.8.3 ADJUSTING LENGTH OF PULL

There are five positions of length of pull adjustment on this stock.

1. To adjust the length of the stock, press in on the serrated stock key to unlock the latch.
2. Adjust the stock to the desired position.
3. Once the stock is at the desired length, release the stock key.
4. Manipulate the stock forward and backward to ensure it is securely engaged in the desired position.





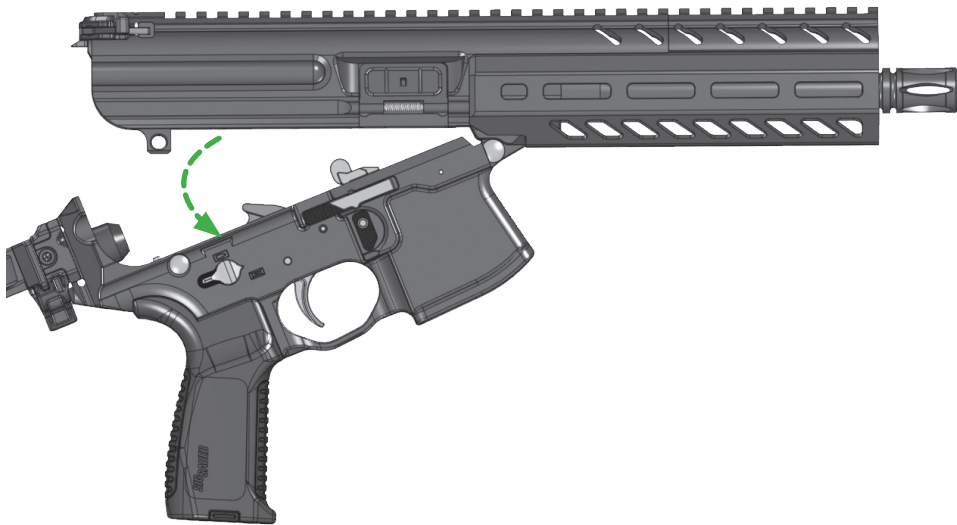
4.0 USER LEVEL AUTHORIZED PREVENTIVE MAINTENANCE

4.1 FIELD STRIP THE SIG MPX

1. Unload and clear the firearm. Ensure the fire control selector is on SAFE.
2. Remove sling if attached.
3. Push takedown pin from left to right until stopped by detent.



