Field Manual for Bolt Actions Rifles

Monolithic Integral Suppressed Barrel (MISB) ™
By SWS Rifles (Patented)

SUPPRESSED WEAPON SYSTEMS

The MISB™ combines a rifle barrel and suppressor into one unit.
The system consists of four parts:

- Barrel with integral suppressor baffles
- Suppressor tube
- Threaded endcap
- Rubber O-rings

Full disassembly and cleaning should be performed after every ~500 rounds.
Tube should be removed and brushed clean every 100 rounds.

Disassembly

1. Unscrew endcap from barrel. Endcap uses common right-hand threads. If endcap will not unscrew by hand, any flat metal object can be used to leverage the cap. (back of a strong knife or a medium sized screwdriver)
2. Remove suppressor tube from barrel by twisting and pulling tube forward.

If tube will not come off after endcap is removed follow these steps:

1. Spray a strong solvent in the breach and muzzle of the rifle. (Bore cleaner, break/carb cleaner)
2. Rotate rifle to spread solvent around. Let rifle sit for 10 minutes.
3. Securely hold the stock and spin the suppressor tube. After the tube breaks free pull forward. (This can take several people to accomplish)

*****Warning****** **NEVER GRAB SUPPRESSOR TUBE WITH A WRENCH, PLIERS, VICE GRIPS OR CHANNEL LOCKS.** This will cause damage to the tube making it impossible to remove.

Cleaning

With suppressor tube removed, clean carbon deposits and debris from barrel exterior and from suppressor baffles. It is normal for barrel surface to remain black in color after adequate cleaning.

Do not use solvents to clean rubber O-rings.

Foreign materiel (mud, sand, snow, ect.) can be cleared from suppressor cavities with any suitable object, such as 5.56 shell casings, cleaning rod, knife ect.

No special care is necessary while cleaning rifle bore. Clean as any other precision rifle. However, caution must be used to prevent cleaning patches from becoming lodged in suppressor baffles. Never push loose patches through rifle without first removing suppressor tube.

***Cleaning patches or other foreign objects that remain in suppressor can deflect bullet upon firing, causing bullet to strike interior of suppressor with catastrophic results.

To clean interior of suppressor tube stuff oiled rag in one end of suppressor tube. Push rag through tube with rifle barrel.

To remove hard baked on carbon deposits the use of a round wire tube brush is permitted. (McMaster-Carr item #7231T14 or similar) Spray a lubricating oil like WD40 into tube. Attach round wire brush on to a non-marring rod. (Wood is preferable). Run rod with wire brush through suppressor tube. A power hand drill can be used to speed this process up.

Wipe carbon buildup from endcap threads and from mating threads in end of barrel. Lightly oil threads.

Reassembly

1. Heavily oil or grease O-rings on the barrel and endcap.
2. Slide suppressor tube onto barrel. Pull tube rearward while twisting until tube is fully seated.
3. Thread endcap onto barrel. Tighten by hand. Suppressor tube will spin freely when endcap is installed.

O-Rings

Rubber O-rings will wear over time. (McMaster-Carr #9396K142)
(1”ID / 1 3/16 OD, 3/32 Diameter)

Replace O-rings if:

- Suppressor tube rattles when assembled on rifle.
- Gas leaks from under suppressor tube when firing.
- Rubber looks damaged.

Old O-rings can be pried or cut from rifle and endcap.

Stretch new O-ring around endcap until it snaps into groove.

The suppressor tube itself can be used as an O-ring installation tool. Stretch new O-rings around the end of suppressor tube. Slide tube over barrel. Roll O-rings off tube into grooves on rear of barrel.