4. Swing receivers apart.

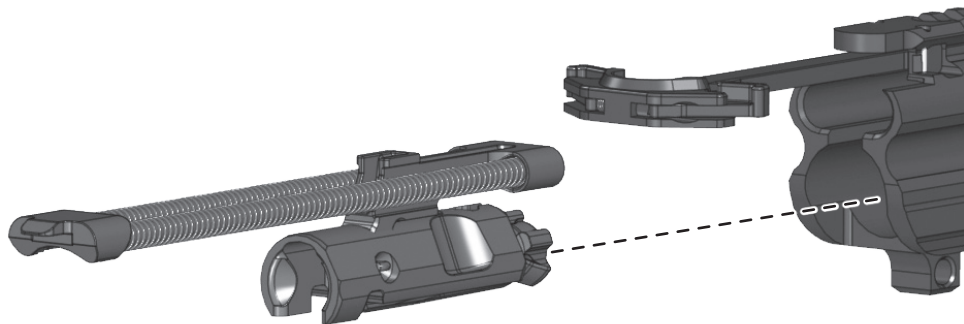




5. Retract charging handle until it stops.

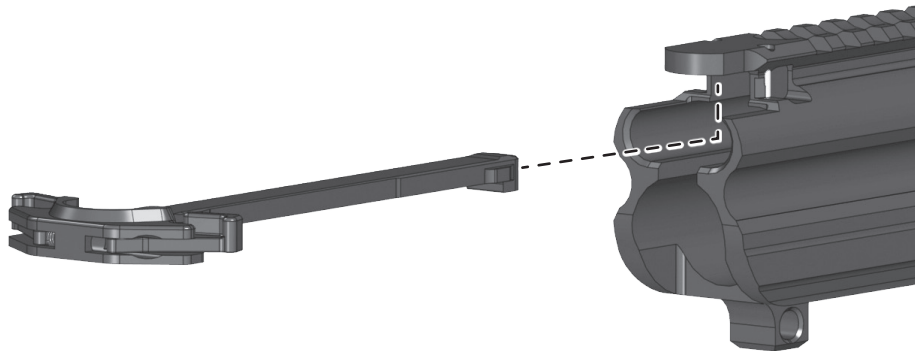


6. Grasp recoil spring plate and pull carriage assembly from upper receiver. It will come out as a complete unit.





7. Remove charging handle from receiver.

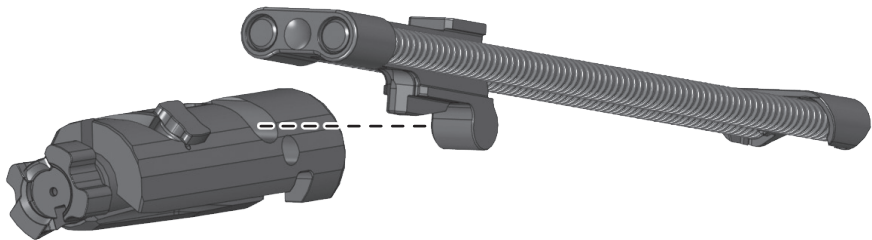


8. Close receivers together and push pivot pin from left to right, then separate receivers.

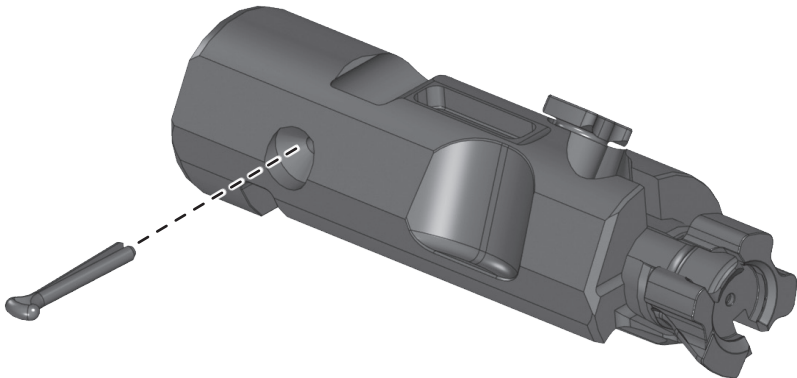




9. Rotate recoil assembly upward and slide it out from left side of bolt carrier.

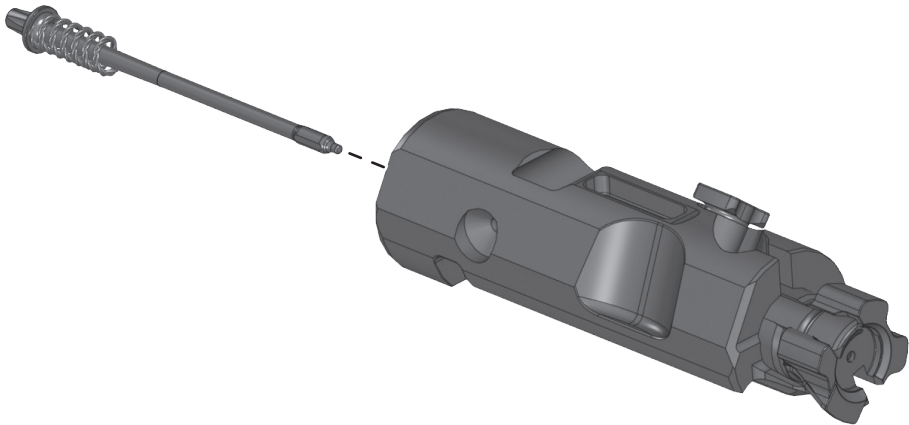


10. Remove firing pin retaining pin.

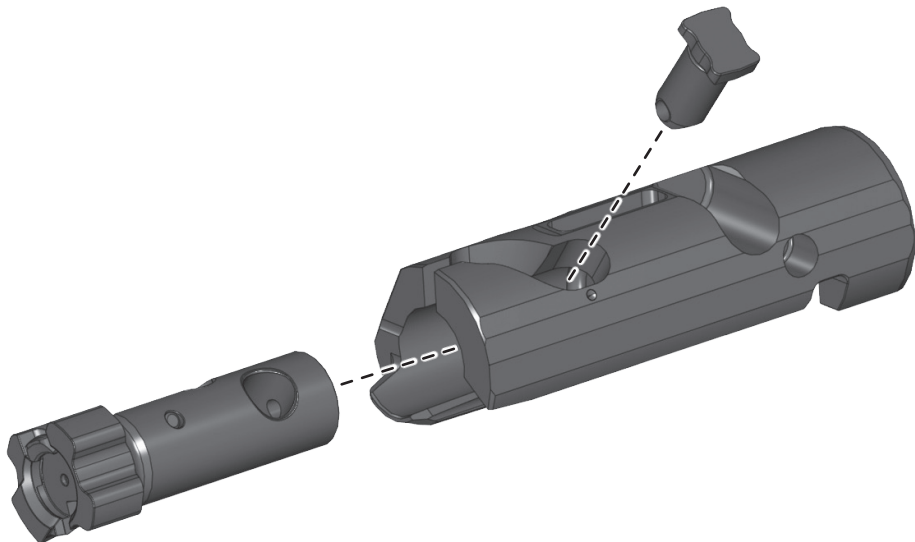




11. Remove firing pin and spring from rear of bolt carrier.

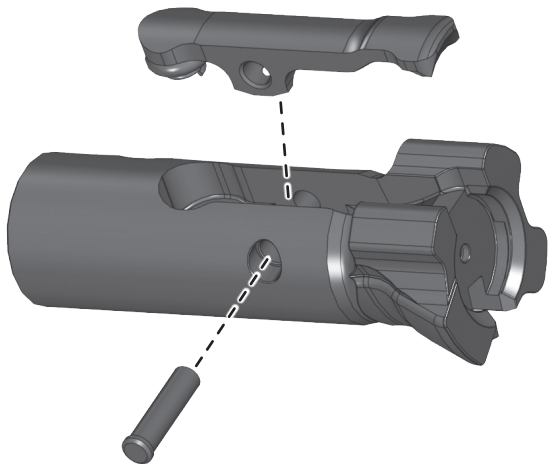


12. Remove cam pin from bolt, then remove bolt from front of carrier.



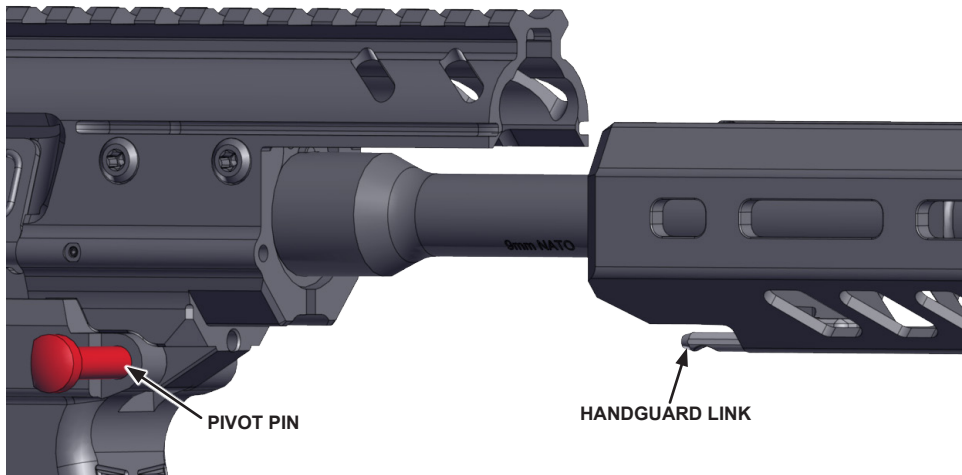


13. Push extractor pin out to right side and remove extractor from the bolt. Do not remove O-ring unless operating in temperatures below -20°F or replacement is necessary. Do not remove extractor spring or extractor insert unless replacement is necessary.



4.2 HANDGUARD REMOVAL

The handguard is held on by the pivot pin passing through the handguard link as shown. To remove, pull pivot pin out to detent, then pull handguard forward off of upper receiver.



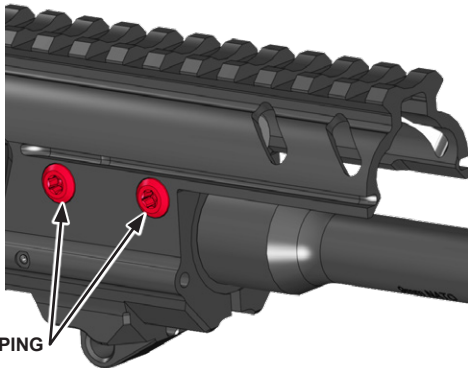


4.3 BARREL REMOVAL

NOTE

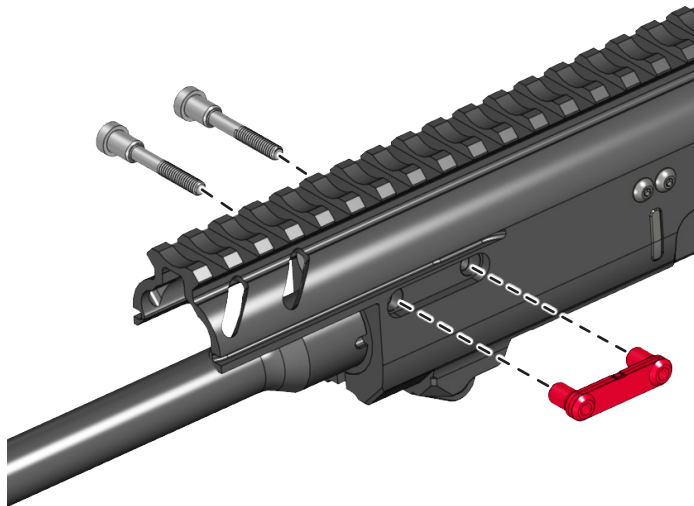
The carriage assembly must be removed prior to removing the barrel. See section “4.1 Field Strip the SIG MPX” on page 50. The barrel extension is engaged by the bolt lugs when the carriage assembly is in the forward position.

1. Use a T25 drive bit to loosen and remove the two barrel clamping screws from the right side of the upper receiver.



**BARREL CLAMPING
SCREWS**

2. Remove barrel clamp from left side of receiver. If the barrel clamp is stuck, thread one of the screws in from the left side and gently pull it out.

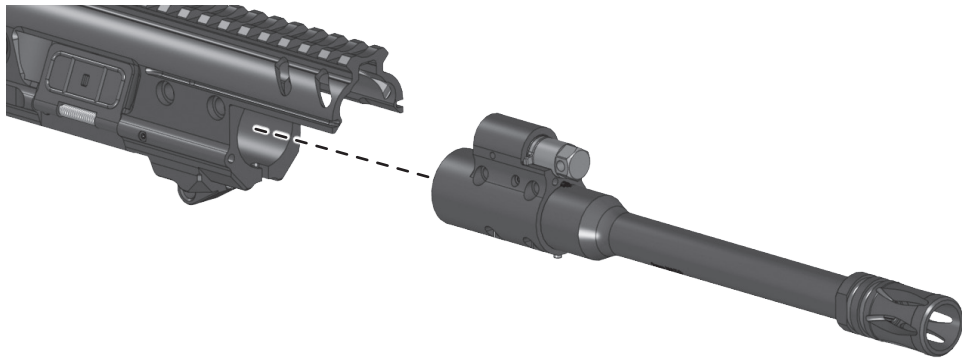




CAUTION

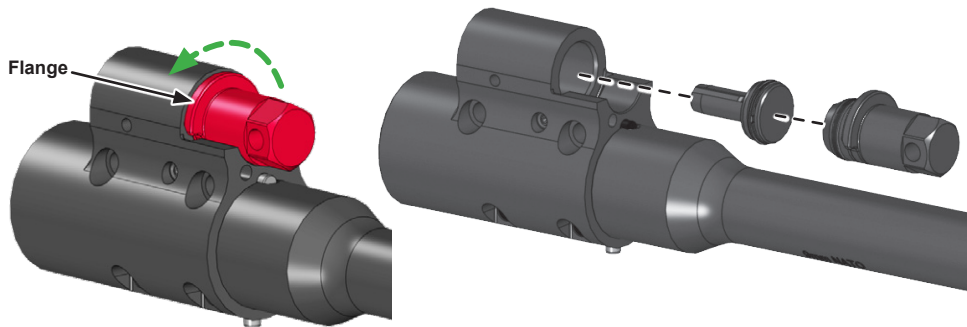
DO NOT WIGGLE BARREL BACK AND FORTH TO REMOVE AS THIS CAN DAMAGE THE UPPER RECEIVER.

3. Pull barrel straight out of upper receiver.



4.4 GAS PLUG AND PISTON REMOVAL

1. Rotate gas plug 180 degrees until flange on plug is fully exposed, allowing plug to be pulled out of gas block.
2. Remove gas plug and piston from the front of gas block.





5.0 CLEANING AND LUBRICATION

- Use only cleaning and lubrication products specifically designed for use on firearms.
- Do not use wire brushes on aluminum surfaces such as the upper/lower receivers, because this can scratch the finish.
- Follow all manufactures instructions and cautions when using cleaning and lubrication products.
- Wherever the term CLP (Cleaner-Lubricant-Preservative) or the words lube or lubrication are used in this manual, it is interpreted to mean that you can use any lubricant designed for use on firearms.
- Wherever propellant gases directly contact operating system parts, carbon will build up. Carbon cannot be removed with a brush and must be scraped.

5.1 CLEANING THE BORE AND CHAMBER

Do not run patches through the bore with a sound suppressor attached.

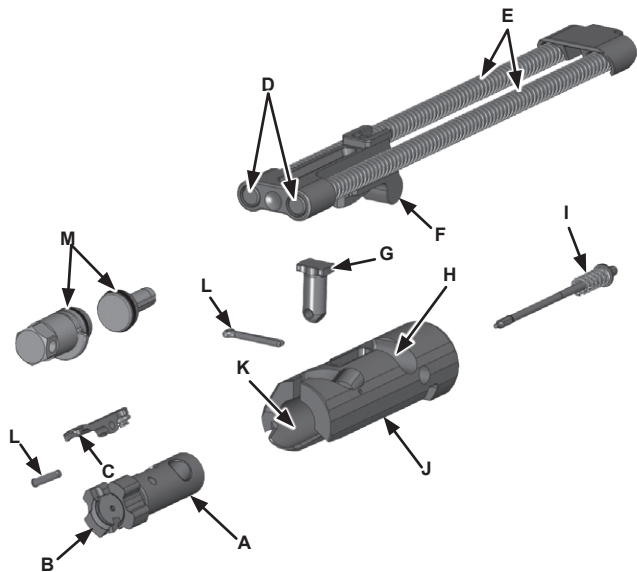
1. Attach the proper caliber jag to the cleaning rod.
2. Moisten a patch with CLP and slowly push it through the bore toward the muzzle end.
3. Allow the CLP to stay in the barrel for several minutes to loosen any fouling.
4. Attach a new clean patch to the cleaning rod.
5. Coat the patch as before and push it through the bore.
6. If heavy fouling is present, use a bore brush to scrub the bore.
7. Push a patch through the bore with CLP to remove any residue loosened by the bore brush.
8. Push new patches through the bore until they come out clean.
9. Coat the chamber brush with CLP.
10. Keep the muzzle elevated so the CLP does not run into the freshly cleaned bore.
11. Make several plunging strokes followed by several 360 degree rotations in the barrel extension to clean the locking lug area.



5.2 CLEANING THE OPERATING SYSTEM

If the MPX is used with a suppressor attached, the back pressure will produce more residue, which will require attention. It is suggested to increase the frequency of regular maintenance.

- A. Clean bolt body with solvent.
- B. Clean any carbon from bolt lugs.
- C. Clean hood of extractor.
- D. Clean recoil spring rods.
- E. Clean recoil springs.
- F. Clean the op rod, paying attention to residue buildup on the lug that engages the bolt carrier.
- G. Clean the cam pin of carbon buildup.
- H. Clean the op rod interface of the bolt carrier.
- I. Wipe down the firing pin and spring.
- J. Wipe down the bolt carrier body.
- K. Clean the bolt channel of any carbon buildup.
- L. Clean the firing pin retaining pin and extractor pin.
- M. Remove carbon buildup from piston and plug.

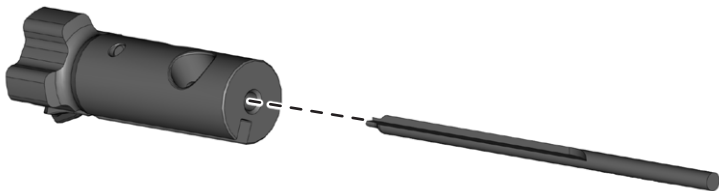




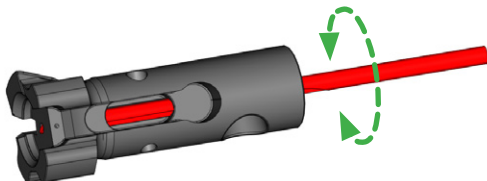
5.3 SCRAPER TOOL

The scraper tool is used to remove carbon buildup for the firing pin channel of the bolt assembly.

- A. Insert scraper tool into firing pin slot in rear of bolt assembly.



- B. Spin tool to remove carbon buildup.



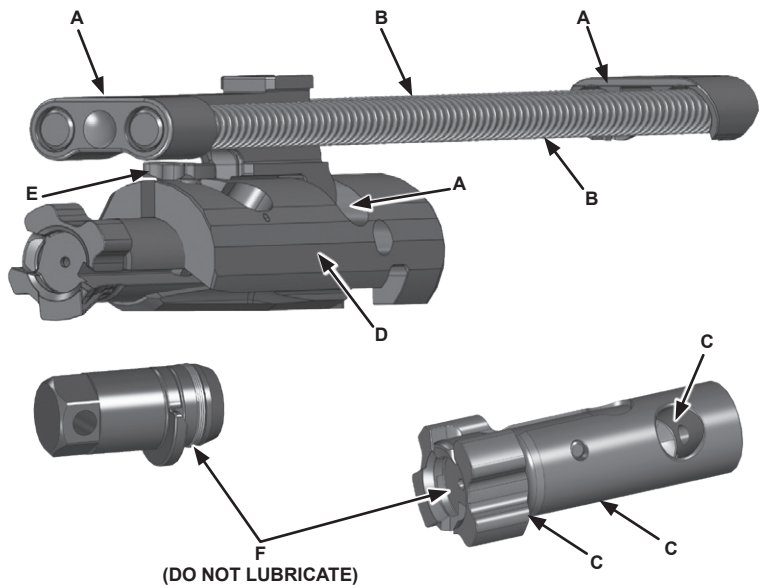
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5.4 LUBRICATION

Carriage Assembly

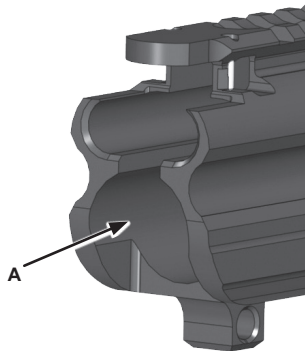
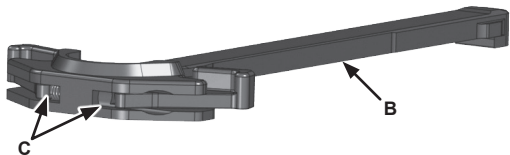
- A. Apply 1 to 2 drops of lubricant where the op-rod contacts the spring guide, recoil plate, and bolt carrier.
- B. Apply a thin film of lubricant to the spring guide rods and recoil springs.
- C. Apply a thin coat of lubricant to the back of bolt lugs, bolt body, and cam pin hole.
- D. Apply a thin coat of lubricant to the bolt carrier contact surfaces.
- E. Apply 1 to 2 drops of lubricant to the cam pin.
- F. Do not lubricate the face of the bolt or the gas plug.





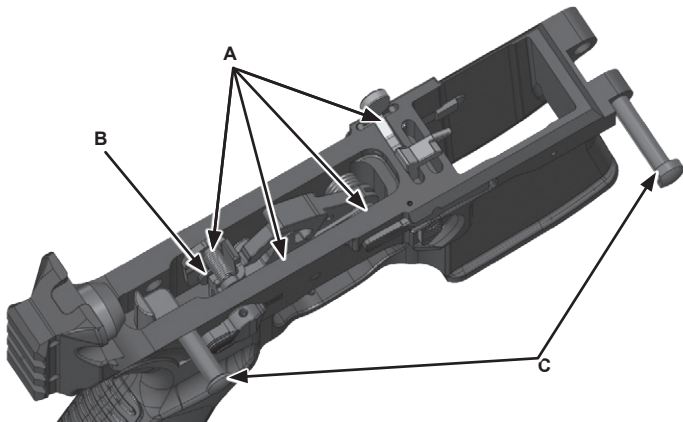
Upper Receiver

- A. Apply a thin film of lubricant to the inside of the upper receiver to the surfaces where the carriage assembly makes contact.
- B. Apply a thin film of lubricant to the sides of the charging handle.
- C. Apply 1 to 2 drops of lubricant to the charging handle latches.



Lower Receiver

- A. Apply 1 to 2 drops of lubricant to the hammer, trigger, auto sear (auto variants only), and bolt catch where these parts contact their respective pins.
- B. Apply 1 to 2 drops of lubricant to the selector where it contacts the lower receiver.
- C. Apply 1 to 2 drops of lubricant to pivot and takedown pins.

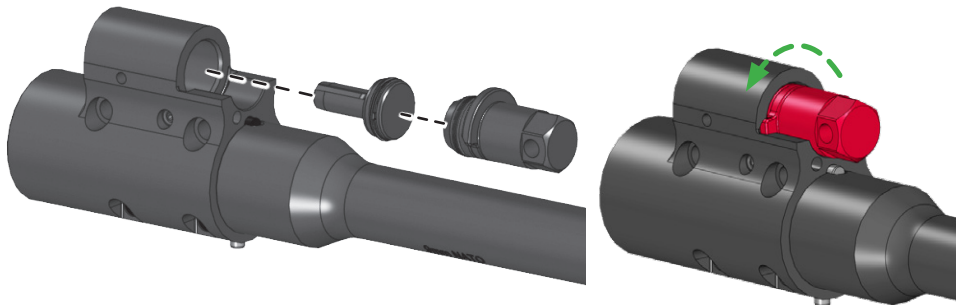




6.0 REASSEMBLY FROM FIELD STRIP

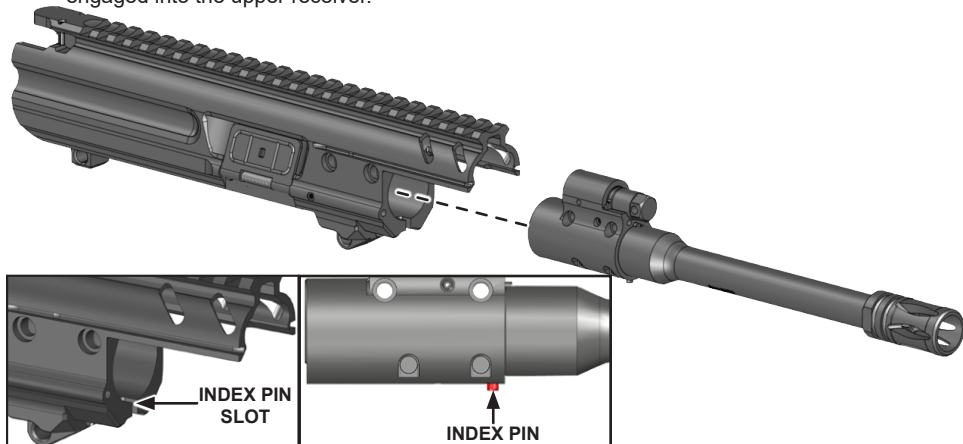
6.1 GAS PLUG AND PISTON INSTALL

1. Insert the piston and gas plug into the gas block.
2. Rotate the gas plug 180 degrees to lock it in the gas block.



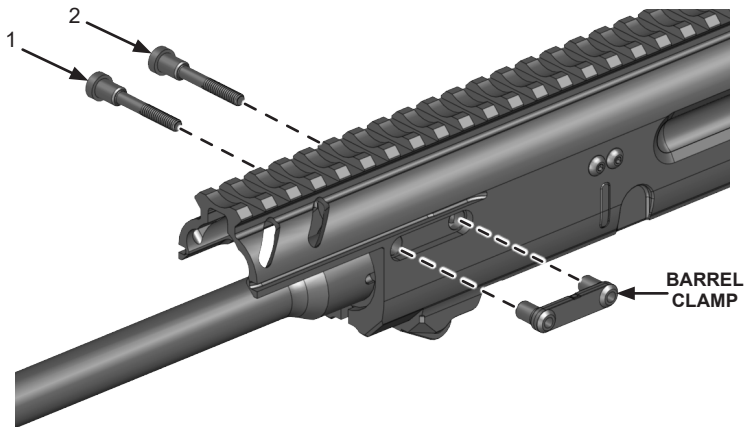
6.2 BARREL INSTALL

1. Ensure that all mating surfaces are clean.
2. Check the barrel index pins for damage or looseness.
3. Slide the barrel assembly back into the upper receiver, making sure the index pin is properly engaged into the upper receiver.

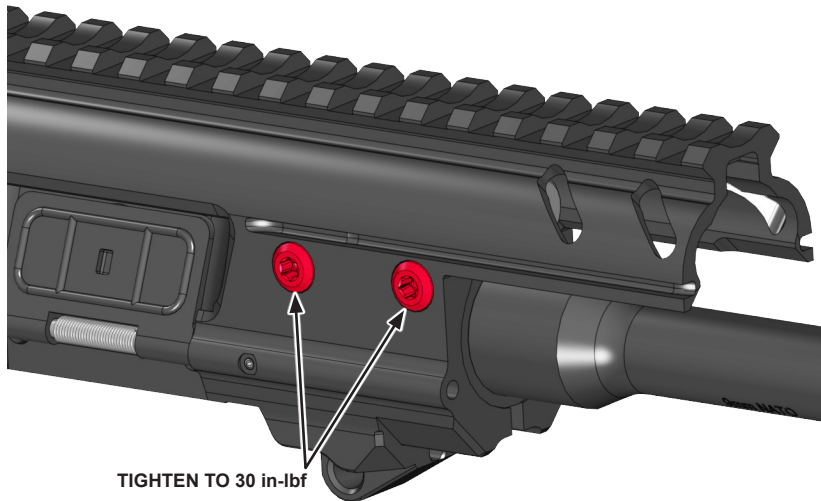




4. Insert the barrel clamp into the upper receiver.
5. Insert screw #1 and tighten several revolutions with a T25 drive bit. Insert screw #2 and tighten several revolutions.
6. Continue to tighten screws, alternating evenly back and forth until the barrel clamp is firmly seated in upper receiver.



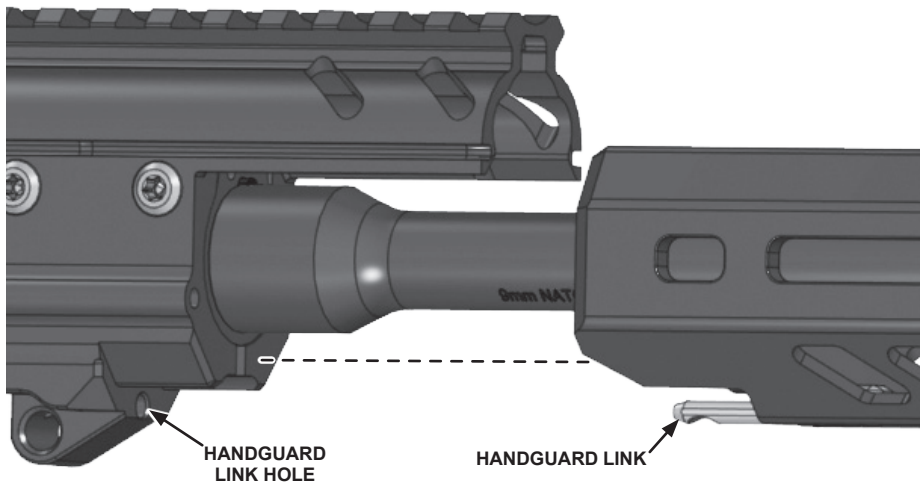
7. Tighten screws to 30 in-lbf. Double check for proper torque.





6.3 HANDGUARD INSTALLATION

1. Slide handguard onto upper receiver. Ensure handguard link lines up with the hole in the upper receiver.

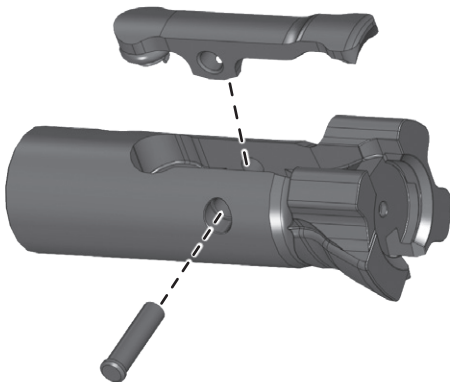


6.4 CARRIAGE ASSEMBLY

NOTE

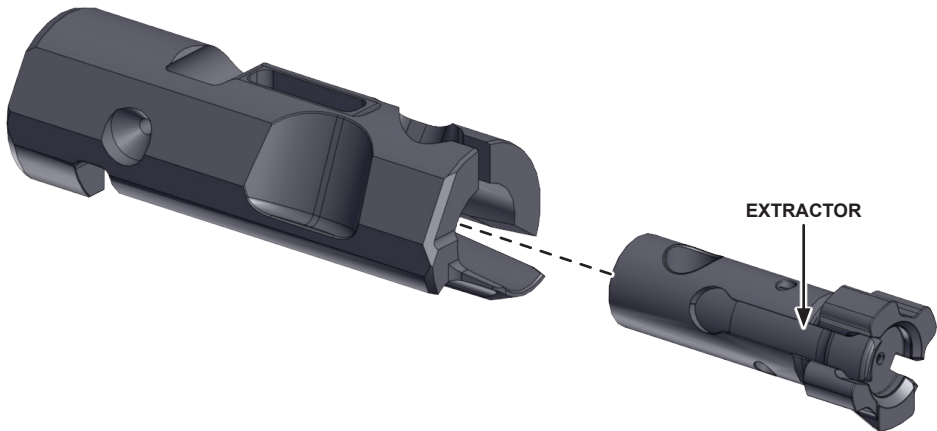
Do not install O-Ring if operating in or below -20°F.

1. Attach the extractor to the bolt body and insert extractor pin from right side.





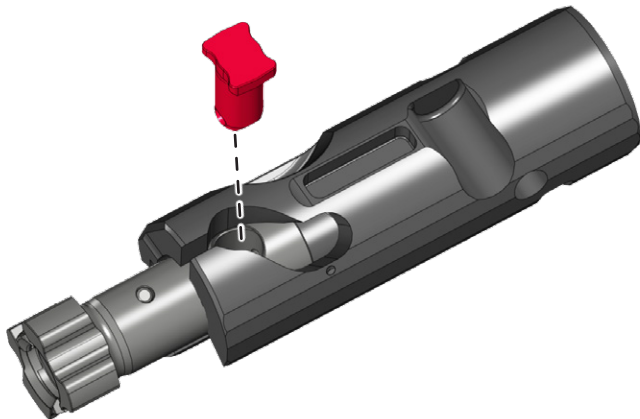
2. Insert bolt into bolt carrier with extractor oriented as shown below.



**WARNING PHYSICAL INJURY/DAMAGE**

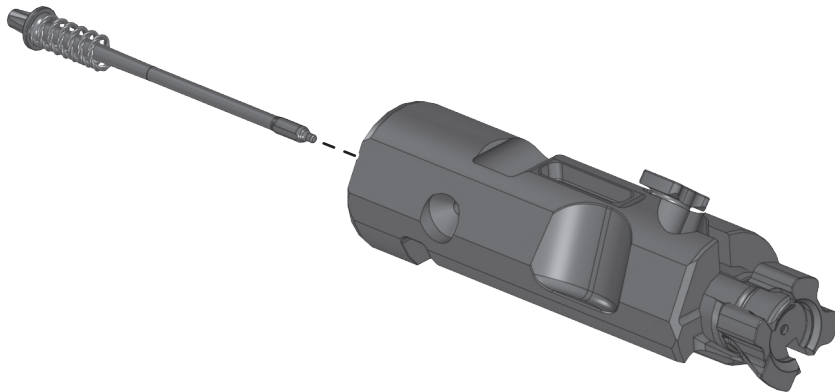
FAILURE TO INSTALL CAM PIN MAY RESULT IN SERIOUS INJURY OR DEATH TO THE USER AND CATASTROPHIC DAMAGE TO THE FIREARM.

3. Insert cam pin and align firing pin through hole to firing pin bore.

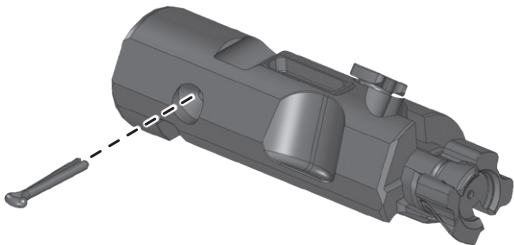




4. Install the firing pin and spring into the rear of the bolt.

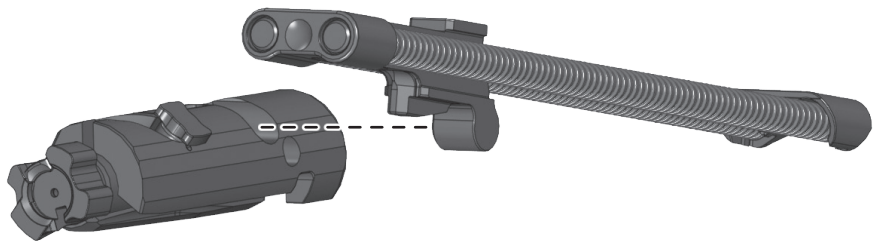


5. Push firing pin Inward completely, compressing firing pin spring.
6. Install firing pin retaining pin from right side of bolt carrier with split in pin vertical.
7. Release firing pin. Firing pin retaining pin must be positioned behind the large flange of the firing pin.



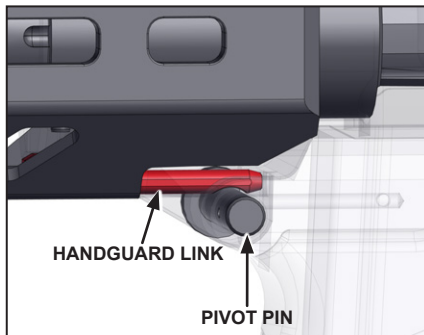
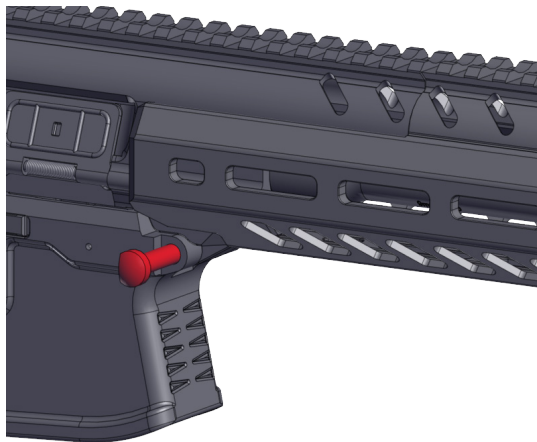


8. Install the recoil assembly into the carrier from the left side.



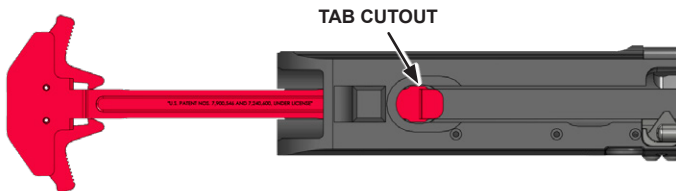
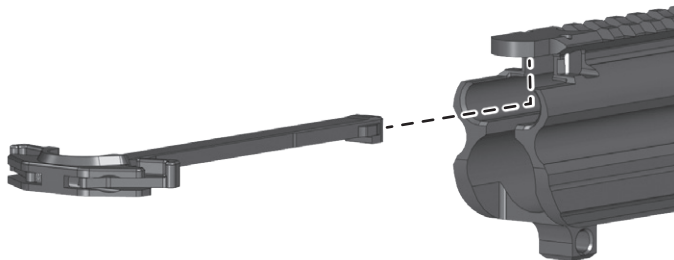
6.5 UPPER AND LOWER RECEIVER

1. Attach upper receiver to lower receiver using pivot pin. Ensure that the handguard is completely rearward and that the pivot pin passes through the cutout in the handguard link.





2. Insert charging handle into upper receiver by lining up the tabs on the charging handle with the cutout in the upper receiver. Leave charging handle about halfway in for the next step.

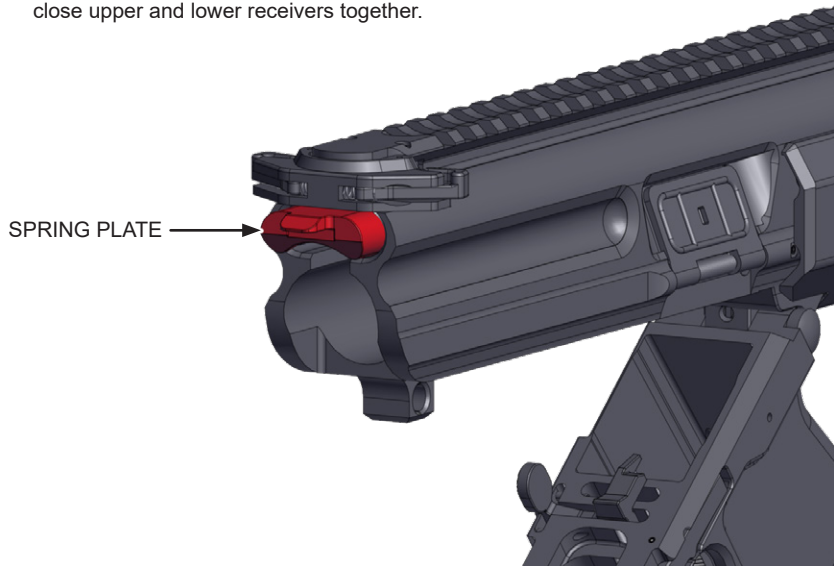


3. Insert carriage assembly into the upper receiver, then push charging handle forward until it locks in place.





4. Press down and maintain pressure on spring plate until it is inside the upper receiver, then close upper and lower receivers together.



5. Hold receivers together and push takedown pin back in place.





6.6 FUNCTION CHECK



WARNING

UNLOAD/CLEAR



PRIOR TO STARTING THE FUNCTION CHECK ENSURE THE FIREARM IS UNLOADED/ CLEARED AND ON SAFE WITH THE BOLT FORWARD AND LOCKED. FAILURE TO COMPLY COULD RESULT IN SERIOUS INJURY OR DEATH.

1. Insert unloaded magazine into magazine well and verify it is fully seated by pulling downward.
2. Pull charging handle completely to rear. Bolt must lock back on empty magazine. Push charging handle forward until it locks in place.
3. Press magazine release. Magazine must fall free under its own weight.
4. Pull charging handle completely to rear. You should hear a slight click and visually see the bolt catch rotate upward. Release the charging handle, allowing the bolt to go forward.
5. Press and hold the bottom of the bolt catch while pulling the charging handle fully to the rear. The bolt should lock to the rear. Return the charging handle forward and press the bolt release located on the right side of upper receiver. Bolt should go forward and lock.
6. With muzzle pointed in a safe direction and fire control selector on SAFE, press trigger. Nothing should happen.
7. Rotate fire control selector to SEMI (FIRE) position, press and hold trigger to the rear. You should hear the hammer fall.
8. With the trigger still held rearward, pull charging handle completely to rear and release. Slowly release the trigger. You should hear an audible click and feel sear reset.

9. Rotate the selector to AUTO (if applicable).
10. Pull the charging handle to the rear and release it.
11. Press the trigger and hold to the rear. You should hear a loud click as the hammer falls.
12. With the trigger still pressed to the rear, pull the charging handle to the rear and ease it fully forward. A loud click should be heard at the end of the travel.
13. Release the trigger.
14. No click should be heard as the hammer should have followed the bolt carrier forward.
15. Press the trigger. No click should be heard. Release the trigger.
16. Pull the charging handle fully to the rear and release one more time. Rotate the selector back to SAFE.



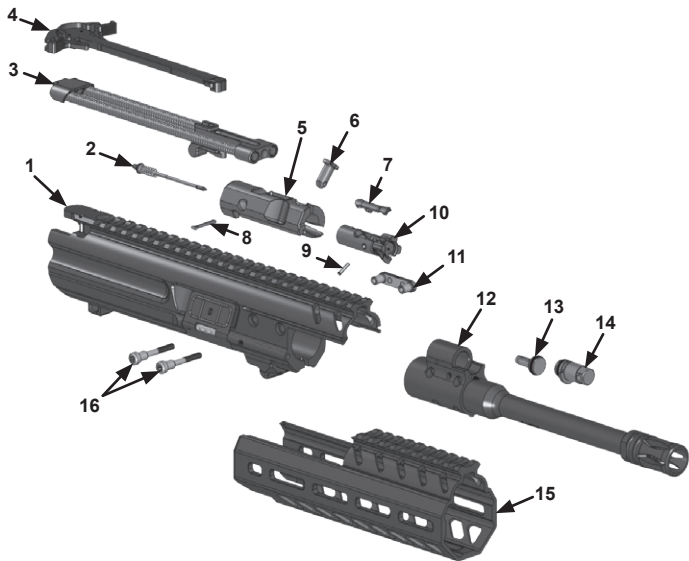
7.0 TROUBLESHOOTING

Stoppage	Test/Inspection	Corrective Action
<i>Fails to Fire</i>	Selector on SAFE	Rotate to a fire position
	Improper installation of firing pin	Assembly correctly
	Excessive oil in firing pin recess of bolt	Clean out with pipe cleaner
	Defective ammunition	Remove / Discard defective ammunition
<i>Bolt Fails to Unlock</i>	Dirty bolt	Clean and reinstall bolt
	Burred Bolt Lugs	Contact Customer Service
<i>Failure to Feed</i>	Dirty/Corroded ammunition	Clean and replace ammunition
	Dirty magazine	Clean and replace magazine
	Defective magazine	Replace magazine
	Overloaded magazine	Remove excess rounds
	Magazine not seated	Check magazine catch adjustment
	Under function	Contact Customer Service
<i>Double Feed</i>	Defective magazine	Replace magazine

Stoppage	Test/Inspection	Corrective Action
<i>Failure to Chamber</i>	Dirty/Corroded ammunition	Clean/Replace ammunition
	Damaged ammunition	Discard/Replace ammunition
	Dirty chamber	Clean chamber
<i>Bolt Fails to Lock</i>	Dirty bolt lugs	Clean lugs
<i>Failure to Extract</i>	Frozen extractor	Remove/Clean extractor
	Broken extractor spring	Contact Customer Service
	Restricted movement of bolt carrier	Remove, clean, and lube bolt carrier
	Dirty/Corroded ammo	Remove/clean
	Dirty chamber	Clean chamber
<i>Fails to Lock Bolt to Rear after Last Round</i>	Faulty magazine	Replace magazine
	Broken bolt catch	Contact Customer Service
	Reduced Function	Inspect gas system components
<i>Frozen Selector Lever</i>	Needs oil	Lubricate
	Dirt/Residue under trigger	Clean trigger



8.0 MPX & MPX-K UPPER RECEIVER PARTS DIAGRAM



Number	Nomenclature
1	Upper Receiver Assembly
2	Firing Pin and Spring
3	Recoil Assembly
4	Ambidextrous Charging Handle
5	Bolt Carrier
6	Cam Pin
7	Extractor
8	Firing Pin Retaining Pin
9	Extractor Pin
10	Bolt Assembly
11	Barrel Clamp
12	Barrel/Gas Block Assembly a. 8 in. (Shown) b. 4.5 in.
13	Piston
14	Gas Plug
15	Handguard Assembly a. 8 in. (Shown) b. 4.5 in.
16	Barrel Clamp Screws

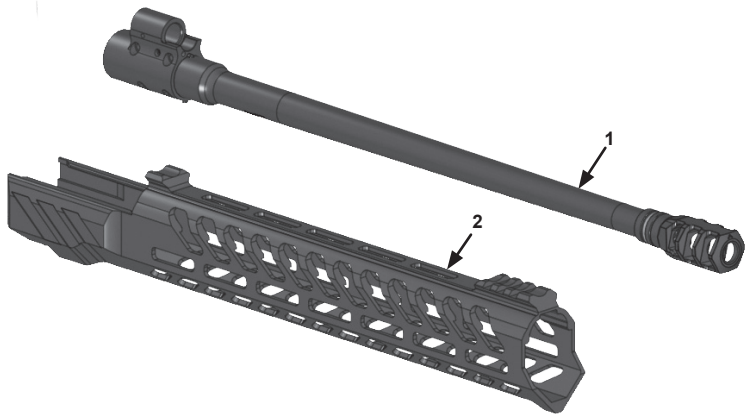


8.1 MPX & MPX-K LOWER RECEIVER PARTS



Number	Nomenclature
1	Lower Receiver Assembly
2	Magazine, 10 Rounds 9 mm
3	Magazine, 30 Rounds 9 mm

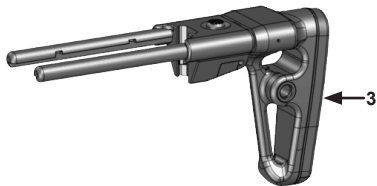
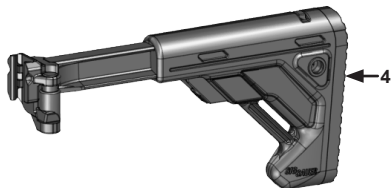
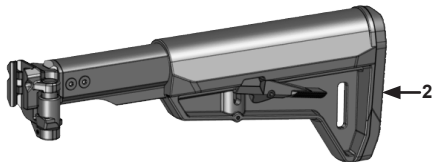
8.2 MPX PCC SPECIFIC UPPER RECEIVER PARTS



Number	Nomenclature
1	Barrel/Gas Block Assembly 16 in. PCC
2	Handguard Assembly 16 in. PCC



8.3 OPTIONAL STOCKS



Number	Nomenclature
1	Pistol Brace Assembly
2	Magpul Stock Assembly
3	Telescoping Stock Assembly
4	Stock Assembly, Folding/adjustable

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9.0 STORAGE AND TRANSPORTATION



WARNING UNLOAD/CLEAR



YOU MUST VISUALLY AND PHYSICALLY CONFIRM THAT THE MAGAZINE IS REMOVED AND THE FIREARM IS UNLOADED AND CLEARED PRIOR TO TRANSPORT. SEE SECTION “3.3 UNLOADING AND CLEARING THE SIG MPX” ON PAGE 38. FAILURE TO ENSURE THE MAGAZINE IS REMOVED AND THE FIREARM IS UNLOADED AND CLEARED PRIOR TO TRANSPORT COULD RESULT IN UNINTENTIONAL DISCHARGE, CAUSING SERIOUS INJURY OR DEATH TO YOURSELF OR OTHERS, OR DAMAGE TO PROPERTY.



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 YOUR FIREARMS MAY CAUSE SERIOUS INJURY OR DEATH TO YOURSELF OR OTHERS, OR DAMAGE TO PROPERTY.

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.



10.0 REPLACEMENT PARTS POLICY



WARNING

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 your firearm, the skill and workmanship of any particular third-party gunsmith is totally beyond our control.

Should your firearm ever require service, we strongly recommend that you return it 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 AFTERMARKET PARTS IS NOT AUTHORIZED AND 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 which will take you to the Small Parts Shopper page at sigsauer.com.



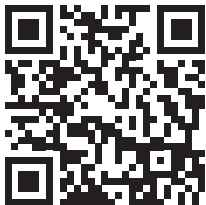


11.0 FACTORY REPAIR OF YOUR FIREARM

If you have questions or concerns regarding the performance or serviceability of your firearm, there are two ways to contact Customer Service:

Before contacting Customer Service, have your firearm's serial number readily available.

1. Call us at (603) 610-3000, choose option 1.
2. Email us at CustomerService@sigsauer.com.
3. Go to <https://www.sigsauer.com/customer-support> where you can message customer service electronically. Scan the QR code below which will take you to the Customer Support page at [sigsauer.com](https://www.sigsauer.com).



11.1 RETURNING FIREARMS FOR REPAIR

Please do not ship your firearm until you obtain an RMA number from Customer Service.



WARNING DO NOT SHIP AMMUNITION



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

1. The RMA number allows SIG SAUER to track the status of your return from its receipt at SIG SAUER through its return to you.
2. Ensure that the chamber and magazine(s) are unloaded and that no ammunition is included with your returned firearm.
3. Package the firearm securely to prevent damage. With the exception of extra magazines, do not include any other accessories such as scopes or mounts unless directed to do so.
4. Generally, an individual may ship firearms to the manufacturer for repair or service. Some states and localities, however, prohibit this. If you live in such an area, the firearms must be shipped by and returned to 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. (Note: 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, which you must strictly follow; prior to exporting any firearm you should seek legal counsel.)



6. SIG SAUER is not responsible for any firearm until it is received, nor for damage incurred during shipment.
7. Ship your firearms insured and prepaid (we do not accept collect shipments) to the address provided by Customer Service.

SIG SAUER INFINITE GUARANTEE™

For warranty information on your new SIG SAUER firearm, scan the QR code below. This will take you to the SIG SAUER Warranty Information and Registration page on our website. There you will also be able to register your new firearm and find information about our warranty.





NOTES:

NOTES:

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